



Daffodil
International
University

Faculty of Engineering

Department of Textile Engineering

REPORT ON

‘Study on the Comments of Sample Garments’

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Course Code: TE 4214

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

Advance in Apparel Manufacturing Technology

30th June,2021

Declaration

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

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Approval Sheet

This research entitled “**Study on the Comments of Sample Garments**” at Daffodil International University, June,2021” prepared and submitted by Md. Sohel Rana (ID#: 172-23-5043) in partial fulfillment of the requirement for the degree of Bachelor in Science Textile Engineering has been examined and hereby recommended for approval and acceptance.

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Abstract

Garment sample is merely important and is developed before starting the bulk production. It refers that making a sample of the garment that need to be satisfactory to the buyer. Sampling is one of the prime processes in Garment Industry and it has a significant play to attract the buyers. It is note worth that the buyers normally places the order after being satisfied with the quality of the Samples. The samples intimate the ability of a supplier. The buyer will consider the supplier and the organization nothing but the samples. Whether the samples meet the quality requirement and having reasonable price, generously the buyers are to be attracted to place the order. So it is necessary that the samples having innovative and with up to the quality. By making samples, the supplier can calculate the consumption of yarn to develop the fabric, a clear concept on costing more ever the manufacturing difficulties. Besides by developing sample, the supplier can optimize the processing parameters for bulk production, which helps to avoid all kind of bottlenecks. All these works are conducted by the sample department that deals with the buyer at the frontier

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1. Introduction

Sample section is the branch of a garment manufacturing industry that involves how to make garment better to satisfy the buyer. Sample section is also concerned with developing sample and its making method which attracts the buyer, improves quality of the products.

It is one of the main processes in garment manufacturing and it plays vital role in attracting buyers and confirming the order. It is the most crucial and most important sphere of merchandising. Sample section makes sample relying on the specification and requirement by the buyer. Sampling in merchandising may be defined as "The concept, perception and ideas of fashion designer developed into product samples, in systematic stages of product development, with technical and quality clarity in a development." Though sampling is a difficult and time bound process, it helps the supplier to get order from the buyer. Before placing any order to the factory, the buyer is keen to know whether the factory is capable of producing the styles with the desired quality levels or not. The samples imply the ability of supplier to deal with any given style of garment. The buyer accesses the capability of supplier nothing but the help of sample. If the samples are of good quality naturally the buyers will be willing to place the order to factory. Sampling also work as a bridge between the productions and marketing department, hence it has the influence of both marketing as well as production department. So it is essential that the samples should be innovative and should be manufactured with optimum quality.

1.1 Objectives of this thesis:

- To know about the sampling parameters
- To identify the reason of sample fails
- To identify the most tendency for the sample fail
- To have a statistics overview of sample failure

1.2 Scope of this thesis:

- Study, measure and improve the individual performance
- Establish a better system to rectify the sample failure percentage
- Specify, Predict and evaluate the works

1.3 Limitation of this thesis:

- It is a critical to be accessed
- Complexity in tolerance level

2.Literature Review

2.1. Garments Sampling

Garment sampling is very much important process. It is a model of what the bulk production is going to be done. The sampling is quite difficult but it will make the buyers to get attractiveness towards the industry. Because the buyers generally place the order after they are satisfied with the quality of the samples. Garment sampling is a very important task in an apparel manufacturing because it gives the satisfaction of the customer with respect to the product being manufactured. This is in turn important because if the buyer is not satisfied by the samples, this puts the following at risk:

- Placement of the order
- Acceptance of the some or the entire quantity of garments produced.

There may be a separate sampling department in a company. But as the merchandiser is the person who is interacting with the buyers regarding samples and other requirements, this sampling department will work under the guidance Also as the samples are to be made according to the buyers' price ranges and quality levels, merchandiser has to advise.

2.2. Purpose of Sampling

- a. To allow the buyer to judge the production capabilities of the manufacturer.
- b. To provide a means for making revisions in the bulk production process.
- c. To let the manufacturer estimate the thread and fabric consumption, and develop cost quotations.

2.3 The Details Attached to the Garment Sample

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

- Ref no.
- Color
- Fabric

- Composition
- Description
- Quantity
- Style no/ Size
- Store

2.4 Sampling Process

The process of sample development varies continuously, and the development process will cover a wide range of unique products from new fibers, fiber blends, new yarns, fabric structures, finishes and surface effects new technology and all types of made up products such as woven, knit wear, hosiery, cut and sewn garments, household products, technical and medical products.

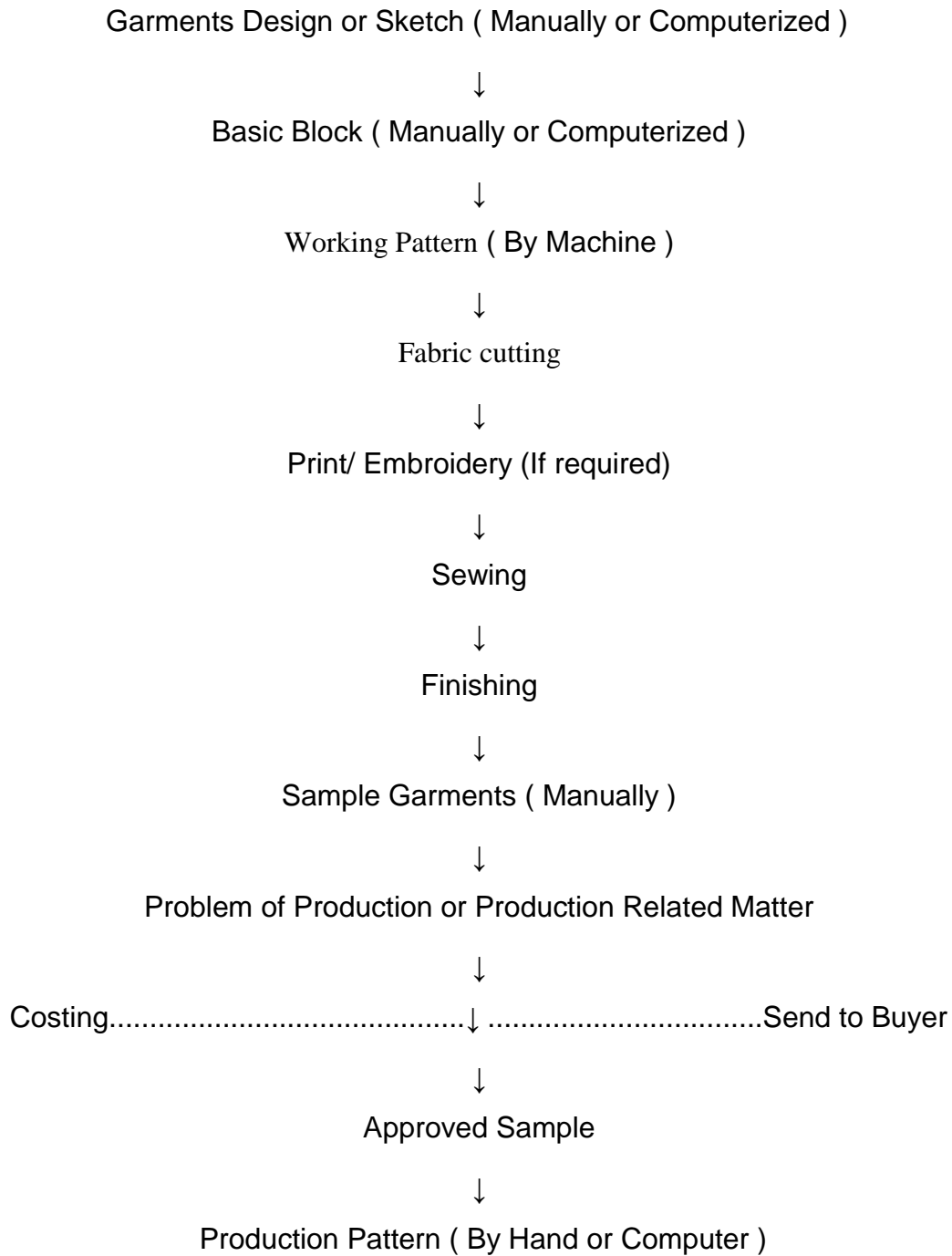
There are different phases of sampling; the first phase covers the development of the initial concept or design idea and getting the approval by the customer.

The second phase covers the process after getting acceptance of the first prototype sample and carry out the functions of sourcing and ordering component, testing the product and carry out trials once the finalized sample specifications has been drawn up.

The third and final phase includes a range of activities that are carried out before large scale or bulk production capacity outside the producer/developers if this is needed.

2.5 Flowchart of Sampling

Flow Chart of Garment Sample Making



2.6 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

2.6.1 Proto Samples or Fit Samples

These samples are done after getting the new order from the buyer. These samples are needed to check the measurements, style and fit. So they can be made in available similar fabrics but in the actual measurements and specifications given from the buyer.

Some buyers may need these samples if they want to print the photos of garments on packing box, hang tag, in showrooms, etc.

After sending the proto samples the buyers will conduct discussion over the samples and they will access the content of the sample and give us comment and reviews.

2.6.2 Photo shoot Sample

In this category which deals mainly with the real fitting on garments. The buyers will conduct photoshoot sessions with the samples we have sent. By this we can clearly get the fitting requirements and problems in the measurements. By doing this buyers can give us comments with the photo attachments.

2.6.3 Salesman Sample

The buyer needs these samples for getting the orders from their customers. If the buyer is having 7 salesmen in his office, then the buyer will ask us to make 7 samples in each style.

The salesmen will book the orders from their customers, by showing these samples. Buyer will place the order to us according to customer attractiveness towards the sample.

Sales samples are made with actual fabric and trims and accessories. Buyer pays for salesman samples to the developer.

2.6.4 Sizeset Samples

These sample are done after the salesman sample. In SMS we will sent samples in one size only. Hence sizeset samples are done to check the grading of all sizes are ok and the measurements are quite good.

2.6.5 Counter Sample or Reference Sample

These are the sample which are made as same as the other samples. We will sent samples to the buyer and keep one of the same sample for our reference. By getting acceptance from the buyer we can proceed the work according to the reference sample we have with us.

2.6.6 Pre-production Samples

These samples are almost like approval samples. They have to be made in actual production fabric with actual bulk trims. They will represent that the production will be like these samples.

2.6.7 Wash Sample

Wash sample is made and submitted to buyer for assessment of feel and handle of fabric after washing of Denim or shirt washing program, hence either at size set stage or PP stage washing sample is sent to buyer for approval and carry forward of washing program. If sample is not approved or approved with comments, factory needs to submit 2nd sample to get approval. After feel assessment buyer may suggest the changes in washing program.

2.6.8 Online Sample

Once production is online, few pieces is taken out in the middle of the production. Production pieces are sent to buyer as TOP sample. All buyers do not ask for TOP sample. Purpose is to cross-check whether factory is following PP sample specification or not.

2.6.9 Shipment Samples

These samples are to be sent just before shipment. They should be sent in actual packing with all labels, tags, etc. (Generally these samples will not be tested by buyer for anything). And even if we get some comments from buyers like changes in price tag or changes in the assortments we can adopt the changes in the process but it's not the risk for the supplier.

2.7 Meeting with Buyers

In this stage designer of a manufacturing house shows their creations, latest designs to buyers. On other hand if buyer already had fixed design of a style and need few changes on it related to fit, fabrics or trims they discuss those thing with the merchandiser of the manufacturing unit.

2.8 Development of Initial Samples for the Buyer

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

2.9 Development of Fabric Sample, Bit Loom, Print and Embroidery

Artwork

Fabric is developed as per the buyer requirement. Fabric development means sourcing of customer specific fabric with matching properties, dyed and finished for solid colors. For the solid color lap dip approval is very important process. Until lap dip sample is approved merchants re-submit lap dips. In case of yarn dyed fabrics merchants develop fabric sample with specified design, stripes or checks. These fabric samples called as Bit Loom. Other approvals such as print and embroidery artwork approval and color approval are done. It may be done later stage at time of pre-production.

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

Merchants prepare cost sheet with details cost break up such as raw material cost, manufacturing cost, overheads and margin. Costing is very a critical stage. Because whether a company will get order or not depends on their costing. If they garment cost is very high then manufacturer may lose the order and on other hand if factory keep their cost low, they will not earn profit from the order. Estimation of the garment cost should be done on data based.

3.Methodology

3.1. SAMPLE COMMENT OF PO. 10058607

Buyer	NKD
Item	Da. Caprilegging/ La. Caprilegging
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute M=missing	
	Yes no	S M	Comments

Style	x				
Fitting		x			We found some measurement out of tolerance Size: 44/46 48/50 ½ knee width +0.5cm +1cm Inseam length +2cm +1cm Pls. follow the measurement chart exactly
Workmanship		x			-waistband gathering sb regular -all the stitching tension sb free
Material/quality	x				Required gsm 190, found gsm 171, -11%.pls. improve the gsm
Colour	x				
Accessories	x				
Embroidery					
Application	x				But grading should be even size wise if any
Print					
Woven-label	x				
Hangtag				x	Plz ensure to attach the missing hang tag “Laura Torelli Plus”
Size-label					
Care-label	x				Wash/Care label must be clearly visible
Price-label				x	Plz ensure to attach at bulk
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Plz. Improve all mentioned points for further process

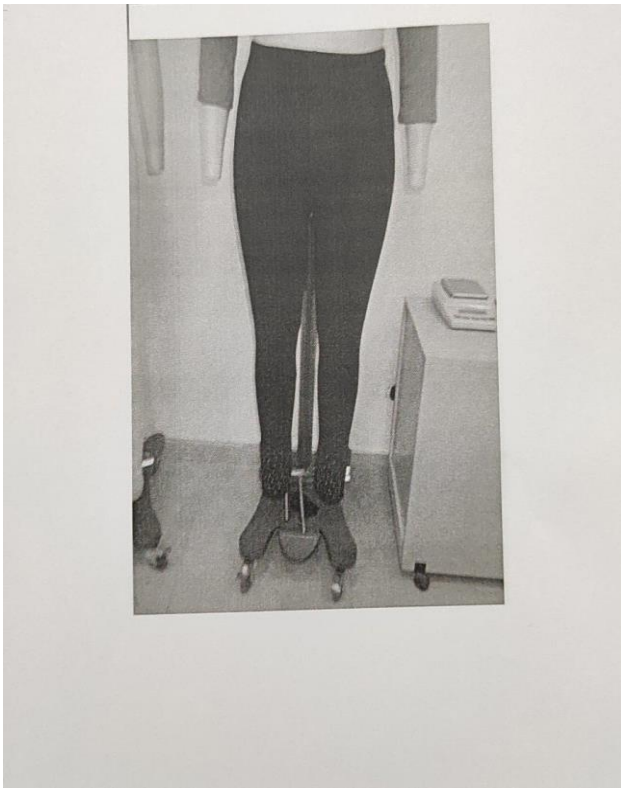


Fig. 3.1. Defect of PO 10058607(front view)

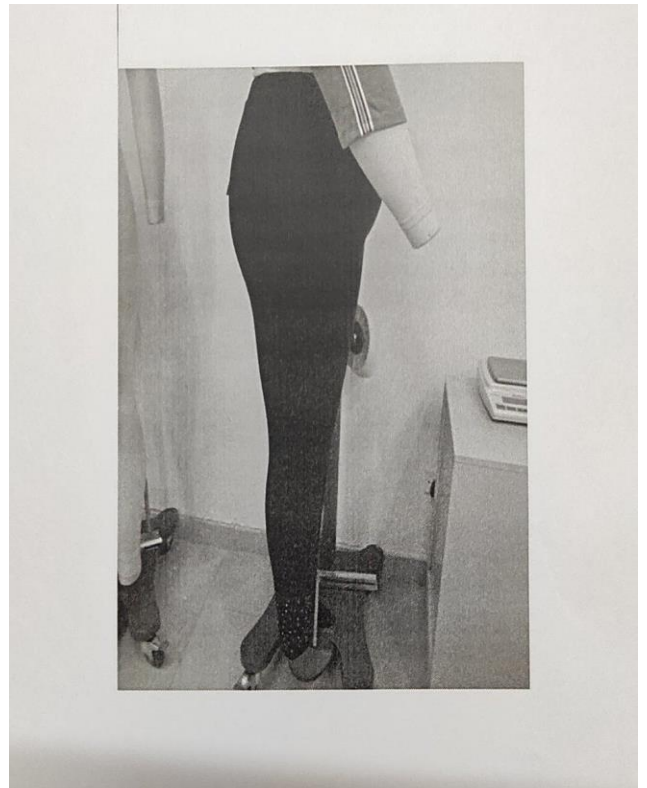


Fig. 3.2. Defect of PO 10058607(side view)

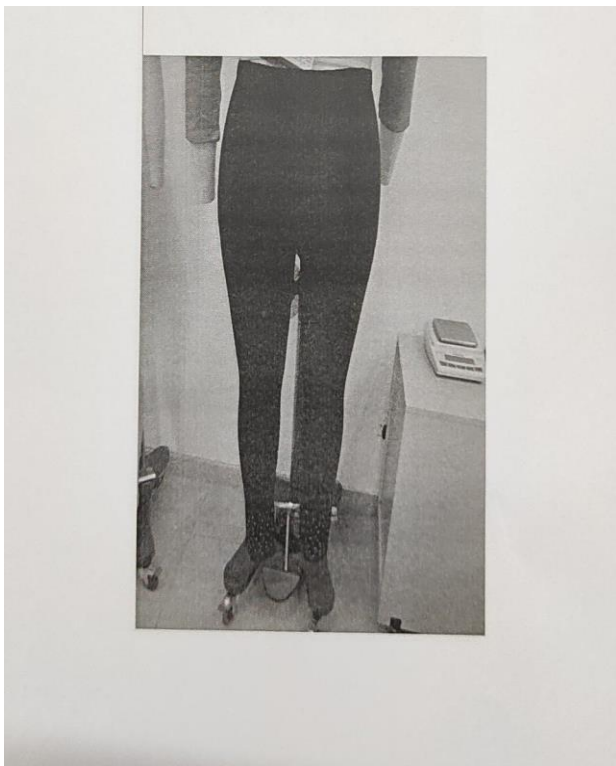


Fig. 3.3. Defect of PO 10058607(back view)



Fig. 3.4. Defect of PO 10058607(wash view)

3.2. SAMPLE COMMENT OF PO. 10061251

Buyer	NKD
Item	Da. T-Shirt/ LW-S. Sleeves T-Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute		
		M=missing		
	Yes	no	S	M
				Comments

Style	x				
Fitting		x			<p>We found measurement in tolerance except neck opening seam to seam</p> <p>Size S M</p> <p>Neck opening straight seam to seam -1cm -0.5cm</p> <p>We don't accept that. Plz follow the MC exactly to have no deviations.</p>
Workmanship		x			<p>All seam tension s/b free.</p> <p>Sleeve turn-up height uneven not ok, its s/b even.</p> <p>Sleeve turn-up inside row-edge too much visible not accept. Edge s/b inside stitching.</p> <p>Fabric on too much naps not ok. Its s/b clean.</p>
Material/quality	x				<p>Found naps pls improve during bulk.</p> <p>Weight we found ross 179gsm, green 182gsm, yellow 170gsm, black 209gsm, is too high and some are to less not accept, we can accept +-5%</p>
Colour	x				
Accessories	x				
Embroidery					
Application					
Print					

Woven-label	x				
Hangtag					
Size-label	x				
Care-label	x				
Price-label				x	
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Plz improve all the point on pp meeting. Must be improve fabric quality.

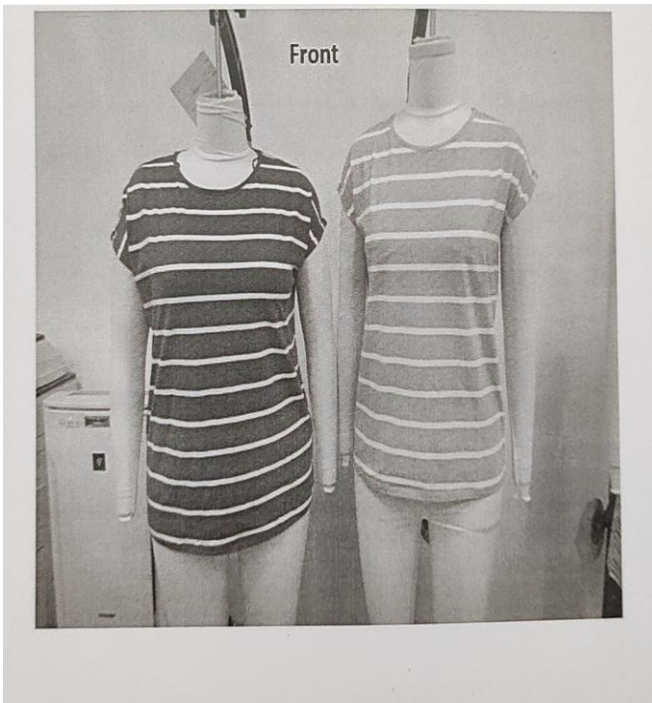


Fig. 3.5. Defect of PO 10061251

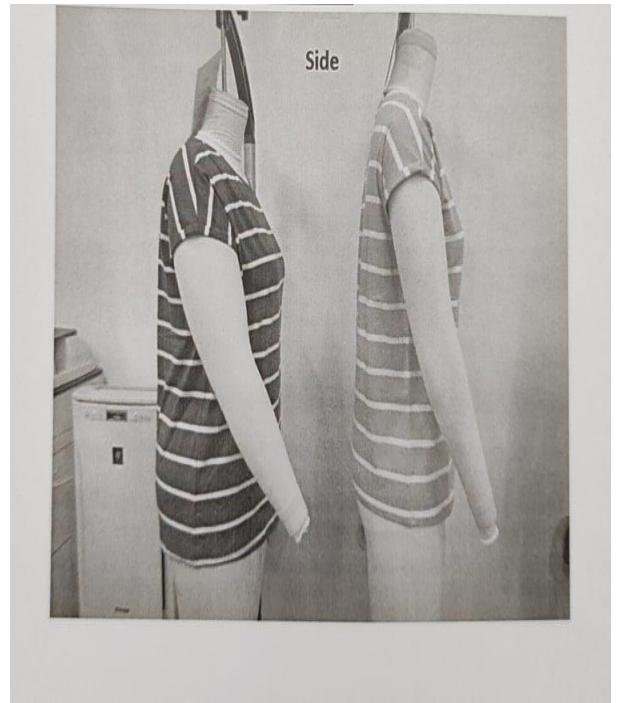


Fig. 3.6. Defect of PO 10061251

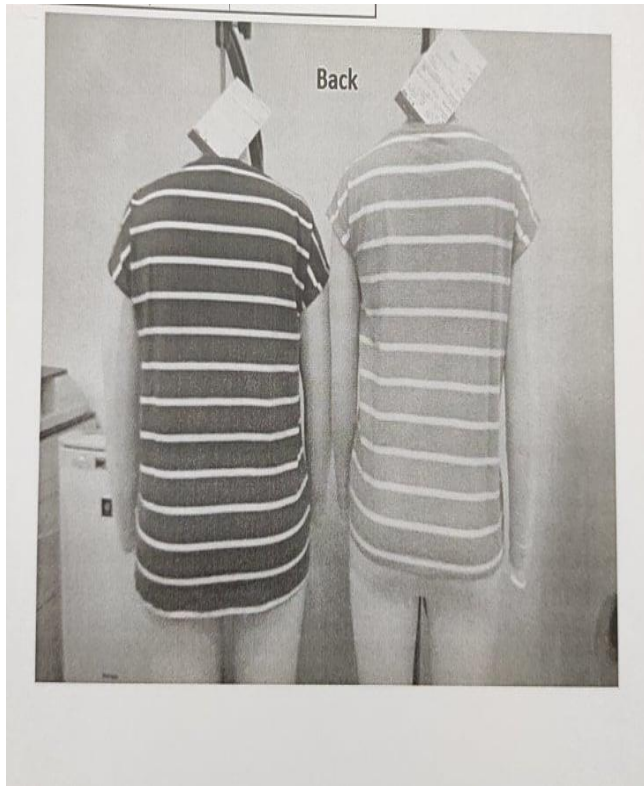


Fig. 3.7. Defect of PO 10061251



Fig. 3.8. Defect of PO 10061251

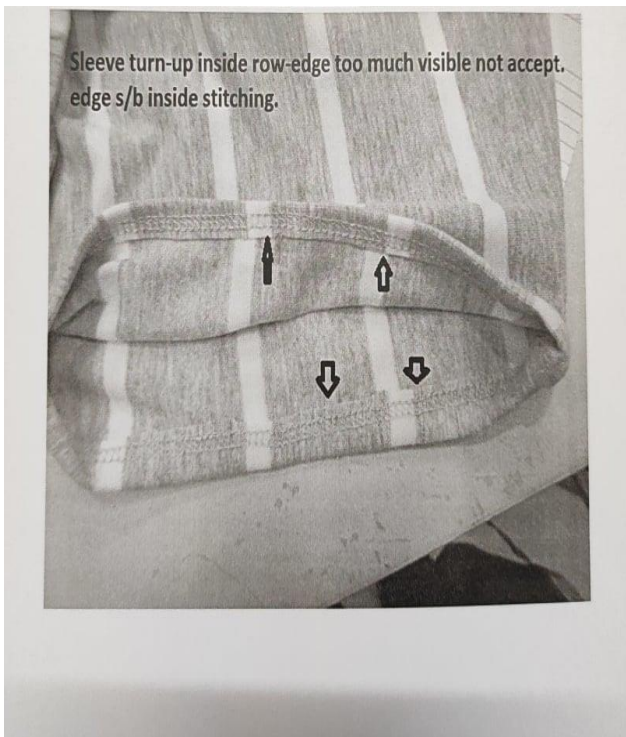


Fig. 3.9. Defect of PO 10061251



Fig. 3.10. Defect of PO 10061251



Fig. 3.11. Defect of PO 10061251

3.3. SAMPLE COMMENT OF PO. 10050307

Buyer	NKD
Item	Kinder Jungen Bermuda/ Kids Boys
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes	no	S M Comments

Style	X				
Fitting		X			<p>We found some measurement out of tolerance</p> <p>Size: 110/116 122/128</p> <p>Zipper stitching length -0.5cm</p> <p>Pocket at side +0.5cm</p> <p>Max. visible string length +2cm +2.5cm</p> <p>Thigh pocket length incl.flap +0.5cm</p> <p>Thick pocket flap width -0.5cm -0.5cm</p> <p>Pls. follow the measurement chart exactly</p>
Workmanship		X			<p>-Waistband gathering slanted and irregular gathering, gathering must be need regular.</p> <p>-String edge fray out, fray out not accepted, its s/b clean finish. Plz see the attach picture and follow.</p> <p>-Waistband height must be even, uneven height non allow.</p> <p>-all the stitching tension must be free.</p> <p>-Spare button must be add in the zip-poly, its must be compulsory for nkd.</p>
Material/quality	X				Gsm is ok
Colour	X				
Accessories	X				Tape color ok. Plastic button is ok
Embroidery					
Application					

Print					
Woven-label	x				
Hangtag					Oeko-tex hang tag s/b in English language.
Size-label	x				
Care-label				x	
Price-label					
Size-spec		x			Plz follow revise mc, update in the txt. Date:20.12.19
Wash-test	x				
Revised sample		x			
General remarks					Plz. Improve all mentioned points and send us reverence sample from the pp meeting. Follow the new spec.

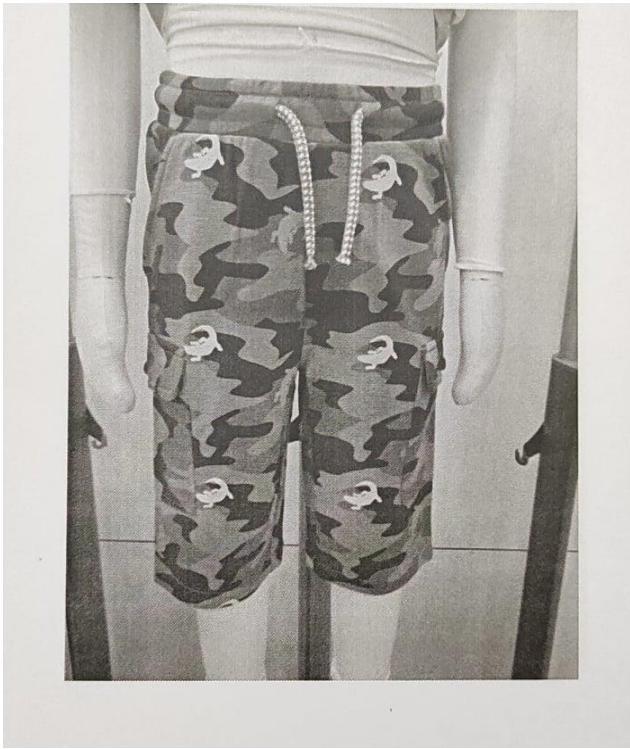


Fig. 3.12. Defect of PO 10050307(front view)



Fig. 3.13. Defect of PO 10050307(side view)

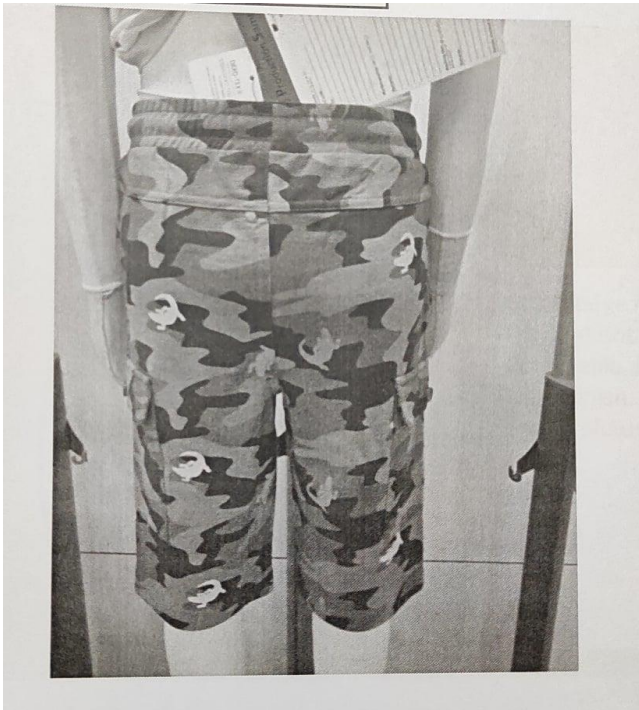


Fig. 3.14. Defect of PO 10050307(back view)

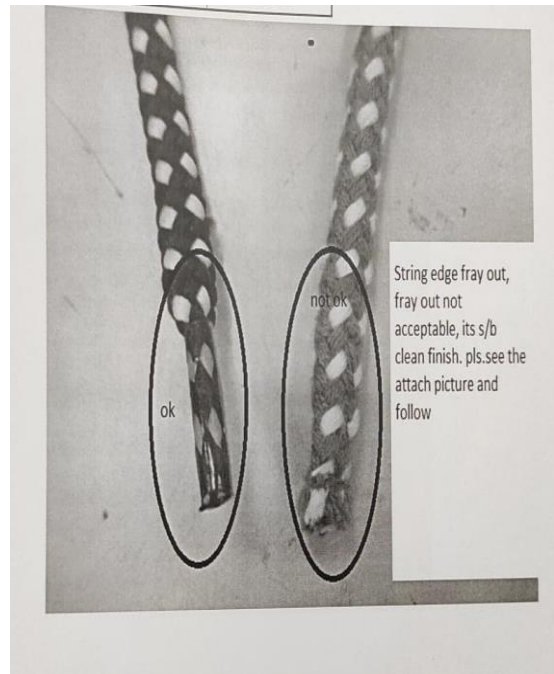


Fig. 3.15. Defect of PO 10050307

Side pocket bottom side 1cm reduce and width shape some increase then we found flap pocket position is ok, pls. see the attach picture and must be follow only for 110/116 size and 98/104size but 122/128 size flap pocket just move 1cm#

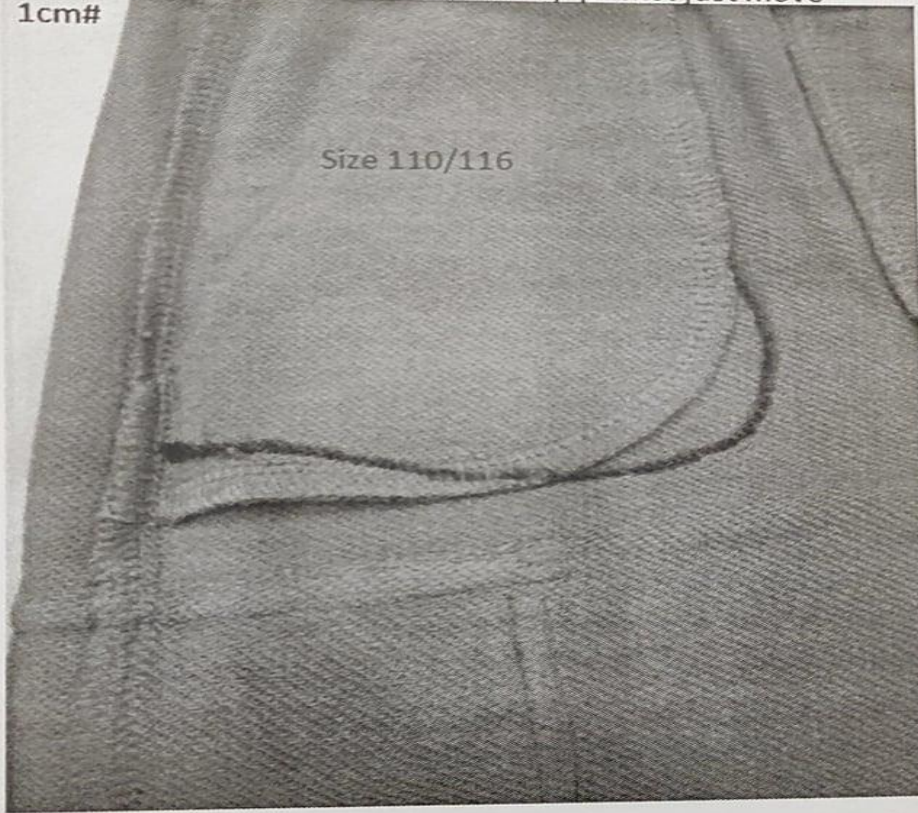


Fig. 3.16. Defect of PO 10050307

3.4. SAMPLE COMMENT OF PO. 10061058

Buyer	NKD
Item	YFW T-Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes	no	S M Comments

Style	x																									
Fitting		x			<p>We found some measurement discrepancy from the size chart.</p> <table> <tr> <td>Size:</td> <td>XS</td> <td>S</td> </tr> <tr> <td>Front width 15cm fm hsp</td> <td>+1cm</td> <td>+0.5cm</td> </tr> <tr> <td>Back width 15cm fm hsp</td> <td>+1cm</td> <td>+0.5cm</td> </tr> <tr> <td>½ bottom width</td> <td>-1cm</td> <td>-1cm</td> </tr> <tr> <td>Body length from hsp</td> <td>+1cm</td> <td>+1cm</td> </tr> <tr> <td>Tape length</td> <td>+1cm</td> <td>+1cm</td> </tr> <tr> <td>Neck opening edge to edge</td> <td>-0.5cm</td> <td>-0.5cm</td> </tr> </table> <p>Pls. improve pattern and work exactly from the size chart.</p> <p>Fitting: Sleeve head pointed, see photo, sleeve head s/b rounded shape, plz improve.</p>	Size:	XS	S	Front width 15cm fm hsp	+1cm	+0.5cm	Back width 15cm fm hsp	+1cm	+0.5cm	½ bottom width	-1cm	-1cm	Body length from hsp	+1cm	+1cm	Tape length	+1cm	+1cm	Neck opening edge to edge	-0.5cm	-0.5cm
Size:	XS	S																								
Front width 15cm fm hsp	+1cm	+0.5cm																								
Back width 15cm fm hsp	+1cm	+0.5cm																								
½ bottom width	-1cm	-1cm																								
Body length from hsp	+1cm	+1cm																								
Tape length	+1cm	+1cm																								
Neck opening edge to edge	-0.5cm	-0.5cm																								
Workmanship		x			<p>Neck shape uneven, see photo, plz improve</p> <p>Stripe uneven at both side neck/ shoulder, plz improve during cutting and swing.</p>																					
Material/quality	x				Weight we found 216gsm too high, require weight 180gsm and we will accept +-5%																					
Colour	x																									
Accessories	x																									
Embroidery																										
Application																										
Print																										

Woven-label	x				
Hangtag					
Size-label	x				
Care-label	x				
Price-label				x	
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Plz improve all points during pp meeting. Special attention: neck and armhole shape, bottom ribbon, measurement.

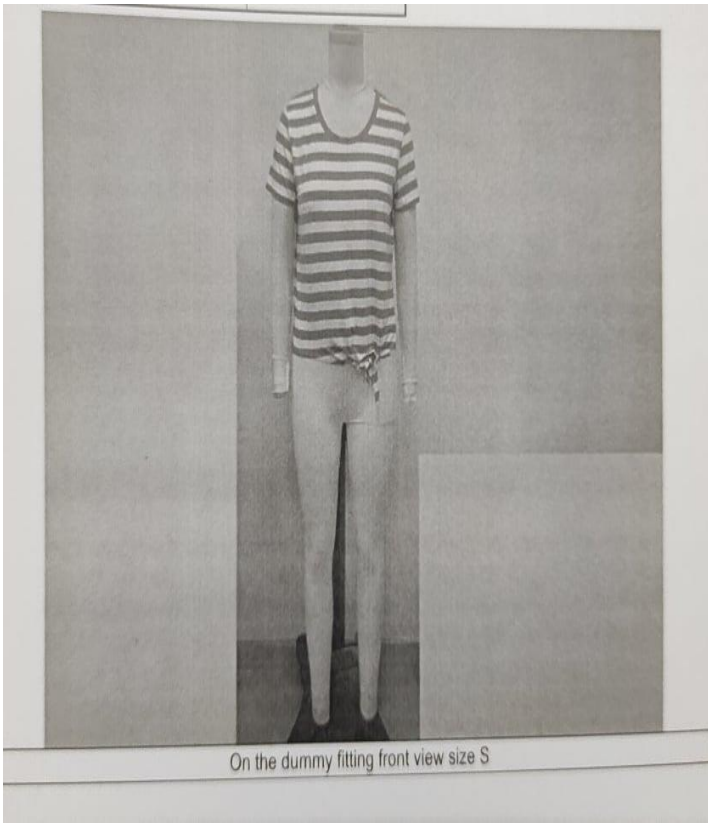


Fig. 3.17. Defect of PO 10061058

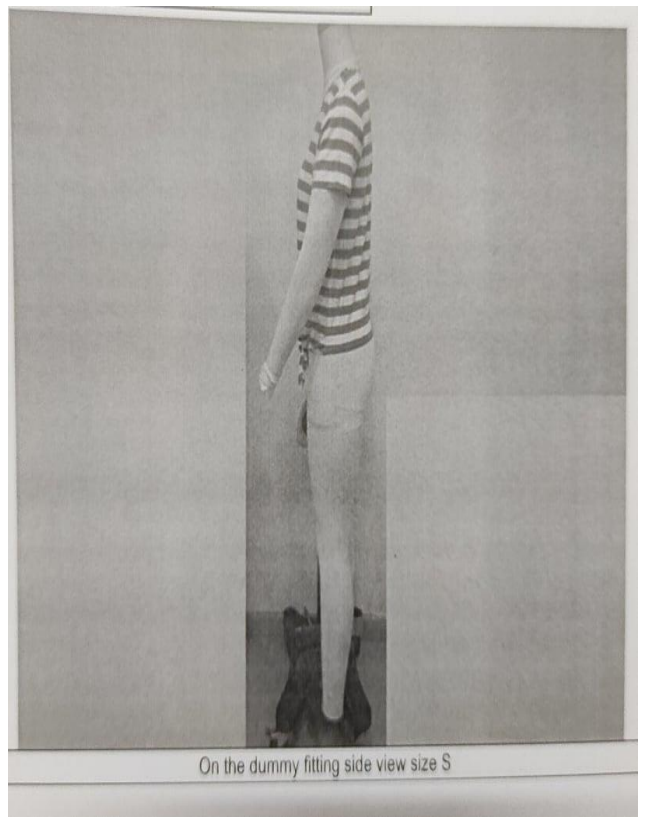


Fig. 3.18. Defect of PO 10061058

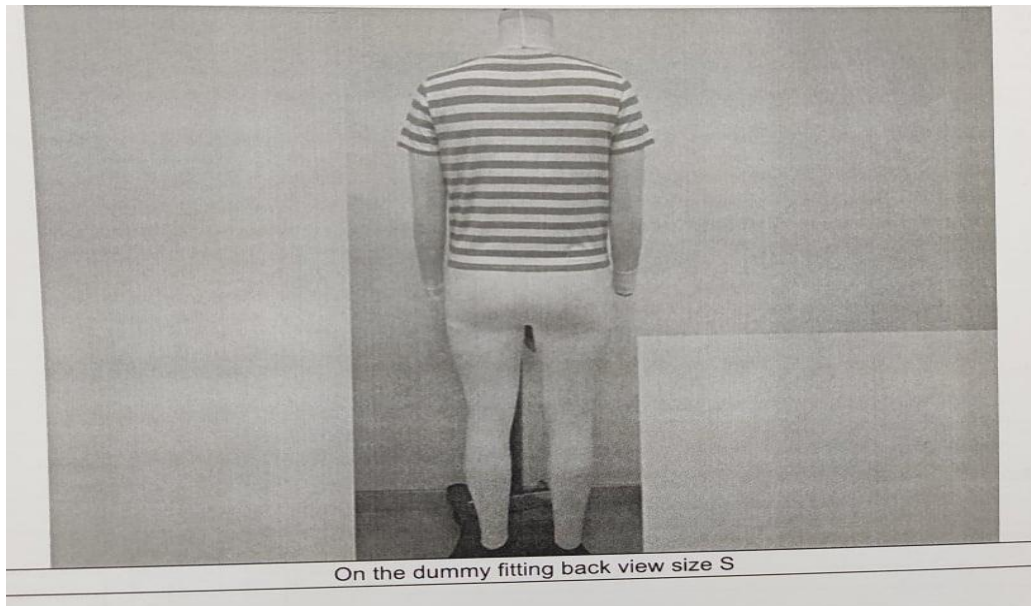


Fig. 3.19. Defect of PO 10061058

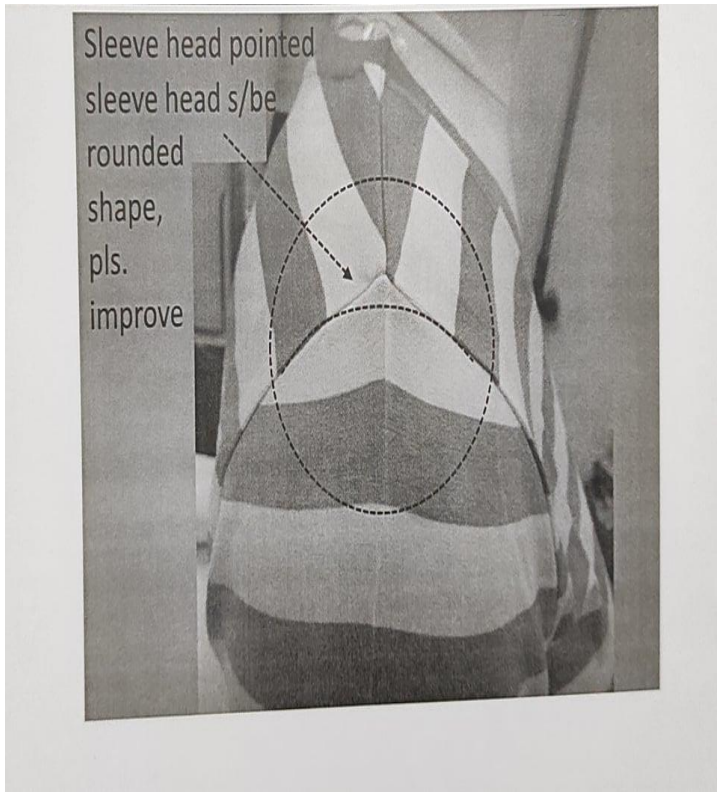


Fig. 3.20. Defect of PO 10061058

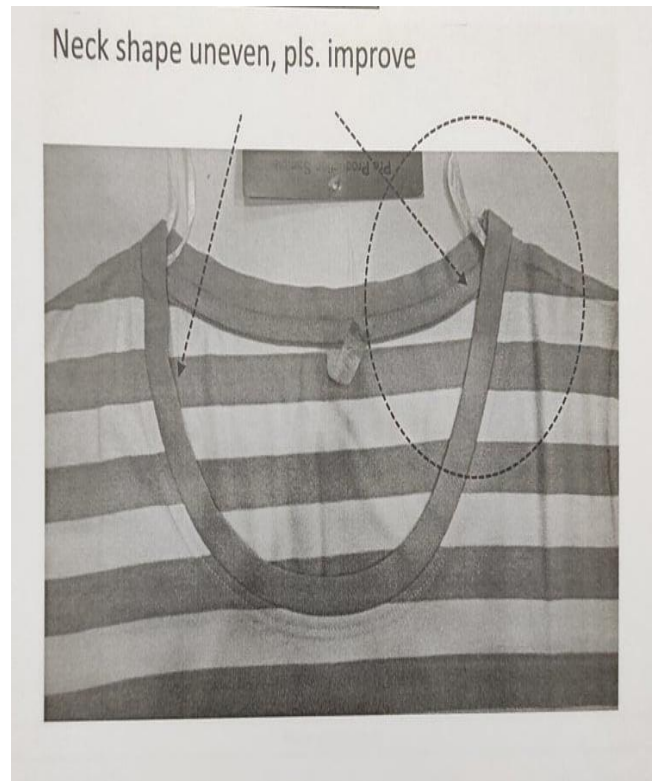


Fig. 3.21. Defect of PO 10061058

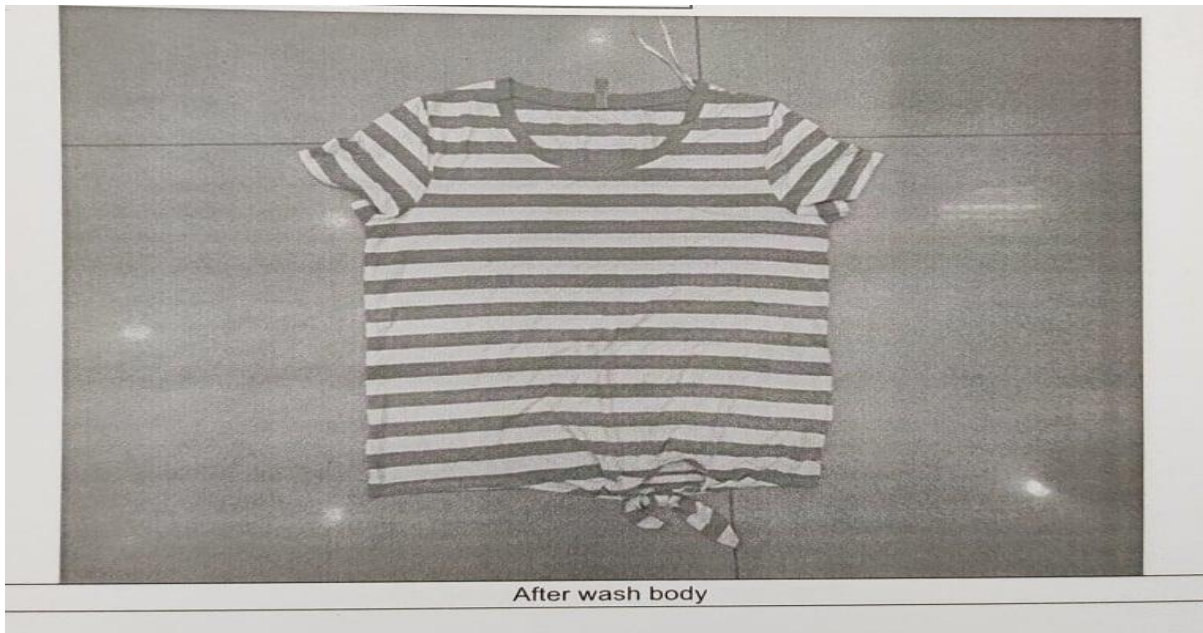


Fig. 3.22. Defect of PO 10061058

3.5. SAMPLE COMMENT OF PO. 10057699

Buyer	NKD
Item	YFW Sweatshirt 1/1 Arm / YFW
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute		
		M=missing		
	Yes no	S M	Comments	

Style	x													
Fitting		x			<p>We found some measurement discrepancy from the size chart.</p> <table style="width: 100%;"> <tr> <td>Size:</td> <td style="text-align: center;">XS</td> <td style="text-align: center;">S</td> </tr> <tr> <td>Hood height from shoulder ...</td> <td></td> <td style="text-align: center;">-1cm</td> </tr> <tr> <td>Hood height(depth) max</td> <td style="text-align: center;">-1cm</td> <td style="text-align: center;">-1cm</td> </tr> </table> <p>Pls. improve pattern and work exactly from the size chart.</p> <p>Fitting: neck shape slop both side high low/uneven, see photo, pls. improve pattern</p>	Size:	XS	S	Hood height from shoulder ...		-1cm	Hood height(depth) max	-1cm	-1cm
Size:	XS	S												
Hood height from shoulder ...		-1cm												
Hood height(depth) max	-1cm	-1cm												
Workmanship		x			<p>Hood lining joint not correct, hood lining s/b joint with shell fabric tape, pls. improve.</p> <p>Fabric stripe should be match at both side neck, sleeve and side seam, pls take care during cutting.</p> <p>Stripe uneven at front zipper joint, see photo, pls. improve.</p>									
Material/quality	x				Weight we found 291gsm high, require weight 270gsm and we accept +-5%									
Colour	x				Pls. remove the yellow tone from the ecru color & send us bulk fabric for our approval									
Accessories	x													
Embroidery														
Application														

Print		x			Chest print & hood inner print not ok, we change the print & after receive rev. strike off we will approve by separately.
Woven-label	x				
Hangtag					
Size-label	x				
Care-label					
Price-label				x	
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					

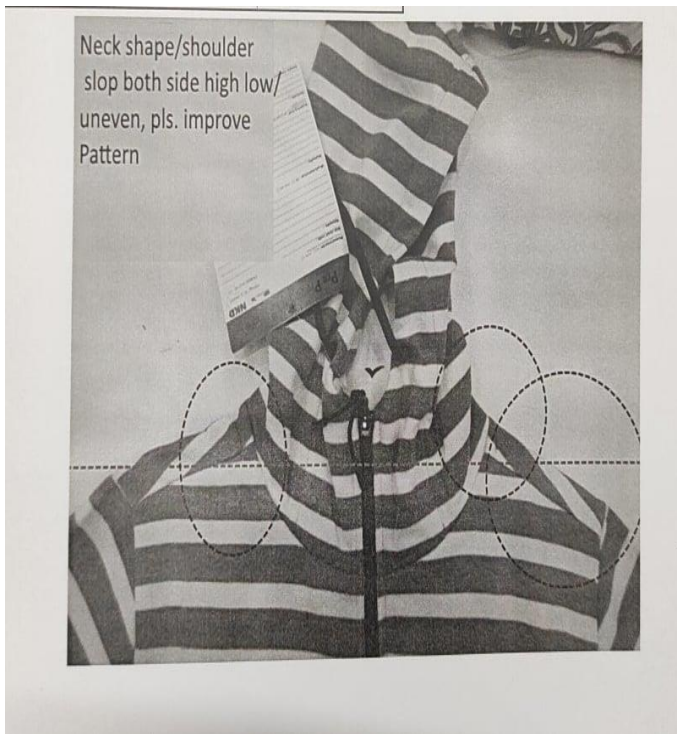


Fig. 3.23. Defect of PO 10057699

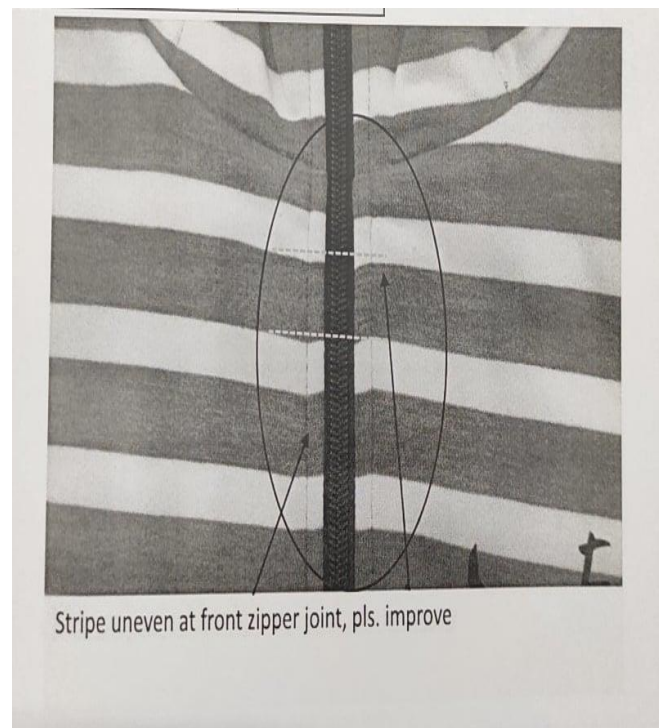


Fig. 3.24. Defect of PO 10057699

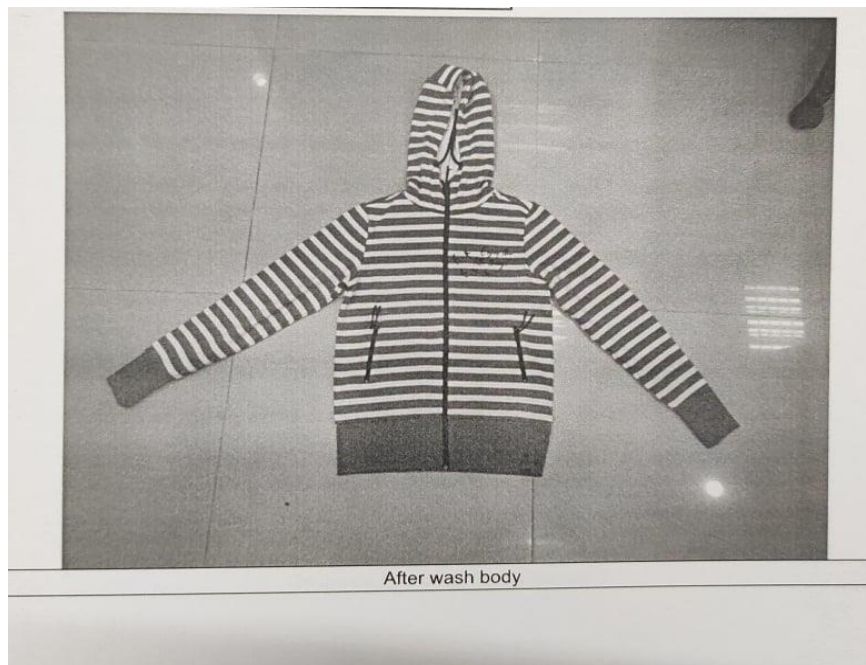


Fig. 3.25. Defect of PO 10057699

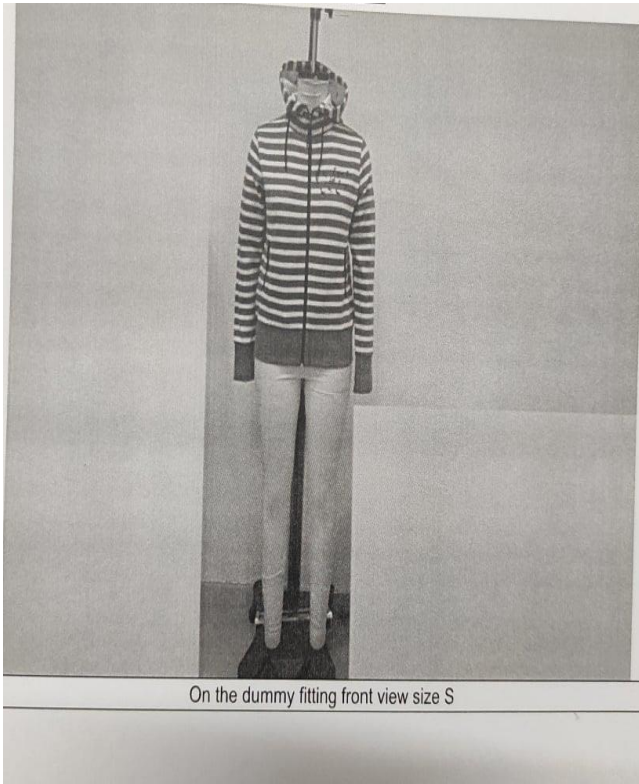


Fig. 3.26. Defect of PO 10057699

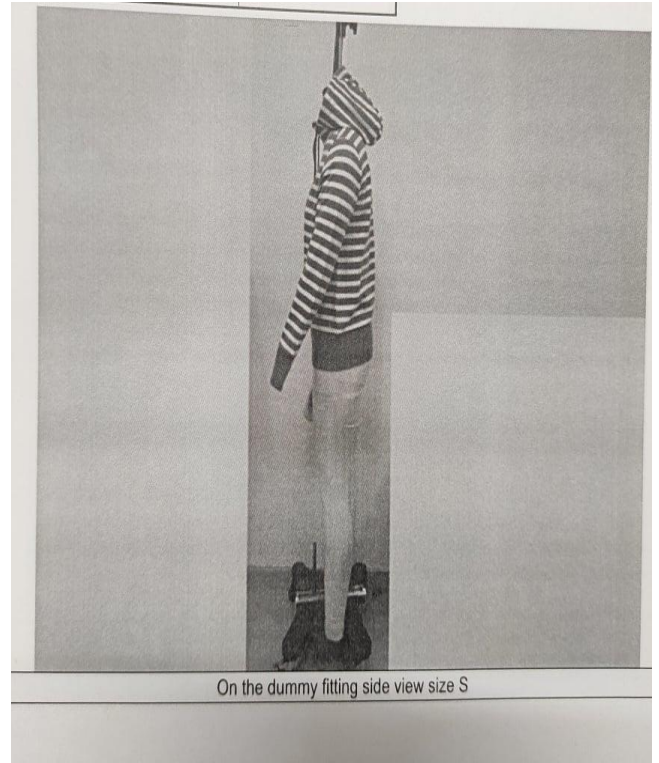


Fig. 3.27. Defect of PO 10057699

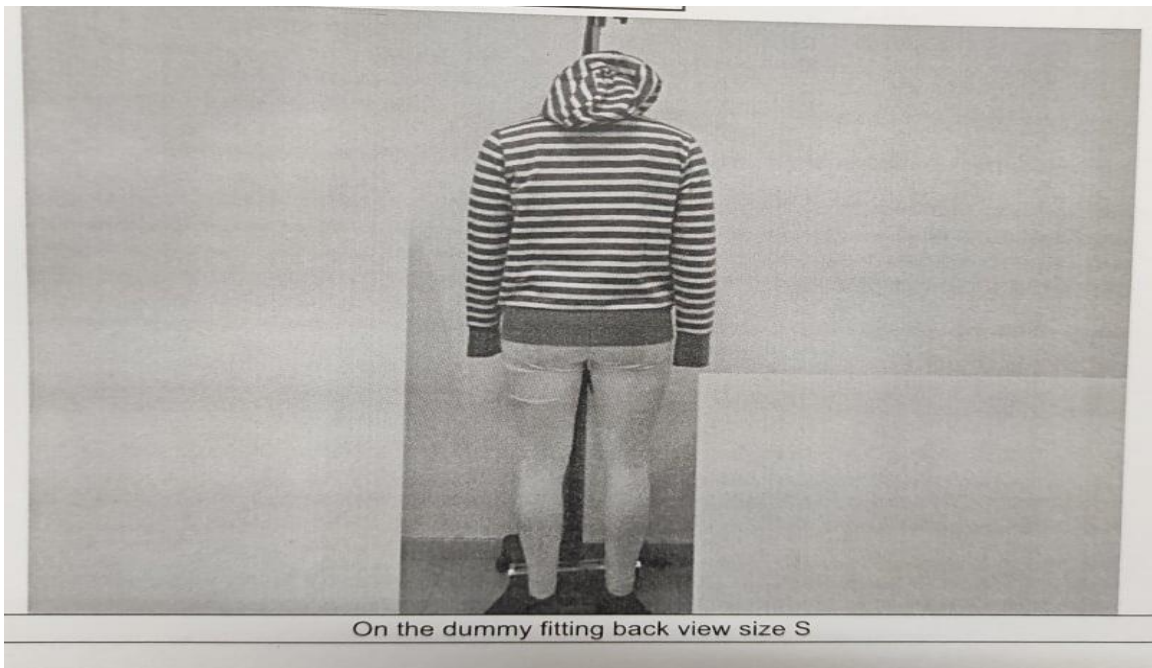


Fig. 3.28. Defect of PO 10057699

3.6. SAMPLE COMMENT OF PO. 10061193

Buyer	NKD
Item	Da. Poloshirt / LW-polo Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x																												
Fitting		x			<p>We found some measurement discrepancy from the size chart.</p> <table> <tr> <td>Size:</td> <td>S</td> <td>L</td> </tr> <tr> <td>½ waist width</td> <td>+1cm</td> <td>+1cm</td> </tr> <tr> <td>across shoulder</td> <td>+1cm</td> <td>+1cm</td> </tr> <tr> <td>½ armhole straight</td> <td>+1cm</td> <td>..... ½</td> </tr> <tr> <td>upper arm width</td> <td>+1cm</td> <td>+0.5cm</td> </tr> <tr> <td>sleeve length from sp</td> <td>+1.2cm</td> <td>+1cm</td> </tr> <tr> <td>neck drop front hsp to seam</td> <td>+1cm</td> <td>-0.5cm</td> </tr> <tr> <td>v-slit opening</td> <td>-1.5cm</td> <td>-0.5cm</td> </tr> </table> <p>Pls. improve pattern and work exactly from the size chart.</p>	Size:	S	L	½ waist width	+1cm	+1cm	across shoulder	+1cm	+1cm	½ armhole straight	+1cm ½	upper arm width	+1cm	+0.5cm	sleeve length from sp	+1.2cm	+1cm	neck drop front hsp to seam	+1cm	-0.5cm	v-slit opening	-1.5cm	-0.5cm
Size:	S	L																											
½ waist width	+1cm	+1cm																											
across shoulder	+1cm	+1cm																											
½ armhole straight	+1cm ½																											
upper arm width	+1cm	+0.5cm																											
sleeve length from sp	+1.2cm	+1cm																											
neck drop front hsp to seam	+1cm	-0.5cm																											
v-slit opening	-1.5cm	-0.5cm																											
Workmanship		x			<p>Placket high low at neck point, see photo, placket s/b even at neck point, pls. improve</p> <p>Pleat at end of placket, see photo, pls. improve</p> <p>Printed stripe s/b even at both side placket, neck, sleeve and side seam</p> <p>Contrast visible at collar joint, see photo, pls. close seam at this point</p> <p>AOP fabric/print cutting should be one right way</p>																								
					<p>Collar edge not trim properly, s/b clean finish, we mention also in sss comments but no improvement, pls. improve</p>																								

Material/quality	x				Weight we found ok both colors
Colour	x				
Accessories	x				
Embroidery					
Application					
Print	x				AOP is okay.
Woven-label	x				
Hangtag					
Size-label					
Care-label	x				
Price-label				x	
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all points during pp meeting.

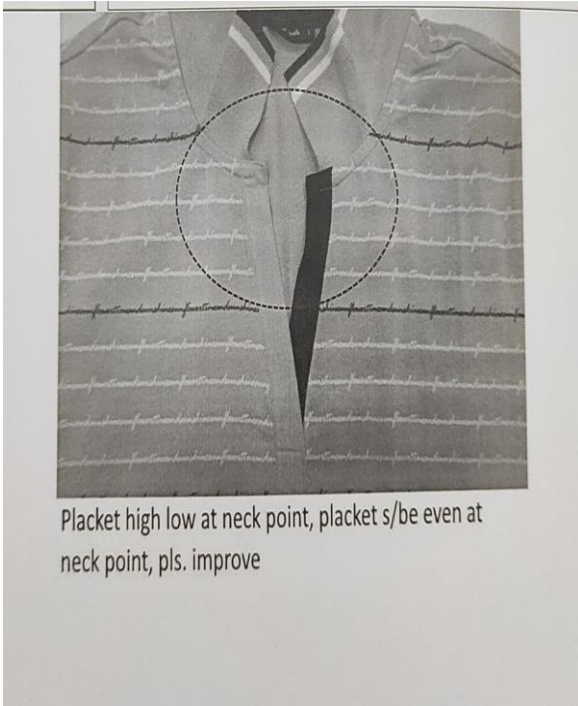


Fig. 3.29. Defect of PO 10061193

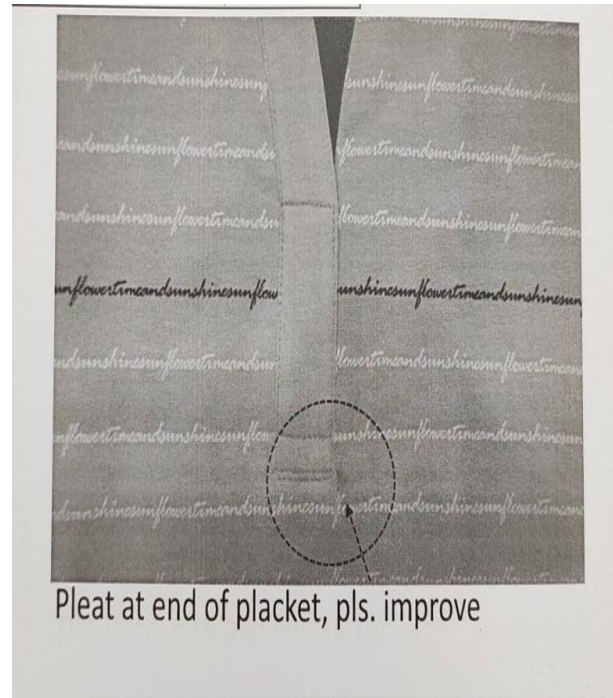


Fig. 3.30. Defect of PO 10061193

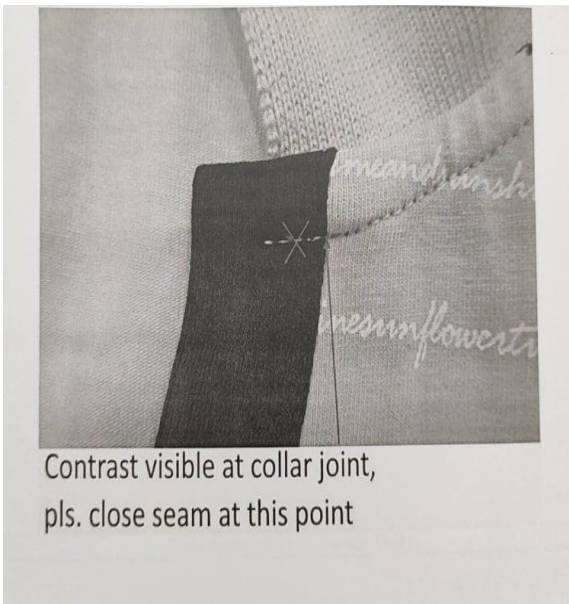


Fig. 3.31. Defect of PO 10061193



Fig. 3.32. Defect of PO 10061193

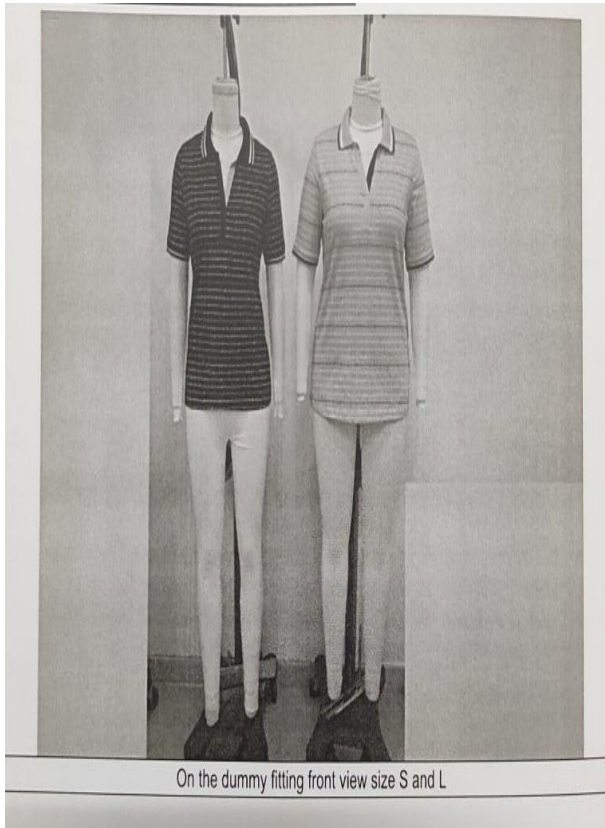


Fig. 3.33. Defect of PO 10061193



Fig. 3.34. Defect of PO 10061193

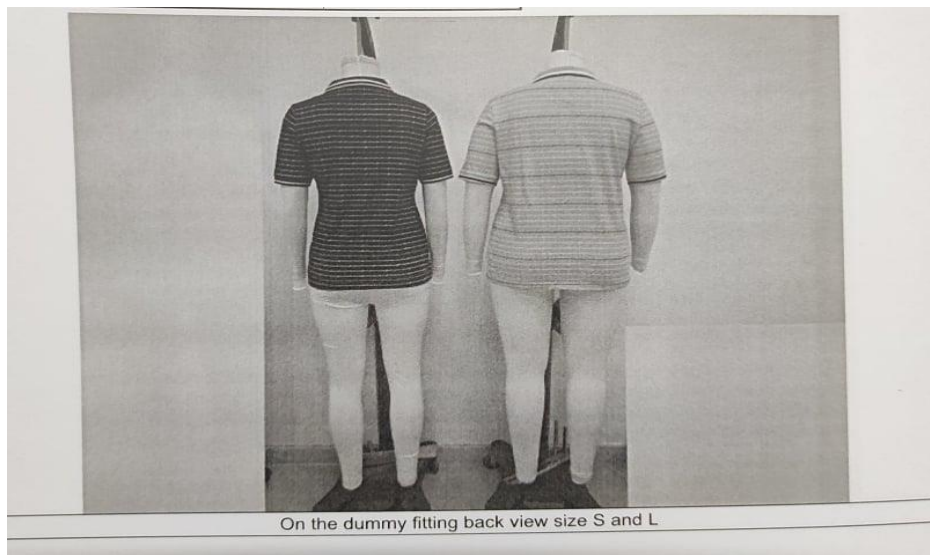


Fig. 3.35. Defect of PO 10061193

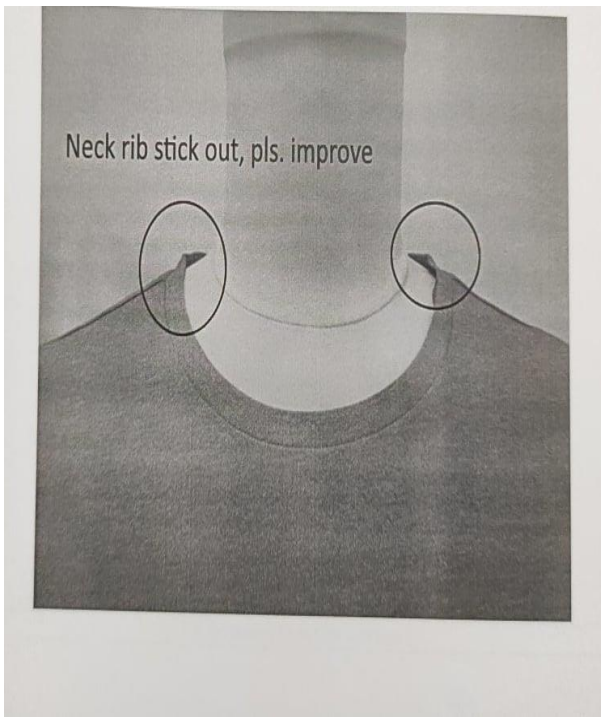
3.7. SAMPLE COMMENT OF PO. 10062793

Buyer	NKD
Item	Da. T-Shirt/ LW-S Sleeves T-Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x																									
Fitting		x			<p>We found some measurement discrepancy from the size chart.</p> <table> <tr> <td>Size:</td> <td>S</td> <td>M</td> </tr> <tr> <td>Back width</td> <td>-1cm</td> <td>-0.5cm</td> </tr> <tr> <td>Arm ball total</td> <td>-2cm</td> <td>-2.5cm ½</td> </tr> <tr> <td>sleeve head width</td> <td>+0.5cm</td> <td>+1cm</td> </tr> <tr> <td>sleeve length from sp</td> <td>-1cm</td> <td>-1cm</td> </tr> <tr> <td>neck opening seam to seam</td> <td>-0.5cm</td> <td>-1cm</td> </tr> <tr> <td>neck drop front hsp to seam</td> <td>.....</td> <td>+0.5cm</td> </tr> </table> <p>Pls. improve pattern and work exactly from the size chart.</p>	Size:	S	M	Back width	-1cm	-0.5cm	Arm ball total	-2cm	-2.5cm ½	sleeve head width	+0.5cm	+1cm	sleeve length from sp	-1cm	-1cm	neck opening seam to seam	-0.5cm	-1cm	neck drop front hsp to seam	+0.5cm
Size:	S	M																								
Back width	-1cm	-0.5cm																								
Arm ball total	-2cm	-2.5cm ½																								
sleeve head width	+0.5cm	+1cm																								
sleeve length from sp	-1cm	-1cm																								
neck opening seam to seam	-0.5cm	-1cm																								
neck drop front hsp to seam	+0.5cm																								
Workmanship		x			<p>Gathering balance (both side) sleeve uneven, gathering should be even in both side sleeve. But pls. see the attached photos for gathering position and improve.</p> <p>Neck rib stick out, see photo, pls. improve.</p>																					
Material/quality			x																							
Colour																										
Accessories																										
Embroidery																										
Application																										

Print					
Woven-label		x			
Hangtag					
Size-label		x			
Care-label					
Price-label					
Size-spec	x				
Wash-test					
Revised sample		x			
General remarks					Pls. improve all points during pp meeting.



3.36. Defect of PO 10062793

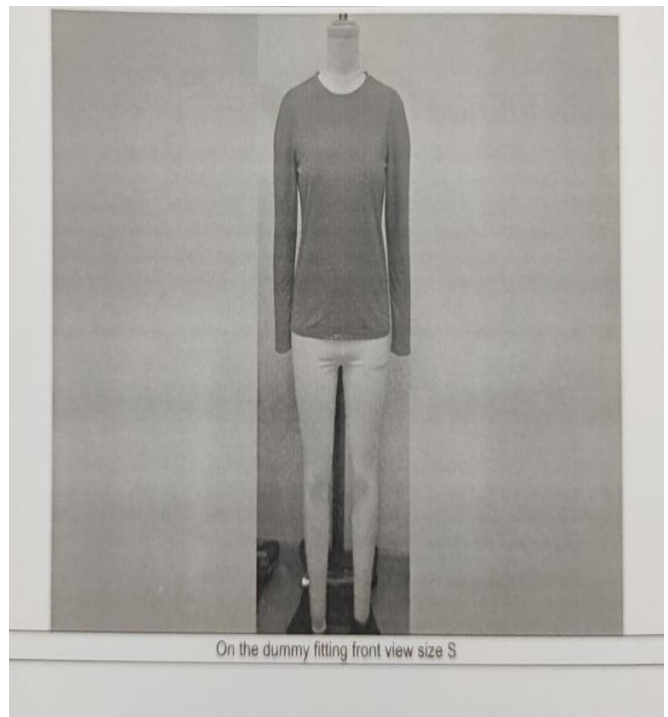


Fig. 3.37. Defect of PO 10062793 Fig.

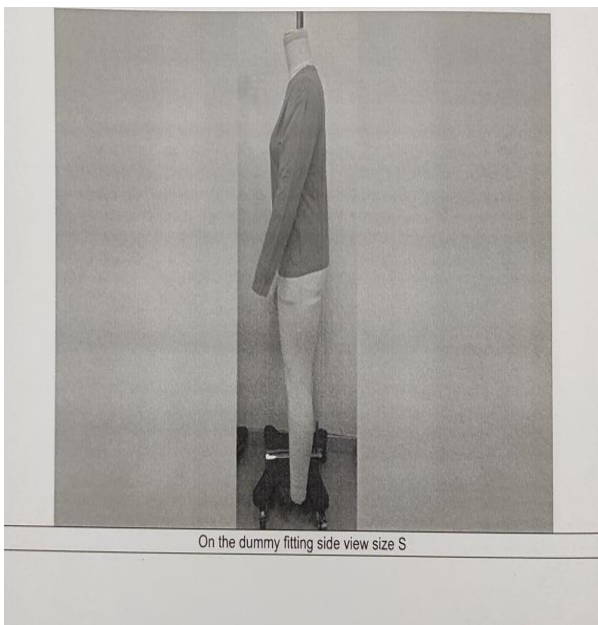


Fig. 3.38. Defect of PO 10062793

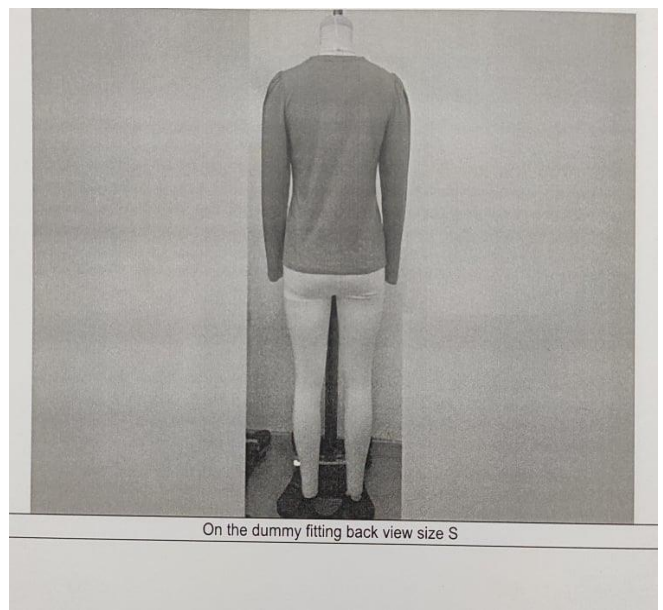


Fig. 3.39. Defect of PO 10062793

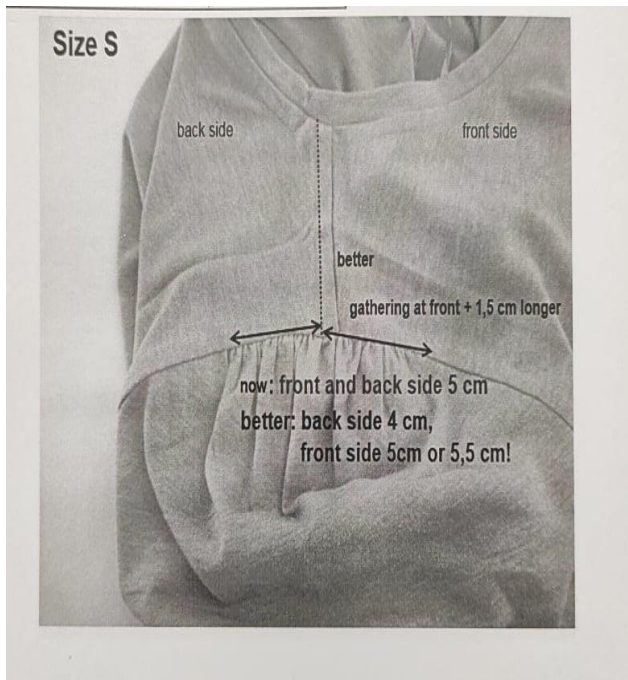


Fig. 3.40. Defect of PO 10062793

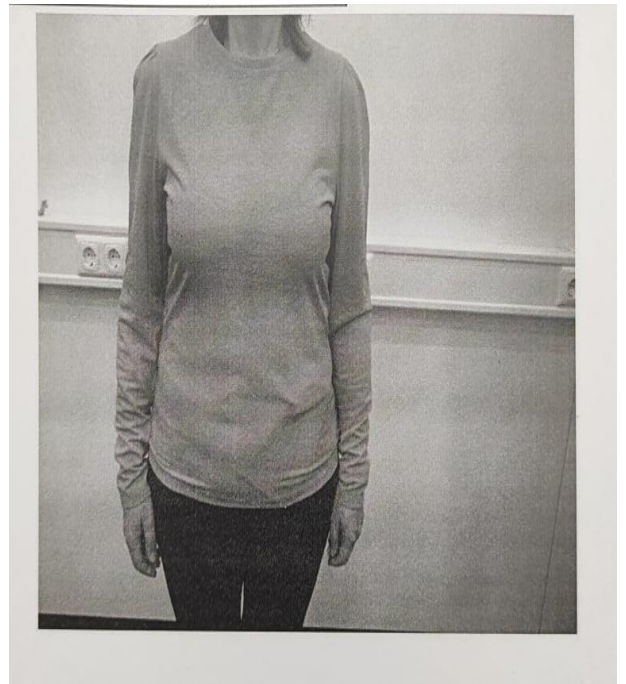


Fig. 3.41. Defect of PO 10062793

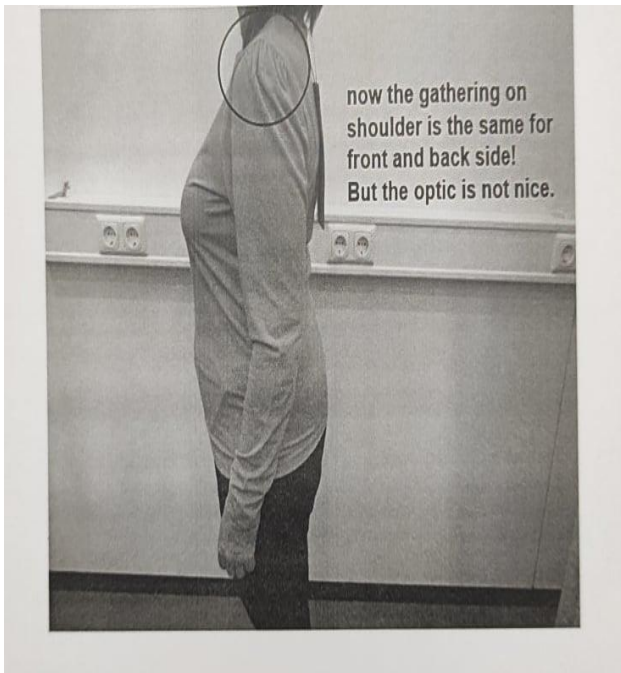


Fig. 3.42. Defect of PO 10062793

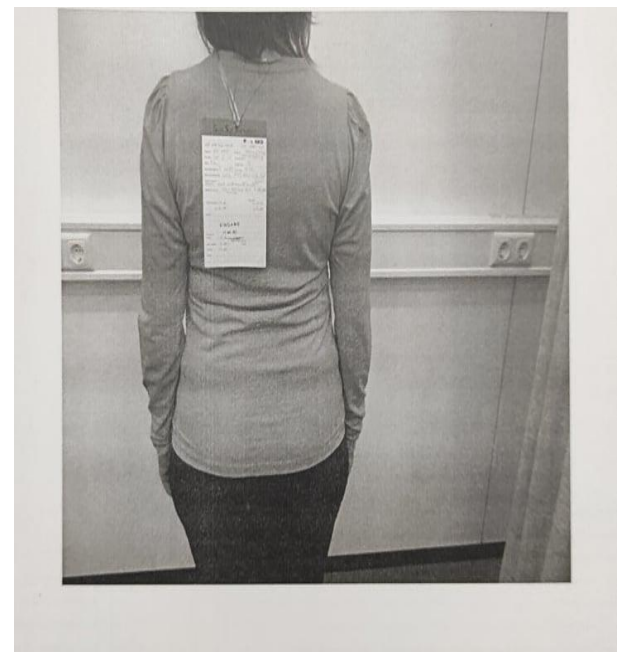


Fig. 3.43. Defect of PO 10062793

3.8. SAMPLE COMMENT OF PO. 10052581

Buyer	NKD
Item	Kids Girls Short
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x																			
Fitting		x			<p>We found some measurement discrepancy from the size chart.</p> <table> <tr> <td>Size:</td> <td>110/116</td> <td>122/128</td> </tr> <tr> <td>pocket at side</td> <td>-0.5cm</td> <td>-0.7cm</td> </tr> <tr> <td>pocket below w/b</td> <td>-0.5cm</td> <td>-0.5cm</td> </tr> <tr> <td>Inseam hiking</td> <td>+0.5cm</td> <td>+0.5cm</td> </tr> <tr> <td>maximum visible string length</td> <td>-3cm</td> <td>-3.5cm</td> </tr> </table> <p>Pls. recheck pattern as mentioned measurement points and do the work exactly from the further process.</p> <p>-special take care in hiking and crotch shape, pps sample is ok. Pls. take care in bulk.</p>	Size:	110/116	122/128	pocket at side	-0.5cm	-0.7cm	pocket below w/b	-0.5cm	-0.5cm	Inseam hiking	+0.5cm	+0.5cm	maximum visible string length	-3cm	-3.5cm
Size:	110/116	122/128																		
pocket at side	-0.5cm	-0.7cm																		
pocket below w/b	-0.5cm	-0.5cm																		
Inseam hiking	+0.5cm	+0.5cm																		
maximum visible string length	-3cm	-3.5cm																		
Workmanship		x			<p>-waistband gathering irregular, gathering sb regular. Irregular gathering not acceptable.</p> <p>-both side pocket shape not ok, sb same. Pls. see the attach picture and improve.</p> <p>-side seam shape both side sb same</p> <p>-drawstring hole distance too long, distance sb 5cm for kids. Pls. see the attach photo.</p>															
Material/quality	x				<p>Required gsm 180, found gsm 188. Gsm at border. Pls. take care going the bulk.</p>															
Colour		x			<p>Looks yellowish. Pls. follow the approved lab dips.</p>															

Accessories	x				Tape color not ok, s/b match with the approved lab dips. Lace look stretched s/b rounded like the approved swatch.
Embroidery					
Application					
Print					
Woven-label	x				
Hangtag					Need to test for the lace.
Size-label	x				
Care-label				x	
Price-label					
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points for further process.

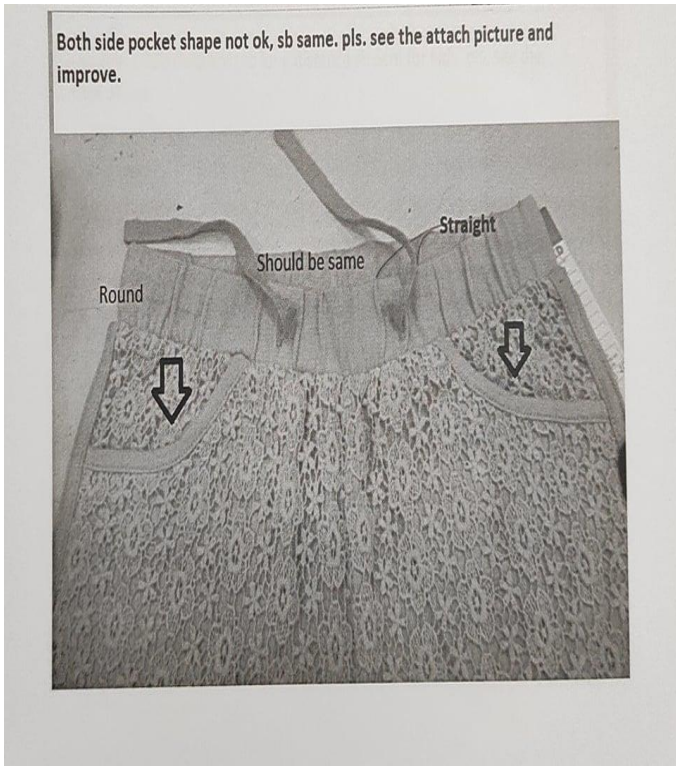


Fig. 3.44. Defect of PO 10052581

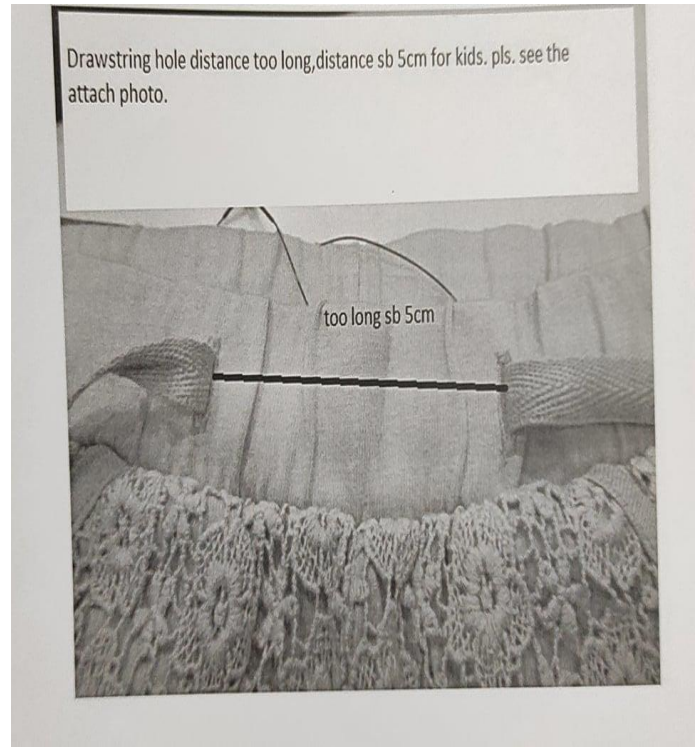


Fig. 3.44. Defect of PO 10052581

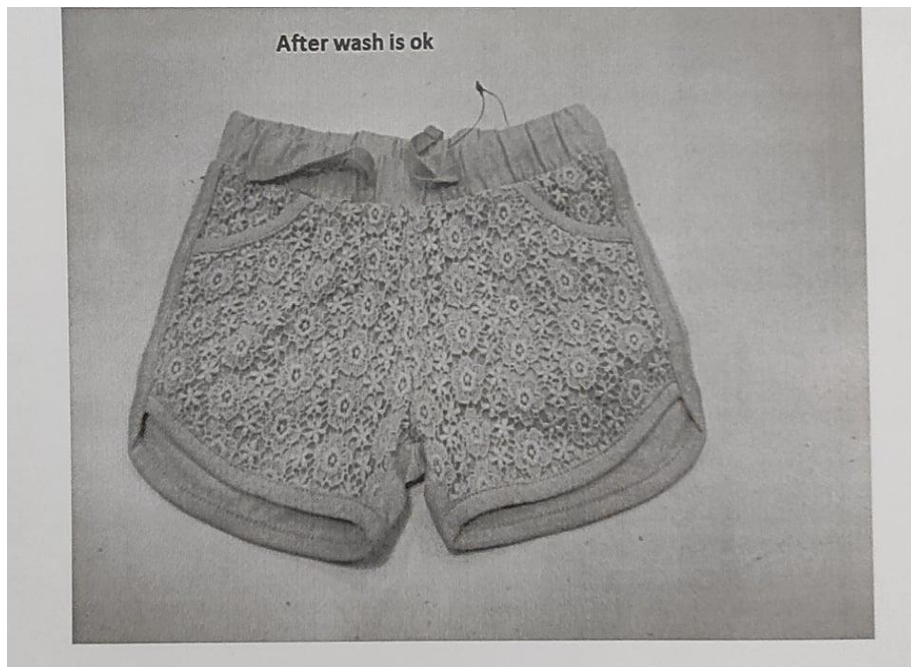


Fig. 3.45. Defect of PO 10052581

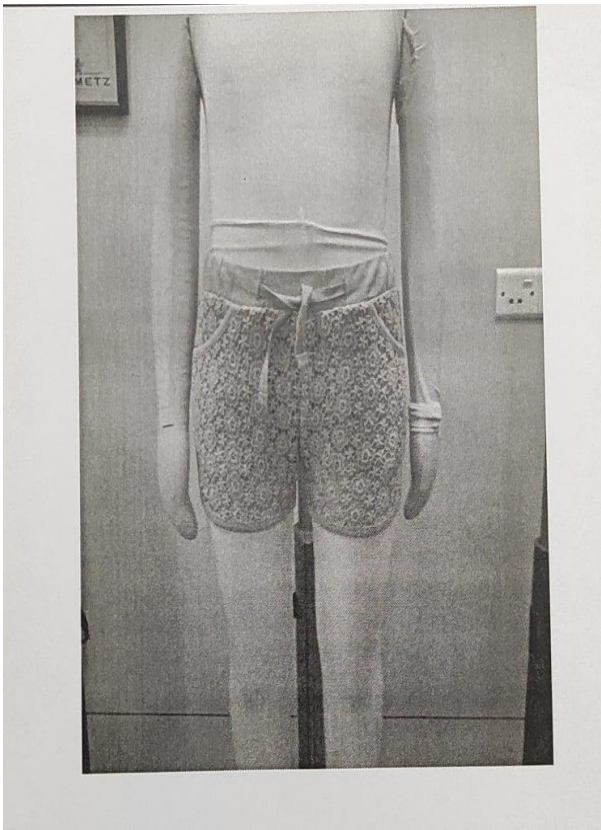


Fig. 3.46. Defect of PO 10052581

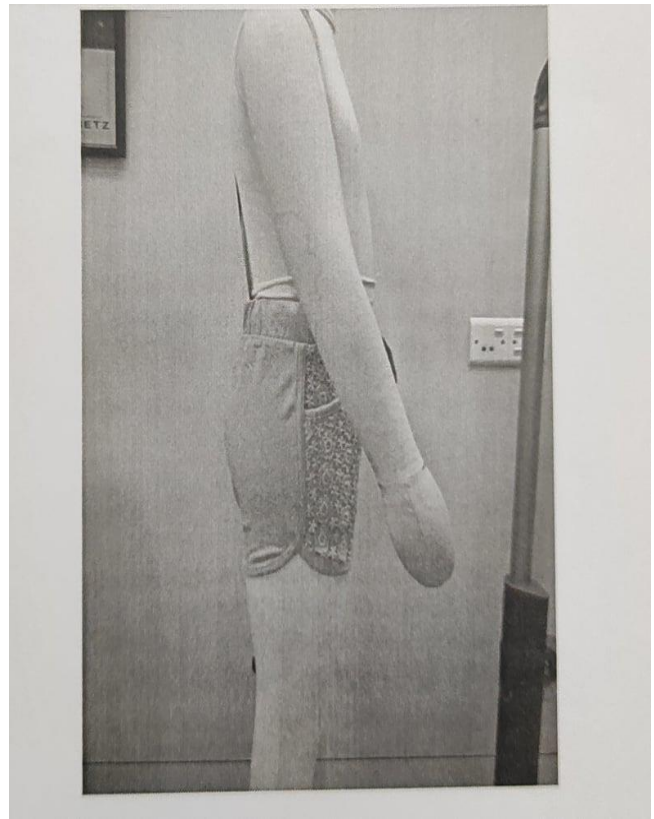


Fig. 3.47. Defect of PO 10052581

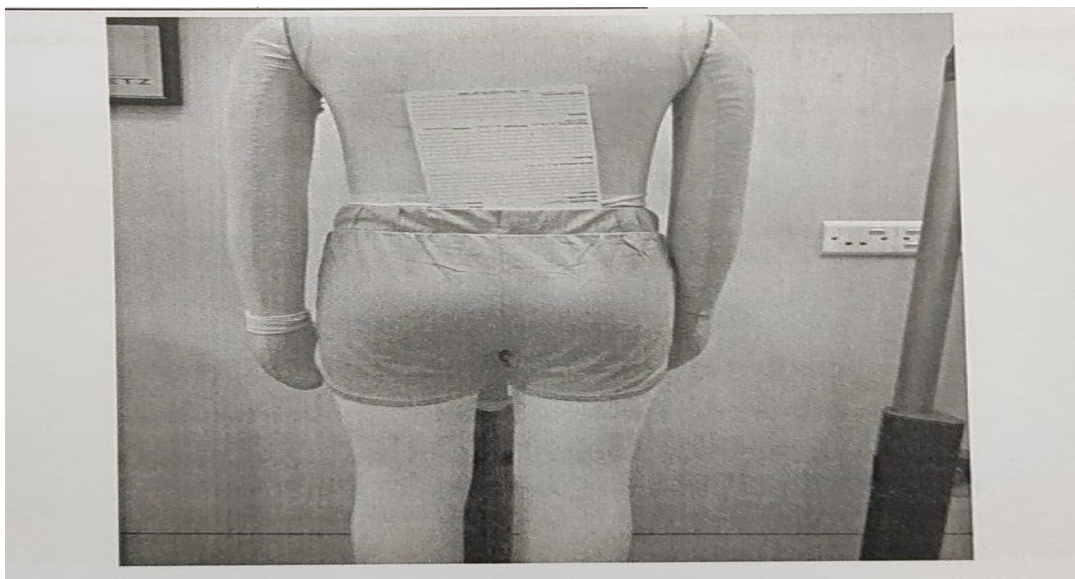


Fig. 3.47. Defect of PO 10052581

3.9. SAMPLE COMMENT OF PO. 10047868

Buyer	NKD
Item	Baby Madchen Set/ Baby Girls Set
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x			Stitching colour of pant not ok. It should be DTM with body colour.															
Fitting		x		<p>Top: Measurements within tolerances. bottom: We found some measurement discrepancy from the size chart.</p> <table> <tr> <td>Size:</td> <td>68</td> <td>92</td> </tr> <tr> <td>½ hip</td> <td>+1cm</td> <td>+0.5cm ½</td> </tr> <tr> <td>thigh</td> <td>+0.5cm</td> <td>+1cm</td> </tr> <tr> <td>pocket at side excld wb</td> <td>.....</td> <td>+0.5cm</td> </tr> <tr> <td>pocket along wb excld wb</td> <td>+0.5cm</td> <td>.....</td> </tr> </table> <p>Plz . follow the measurement chart exactly.</p>	Size:	68	92	½ hip	+1cm	+0.5cm ½	thigh	+0.5cm	+1cm	pocket at side excld wb	+0.5cm	pocket along wb excld wb	+0.5cm
Size:	68	92																	
½ hip	+1cm	+0.5cm ½																	
thigh	+0.5cm	+1cm																	
pocket at side excld wb	+0.5cm																	
pocket along wb excld wb	+0.5cm																	
Workmanship		x		<p>Top</p> <ul style="list-style-type: none"> -avoid shinning mark. Use Teflon shoe and adjust temperature accordingly. -placket at back side wavy see attached photo. -print position from cf neck seam s/b 5cm -the frill width s/b even -the frill length and position both side must be symmetrical. Also gathering and curling both side symmetrical -no curling in baby lock stitch, need more curling. - shape of armhole has to be the same on left and right side -the flag label joint smile face s/b center of the label 															

					means both side gape s/b symmetrical. Pls. take care during label joint. Bottom -wb gathering w/b even -the flag label joint smile face s/b center of the means both side gape s/b symmetrical. Pls. take care during label joint.
Material/quality		x			Required gsm 280, found top gsm 281 bottom 297(+6.07) accepted tolerances +-5% Bottom: -fabric hole found, see photo. Improve fabric quality.
Colour	x				Body colour top, body colour pant
Accessories	x				Stickers 2 pcs. 1 price
Embroidery					
Application					
Print	x				
Woven-label	x				liegelind
Hangtag					
Size-label	x				
Care-label	x				
Price-label					Selling price 9.99 euro
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points for further process.

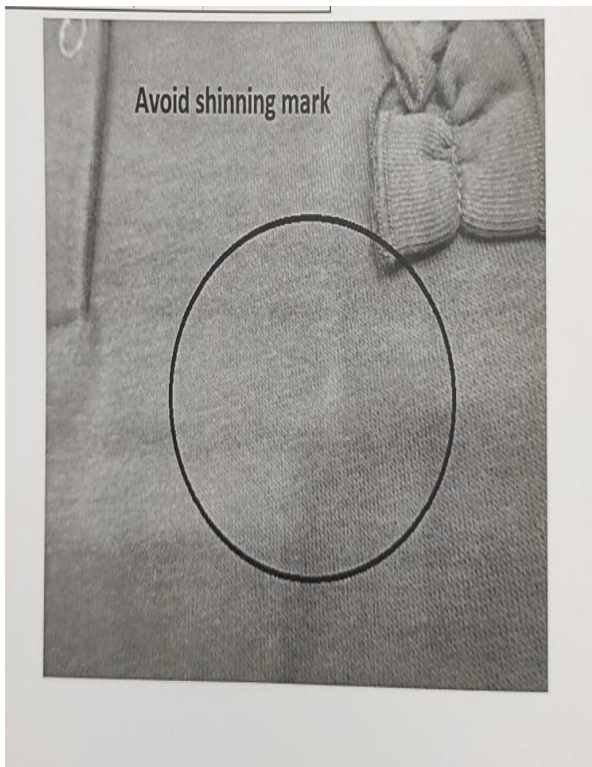


Fig. 3.48. Defect of PO 10047868



Fig. 3.49. Defect of PO 10047868

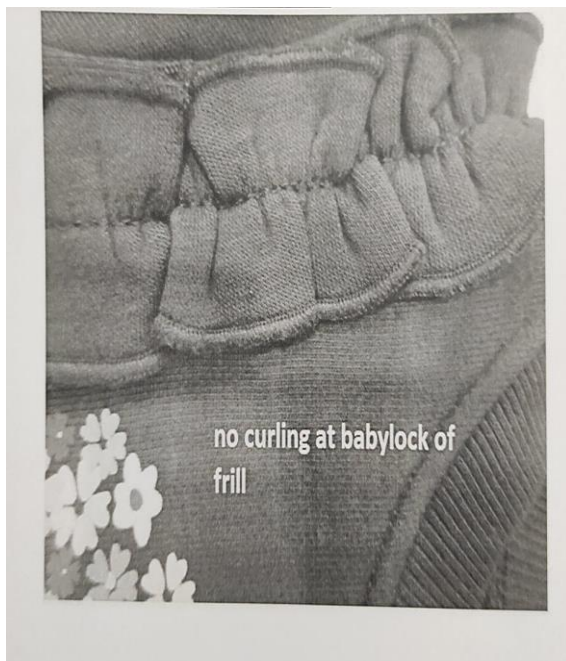


Fig. 3.50. Defect of PO 10047868

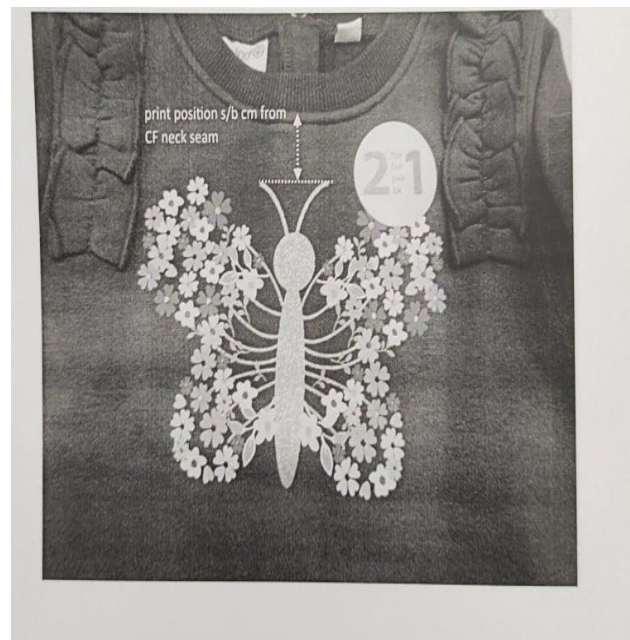


Fig. 3.51. Defect of PO 10047868



Fig. 3.52. Defect of PO 10047868

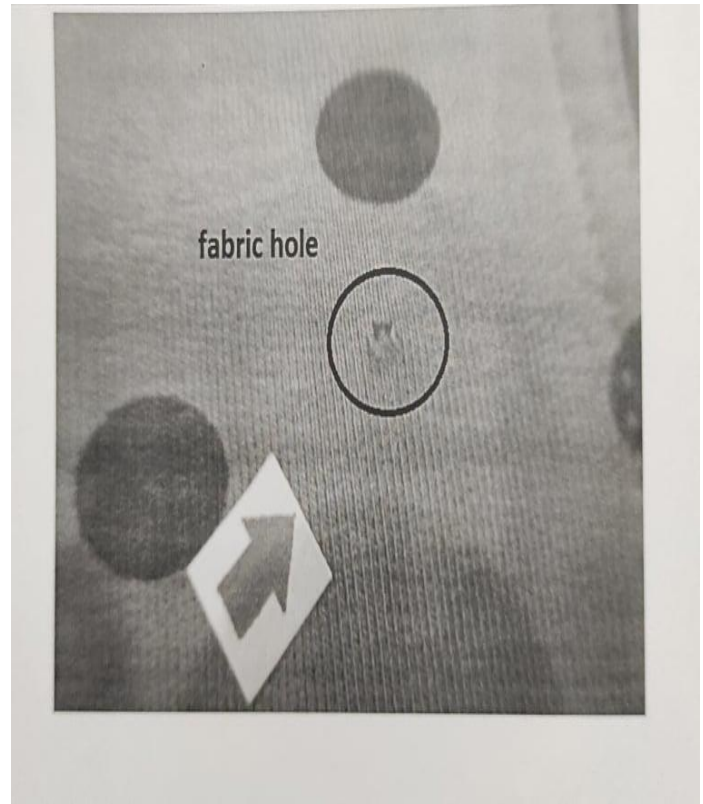


Fig. 3.53. Defect of PO 10047868

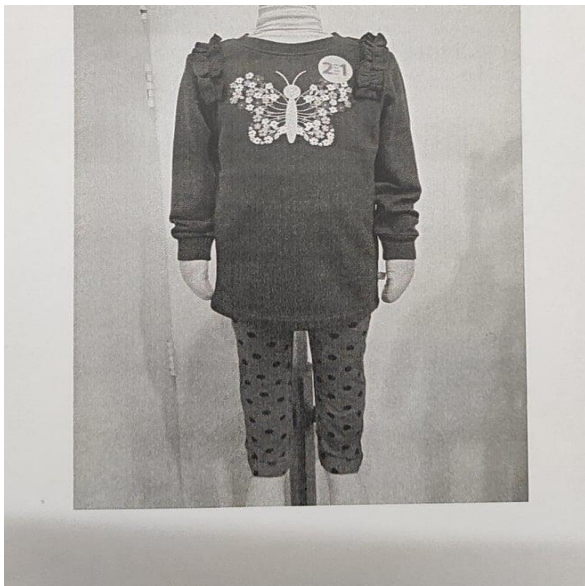


Fig. 3.54. Defect of PO 10047868

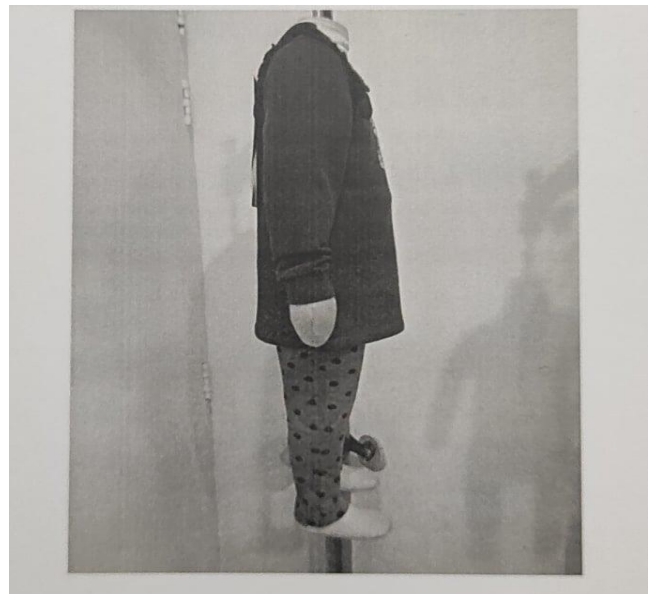


Fig. 3.55. Defect of PO 10047868

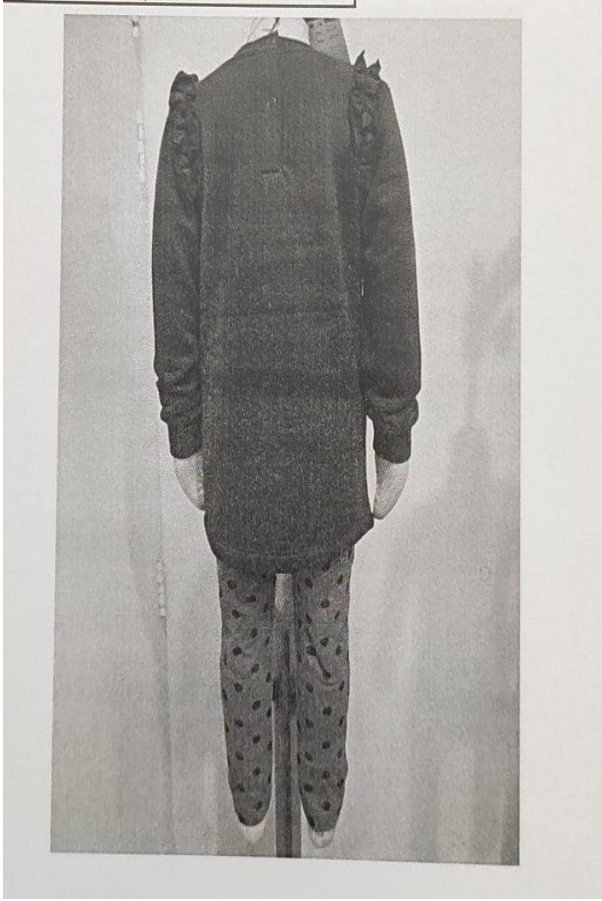


Fig. 3.56. Defect of PO 10047868

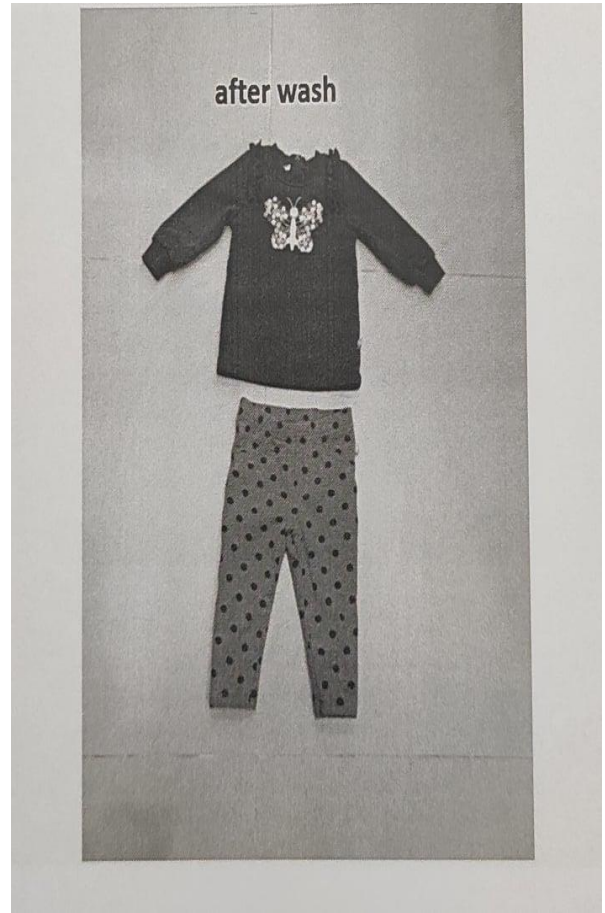


Fig. 3.57. Defect of PO 10047868

3.10. SAMPLE COMMENT OF PO. 10057787

Buyer	NKD
Item	Baby Jungen Set/ Baby boys Set
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute M=missing	
	Yes no	S M	Comments

Style	x				
Fitting		x			Measurement partly in tolerance
Workmanship		x			<p>JACKET -the zipper band should be less visible, ca. 3mm on each side of chain also the visible zipper tape both side must be even width. -avoid zipper wavy -all the cuff joint s/b even</p> <p>SHIRT -puckering along neck hole and back opening not ok, pls. avoid neck puckering and poor neck shape - shape of armholes has to be the same on left and right side</p> <p>PANT -pocket shape both side s/b symmetrical All the cuff joint s/b even</p>

Material/quality	x				-Required weight jacket 270gsm found 302 gsm too high +11.85% -Required weight shirt 160gsm found 170 gsm too high +6.25% -Required weight trouser 280gsm found 303 gsm too high +8.21% Pls. improve the fabric and check all the roll before going to bulk. We can accept +/-5%
Colour	x				Body colour jacket, body colour pant, body colour t-shirt, neck tape colour.
Accessories	x				Stickers 3 pcs. 1 price
Embroidery	x				
Application					
Print	x				
Woven-label	x				liegelind
Hangtag					
Size-label	x				
Care-label	x				
Price-label					Selling price 12.99 euro
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points for further process.

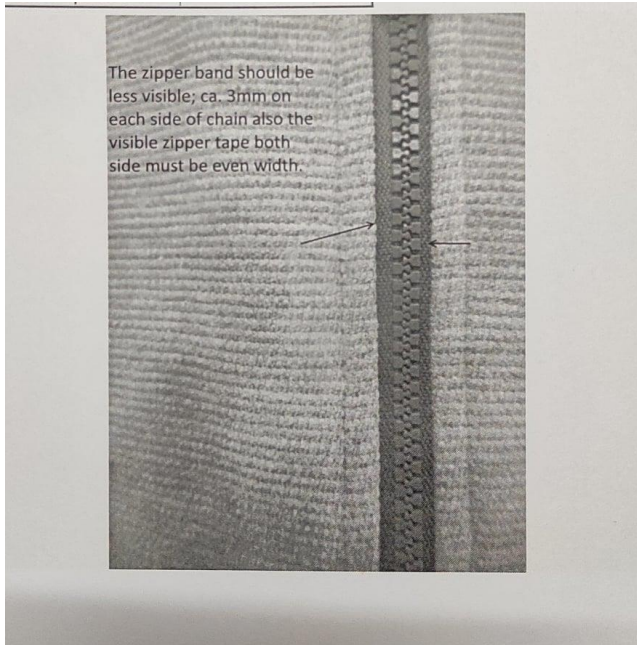


Fig. 3.58. Defect of PO 10057787

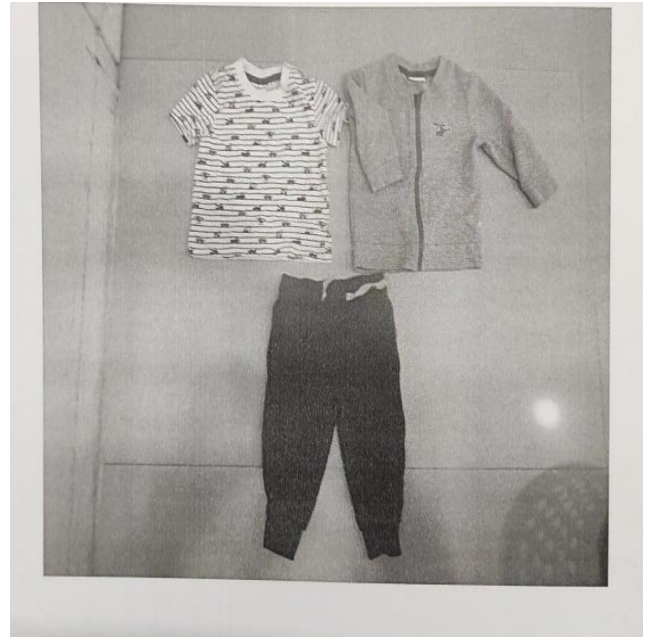


Fig. 3.59. Defect of PO 10057787

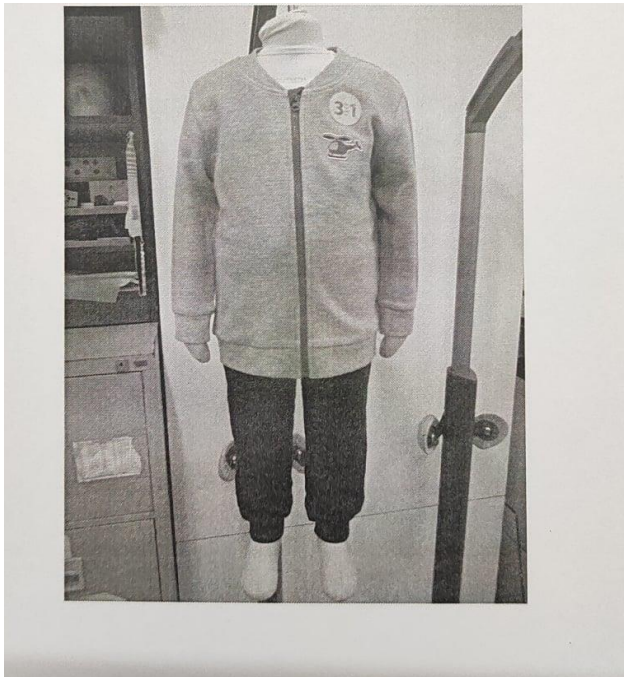


Fig. 3.60. Defect of PO 10057787

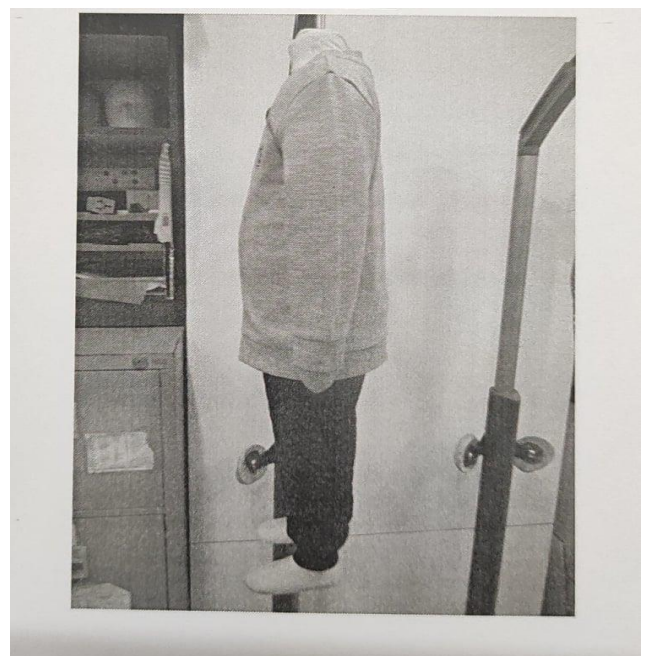


Fig. 3.61. Defect of PO 10057787

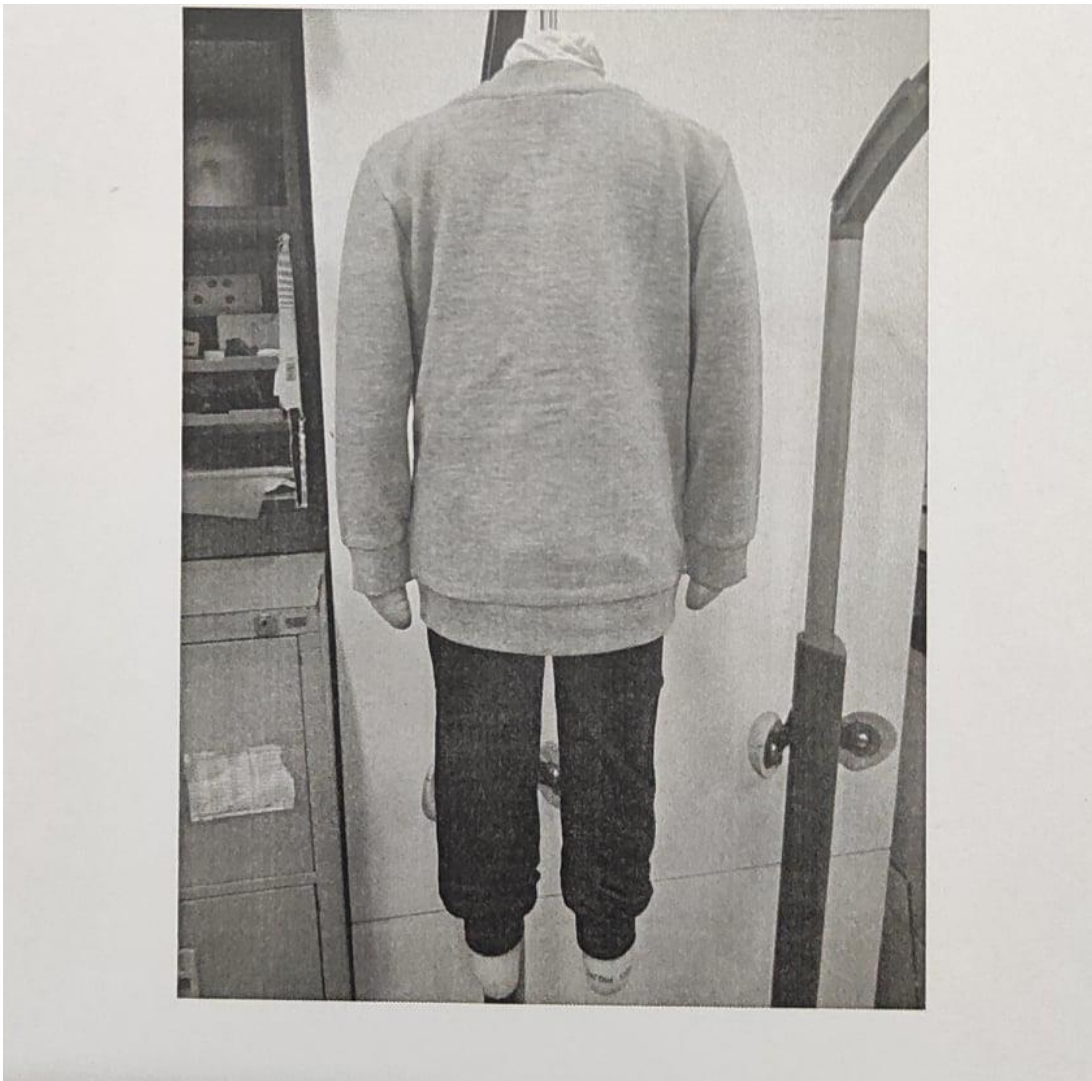


Fig. 3.62. Defect of PO 10057787

3.11. SAMPLE COMMENT OF PO. 10060017

Buyer	NKD
Item	Da. T-Shirt/ LW T-Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute M=missing	
	Yes no	S M	Comments

Style	x																								
Fitting		x		<p>We found following deviations from the MC</p> <table> <tr> <td>Size</td> <td>44/46</td> <td>48/50</td> </tr> <tr> <td>½ bottom</td> <td>-1cm</td> <td>-1cm</td> </tr> <tr> <td>½ sleeve opening</td> <td>-0.5cm</td> <td>-0.8cm</td> </tr> <tr> <td>across shoulder</td> <td>-1cm</td> <td>-1cm</td> </tr> <tr> <td>neck opening straight</td> <td>...</td> <td>-1cm</td> </tr> <tr> <td>front neck drop</td> <td>-1cm</td> <td>-1cm front</td> </tr> <tr> <td>lace height from HSP</td> <td>+1cm</td> <td>+0.5cm</td> </tr> </table> <p>-we don't accept that. Pls. follow the mc exactly to have no deviations.</p>	Size	44/46	48/50	½ bottom	-1cm	-1cm	½ sleeve opening	-0.5cm	-0.8cm	across shoulder	-1cm	-1cm	neck opening straight	...	-1cm	front neck drop	-1cm	-1cm front	lace height from HSP	+1cm	+0.5cm
Size	44/46	48/50																							
½ bottom	-1cm	-1cm																							
½ sleeve opening	-0.5cm	-0.8cm																							
across shoulder	-1cm	-1cm																							
neck opening straight	...	-1cm																							
front neck drop	-1cm	-1cm front																							
lace height from HSP	+1cm	+0.5cm																							
Workmanship		x		<p>-sleeve opening lace seam tension too high not ok. - front yoke inside lining must be loose from shell part</p> <p>-all seam tension s/b free</p> <p>-front cut & sewn seam tension s/b free</p> <p>We noticed that the lace is uneven at the shoulders for all pcs. Pls. find attached picture.</p> <p>Please also watch that there are no loose parts of the lace sticking out on the shoulders.</p>																					
Material/quality	x			Weight we found 153gsm is too high we can accept +-5%																					
Colour	x																								

Accessories	x				
Embroidery					
Application					
Print					
Woven-label	x				
Hangtag				x	Plz. Ensure to attach the missing “laura torelli plus” & oeko tax tag at bulk.
Size-label					
Care-label	x				
Price-label				x	Plz. Ensure to attach the bulk.
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points and send us ref from pp meeting.



Fig. 3.63. Defect of PO 10060017



Fig. 3.64. Defect of PO 10060017



Fig. 3.65. Defect of PO 10060017



Fig. 3.66. Defect of PO 10060017



Fig. 3.67. Defect of PO 10060017



Fig. 3.68. Defect of PO 100560017

3.12. SAMPLE COMMENT OF PO. 10060019

Buyer	NKD
Item	Da. T-Shirt/ LW T-Shirt
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x																			
Fitting		x			<p>We found following deviations from the MC</p> <table> <tr> <td>Size</td> <td>44/46</td> <td>48/50</td> </tr> <tr> <td>across shoulder</td> <td>-1cm</td> <td>---</td> </tr> <tr> <td>neck opening straight</td> <td>-1cm</td> <td>---</td> </tr> <tr> <td>front neck drop</td> <td>-1cm</td> <td>-1cm</td> </tr> <tr> <td>front lace height from HSP</td> <td>+1cm</td> <td>+1cm</td> </tr> </table> <p>-we don't accept that. Pls. follow the mc exactly to have no deviations.</p>	Size	44/46	48/50	across shoulder	-1cm	---	neck opening straight	-1cm	---	front neck drop	-1cm	-1cm	front lace height from HSP	+1cm	+1cm
Size	44/46	48/50																		
across shoulder	-1cm	---																		
neck opening straight	-1cm	---																		
front neck drop	-1cm	-1cm																		
front lace height from HSP	+1cm	+1cm																		
Workmanship		x			<p>-sleeve opening lace seam tension too high not ok. - front yoke inside lining must be loose from shell part -lace twisting, looseness not ok, pls. take care on sweing -all seam tension s/b free -front cut & sewn seam tension s/b free</p> <p>We noticed that the lace is uneven at the shoulders for all pcs. Pls. find attached picture.</p> <p>Please also watch that there are no loose parts of the lace sticking out on the shoulders.</p>															
Material/quality	x				Weight we found 151gsm is too high we can accept +-5%															
Colour	x																			
Accessories	x																			
Embroidery																				

Application					
Print					
Woven-label	x				
Hangtag				x	Plz. Ensure to attach the missing “laura torelli plus” & oeko tax tag at bulk.
Size-label					
Care-label	x				
Price-label				x	Plz. Ensure to attach the bulk.
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points and send us ref PPS from pp meeting.



Fig. 3.69. Defect of PO 100560019



Fig. 3.70. Defect of PO 100560019

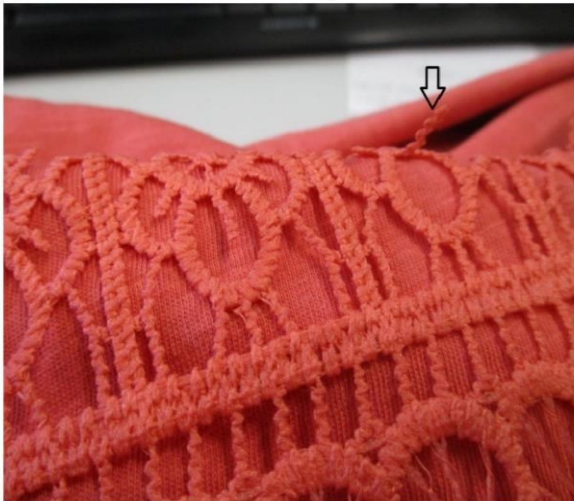


Fig. 3.71. Defect of PO 100560019



Fig. 3.72. Defect of PO 100560019



Fig. 3.73. Defect of PO 100560019



Fig. 3.74. Defect of PO 100560019



Fig. 3.75. Defect of PO 100560019

3.13. SAMPLE COMMENT OF PO. 10045771

Buyer		NKD		
Item		Teener Boys Pyjama/ Teener Boys		
Sample type		Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample		
	accepted	S=substitute		
		M=missing		
	Yes no	S M	Comments	

Style	x				
Fitting	x				Measurement in tolerance
Workmanship		x			-print hand feel s/b more soft -pls. avoid neck puckering and poor neck shape - armhole shape and both side sleeve length must be even -all stitch machine tension must be relax
Material/quality	x				Weight in tolerance
Colour	x				Top & Bottom body colour ok.
Accessories					
Embroidery					
Application					
Print	x				Placement print ok.
Woven-label	x				
Hangtag					
Size-label					
Care-label	x				
Price-label					
Size-spec	x				

Wash-test		x			Wash test fail due to twisting at sleeve 3cm out of tolerance. Please improve the fabric and cutting.
Revised sample		x			
General remarks					Pls. improve all mentioned points and send us ref PPS from pp meeting.



Fig. 3.76. Defect of PO 10045771



Fig. 3.77. Defect of PO 10045771



Fig. 3.78. Defect of PO 10045771



Fig. 3.79. Defect of PO 10045771

3.14. SAMPLE COMMENT OF PO. 10045747

Buyer	NKD
Item	Te. Girls Jumpsuit
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x				
Fitting		x			We found some measurements deviations from measurement chart. Size 146/152 170/176 ½ waist crimped +1cm --- front rise from attachment seam -0.5cm -1cm waist stretched total visible string +1.5cm +2cm length Plz. Recheck pattern as mentioned measurements points and work exactly from the size chart.
Workmanship		x			-armhole shape both side s/b balances symmetrical. -both side strap length(shoulder and waist) s/b identical in length. bottom hem raw edge s/b cover by overlock -all stitching s/b elastic/same as fabric. Attention in bottom hem 2NS. -gathering s/b regular at waist
Material/quality	x				GSM is ok.
Colour	x				body colour ok.
Accessories					
Embroidery					
Application					
Print	x				AOP print ok.
Woven-label	x				

Hangtag					
Size-label					
Care-label		x			Care label missing. Pls. attached approved care label during bulk
Price-label					
Size-spec	x				
Wash-test					Pending for wash test
Revised sample		x			
General remarks					Pls. improve all mentioned points and send us ref PPS from pp meeting.



irregular gathering at waistband

Fig. 3.81. Defect of PO 10045747



both side strap length s/b same

Fig. 3.80. Defect of PO 10045747



bottom hem 2NS tension tight

Fig. 3.82. Defect of PO 10045747



bottom hem raw edge s/b covered by overlock

Fig. 3.83. Defect of PO 10045747



Fig. 3.84. Defect of PO 10045747



Fig. 3.85. Defect of PO 10045747



Fig. 3.86. Defect of PO 10045747

3.15. SAMPLE COMMENT OF PO. 10060314

Buyer	NKD
Item	Da. Top/ LW-Top
Sample type	Fitting sample, size set sample, preproduction sample, production/ shipment, revised sample

	accepted	S=substitute	
		M=missing	
	Yes no	S M	Comments

Style	x																									
Fitting		x			<p>We found some measurements out of tolerance</p> <table> <tr> <td>Size</td> <td>44/46</td> <td>48/50</td> </tr> <tr> <td>front at ½ armhole</td> <td>----</td> <td>-1cm</td> </tr> <tr> <td>back at ½ armhole</td> <td>----</td> <td>-1cm</td> </tr> <tr> <td>neck opening straight</td> <td>+0.5cm</td> <td>----</td> </tr> <tr> <td>neck drop front</td> <td>-----</td> <td>-0.5cm</td> </tr> <tr> <td>neck seam at placket seam</td> <td>-0.5cm</td> <td>-0.6cm</td> </tr> <tr> <td>by yoke cb</td> <td>+1cm</td> <td>+1cm</td> </tr> </table> <p>Plz. Follow the measurement chart exactly</p>	Size	44/46	48/50	front at ½ armhole	----	-1cm	back at ½ armhole	----	-1cm	neck opening straight	+0.5cm	----	neck drop front	-----	-0.5cm	neck seam at placket seam	-0.5cm	-0.6cm	by yoke cb	+1cm	+1cm
Size	44/46	48/50																								
front at ½ armhole	----	-1cm																								
back at ½ armhole	----	-1cm																								
neck opening straight	+0.5cm	----																								
neck drop front	-----	-0.5cm																								
neck seam at placket seam	-0.5cm	-0.6cm																								
by yoke cb	+1cm	+1cm																								
Workmanship		x			<p>-front armhole shapes both side balance uneven not ok. Both side s/b balances. shoulder forwarded both side sb even</p> <p>-collar shape edge should not move in front of line, see photo and follow.</p> <p>-stick out at under armhole</p> <p>-found looseness at top placket area, see and adjust.</p> <p>-all stitching tension sb free</p>																					
Material/quality	x				GSM is ok.																					
Colour	x																									
Accessories	x																									
Embroidery																										
Application																										

Print					
Woven-label	x				
Hangtag				x	Plz. Ensure to attach the missing laura torelli plus hang tag.
Size-label					
Care-label		x			Must add NKD group Gmbh
Price-label				x	Plz. Ensure to attach at bulk.
Size-spec	x				
Wash-test	x				
Revised sample		x			
General remarks					Pls. improve all mentioned points and send us ref PPS from pp meeting.



Fig. 3.87. Defect of PO 10060314

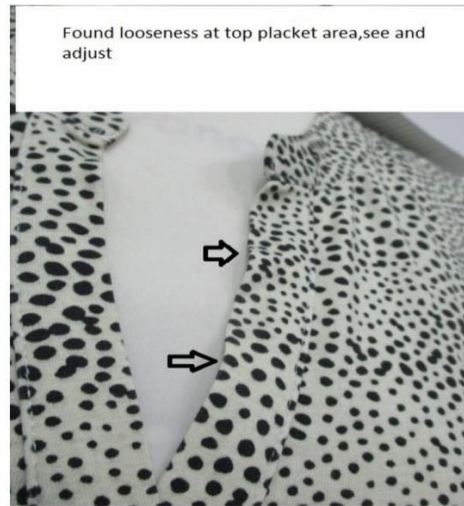


Fig. 3.88. Defect of PO 10060314



Fig. 3.89. Defect of PO 10060314



Fig. 3.90. Defect of PO 10060314



Fig. 3.91. Defect of PO 10060314



Fig. 3.92. Defect of PO 10060314



Fig. 3.93. Defect of PO 10060314



Fig. 3.94. Defect of PO 10060314

4.Result & Discussion

4.1 Summary of Sample Comments Report

	Defects/Faults											
SL	PO	A	B	C	D	E	F	G	H	I	J	K
1	10058607		X	X							X	
2	10061251		X	X	X						X	
3	10050307		X	X							X	
4	10061058		X	X							X	
5	10057699		X	X	X	X	X				X	
6	10061193		X	X							X	
7	10062793		X	X							X	
8	10052581		X	X		X					X	
9	10047868		X	X	X	X						
10	10057787		X	X								
11	10060017		X	X							X	
12	10060019		X	X							X	
13	10045771			X								X
14	10045747		X	X							X	
15	10060314		X	X							X	
	Total	-	14	15	3	3	1	-	-	-	12	1
	% of Defects		29%	31%	6.12%	6.12%	2.04%				24.48%	2.04%
Total Defects=49												

Table 4.1 Summary of Sample Comments

Note:

A= Style

B= Fitting

C= Workmanship

D= Materials

E= Color

F= All over Print/ Print

G= Accessories

H= Embroidery

I= Application

J= Care Label, Price Label Size Label, Hangtag, Woven Label etc. K=

Wash Test

4.2 Comments/Fault Percentage Calculation

Percentage of fault/comments

$$= (\text{No. of Particular Fault} \times 100) \div \text{Total No. of Fault}$$

Example: Fitting Fault Percentage

$$= (14 \times 100) \div 49$$

$$= 28.57 \%$$

$$= 29 \%$$

4.3 Comments/Fault Percentage Report

SL.	Defects/Faults	Fault Percentages
1.	Style	0%
2.	Fitting	29%
3.	Workmanship	31%
4.	Material	6.12%

5.	Color	6.12%
6.	AOP/ Print	2.04%
7.	Accessories	0%
8.	Embroidery	0%
9.	Application	0%
10.	Care Label , Size Label , Hangtag , Woven Label etc	24.48%
11.	Wash Test	2.04%
	Total	100%

Table 2 : Fault Percentages Report

Pie Chart

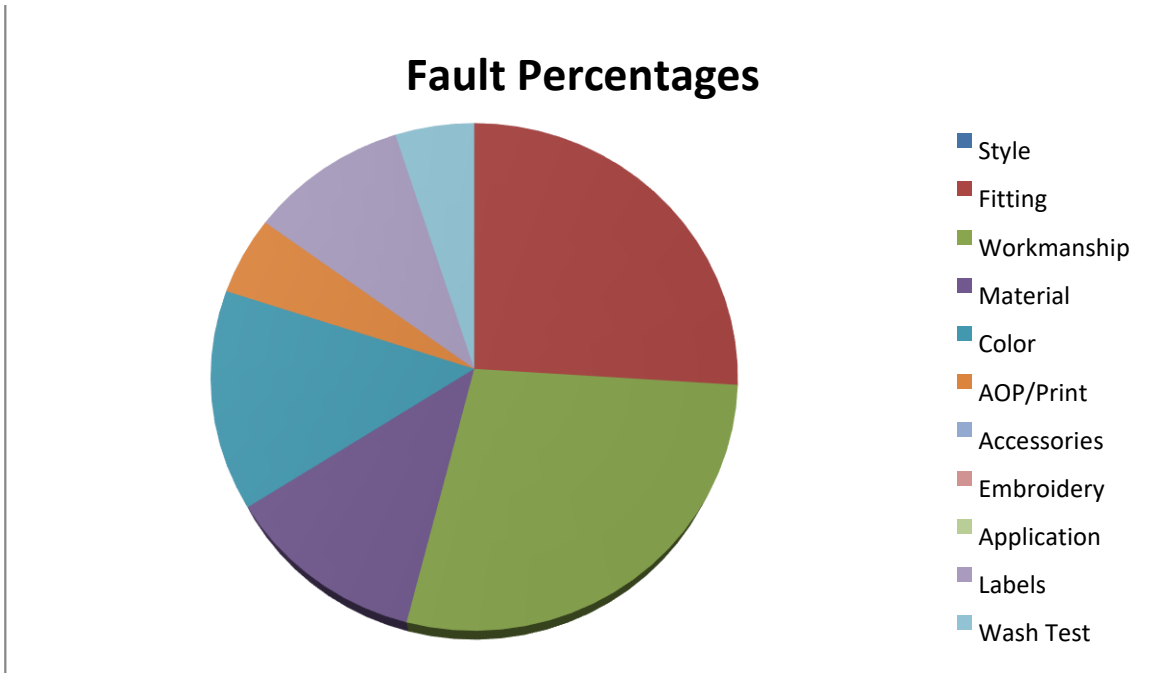


Fig 4.1 Fault Percentages in Pie Chart

4.4 Faults / Defects of Samples with Remedies

4.4.1 Fitting Problems

Reasons :

- » Less skill of the sample pattern maker
 - »Less skill of the sample cutting m
- » Less skill of the sample sewing person
- » Less skill of the sample man to understand the Measurement Sheet

Remedies:

- »Have to improve the skill of pattern maker
- »Have to improve the skill of sample cutting man
- »Have to improve the skill of sample sewing person
- »Have to improve the skill of the sample man to understand the Measurement Sheet.

4.4.2 Workmanship Problems

Reason:

- » Less skill of the sample sewing person
- » Poor type of sewing thread should be used.
- » Sewing m/c miss handling properly

Remedies:

- »Have to improve the skill of sample sewing person »
- Good type of sewing thread should be used.
- » Sewing m/c should be handled properly

4.4.3 Material Problem

Reason:

- » Less skill of the sample Knitting, Dyeing person
- » Poor type of Yarn & Chemical should be used.
- » Knitting, Compactor m/c miss handling properly

Remedies:

- » Have to improve the skill of Knitting Operators
- » Good type of yarn & chemical should be used.
- » Compactor m/c should be handled properly.

4.4.4 Color Problem

Reason:

- » Poor workmanship.

Remedy:

- » Workmanship should be good.

4.4.5 AOP/Printing Problem

Reason:

- » Less skill of the Printing person
- » Poor type of Paste should be used.
- » Printing m/c miss handling properly

Remedies:

- » Workmanship should be good.
- » Good type of paste should be used
- » Skilled should be improved

4.4.6 Wash Problems

Reason:

- »Poor finishing and poor quality raw material usage.
- »Poor wash technique

Remedies:

- »Finishing should be good.
- »Wash technique should be very good
- »Should be used good quality of raw material.

4.4.7 Label Missing **Reason:**

- » Less skill of the sample sewing person
 - » Poor type of sewing thread should be used.
 - » Sewing m/c miss handling properly
- Less no. of Label is used

Remedies:

- »Label Availability should be ensured
- Have to improve the skill of sample sewing person
- » Good type of sewing thread should be
- » Sewing m/c should be handled properly.

5. Conclusion

Sampling is the heart of any export order processing. The future of any style purely depends on buyer and factory which are adding value to the samples. So it is very important to understand the sample development process to control quality and costs in the initial stage or in the sampling development. Merchandiser plays the central role in sampling process as, the only person between the buyer and factory who understands the buyer specification, technical details and time line of sampling. The process of sampling is about the eventual satisfaction of specific needs. It is about products the company can make or out-source profitably for which there is a market demand. Sampling is the best way to place an order. The purpose of sampling is not only to get bulk order and also it gives some additional benefits to the exporters. The use of technology, computer based designing, as well as innovation and creativity are important tools in driving apparel sampling.

In this report, the finding is that the measurement issue has the most prime key role to sample failure in approx. 31% cases and followed by fitting of garments (29%), Others has the impact of sample failure approx. 40%.

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