



**Daffodil**  
*International*  
**University**

Faculty Of Engineering  
Department Of Textile Engineering

**Study On**

**Analysis of Sewing Faults in a knit Garment Industry**

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Submitted By

Name	ID
Md Parvez Ahmed	173-23-5206
Shajib Dey	181-23-5313

Supervised By:

Mst. Murshida Khatun

Assistant Professor

Department Of Textile Engineering

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

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## **Acknowledgment**

First of all, We'll be grateful to Allah who gave us the power and the opportunity to accomplish this project.


We are sincerely grateful to our supervisor, Mst. Murshida Khatun, Assistant Professor, Department of Textile Engineering, Faculty of Engineering, Daffodil International University. She has helped us in every way to finish this thesis. Her endless patience, continual encouragement, energetic supervision, valuable advice reading may inferior draft and correcting these at all stages have made it possible to complete this project.

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

## Declaration

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

Name	ID	Signature
Md Parvez Ahmed	173-23-5206	
Shajib Dey	181-23-5313	Shajib

## Letter Of Approval

17 September 2021

To,

The Head

Department of Textile Engineering

Daffodil International University

102, Sukrabad, Mirpur Road, Dhaka 1207

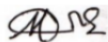
Subject: Approval of Project Report Of B.Sc in TE program

Dear sir,

I am just writing to let you know that this project report titled as **Study on Analysis of Sewing Faults in a knit Garment Industry** has been prepared by the student bearing ID 173-23-5206 and 181-23-5206 is completed for a final evolution. The whole report is prepared based on the proper investigation and information. The student was directly involved in their project activities.

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

Yours Sincerely,



.....

**Mst. Murshida Khatun**

Assistant Professor

Department of Textile Engineering

Daffodil International University

## **Abstract**

Sewing methodology is one of the most important stages in the creation of garments. During the assembly process in the sewing system, a few faults or deformities may occur, resulting in a low quality of the clothing item. Some issues are recoverable, while others are not. Sewing flaws can be the cause of slower production rates, which are no longer appealing for clothing ventures. These flaws also cause delays in shipment, which affects the lead time. The impact of causing flaws has a direct impact on lead time and shipment. The examined had done by us and viewed one several pieces of clothing ventures couple of days for sewing issues, which are as often as possible occurring all through generation activity process through the specialist. During the investigation, the term was discovered of broken stitches, skipped stitches, open seams, and other sewing flaws at Texeurop (BD) Ltd. Join stitch, Uncut threads, Uneven stitch, Fabric Faults, Puckering, Shading, Damage, Size Mistake, Up-down, Raw Edge were discovered. The primary goal of this research is to determine whether the knitwear manufacturing process is under control in a knitwear manufacturing organization, to identify the technique with the lowest possible cost of sewing flaws in the stitching procedure, and to make recommendations for improving quality control.

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# **1 Chapter-I**

## Introduction

## **1.1 Objectives**

- To fixing the objective of the assembling interaction of the T-shirt
- To understand the activity succession of the creation cycle of the T-shirt
- To think about the legitimate quality upkeep of T-shirt producing
- To know the prerequisite of various purchasers of T-shirt fabricating
- To think about the creation quality
- To know the about various kinds of assembling cycles of T-shirt

## **1.2 Limitation**

- We gather just single industrial facility information for the investigation
- At times they can't impart their information to us so we can't gather appropriate information
- Workers are occupied with their work so they can't help as expected
- Absence of data because of time likewise for organization rules
- Absence of availability for understudies in the production line

## **2 Chapter-II**

Literature Review

## 2.1 What is T-Shirt?

A T-shirt, or tee-shirt, is a style of fabric shirt named after the T shape of its body and sleeves. Traditionally, it has short sleeves and a round neckline, known as a crew neck, which lacks a collar.



*Figure 2-1 (T-Shirt)*

## 2.2 Types of Fabric Used

- Cotton
- Combed Cotton
- Organic Cotton
- Supima Cotton
- Polyester
- Linen
- Rayon
- Modal
- Blends
- Tri-blends

### **Cotton**

There are so many fabrics to choose from for making a custom T-shirt. However, out of all the fabric options out there, cotton is still by far a favorite. Cotton is such a great fabric to work with because it is a strong material that still feels soft to the touch. Cotton is also one of the more affordable materials available. The only real negative to this versatile fabric is that it does wrinkle easily. Wrinkling of the fabric may prove difficult during the custom printing process. Within the category of cotton, there are various subcategories to choose from as well. Each of these has its own set of characteristics.

### **Combed Cotton**

Combed cotton is a favorite because it is softer than other types of cotton. This softness comes from the production process in which the fibers are treated before they get spun into yarn. The drawback of combed cotton is the price. This kind of cotton is more expensive than other types of cotton.

## **Organic Cotton**

Organic cotton is another type of cotton with a higher price tag than basic cotton. There are fewer pesticides and fertilizers used in the production process of organic cotton. This method of production is better for the environment than other cotton production techniques because it allows the soil to maintain its fertility and does not use unnecessary toxins.

## **Supima Cotton**

Supima cotton is considered to be one of the highest quality types of cotton. This material is ultra-strong and resistant to fading, stretching, and pilling. The more you wash it, the softer it gets.

## **Polyester**

Polyester is a synthetic fiber that is a common fabric for T-Shirts. Polyester is the material you will need to make a custom print through dye sublimation. Polyester has a lot of great qualities. It is easy to wash, dries fast, and does not require ironing. This fabric is strong and keeps its shape well over time. For this reason, polyester is a great choice for athletic clothing.

## **Linen**

The linen is light and airy fabric... The only real downside to linen is that it gets wrinkled super easily. For T-shirts, linen is not as popular of fabric as cotton and some of the other fabrics out there. Linen is used more often for jackets and lightweight outer layers.

### **2.2.1 Fabric Characteristics**

#### **Stretch**

The material ought to have the normal stretching ability. They are generally utilized for easygoing wear, and the exercises required some level of stretch. Those that don't stretch a great deal will make somebody agreeable except if they are huge.

#### **Weight**

The best weight ought to be medium to adjust between warmth and flexibility. The casual activities don't need a massive option and realizing how to adjust this is essential. T-shirts are made of slightly lighter material.

#### **Drape**

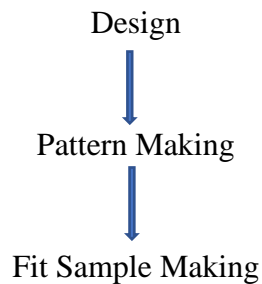
A decent drape implies style. The material ought not to compromise the style and consequently drape ought to be a factor to consider. Guarantee the material isn't influenced by essential washing systems. Be that as it may, in case there is guidance on the most proficient method to wash the fabric, it ought to be followed definitely to keep the quality material.

## 2.3 Garments Manufacturing

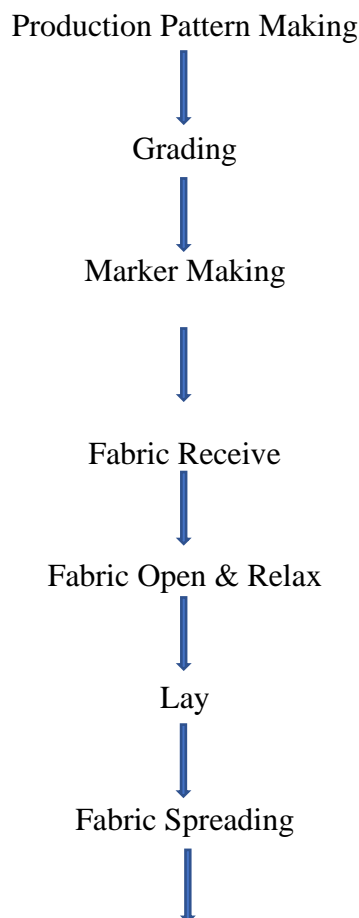
A complete garment needs to confront a few cycles from its request getting to shipment. During garments manufacturing, an interaction stream diagram should be expected to complete a request without any problem. Additionally, an interaction stream outline assists with understanding a garment manufacturing strategy that how the crude materials are changed over into wearable garments.

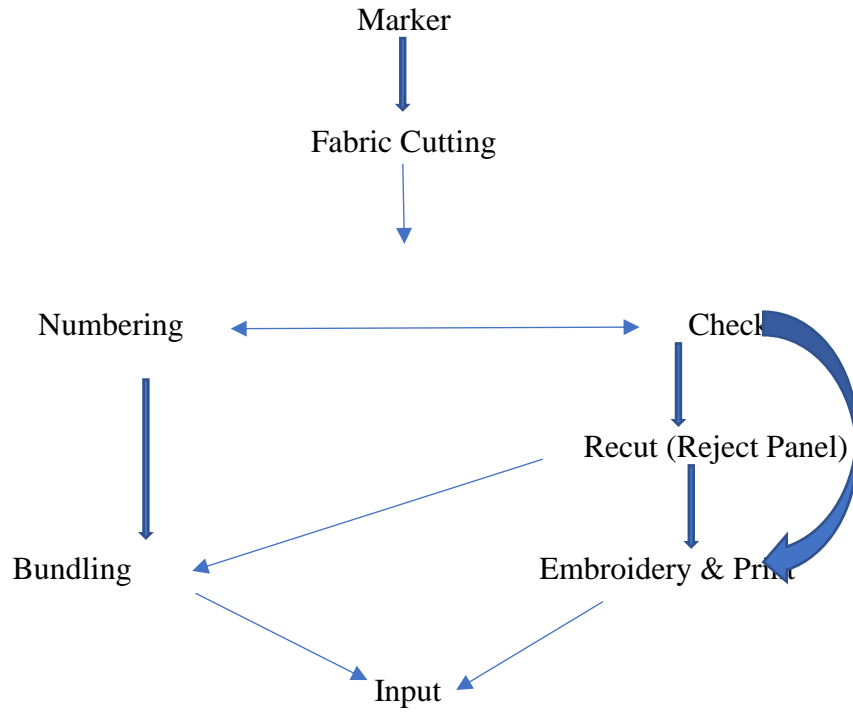
## 2.4 The manufacturing Process sequence of the T-shirt

### 2.4.1 Pre-production process

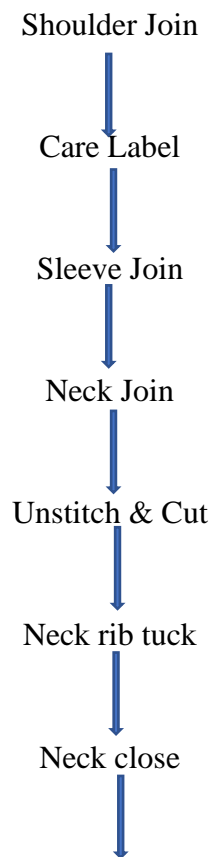


### 2.4.2 Cutting Process

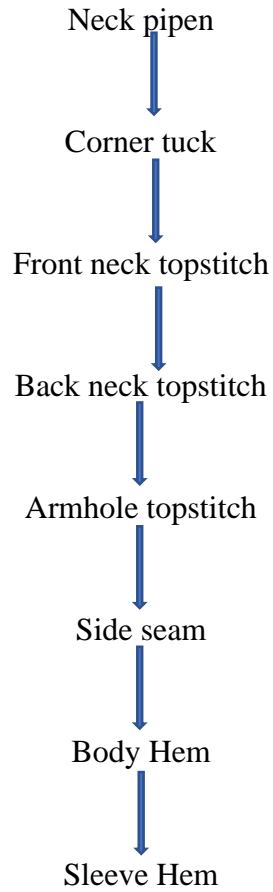




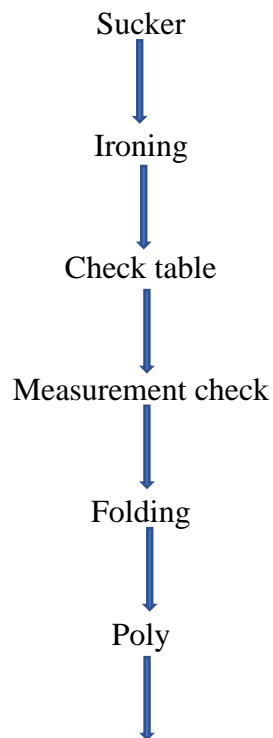
### 2.4.3 Sewing Process

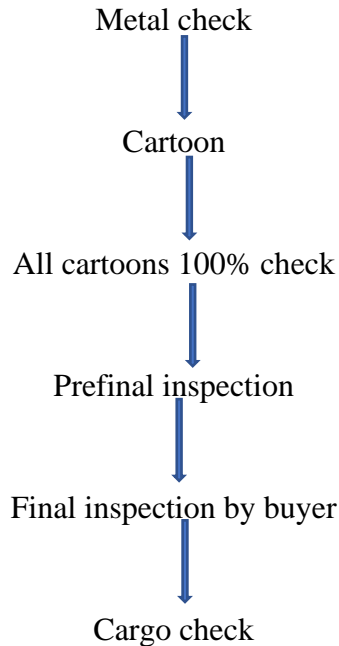






#### 2.4.4 Finishing Process





## 2.5 Quality Control

Quality meant a degree of excellence.

## 2.6 Quality Control in Garment Industry

From the first stage of obtaining raw materials through the last stage of a produced garment, garment quality control is practiced in the garment business.

Quality means that customer requirements must be met. Therefore it can be unsuccessful not to maintain a sufficient quality standard. However, maintaining a high standard of quality also takes time and energy. The first study to find out, through the processes of design, specification, controlled production, and sales, what potential customer wants for a new product.

## 2.7 A different section of quality checking in garments manufacturing

QC/QA Garments Checkpoints: There are four parts of the manufacturing process, which may cause manufacturing defects, which are cutting, cutting, washing, and finishing sections and some criteria have to be reviewed by the QC team in the quality of the garments. This article shows clearly the quality control criteria of all quality control points in the factory and the quality requirements of the clothing. I hope you have a good idea of garments quality control points and their quality control after reading this.

## Quality control in garments manufacturing are operated in the different sector

- Cutting section
- Sewing section
- Washing section
- Finishing section

## The various stages of garments manufacturing where in-process inspection & quality control is done

- Fabric inspection
- Inspection in fabric cutting section
- Inspection in the sewing section
- Inspection of washing section
- Inspection in finishing section

### 2.7.1 Cutting Process Quality Check Point

- **Fabric upside down:** Make sure the fabric is not upside down.
- **Fabric Skewing:** A maximum skewing of 2 cm for the chest of 60 cm is acceptable, but not more. This defect can be solved by re-setting of the fabric at the fabric mill.
- **Relaxation:** Before cutting, knitted, elasticized woven fabrics should be suitably relaxed for around 12~24 hours or more, depending on the type of fabric. Relaxation is mandatory for stretch fabrics.
- **The height of the cutting pile:** The higher the pile on the cutting table, the more chance the cut pieces are unequal in size. This can lead to size specification & fitting problems. Make sure the height is suitable for the type of fabric (usually 2~3 inches and never more than 5 inches).
- **Numbering and bundling:** Make sure the different parts are properly numbered to avoid shading and that this numbering can be easily removed after sewing is complete.
- **Storing:** Make sure the different parts are properly stored, for example, rolled, and not folded.

### 2.7.2 Sewing Process Quality Check Point

- **Critical operations:** Check all critical operations repeatedly (like the sewing of the neck-seam, armhole, cuff, placket, etc.), so the operator gets the clear input of what is required and how to make it correctly before large quantities of garments are finished.
- Attaching label should be correct as per the size of 100% garments
- Checking bonding strength of interlining in the fusing process.
- **Seam allowance:** check operators repeatedly on this point to make sure they use the correct seam allowance.
- **Numbering:** Make sure the sewing operatives keep parts with the same number together to avoid shading.
- Confirm Garments' styling construction and measurement are correct as per the approved sample.

### 2.7.3 Washing Process Quality Check Point

- **Washing method:** normal wash, stone wash, sand wash, or enzyme wash.
- **Bleaching method:** stone bleach, garment bleach
- Any special process. E.g. over-dye after the washing process
- The color tone of the blue yarn
- The whiteness of the white yarn
- **Resultant color tone:** bluer or yellowish
- **Rubbing effect:** contrast on the blue yarn and white yarn
- Evenness on the blue and white parts
- Hand-feel
- Record the identification of the sealed sample, quality standards on the final inspection report to ensure QC check the bulk according to the correct standards.
- Tick and sign all quality standards as an indication of proper QC checking.
- QC should not release the shipment if they find the following major faults.
- Color out of the approved shade band
- Fabric flaws and washing marks over 1" on the garment zone above the knee
- Fabric flaws and washing marks over 3" on any part of the garment

### 2.7.4 Finishing Process Quality Check Point

- Button attaching and button
- Pressing
- Full Garments quality check
- Packing and carton

### 2.7.5 Button Attaching and Button

- Snap button too loose / too strong
- Snap button not closing properly / broken
- Missing poly washer for snap buttons
- Button coming off
- Fabric not strong enough to hold the button
- Mark from molding
- Paint damaged
- Rust
- Text on button not straight
- Wrong position / not in line with counterpart / incorrect spacing
- Button shank missing when required
- Buttonhole too big or too small
- Buttonhole not clean / badly stitched/ losing shape / stitched with wrong thread quality
- Spare button missing or put in the wrong position

### 2.7.6 Check Pressing

- Shiny marks

- Not pressed or improperly pressed
- Should avoid the press and fold the pigment-dyed fabrics before garment washing entirely. It is because it will leave a visible mark on the garment after washing. After sewing, put the garments on a hanger until washing starts.

### **2.7.7 Full Garments Quality Check**

- Checking full garments workmanship defects
- Measure 100% garments to assure fittings
- Heat seal peeling off
- Confirmation quality check of final garments product

### **2.7.8 Packing and Carton Quality Check**

- Correct ticketing and placement
- Packing accuracy of quantity, assortment, and folding
- Correct carton selection as per customer requirement
- Packaging, sealing, binding, and barcode checking

### **2.7.9 Final Inspection Quality Check Points**

After completing the carton, Garments buyer QC does a Final quality inspection, evaluates final product quality. Final Audit or inspection is the most important factor for a garment factory. Final Audit is the final judgment of product quality from the buyer, the inspection calibrates overall garments factory quality controlling. Without passing a final inspection, garments cannot be shipped. A final inspection report is the quality certificate from a garments buyer that gives a certificate of a factory about their finished product quality that allows or rejects to ship garments. There are specific quality checking points of a finished garments final audit, here I have given these below.

## **2.8 Quality Inspection Criteria's are of Final Audit**

- Workmanship
- Appearance
- Measurement/Fittings
- Materials
- Accessories
- Finishing/Packing

### **2.8.1 Workmanship**

- Fusing
- Open seam
- Broken stitch
- Miss/Skip Stitch
- Mending
- Seam grinning

- SPI incorrect
- Needle damage/cut/holes
- Puckering/Twisting
- Stripes/Plaid Mismatching
- Stepping or Hi-low
- Misaligned/Insecure Buttons
- Crooked stitching
- Raw edge
- Looseness/Knots
- Buttonhole
- Incorrect tension
- Main Label open/slanted
- Contrast thread visible
- Loop slanted

### **2.8.2 Appearance**

- Loose/uncut thread
- Dirt mark
- Oil stain
- Garment damp
- Crushed
- Pressing
- Shinning
- Wrinkle

### **2.8.3 Measurement/Fittings**

- Out of tolerance any measurement points

### **2.8.4 Materials**

- Body fabric way
- Contrast fabric
- Print/Dyeing Fault
- Color Shading
- Bald Patches
- Holes or Cuts
- Yarn Runs
- Slubs
- Color fly / Foreign yarn

### **2.8.5 Accessories**

- Thread/ Yarn
- Main Label

- Care Label
- Zipper
- Tapping/Capping
- Screenprint / Embroidery
- Buttons/Snaps/Rivets
- Velcro
- Elastic
- Finishing/Packing
- Assortment
- Carton Marks
- Polybag printing
- Hangtag
- Price ticket
- Barcode
- Carton Barcode

# **3 Chapter-III**

## Experimental Details





### Sewing Faults per hour

Time: 8-9	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 9-10	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 75	Skip Stitch	1	Oil		Sewing		Ins Qty 87	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 70	Brok Stitch	1	Dirt		Fabric Hole		Qc Pass Qty 80	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	3	Other Mark		Other Fab Rejection	
Other Defect Codes	302/3				DHU%		Other Defect Codes	15/3				DHU%	
Time: 10-11	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 11-12	Sew. Alter Category	10	Stain Mark		Rejection Category	
Ins Qty 106	Skip Stitch	1	Oil		Sewing		Ins Qty 210	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	2	Dirt		Fabric Hole		Qc Pass Qty 200	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	301/3				DHU%		Other Defect Codes	180/06				DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point											
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5	1	2	3	4	5		
Req Mes:		47	66	12	42	20	Req Mes:		51	70	14	47	21	Req Mes:		57	74	16	50	22	Req Mes:		63	78	17.5	59	24
	XXS	+5	+1	v	+1	v		S	+5	+1.5	v	+1	v		L	+5	+1.5	+5	+1	v		XXL	v	+1.5	+1.5	+1	v
		+5	+1	+5	-5	v			v	+1	+5	-5	+5			+1	v	v	+5	+5			+5	+1	v	v	
		v	+5	v	+5	+5			+5	+5	v	+5	v			v	+5	v	v			+5	+1	v	v		
		+5	+1	+5	-5	v			v	+1	+5	-5	+5			+1	v	v	+5	+5			+5	+1	v	v	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	
		+5	+1	+5	-5	v			+5	v	v	+5	+5			v	+1.5	+5	+5	+5			+1	+1.5	+5	+5	

Report 2:

**TEXEUROP (BD) LTD**  
**HOURLY QUALITY INSPECTION REPORT SEWING (END LINE)**

LINE: 10 Issue 02

Date: 02-08-21  
 Buyer: SHYAR...  
 Style No: 11259  
 Order No: 11259  
 Color: 02

Measurement check point Code: ① Chest Width, ② Body Length, ③ Shoulder, ④ Bottom Width, ⑤ Sleeve Length

Time	Defect Category	Defect Mark	Defect Code	Defect Code	Defect Code	Defect Code	Defect Code	Defect Code	Defect Code
11:00	01	01	01	01	01	01	01	01	01
11:05	01	01	01	01	01	01	01	01	01
11:10	01	01	01	01	01	01	01	01	01
11:15	01	01	01	01	01	01	01	01	01
11:20	01	01	01	01	01	01	01	01	01
11:25	01	01	01	01	01	01	01	01	01
11:30	01	01	01	01	01	01	01	01	01
11:35	01	01	01	01	01	01	01	01	01
11:40	01	01	01	01	01	01	01	01	01
11:45	01	01	01	01	01	01	01	01	01
11:50	01	01	01	01	01	01	01	01	01
11:55	01	01	01	01	01	01	01	01	01
12:00	01	01	01	01	01	01	01	01	01

D.H.CC = 9.75%      D.H.CC = 9.22%      D.H.CC = 9.76%      D.H.CC = 9.22%

Figure 3-2(Report 2 )

### Sewing Faults per hour

Time: 9.30	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 10.30	Sew. Alter Category	4	Stain Mark		Rejection Category	
Ins Qty 105	Skip Stitch	2	Oil		Sewing		Ins Qty 124	Skip Stitch		Oil		Sewing	
Qc Pass Qty 200	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	2	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	
Time: 11.30	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 12.30	Sew. Alter Category	4	Stain Mark		Rejection Category	
Ins Qty 126	Skip Stitch	3	Oil		Sewing		Ins Qty 124	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 120	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	1	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	2	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3
		+3	V	+3	V	+3			V	+3	V	+3	V			+3	V	+3	V	+3			V	+3	V	+3	V
		V	+1	V	+3	V			+3	V	+3	V	+3			+3	V	+3	V	+3			+3	V	+3	V	+3
		+3	V	+3	V	+3			V	+3	V	+3	V			+3	V	+3	V	+3			V	+3	V	+3	V
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3
		V	+1	V	+1	V			+3	V	+3	V	+3			+3	V	+3	V	+3			+3	V	+3	V	+3
		+3	V	+3	V	+3			V	+1	V	+1	V			+3	V	+3	V	+3			V	+1	V	+1	V
		V	+3	V	+3	V			+3	V	+3	V	+3			V	+3	V	+3	V			+3	V	+3	V	+3
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:							Req Mes:							Req Mes:							Req Mes:						

Report 3:

CME-13 Issue 12

**TEXEUROP (BD) LTD**  
**HOURLY QUALITY INSPECTION REPORT SEWING (END LINE)**

Date: 07-08-11  
 Buyer: SPO...  
 Order No: 1000000000  
 Color: 00

Unit # 05  
 Q.1  
 AQM  
 PM  
 AQM

Measurement check point Code ① Chest Width, ② Body Length, ③ Shoulder, ④ Bottom Width, ⑤ Sleeve Length

Time	Sp. Alter Category	Stain Mark	Rejection Category	Time	Sp. Alter Category	Stain Mark	Rejection Category	Time	Sp. Alter Category	Stain Mark	Rejection Category	Time	Sp. Alter Category	Stain Mark	Rejection Category
12:00	02	01	01	12:00	02	01	01	12:00	02	01	01	12:00	02	01	01
[Measurement Check Point 1]				[Measurement Check Point 2]				[Measurement Check Point 3]				[Measurement Check Point 4]			
Req Mes →				Req Mes →				Req Mes →				Req Mes →			
D.H.C. = 2.63%				D.H.C. = 9%				D.H.C. = 9.76%				D.H.C. = 9%			

Handwritten notes on the left margin: "D.H.C. = 2.63%", "D.H.C. = 9%", "D.H.C. = 9.76%", "D.H.C. = 9%".

Figure 3-3(Report 3)

### Sewing Faults per hour

Time: 2-3	Sew. Alter Category	3	Stain Mark		Rejection Category		Time: 3-4	Sew. Alter Category	5	Stain Mark		Rejection Category	
Ins Qty 123	Skip Stitch	1	Oil		Sewing		Ins Qty 125	Skip Stitch		Oil		Sewing	
Qc Pass Qty 12	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	2	Other Mark		Other Fab Rejection			Other Sew Alteration	3	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	
Time: 4-5	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 5-6	Sew. Alter Category	5	Stain Mark		Rejection Category	
Ins Qty 126	Skip Stitch	2	Oil		Sewing		Ins Qty 125	Skip Stitch		Oil		Sewing	
Qc Pass Qty 120	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration		Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3
		+3	V	+3	V	+3			V	+3	V	+1	V			+3	V	+3	V	+3			V	+1	V	+1	V
		V	+1	V	+1	V			+3	V	+3	V	+3			V	+3	V	+3	V			+3	V	+3	V	+3
		+3	V	+3	V	+3			V	+3	V	+1	V			+3	V	+3	V	+3			V	+1	V	+1	V
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3	Req Mes:		56	66.4	15.3	56	53.3
		V	+1	V	+1	V			+3	V	+3	V	+3			V	+1	V	+1	V			+3	V	+3	V	+3
		+3	V	+3	V	+3			V	+1	V	+1	V			+3	V	+3	V	+3			V	+1	V	+1	V
		V	+1	V	+1	V			+3	V	+3	V	+3			V	+3	V	+3	V			+3	V	+3	V	+3
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:							Req Mes:							Req Mes:							Req Mes:						



### Sewing Faults per hour

Time: 12-1	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 2-3	Sew. Alter Category	5	Stain Mark		Rejection Category	
Ins Qty 35	Skip Stitch	3	Oil		Sewing		Ins Qty 45	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 30	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 40	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	2	Other Mark		Other Fab Rejection			Other Sew Alteration		Other Mark		Other Fab Rejection	
Other Defect Codes	2/331				DHU%		Other Defect Codes					DHU%	
Time: 3-4	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 4-5	Sew. Alter Category	10	Stain Mark		Rejection Category	
Ins Qty 45	Skip Stitch		Oil		Sewing		Ins Qty 220	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 40	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 210	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	5	Other Mark		Other Fab Rejection			Other Sew Alteration	5	Other Mark		Other Fab Rejection	
Other Defect Codes	5/332				DHU%		Other Defect Codes	5/151				DHU%	

Bundle	Size	Measurement Check Point				Bundle	Size	Measurement Check Point				Bundle	Size	Measurement Check Point				Bundle	Size	Measurement Check Point			
		1	2	3	4			1	2	3	4			1	2	3	4			1	2	3	4
Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5
	9	+5	v	v	+1		9	+5	v	v	+5		9	+5	v	v	v		9	+5	v	+1	v
		v	+5	+1	+5			v	+1	+1	v			v	+1	+1	v			v	+1	+5	+1
		v	v	+5	+1			v	+5	v	v			v	+5	+5	v			+1	+5	v	+5
Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5
	9	+1	v	+1	+5		9	+1	v	v	v		9	+1	v	v	v		9	+1	+1	+5	+1
		+5	+1	v	v			+5	+1	+1	+5			+5	+5	+1	+5			+5	+1	+5	v
		v	+5	+5	+1			v	+5	v	v			v	v	+5	v			+1	+5	+5	+1
Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5	Req Mes:		48.5	61.5	71	26.5
	9	+1	v	+1	v		9	+1	v	v	v		9	+1	v	v	v		9	+1	+1	+1	v
		+5	+1	+5	+5			+5	+1	v	+1			+5	+5	v	+5			+5	+5	+5	+1
		v	+5	v	v			v	+5	+1	+5			v	+1	+1	+5			+5	+1	+1	+5





## Sewing Faults per hour

Time: 12-1	Sew. Alter Category	10	Stain Mark		Rejection Category		Time: 2-3	Sew. Alter Category	3	Stain Mark		Rejection Category	
Ins Qty 115	Skip Stitch	7	Oil		Sewing		Ins Qty 114	Skip Stitch		Oil		Sewing	
Qc Pass Qty 105	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 105	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	7	Other Mark		Other Fab Rejection	
Other Defect Codes	154/3				DHU%		Other Defect Codes	154/5, 161/2				DHU%	
Time: 3-4	Sew. Alter Category	10	Stain Mark		Rejection Category		Time: 4-5	Sew. Alter Category	5	Stain Mark		Rejection Category	
Ins Qty 115	Skip Stitch		Oil		Sewing		Ins Qty 120	Skip Stitch		Oil		Sewing	
Qc Pass Qty 105	Brok Stitch	1	Dirt		Fabric Hole		Qc Pass Qty 115	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	9	Other Mark		Other Fab Rejection			Other Sew Alteration	5	Other Mark		Other Fab Rejection	
Other Defect Codes	154/05, 101/5				DHU%		Other Defect Codes	154/5				DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37
M		+5	+25	+25	+5	-25	M		+25	+5	+25	+25	-25	M		+5	+25	+25	+5	+25	M		+5	+25	+5	V	+25
		V	+5	+25	+25	V			+25	V	+25	+25	+25			V	+5	+25	+25	+5			V	V	+5	+5	+25
		+25	+25	V	V	V			+25	+25	+5	+5	+25			+25	V	V	+25	+25			+25	+25	+25	+25	V
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37
M		V	+75	V	V	V	M		+25	+25	+25	+25	-25	M		+25	+25	+75	+25	M		+5	+25	+75	+5	+25	
		V	V	+25	+25	+75			+5	+25	+25	+25	+25			+5	+25	V	V	+25			V	+25	V	+25	+25
		+25	+5	V	+25	+5			+25	+5	+5	+25	+5			+25	+5	+25	+25	+25			+25	+5	+25	+25	+25
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37	Req Mes:		23	23.25	18.75	20.5	37
M		+25	+25	+25	+25	+5	M		V	+5	+5	V	+5	M		+25	+5	+5	+5	V	M		+5	+25	+25	+25	V
		V	V	+25	V	V			+25	+25		+25	+5			+25	+5	+25	V	V			V	V	+25	+25	
		+25	+25	+25	+25	+25			+25	+5	V	+25	+5			+25	+25	+25	+5	+25			+25	V	+25	V	+25



### Sewing Faults per hour

Time: 8-9	Sew. Alter Category	13	Stain Mark		Rejection Category		Time: 9-10	Sew. Alter Category	11	Stain Mark		Rejection Category	
Ins Qty 103	Skip Stitch	3	Oil		Sewing		Ins Qty 115	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	3	Dirt		Fabric Hole		Qc Pass Qty 105	Brok Stitch	1	Dirt		Fabric Hole	
	Other Sew Alteration	9	Other Mark		Other Fab Rejection			Other Sew Alteration	8	Other Mark		Other Fab Rejection	
Other Defect Codes	16/9				DHU%		Other Defect Codes	154/3, 16/3				DHU%	
Time: 10-11	Sew. Alter Category	12	Stain Mark		Rejection Category		Time: 12-1	Sew. Alter Category	10	Stain Mark		Rejection Category	
Ins Qty 113	Skip Stitch	7	Oil		Sewing		Ins Qty 115	Skip Stitch		Oil		Sewing	
Qc Pass Qty 105	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 105	Brok Stitch	7	Dirt		Fabric Hole	
	Other Sew Alteration	5	Other Mark		Other Fab Rejection			Other Sew Alteration	189/9, 16/4	Other Mark		Other Fab Rejection	
Other Defect Codes	154/05				DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38
	L	+5	+5	+25	+25	-25		L	+25	v	+5	v	v		L	+25	+25	v	+25	+25		L	+5	v	+5	+5	+25
		v	+25	+25	+5	+5			+25	v	v	+25	+25			v	+5	+25	v	+25			+5	+25	+25	+5	+25
		+25	+25	+5	v	+25			+5	+25	v	v	v			+25	+25	+25	v			+25	+25	+25	v	+5	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38
	L	+25	+5	+5	+25	-25		L	v	+25	+25	+25	+5		L	+25	+5	+25	+25	+5		L	+5	+25	+25	+25	v
		+25	v	+25	v	v			+25	+5	v	v	v			+25	+5	+25	+25	+5			v	+25	v	+5	v
		+25	+25	+25	v	+25			+5	v	v	+25	+5			+25	+25	+5				v	+5	v	+25	+25	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38	Req Mes:		24.5	30	20	22	38
	L	+25	+5	v	v	-25		L	+25	+25	+25	+25	+25		L	+25	+25	+25	v	+5		L	+25	v	+25	+25	+5
		+25	v	v	v	+25			+5	v	v	v	+5			v	+5	v	v	+5			+25	+5	+25	+25	v
		v	+25	+5	+25	v			+25	v	+5	+25	+25			+25	v	v	v	+25			+5	v	v	+25	+25



## Sewing Faults per hour

Time: 12.30-1.30	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 2.30-3.30	Sew. Alter Category	8	Stain Mark		Rejection Category	
Ins Qty 128	Skip Stitch	2	Oil		Sewing		Ins Qty 108	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 120	Brok Stitch	3	Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	3	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%	9.00%	Other Defect Codes					DHU%	
Time: 3.30-4.30	Sew. Alter Category	10	Stain Mark		Rejection Category		Time: 4.30-5.30	Sew. Alter Category	10	Stain Mark		Rejection Category	
Ins Qty 110	Skip Stitch	3	Oil		Sewing		Ins Qty 110	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	2	Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch	4	Dirt		Fabric Hole	
	Other Sew Alteration	5	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5	Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5
	2XL	+5	v	v	v	v		XL	+5	v	v	v	v		2XL	+1	v	v	v	v		XL	+5	+1	+5	+5	+5
		v	+5	+5	+5	+1			v	v	+1	v	v			v	v	v	+5	v			+1	+5	v	v	v
		+1	v	v	v	+5			v	v	v	v	v			v	v	v	v	v			+1	+5	v	v	v
Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5	Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5
	2XL	v	v	v	v	v		XL	+1	v	v	v	v		2XL	+5	v	v	v	v		XL	+5	v	v	v	v
		+1	+5	+5	+5	+5			+5	+5	+5	+5	+5			+1	+1	+5	+5	+5			v	+1	+5	+5	+1
		+5	v	v	v	v			+1	v	v	v	v			+5	v	v	v			+1	+5	v	v	v	
Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5	Req Mes:		62	76.5	49	62	47	Req Mes:		47	69	39	47	42.5
	2XL	+5	v	v	v	v		XL	+1	v	v	v	v		2XL	+5	v	v	v	v		XL	+5	v	v	v	v
		v	+1	+1	+5	+5			+5	+1	+5	+1	+5			+1	+5	+1	+5	+5			v	+5	+5	+5	+5
		+5	v	v	v	v			+1	v	+1	+5	v			v	v	+5	+1	+1			+1	+1	v	v	v



### Sewing Faults per hour

Time: 12.30-1.30	Sew. Alter Category	9	Stain Mark		Rejection Category		Time: 2.30-3.30	Sew. Alter Category	8	Stain Mark		Rejection Category	
Ins Qty 109	Skip Stitch	3	Oil		Sewing		Ins Qty 108	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	6	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	82/332, 2/332, 2/154				DHU%	9.00%	Other Defect Codes	82/332, 2/332, 2/154				DHU%	
Time: 3.30-4.30	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 4.30-5.30	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 107	Skip Stitch	2	Oil		Sewing		Ins Qty 107	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	6	Other Mark		Other Fab Rejection			Other Sew Alteration	5	Other Mark		Other Fab Rejection	
Other Defect Codes	82/332, 2/332, 2/154				DHU%		Other Defect Codes	82/332, 2/332, 2/154				DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5	
Req Mes:		24	30	19.5	22	38	Req Mes:		29	33	22	27	41	Req Mes:		24	30	19.5	22	38	Req Mes:		24	30	19.5	22	38	
	L	v	+1/8	v	-1/4	v		3XL	+1/2	v	v	-1/4	v		2XL	v	+1/8	v	+1/4	v		L	+1/4	v	-1/8	-1/8	-1/8	v
		+1/4	v	+1/8	-1/8	-1/4			v	+1/8	v	+1/8	-1/4			+1/4	v	+1/8	-1/8	-1/8			v	-1/8	-1/8	-1/8	-1/8	
		+1/2	+1/8	v	v	-1/4			+1/4	v	-1/8	v	-1/2			+1/4	+1/8	v	v	-1/4			+1/4	v	-1/8	v	-1/2	
Req Mes:		27	32	21	25	40	Req Mes:		25.5	31	20.2	23.5	39	Req Mes:		24	30	19.5	22	38	Req Mes:		27	32	21	25	40	
	2XL	+1/4	v	v	v	+1/8		XL	+1/4	+1/4	v	-1/8	v		2XL	v	+1/8	v	-1/4	-1/4		2XL	+1/2	v	v	-1/4	-1/8	
		v	-1/8	-1/8	v	-1/4			v	-1/8	+1/8	v	v			+1/4	v	+1/8	v	v			v	+1/8	-1/8	v	-1/4	
		+1/8	v		-1/4	-1/4			+1/4	v	v	-1/4	-1/4			+1/8	-1/8	v	-1/8	-1/8			+1/4	v	v	-1/4	v	
Req Mes:		25.5	31	20.2	23.5	39	Req Mes:		25.5	31	20.2	23.5	39	Req Mes:		24	30	19.5	22	38	Req Mes:		27	32	21	25	40	
	XL	+1/8	v	v	-1/4	v		XI	v	+1/4	+1/8	v	-1/4		L	v	+1/8	v	+1/8	v		2XL	v	-1/8	v	-1/4	-1/4	
		v	v	-1/8	-1/8	-1/4			+1/4	v	v	-1/8	v			+1/4	v	-1/8	-1/8	-1/4			+1/4	v	+1/8	+1/8	v	
		+1/2	+1/8	v	v	-1/8			+1/8	-1/8	v	v	-1/4			+1/2	+1/4	v	v	-1/8			+1/4	-1/8	v	v	+1/8	



Report 9:

**TEXEUROP (BD) LTD**

**HOURLY QUALITY INSPECTION REPORT**  Sewing (End Table)  Finishing  Process Unit: **02** Line: **02**

Order No: **07-08-0021** Style No: **FOUR DOME COAT** Color: **38080** Manager GA: **GA**

EM-46. Needle cut, EM-61. Skip Stitch, EM-42. Design Displacement, EM-63. Tension Tight, EM-65. Irregular Stitch, EM-Puckering, 68. Slanted, 329. Yarn shading.  
 PR-79. Uninspected Dot Mark, PR-71. Print Bleed, PR-72. Broken print, PR-73. Print overlapped, PR-74. Wrong Mistake, 325. Color Punched  
 SEW-61. Skip Stitch, SEW-151. Open seam, C-43. Raw Edge, SEW-153. Uneven Stitch Margin, SEW-154. Uneven T/S, SEW-156. Twisting, SEW-161. Pleated form,  
 SEW-162. Poor neck Shape, SEW-163. Foreign Yarn,  
 SEW-170. Destroyed Side Seam, SEW-174. Measurement Discrepancy, SEW-187. Excess thread, SEW-301. Drop stitch, SEW-302. Broken stitch, SEW-303. Sleeve Up down

Line	Req Mes	1	2	3	4	5	Req Mes	1	2	3	4	5	Req Mes	1	2	3	4	5	Req Mes	1	2	3	4	5
1	50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91	
S		+1.5	-1	-0.8	+0.8	+0.8		+1.5	-1	-0.8	+0.8	+0.8		+1.5	-1	-0.8	+0.8	+0.8		+1.5	-1	-0.8	+0.8	+0.8
		+1	-0.5	-1	✓	2.1		+1	-0.5	-1	✓	2.1		+1	-0.5	-1	✓	2.1		+1	-0.5	-1	✓	2.1
		+1	-1.5	-1.5	+0.5	+0.5		+1	-1.5	-1.5	+0.5	+0.5		+1	-1.5	-1.5	+0.5	+0.5		+1	-1.5	-1.5	+0.5	+0.5
2	50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91	
M		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1
		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5
3	50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91		50	78.5	41	50	91	
S		+1.5	-1	-1	✓	2.1		+1.5	-1	-1	✓	2.1		+1.5	-1	-1	✓	2.1		+1.5	-1	-1	✓	2.1
		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1		+1	-0.8	-0.8	✓	2.1
		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5		+1.5	-1.5	-1.5	+0.5	+0.5

Figure 3-9(Report 9)

### Sewing Faults per hour

Time: 8.30-9.30	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 9.30-10.30	Sew. Alter Category	8	Stain Mark		Rejection Category	
Ins Qty 71	Skip Stitch		Oil		Sewing		Ins Qty 108	Skip Stitch		Oil		Sewing	
Qc Pass Qty 65	Brok Stitch	4	Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch	4	Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	3/254, 4/332				DHU%		Other Defect Codes	11/154, 41/382, 1/151				DHU%	
Time: 10.30-11.30	Sew. Alter Category	7	Stain Mark		Rejection Category		Time: 11.30-12.30	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 107	Skip Stitch		Oil		Sewing		Ins Qty 109	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	6	Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch	11	Dirt		Fabric Hole	
	Other Sew Alteration	5	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	4/151, 41/332				DHU%		Other Defect Codes	1/151, 222/332, 111/152				DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		50	73	41	50	41	Req Mes:		53	74	43	53	43	Req Mes:		50	73	41	50	41	Req Mes:		53	74	43	53	43
	S	+1.5	-1	-1.5	+5	-5		M	+1	-1	-1.5	+5	-1		S	+1.5	-1	-1.5	+5	-5		M	+1	-1	-1.5	+5	-1
	S	+1	-1.5	-1	v	-1		M	+1	-1.5	-1	v	-1		S	+1	-1.5	-1	v	-1		M	+1	-1.5	-1	v	-1
	S	+1	-1.5	-1.5	+5	-1.5		M	+1	-1.5	-1.5	+5	+5		S	+1	-1.5	-1.5	+5	+5		M	+1	-1.5	-1.5	+5	-1.5
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		53	74	43	53	43	Req Mes:		50	72.5	41	50	41	Req Mes:		53	74	43	53	42.5	Req Mes:		50	73	41	50	41
	M	+1	-1.5	-1.5	v	-1		S	+1.5	-1	-1.5	+5	-1.5		M	+1	-1	-1.5	+5	-1		S	+1	-1.5	-1.5	v	-1
	M	+1	-1	-1	+5	-1.5		S	+1	-1.5	-1	v	-1		M	+1	-1.5	-1	v	-1.5		S	+1.5	-1	-1	+5	-1.5
	M	+1.5	-1.5	-1.5	+5	-1.5		S	+1	-1.5	-1.5	+5	+5		M	+1	-1.5	-1.5	+5	-1.5		S	+1	-1.5	-1.5	+1.5	+5
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		50	73	41	50	41	Req Mes:		53	74	43	53	43	Req Mes:		50	73	41	50	41			53	74	43	53	43
	S	+1.5	-1	-1	v	-1.5		M	+1	-1	-1.5	+5	-1		S	+1.5	-1.5	-1	v	-1		M	+1.5	-1.5	-1	+5	-1.5
	S	+1	-1.5	-1.5	+5	-1		M	+1	-1.5	-1	v	-1.5		S	+1	-1	-1.5	+5	-1.5		M	+1	-1	-1.5	+5	-1
	S	+1	-1.5	+1.5	+5			M	+1	-1.5	-1.5	+5	-1.5		S	+1	-1.5	-1.5	+5	+5		M	+1	-1.5	-1.5	+5	+5

Report 10:

**TEXELROP (BO) LTD**  
**HOURLY QUALITY INSPECTOR REPORT**

Order No: 07-15-23  
Job No: 18135  
Machine: H-Crop

Hour	1	2	3	4	5
100	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
101	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
102	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
103	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
104	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
105	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
106	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
107	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
108	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
109	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40
110	24 30 19 22 28	29 33 22 27 42	25 31 21 20 29	24 30 19 22 28	27 32 21 25 40

Please mention, if any operator change / Machine change / Needle change more than 2 times in line.

Figure 3-10(Report 10)

### Sewing Faults per hour

Time: 9-10	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 10-11	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 108	Skip Stitch	2	Oil		Sewing		Ins Qty 107	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	6	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	92/332, 02/332,02/184				DHU%	8.00%	Other Defect Codes	92/332, 02/332,02/184				DHU%	7%
Time: 11-12	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 12-1	Sew. Alter Category	8	Stain Mark		Rejection Category	
Ins Qty 106	Skip Stitch	2	Oil		Sewing		Ins Qty 108	Skip Stitch	2	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 100	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration	6	Other Mark		Other Fab Rejection	
Other Defect Codes	92/332, 02/332,02/184				DHU%	6%	Other Defect Codes	92/332, 02/332,02/184				DHU%	8%

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point			
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4
Req Mes:		24	30	19.5	22	25	Req Mes:		29	33	22	27	41	Req Mes:		25.5	31	20.25	23.5	39	Req Mes:		24	30	19.5	22
	L	+1/4	√	-1/4	√	-1/8		3XL	+1/4	√	√	√	-1/2		XL	√	√	-1/8	√	-8		L	-1/4	√	√	-1/4
		√	-1/8	√	-1/8	-1/4			√	-1/8	+1/8	-1/8	-1/8			+1/8	-1/8	√	-1/4	√			√	-1/8	-1/8	+1/8
		+1/4	√	-1/8	-1/4	√			+1/8	√	√	-1/4	√			+1/4	√	-1/4	√	-1/4			-1/8	√	-1/4	√
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point			
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4
Req Mes:		27	32	22	25	40	Req Mes:		24	30	19.5	22	25	Req Mes:		27	32	22	25	40	Req Mes:		24	30	19.5	22
	2XL	+1/8	+1/8	√	√	-1/4		L	+1/2		-1/8	-1/8	√		2XL	√	-1/8	√	-1/4	√		L	+1/8	√	-1/8	-1/8
		√	√	+1/8	-1/8	-1/2			√	√	-1/4	√	-1/4			+1/4		+1/8	+1/8	-1/4			+1/4	-1/2	√	-1/4
		+1/4	-1/4	√	-1/4	√			+1/4	√	+1/8	√	-1/4			+1/8	-1/4	√	√	-1/8			+1/4	√	+1/8	√
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point			
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4
Req Mes:		25.5	31	20.2	23.5	39	Req Mes:		24	30	19.5	22	25	Req Mes:		27	32	22	25	40	Req Mes:		22.5	29.25	18.75	20.25
	XL	√	+1/8	-1/8	√	√		L	√	√	-1/8	-1/8	√		2XL	+1/4	√	√	-1/8	√		M	+1/4	√	√	-1/8
		+1/4	√	√	+1/8	-1/8			+1/4	-1/8	√	-1/4	-1/4			√	-1/8	+1/8	-1/4	-1/4			√	√	+1/8	-1/4
		+4	-1/8	√	√	-1/4			+1/4	√	-1/4	√	-1/8			+1/4	√	-1/4	√	-1/4			+1/2	-1/4	√	√

Report 11:

Line-22

**TEXEUROP (BD) LTD**  
**HOURLY QUALITY INSPECTION REPORT SEWING (END LINE)**

Date: 07-08-21  
Buyer: Polyconer  
Style No: 58800  
Order No:  
Color: 44-BLUE

Unit # 85  
Q.I. AQM PM  
Fahima

Measurement check part Code: ① Chest Width ② Body Length ③ Shoulder ④ Bottom Width ⑤ Sleeve Length

Time	See Alter Category	Stain Mark	Rejection Category	Time	See Alter Category	Stain Mark	Rejection Category	Time	See Alter Category	Stain Mark	Rejection Category
10	10			11	11			12	12		
11	11			13	13			13	13		
12	12			14	14			14	14		
13	13			15	15			15	15		
14	14			16	16			16	16		
15	15			17	17			17	17		
16	16			18	18			18	18		
17	17			19	19			19	19		
18	18			20	20			20	20		
19	19			21	21			21	21		
20	20			22	22			22	22		
21	21			23	23			23	23		
22	22			24	24			24	24		
23	23			25	25			25	25		
24	24			26	26			26	26		
25	25			27	27			27	27		
26	26			28	28			28	28		
27	27			29	29			29	29		
28	28			30	30			30	30		
29	29			31	31			31	31		
30	30			32	32			32	32		
31	31			33	33			33	33		
32	32			34	34			34	34		
33	33			35	35			35	35		
34	34			36	36			36	36		
35	35			37	37			37	37		
36	36			38	38			38	38		
37	37			39	39			39	39		
38	38			40	40			40	40		
39	39			41	41			41	41		
40	40			42	42			42	42		
41	41			43	43			43	43		
42	42			44	44			44	44		
43	43			45	45			45	45		
44	44			46	46			46	46		
45	45			47	47			47	47		
46	46			48	48			48	48		
47	47			49	49			49	49		
48	48			50	50			50	50		
49	49			51	51			51	51		
50	50			52	52			52	52		
51	51			53	53			53	53		
52	52			54	54			54	54		
53	53			55	55			55	55		
54	54			56	56			56	56		
55	55			57	57			57	57		
56	56			58	58			58	58		
57	57			59	59			59	59		
58	58			60	60			60	60		
59	59			61	61			61	61		
60	60			62	62			62	62		
61	61			63	63			63	63		
62	62			64	64			64	64		
63	63			65	65			65	65		
64	64			66	66			66	66		
65	65			67	67			67	67		
66	66			68	68			68	68		
67	67			69	69			69	69		
68	68			70	70			70	70		
69	69			71	71			71	71		
70	70			72	72			72	72		
71	71			73	73			73	73		
72	72			74	74			74	74		
73	73			75	75			75	75		
74	74			76	76			76	76		
75	75			77	77			77	77		
76	76			78	78			78	78		
77	77			79	79			79	79		
78	78			80	80			80	80		
79	79			81	81			81	81		
80	80			82	82			82	82		
81	81			83	83			83	83		
82	82			84	84			84	84		
83	83			85	85			85	85		
84	84			86	86			86	86		
85	85			87	87			87	87		
86	86			88	88			88	88		
87	87			89	89			89	89		
88	88			90	90			90	90		
89	89			91	91			91	91		
90	90			92	92			92	92		
91	91			93	93			93	93		
92	92			94	94			94	94		
93	93			95	95			95	95		
94	94			96	96			96	96		
95	95			97	97			97	97		
96	96			98	98			98	98		
97	97			99	99			99	99		
98	98			100	100			100	100		

Please mention, if any operator change / Machine change / Needle change more than 2 times in line :

D.H.U-9%, D.H.U-9%, D.H.U-12%, D.H.U-8%

Figure 3-11(Report 11)

## Sewing Faults per hour

Time: 8.30-9.30	Sew. Alter Category	10	Stain Mark		Rejection Category		Time: 9.30-10.30	Sew. Alter Category	11	Stain Mark		Rejection Category	
Ins Qty 110	Skip Stitch	2	Oil		Sewing		Ins Qty 131	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	3	Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	4	Dirt		Fabric Hole	
	Other Sew Alteration	5	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes						DHU%	Other Defect Codes						DHU%
Time: 10.30-11.30	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 11.30-12.30	Sew. Alter Category	10	Stain Mark		Rejection Category	
Ins Qty 68	Skip Stitch	3	Oil		Sewing		Ins Qty 130	Skip Stitch	3	Oil		Sewing	
Qc Pass Qty 60	Brok Stitch	2	Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	5	Other Mark		Other Fab Rejection	
Other Defect Codes						DHU%	Other Defect Codes						DHU%

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41	Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41
	XS	+5	√	√	√	√		S	+1	√	√	√	+5		XS	+1	√	√	√	√		S	+5	√	√	√	√
		+1	+1	+5	-5	+1			+5	+1.5	√	+5	√			+1.5	+1	+5	+5	+5			+1	√	+5	+5	+1
		+5	+5	+1	√	√			√	√	+5	√	√			√	√	√	√	+4			√	+1	√	√	√
Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41	Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41
	XS	+5	√	√	√	√		S	+1	√	√	√	√		XS	+5	+1	√	√	√		S	√	√	√	√	√
		√	+5	+5	+5	+5			√	+1.5	+1	+5	+5			+4	+5	+1	+5	+5			+1	+5	+5	√	+5
		+5	√	√	√	√			+1	√	+5	√	√			√	√	+5	+4	√			+1	√	+4	+1.5	+4
Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41	Req Mes:		47	49	39	47	42.5	Req Mes:		50	90.5	41	50	41
	XS	+1	√	√	√	√		S	+5	√	√	√	√		XS	+1	√	√	+1	√		S	√	+1	+5	√	+5
		+5	+1.5	+5	+1	+5			√	+5	+5	+5	+5			+5	+1	+5	+5	+5			+5	+1	+4	+1	+4
		+4	√	√	+5	√			√	√	√	+1	√			√	+1.5	+5	+5	+4			√	+1.5	√	√	+5

Report 12:

**TEXEUROP (BD) LTD**  
**HOURLY QUALITY INSPECTION REPORT SEWING (END LINE)**

Unit # 03  
 Q. I  
 AQM  
 PM  
 AQM

Date: 02-08-21  
 Buyer: SHARAD  
 Style No: 11259  
 Order No: 11259  
 Color: 02

Measurement check point Code: ① Chest Width, ② Body Length, ③ Shoulder, ④ Bottom Width, ⑤ Sleeve Length

Time	Ins. City	Alter Category	Start Mark	Rejection Category	Time	Ins. City	Alter Category	Start Mark	Rejection Category	Time	Ins. City	Alter Category	Start Mark	Rejection Category	Time	Ins. City	Alter Category	Start Mark	Rejection Category
10:00	100	02	01	01	11:00	100	02	01	01	12:00	100	02	01	01	13:00	100	02	01	01
<p>Defect Code: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100</p> <p>Req. Mes. → 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100</p>																			

D.H.C. = 9.75%      D.H.C. = 9.22%      D.H.C. = 9.76%      D.H.C. = 9.22%

Figure 3-12(Report 13 )

### Sewing Faults per hour

Time: 9-10	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 10-11	Sew. Alter Category	4	Stain Mark		Rejection Category	
Ins Qty 105	Skip Stitch	2	Oil		Sewing		Ins Qty 124	Skip Stitch		Oil		Sewing	
Qc Pass Qty 200	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	2	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	
Time: 11-12	Sew. Alter Category	6	Stain Mark		Rejection Category		Time: 12-1	Sew. Alter Category	4	Stain Mark		Rejection Category	
Ins Qty 126	Skip Stitch	3	Oil		Sewing		Ins Qty 124	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 120	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 120	Brok Stitch	1	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	2	Other Mark		Other Fab Rejection	
Other Defect Codes					DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point											
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5							
Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5					
	52	+3	√	+3	√	+3		52	√	+3	√	+1	√		52	+3	√	+3	√	+3	√		52	√	+1	√	+1	√						
		√	+1	√	+1	√			+3	√	+3	√	+3			√	+3	√	+3	√			+3	√	+3	√	+3							
		+3	√	+3	√	+3			√	+3	√	√	√			+3	√	+3	√	+3			√	+1	√	+1	√							
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point											
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5					
	52	√	+1	√	+3	√		52	+3	√	+3	√	+5		52	√	+1	√	+1	√		52	+3	√	+3	√	+3							
		+3	√	+3	√	+3			√	+1	√	+1	√			+3	√	+3	√	+3			√	+1	√	+1	√							
		√	+1	√	+1	√			+3	√	+3	√	+3			√	+3	√	+3	√			+3	√	+3	√	+3							
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point											
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5	Req Mes:	56	66.4	53	26	23.5					



Report 13:

L16

L-16

### TEXEUROP (BD) LTD

#### HOURLY QUALITY INSPECTION REPORT

Sewing (End Table)        Finishing        Process    Unit    Line    1-6

Date: 23/11/11  
 Buyer: [Handwritten]  
 Style No: 100880  
 Order No: [Handwritten]  
 Color: [Handwritten]

Embroidery Defect: EM-60. Needle cut, EM-61. Skip Stitch, EM-62. Design Displaced, EM-63. Tension Tight, EM-65. Irregular Stitch, EM-Puckering, 68. Started, 329. Yarn shading.  
 Sewing Defect: PR-70. Unexpected Dot Mark, PR-71. Print Bleed, PR-72. Broken print, PR-73. Print overlapped, PR-74. Wrong Mistake, 68. Started, 329. Yarn shading.  
 Sewing Defect: SEW-81. Skip Stitch, SEW-151. Open seam, C-43. Raw Edge, SEW-153. Uneven Stitch Margin, SEW-154. Uneven TIS, SEW-158. Twisting, SEW-161. Pleated form.  
 Sewing Defect: SEW-170. Destroyed Side Seam, SEW-174. Measurement Discrepancy, SEW-187. Excess thread, SEW-301. Drop stitch, SEW-302. Broken stitch, SEW-303. Sleeve Up down

Q.I  
 QA/NC/JQM  
 PM/SM

Time	Sec. Alter Category	Stain Mark	Rejection Category	Time	Sec. Alter Category	Stain Mark	Rejection Category
005	QC	QC	QC	011	QC	QC	QC
010	QC	QC	QC	012	QC	QC	QC
015	QC	QC	QC	013	QC	QC	QC
020	QC	QC	QC	014	QC	QC	QC
025	QC	QC	QC	015	QC	QC	QC
030	QC	QC	QC	016	QC	QC	QC
035	QC	QC	QC	017	QC	QC	QC
040	QC	QC	QC	018	QC	QC	QC
045	QC	QC	QC	019	QC	QC	QC
050	QC	QC	QC	020	QC	QC	QC
055	QC	QC	QC	021	QC	QC	QC
060	QC	QC	QC	022	QC	QC	QC
065	QC	QC	QC	023	QC	QC	QC
070	QC	QC	QC	024	QC	QC	QC
075	QC	QC	QC	025	QC	QC	QC
080	QC	QC	QC	026	QC	QC	QC
085	QC	QC	QC	027	QC	QC	QC
090	QC	QC	QC	028	QC	QC	QC
095	QC	QC	QC	029	QC	QC	QC
100	QC	QC	QC	030	QC	QC	QC

Measurement Check Point (MCP) tables with columns for Bundle, Size, and Req Mes. Handwritten data is present in these tables.

Figure 3-13(Report 13)

### Sewing Faults per hour

Time: 8-9	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 9-10	Sew. Alter Category	4	Stain Mark		Rejection Category	
Ins Qty 208	Skip Stitch	1	Oil		Sewing		Ins Qty 225	Skip Stitch		Oil		Sewing	
Qc Pass Qty 200	Brok Stitch	1	Dirt		Fabric Hole		Qc Pass Qty 220	Brok Stitch	11	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	152/11, 303/11				DHU%	3.30%	Other Defect Codes	152/4, 303/11				DHU%	
Time: 10-11	Sew. Alter Category	7	Stain Mark		Rejection Category		Time: 11-12	Sew. Alter Category	8	Stain Mark		Rejection Category	###
Ins Qty 227	Skip Stitch	1	Oil		Sewing		Ins Qty 208	Skip Stitch	11	Oil		Sewing	
Qc Pass Qty 220	Brok Stitch	11	Dirt		Fabric Hole		Qc Pass Qty 200	Brok Stitch	11	Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	152/11, 303/11				DHU%	3%	Other Defect Codes	152/11, 303/11				DHU%	4%

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		51	70	13.5	47	21	Req Mes:		57	74	15.5	53	22	Req Mes:		68	78	17.5	59	24	Req Mes:		51	70	15.5	47	11
	S	+1	√	√	+5			L	+5	√	-1	√	-2		2XL	+2	√	-1	√	√		S	+1.5	√	-1	√	+5
		√	√	√	√	√			√	√	√	√	√			√	√	√	√	√			√	√	√	√	
		√	√	-1	√	+2			√	+1	√	+2	√			√	+1	√	√	-2			√	+1	√	+2	√
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		54	72	14.5	50	22	Req Mes:		60	76	16.5	55	23	Req Mes:		66	80	18.5	25		Req Mes:		54	72	14.5	50	22
	M	+5	√	-1	√	√		XL	+1	√	+2	√	√		3XI	+2	√	-1	√	√		M	-5	√	-1	√	√
		√	√	√	√	√			√	√	√	√	√			√	√	√	√	√			√	√	√	√	√
		√	+1	√	+2	√			√	-1	√	√	+5			√	+1	√	+5	√			√	+1	√	+2	√
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:							Req Mes:							Req Mes:							Req Mes:						

Report 14:

**TEXEUROP (BD) LTD**  
**HOURLY QUALITY INSPECTION REPORT**

Date: 7.8.21  
 Buyer: Tom color  
 Style No: 1008637  
 Order No:  
 Color: 10800

Embroidery Defect: EM-60. Needle cut, EM-61. Skip Stitch, EM-62. Design Displaced, EM-63. Tension Tight, EM-65. Irregular Stitch, EM-Puckering, 68. Slanted, 329. Yarn shading.  
 Printing Defect: PR-70. Unexpected Dot Mark, PR-71. Print Bleed, PR-72. Broken print, PR-73. Print overlapped, PR-74. Wrong Mistake, 325. Color Punched.  
 Sewing Defect: SEW-61. Skip Stitch, SEW-151. Open seam, C-43. Raw Edge, SEW-153. Uneven Stitch Margin, SEW-154. Uneven T/S, SEW-158. Twisting, SEW-161. Pleated form, SEW-162. Poor neck Shape, SEW-163. Foreign Yarn, SEW-170. Destroyed Side Seam, SEW-174. Measurement Discrepancy, SEW-187. Excess thread, SEW-301. Drop stitch, SEW-302. Broken stitch, SEW-303. Sleeve Up down

Process: Sewing (End Table)  Finishing

Unit: 1000, Line: 15

QA INC/AQM:  PM/FM:

Manager QA: [Signature]

Chest Width				Body Length				Shoulder				Bottom Width				Sleeve Length			
Time	Sew. Alter. Category	Stain Mark	Rejection Category	Time	Sew. Alter. Category	Stain Mark	Rejection Category	Time	Sew. Alter. Category	Stain Mark	Rejection Category	Time	Sew. Alter. Category	Stain Mark	Rejection Category	Time	Sew. Alter. Category	Stain Mark	Rejection Category
12	8			12	8			12	8			12	8			12	8		
Ins. Qty: 188	Skip Stitch: 11	Oil: 11	Sewing: 11	Ins. Qty: 167	Skip Stitch: 11	Oil: 11	Sewing: 11	Ins. Qty: 229	Skip Stitch: 11	Oil: 11	Sewing: 11	Ins. Qty: 228	Skip Stitch: 11	Oil: 11	Sewing: 11	Ins. Qty: 228	Skip Stitch: 11	Oil: 11	Sewing: 11
QC: 180	Other Sew. Alteration: 6	Other Mark: 6	Other Fab. Rejection: 6	QC: 168	Other Sew. Alteration: 6	Other Mark: 6	Other Fab. Rejection: 6	QC: 229	Other Sew. Alteration: 6	Other Mark: 6	Other Fab. Rejection: 6	QC: 228	Other Sew. Alteration: 6	Other Mark: 6	Other Fab. Rejection: 6	QC: 228	Other Sew. Alteration: 6	Other Mark: 6	Other Fab. Rejection: 6
Other Defects Code: 12, 8, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11				Other Defects Code: 12, 8, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11				Other Defects Code: 12, 8, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11				Other Defects Code: 12, 8, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11, 11							
DNU (%): 115				DNU (%): 115				DNU (%): 34				DNU (%): 34				DNU (%): 34			

Bundle	Size	Req Mes	Measurement Check Point	Bundle	Size	Req Mes	Measurement Check Point	Bundle	Size	Req Mes	Measurement Check Point	Bundle	Size	Req Mes	Measurement Check Point
S	1 2 3 4 5	51 70 135 97 21	✓ ✓ ✓ ✓ ✓	L	1 2 3 4 5	57 74 135 53 22	✓ ✓ ✓ ✓ ✓	L	1 2 3 4 5	69 78 135 59 24	✓ ✓ ✓ ✓ ✓	L	1 2 3 4 5	51 70 135 97 21	✓ ✓ ✓ ✓ ✓
M	1 2 3 4 5	34 76 165 50 22	✓ ✓ ✓ ✓ ✓	L	1 2 3 4 5	60 76 165 56 23	✓ ✓ ✓ ✓ ✓	L	1 2 3 4 5	66 86 165 62 25	✓ ✓ ✓ ✓ ✓	M	1 2 3 4 5	54 72 165 50 22	✓ ✓ ✓ ✓ ✓

Figure 3-14(Report 14)

### Sewing Faults per hour

Time: 12-1	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 9-8	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 188	Skip Stitch		Oil		Sewing		Ins Qty 167	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 180	Brok Stitch	11	Dirt		Fabric Hole		Qc Pass Qty 166	Brok Stitch	11	Dirt		Fabric Hole	
	Other Sew Alteration	6	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	152/11, 303/81, 151/11				DHU%	4.25%	Other Defect Codes	152/11, 703/11				DHU%	4%
Time: 3-4	Sew. Alter Category	7	Stain Mark		Rejection Category		Time: 4-5	Sew. Alter Category	8	Stain Mark		Rejection Category	
Ins Qty 227	Skip Stitch	1	Oil		Sewing		Ins Qty 228	Skip Stitch	11	Oil		Sewing	
Qc Pass Qty 212220	Brok Stitch	11	Dirt		Fabric Hole		Qc Pass Qty 220	Brok Stitch	11	Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	152/11, 303/1				DHU%	3%	Other Defect Codes	152/11m, 303/11				DHU%	4%

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		51	70	13.5	47	121	Req Mes:		57	74	13.5	53	22	Req Mes:		63	78	17.5	59	24	Req Mes:		51	70	13.5	47	21
	S	+1	√	√	+2	√		L	+2	√	√	-1	√		2XL	+5	√	√	-1	√		S	+1.5	√	-1	√	-2
		√	√	√	√	√			√	√	√	√	√			√	√	√	√	√			√	√	√	√	√
		√	√	-1	√	+5			√	√	+1	√	+5			√	√	+1	√	+2			√	+1	√	+2	√
	M	+2	√	-1	√	√		XL	+5	√	√	-1	√		3XL	+1	√	+2	√	+5		M	+5	√	√	-1	√
		√	√	√	√	√			√	√	√	√	√			√	√	√	√	√			√	√	√	√	√
		√	+1	√	√	+2			√	√	+1	√	+2			√	-1	√	-2	√			√	√	+1	√	+2
Req Mes:						Req Mes:						Req Mes:						Req Mes:									

Report 15:

**TEXEUROP (BD) LTD**

line - 12

**HOURLY QUALITY INSPECTION REPORT**

Form No. FQA000119 Issue 02

Order No <b>456024116</b>	Embroidery Defect <b>1-3-2</b>	Sewing (End Table) <input type="checkbox"/>	Finishing <input type="checkbox"/>	Process <input type="checkbox"/>	Unit <input type="checkbox"/>	Line <input type="checkbox"/>
Style No <b>108638</b>	Printing Defect	EM-60. Needle cut, EM-61. Skip Stitch, EM-62. Design Dispalced, EM-63. Tension Tight, EM-65. Irrigular Stitch, EM-Puckering, 68. Slanted, 329. Yarn shading,				Q. I
Color <b>29999</b>	Sewing Defect	PR-70. Unexpected Dot Mark, PR-71. Print Bleed, PR-72. Broken print, PR-73. Print overlapped, PR-74. Wrong Mistake, 325. Color Punched				QA INC./AQM
Order No <b>456024116</b>		SEW-61. Skip Stitch, SEW-151. Open seam, C-43. Raw Edge, SEW-153. Uneven Stitch Margin, SEW-154. Uneven T/S, SEW-158. Twisting, SEW-161. Pleated form, SEW-162. Poor neck Shape, SEW-163. Foreign Yarn,				PM/PM
Color <b>29999</b>		SEW-170. Destroyed Side Seam, SEW-174. Measurement Discrepancy, SEW-187. Excess thread, SEW-301. Drop stitch, SEW-302. Broken stitch, SEW-303. Sleeve Up down				

Measurement check point Code		Chest Width	Body Length	Shoulder	Bottom Width	Sleeve Length	Manager QA
Time: <b>8-10</b>	Sew Alter Category: <b>5</b>	Stain Mark: <b>1</b>	Rejection Category: <b>1</b>	Time: <b>9-10</b>	Sew Alter Category: <b>7</b>	Stain Mark: <b>1</b>	Rejection Category: <b>1</b>
Ins. Qty: <b>209</b>	Skip Stitch: <b>1</b>	Oil: <b>1</b>	Sewing: <b>1</b>	Ins. Qty: <b>227</b>	Skip Stitch: <b>1</b>	Oil: <b>1</b>	Sewing: <b>1</b>
QC: <b>200</b>	Break Stitch: <b>1</b>	Dirt: <b>1</b>	Fab.Hole: <b>1</b>	QC: <b>220</b>	Break Stitch: <b>1</b>	Dirt: <b>1</b>	Fab.Hole: <b>1</b>
Pass Qts: <b>200</b>	Other Sew Alteration: <b>1</b>	Other Fab Rejection: <b>1</b>	Other Mark: <b>1</b>	Pass Qts: <b>220</b>	Other Sew Alteration: <b>1</b>	Other Fab Rejection: <b>1</b>	Other Mark: <b>1</b>
Other Defects Code: <b>153</b>	DHU (%): <b>153</b>	Other Defects Code: <b>154</b>	DHU (%): <b>154</b>	Other Defects Code: <b>154</b>	DHU (%): <b>154</b>	Other Defects Code: <b>154</b>	DHU (%): <b>154</b>

Bundle Size	Measurement Check Point					Bundle Size	Measurement Check Point					Bundle Size	Measurement Check Point					Bundle Size	Measurement Check Point				
Req Mes--	1	2	3	4	5	Req Mes--	1	2	3	4	5	Req Mes--	1	2	3	4	5	Req Mes--	1	2	3	4	5
M	54	72	145	50	22	M	60	76	165	56	24	M	60	76	165	56	24	M	54	72	145	50	22
	15	15	15	15	15		15	15	15	15	15		15	15	15	15	15		15	15	15	15	15
	15	15	15	15	15		15	15	15	15	15		15	15	15	15	15		15	15	15	15	15
	15	15	15	15	15		15	15	15	15	15		15	15	15	15	15		15	15	15	15	15

Figure 3-15(Report 15)

### Sewing Faults per hour

Time: 8-9	Sew. Alter Category	5	Stain Mark		Rejection Category		Time: 9-10	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 205	Skip Stitch	1	Oil		Sewing		Ins Qty 227	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 200	Brok Stitch	1	Dirt		Fabric Hole		Qc Pass Qty 220	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	15/3				DHU%		Other Defect Codes	15/4				DHU%	
Time: 10-11	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 11-12	Sew. Alter Category	7	Stain Mark		Rejection Category	
Ins Qty 228	Skip Stitch	2	Oil		Sewing		Ins Qty 227	Skip Stitch	1	Oil		Sewing	
Qc Pass Qty 212220	Brok Stitch	2	Dirt		Fabric Hole		Qc Pass Qty 220	Brok Stitch	2	Dirt		Fabric Hole	
	Other Sew Alteration	4	Other Mark		Other Fab Rejection			Other Sew Alteration	4	Other Mark		Other Fab Rejection	
Other Defect Codes	154/4				DHU% 4%		Other Defect Codes	154/4				DHU% 4%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		54	72	14.5	50	22	Req Mes:		60	76	16.5	56	24	Req Mes:		66	80	18.5	62	26	Req Mes:		57	74	15.5	53	23
	M	+5	v	v	+5	v		XL	+5			+5	+5		3XL	+5	v	+5	v	v		L	+5	v	v	+5	v
		+5	-5	v	+5	-5			+5	-5		+5				-5	-5	v	+5	+5			+5	-5	v	+5	-5
		v	v	v	v	+5				+5						v	+5	v	v	+5			v	+5	v	v	v
Req Mes:		57	74	15.5	53	23	Req Mes:		63	78	17.5	59	25	Req Mes:		54	72	14.5	50	22	Req Mes:		60	76	16.5	56	24
	L	+5	+5	v	+5	v		2XL	+5	v	v	+5	v		M	+5	v	+5	+5	v		XL	+5	v	v	+5	v
		v	+5	v	+5	-5			v	+5	+5	+5	-5			v	+5	v	+5	+5			+5	-5	v	+5	-5
		v	v	v	v	+5			v	-5	v	v	+5			+5	+5	v	v	+5			v	-5	v	v	+5
Req Mes:							Req Mes:						Req Mes:						Req Mes:								

Report 16:

**TEXEUROP (BD) LTD**

Line - 04

**HOURLY QUALITY INSPECTION REPORT**

Date: 12/12/11  
 Buyer: 101122  
 Order No: 101122  
 Color: 10668

Embroidery Defect: EM-60. Needle cut, EM-61. Skip Stitch, EM-62. Design Displaced, EM-63. Tension Tight, EM-65. Irregular Stitch, EM-Puckering, 66. Slanted, 329. Yarn shading.  
 Finishing Defect: FR-70. Uninspected Dot Mark, PR-71. Print Bleed, PR-72. Broken print, PR-73. Print overlapped, PR-74. Wrong Mistake, 325. Color Punched  
 Sewing (End Table) Defect: SEW-61. Skip Stitch, SEW-161. Open seam, C-43. Raw Edge, SEW-153. Uneven Stitch Margin, SEW-154. Uneven TIS, SEW-156. Twisting, SEW-161. Pleated form, SEW-162. Poor neck Shape, SEW-163. Foreign Yarn.  
 Process Defect: SEW-170. Destroyed Side Seam, SEW-174. Measurement Discrepancy, SEW-187. Excess thread, SEW-361. Drop stitch, SEW-362. Broken stitch, SEW-363. Sleeve Up down

Unit: 205  
 Line: 04  
 GA I:   
 GA IBC/AGM:   
 P/M/F/M:   
 Manager QA: \_\_\_\_\_

Measurement check point Code				Chest Width				Body Length				Shoulder				Bottom Width				Sleeve Length			
Time	Raw Alter Category	Main Mark	Rejection Category	Time	Raw Alter Category	Main Mark	Rejection Category	Time	Raw Alter Category	Main Mark	Rejection Category	Time	Raw Alter Category	Main Mark	Rejection Category	Time	Raw Alter Category	Main Mark	Rejection Category				
20	20			210	210			220	220			212	212			212	212						
DHR (%) 41				DHR (%) 41				DHR (%) 41				DHR (%) 41				DHR (%) 41							
127/44 130/44				15/44 150/44				127/44 161/44				127/44 161/44				127/44 161/44							
Req Mes - 1 2 3 4 5				Req Mes - 1 2 3 4 5				Req Mes - 1 2 3 4 5				Req Mes - 1 2 3 4 5				Req Mes - 1 2 3 4 5							
57 29 16 53 24				54 32 11 50 22				57 34 19 53 22				57 34 19 53 22				57 34 19 53 22							
1.5 ✓ ✓ ✓ ✓ ✓				1.5 ✓ ✓ ✓ ✓ ✓				1.5 ✓ ✓ ✓ ✓ ✓				1.5 ✓ ✓ ✓ ✓ ✓				1.5 ✓ ✓ ✓ ✓ ✓							
M				M				M				M				M							

Figure 3-16(Report 16)

### Sewing Faults per hour

Time: 12-1	Sew. Alter Category		Stain Mark		Rejection Category		Time: 2-3	Sew. Alter Category		Stain Mark		Rejection Category	
Ins Qty 200	Skip Stitch		Oil		Sewing		Ins Qty	Skip Stitch		Oil		Sewing	
Qc Pass Qty 192	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	8	Other Mark		Other Fab Rejection			Other Sew Alteration	8	Other Mark		Other Fab Rejection	
Other Defect Codes	187/41, 302/41				DHU%		Other Defect Codes	151/41, 150/41				DHU%	4%
Time: 3-4	Sew. Alter Category		Stain Mark		Rejection Category		Time: 4-5	Sew. Alter Category		Stain Mark		Rejection Category	
Ins Qty 220	Skip Stitch		Oil		Sewing		Ins Qty 200	Skip Stitch		Oil		Sewing	
Qc Pass Qty 212	Brok Stitch		Dirt		Fabric Hole		Qc Pass Qty 192	Brok Stitch		Dirt		Fabric Hole	
	Other Sew Alteration	8	Other Mark		Other Fab Rejection			Other Sew Alteration	8	Other Mark		Other Fab Rejection	
Other Defect Codes	187/41, 161/4				DHU%	4%	Other Defect Codes	304/14, 187/44				DHU%	4%

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		57	74	15.5	53	22	Req Mes:		54	72	14.5	50	22	Req Mes:		57	74	14.5	53	22	Req Mes:		54	72	14.5	50	22
	L	+5	v	v	v	v		M	+5	v	v	v	v		L	+5	v	v	+5	v		M	+5	v	v	-1.5	v
		-5	+1.5	v	v	v				+5	.5	v	v			v	+5	v	v	v			-5	+5	v	v	v
		v	v	v	v	v			+5	v	v	v	v			-5	v	v	+5	v			v	v	v	v	v
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
		1	2	3	4	5			1	2	3	4	5			1	2	3	4	5			1	2	3	4	5
Req Mes:		64	72	14.5	50	22	Req Mes:		57	74	16.5	53	22	Req Mes:		54	72	14.5	50	22	Req Mes:		57	74	15.5	53	22
	M	v	-5	v	+6	v		L	v	v	v	v	v		M	v	v	v	+5	v		L	+5	v	v	-1.5	v
		+5	+5	v	v	v			+5	+5	v	v	v			+5	-5	v	v	v			v	+5	v	v	v
		v	v	v	v	v			+5	v	v	v	v			v	v	v	v	v			-1.5	v	v	v	v
Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point				
Req Mes:							Req Mes:							Req Mes:							Req Mes:						





## Sewing Faults per hour

Time: 8-9	Sew. Alter Category	8	Stain Mark		Rejection Category		Time: 9-10	Sew. Alter Category	6	Stain Mark		Rejection Category	
Ins Qty 103	Skip Stitch	11	Oil		Sewing		Ins Qty 88	Skip Stitch	111	Oil		Sewing	
Qc Pass Qty 100	Brok Stitch	111	Dirt		Fabric Hole		Qc Pass Qty 80	Brok Stitch	111	Dirt		Fabric Hole	
	Other Sew Alteration	3	Other Mark		Other Fab Rejection			Other Sew Alteration		Other Mark		Other Fab Rejection	
Other Defect Codes	111/111				DHU%		Other Defect Codes					DHU%	
Time: 10-11	Sew. Alter Category	13	Stain Mark		Rejection Category		Time: 12-1	Sew. Alter Category	6	Stain Mark		Rejection Category	
Ins Qty 103	Skip Stitch	11	Oil		Sewing		Ins Qty 96	Skip Stitch	111	Oil		Sewing	
Qc Pass Qty 90	Brok Stitch	11	Dirt		Fabric Hole		Qc Pass Qty 90	Brok Stitch	111	Dirt		Fabric Hole	
	Other Sew Alteration	9	Other Mark		Other Fab Rejection			Other Sew Alteration		Other Mark		Other Fab Rejection	
Other Defect Codes	154/111, 161/111, 151/111				DHU%		Other Defect Codes					DHU%	

Bundle	Size	Measurement Check Point					Bundle	Size	Measurement Check Point					Bundle	Size	Measur	
		1	2	3	4	5			1	2	3	4	5			1	2
Req Mes:		21	27.25	15.75	22.75	34.25	Req Mes:		24	28.75	17.25	25.75	36	Req Mes:		21	27.25
	L	+1/4	+1/4	-1/2	-1/2	+1/4		2XL	+1/2	v	-1/4	v	-1/4		L	+1/2	v
		v	+1/2	-1/4	v	v			+1/2	-1/4	v	-1/2	v			+1/8	
		-1/2	v	v	-1/2	-1/2			+1/2	v	-1/2	v	-1/2			-1/2	v
Req Mes:		22.5	28	16.5	24.25	25.25	Req Mes:		18.5	26	14.75	20	32.75	Req Mes:		22.5	28
	XL	+1/2	-1/2	v	-1/4	v		S	-1/2	v	-1/4	v	-1/2		XL	+1/2	+1/8
		+1/4	v	-1/2	v	-1/2			v	-1/2	v	-1/4	v			1/4	v
		v	-1/4	v	-1/4	v			-1/4	v	-1/2	v	-1/4			+1/2	-1/2
Req Mes:							Req Mes:							Req Mes:			

## **4 Chapter-IV**

Discussion of Result

## **4.1 Discussion of Sewing Line Quality Check:**

### **4.1.1 In-line Check:**

Checkpoints for critical operations are generally maintained in the assembly line. In these checkpoints, 100% of checks for partially sewn garments are carried out and faultless parts are transferred into the subsequent process. This type of inspection is used for high-value clothing.

### **4.1.2 Roaming inspection:**

In this case, checkers roam the line and check each operation by random measurement.

### **4.1.3 Traffic light inspection system:**

This inspection technique has been used by certain firms. Every operator is issued a card in this system to measure its quality performance. The quality checker goes to the operator, checks randomly for a few parts, and the inspector marks red or green as per the grading criteria on the card according to the inspection results.

### **4.1.4 End of line inspection or table checking:**

At the end of the line, a checker examines a fully sewn garment. Here is made a 100% check

### **4.1.5 Audit of the checked pieces:**

Although some factories follow this audit method, it is necessary to ensure that only 100% of the examined garment has been sent out from the sewing department to be finished. Before shipping to the final section, all faulty parts have been fixed.

## **4.2 Garments Finishing Report Analysis**

This research shows that 69 types of T-Shirt defects typically occur. 13 kinds of defects were detected. Respectively faults: Skip a stitch, Broken-stitch, Down-stitch, Open seam, joint un-missing, pleat, Armhole point up-down, etc. More than 5-6 defects had been noticed each day. For example Skip Stitch, Open seam, Pleat, Up-down Arm-hole, Un-missing Joint. In a sewing line, we have seen about 80 to 100 alterations per day

### 4.3 Graphical Analysis

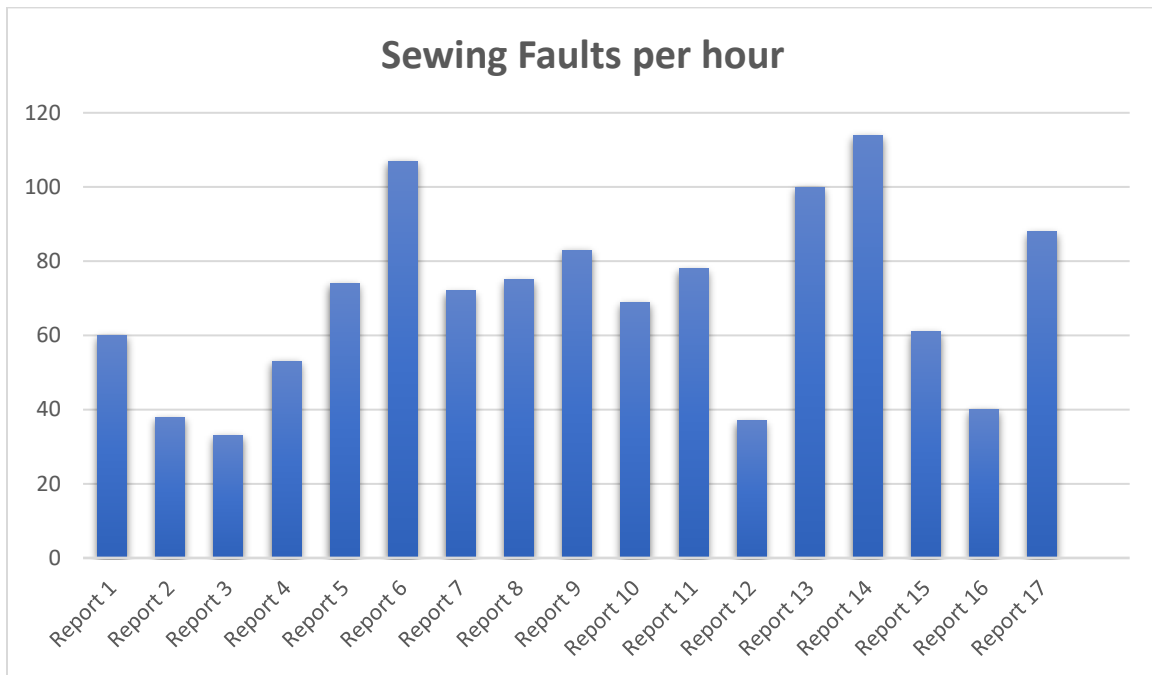


Fig 4.3.1: Graphical Analysis

### 4.4 Discussion:

We watched and collected data for 1 working day of different styles in different lines at Texeurop (BD) Ltd. We discovered that a total of 49369 pieces of clothing were inspected, with ok products totaling 48187 pieces and faulty garments totaling 1182 pieces, with 106 completely rejected and 1076 merely defective being recoverable. In the upper poll, we can see the sewing faults of 17 reports we collected. In the 1<sup>st</sup> report we found 60 faults in the 2<sup>nd</sup> it decreased to 38 in 3<sup>rd</sup> report it was 32. After the 3<sup>rd</sup> report, we can see it increased for 4 reports. In the 7<sup>th</sup> report, we see it was again decreased to 75 faults. And after this report, we can see 8<sup>th</sup> one have 77 faults and in 9<sup>th</sup> one has 82 faults. In the 10<sup>th</sup> one, we see it decreased to 75 faults. But in the 12<sup>th</sup> poll, there was a big decrease from 78 to 38 faults. And after that in the 13<sup>th</sup> poll, it increases and stands at 100 faults. In the 14<sup>th</sup> poll, it was the highest faults detected 117 faults. In the 15<sup>th</sup> poll, it was 60, and in the 16<sup>th</sup> poll, it was 40. In the last poll, it shows us almost 90 faults were detected.

## **5 Chapter V**

### Conclusion

## 5.1 Conclusion

From this venture, we have achieved our understanding with regards to how sewing is done, why defects occur during sewing, why sewing disfigurements should be relieved, and how those issues are limit during age. We concentrate on investigated knitwear sewing measures in instant apparel Enterprise, the reasons extending quality imperfections and the requirements were settled for the improvement contemplates. At the point when we inspected the complete merchandise is 49369, then, at that point, we finally discovered by and large a normal 2.39% of sewing Faults. Various sewing faults identify as a broken stitch, skip a stitch, puckering, open seam, and others. To enable a decent quality framework in endeavors, there ought to be an adequate number of qualified staff and the quality cognizance of laborers ought to be increased. In this current condition, the garments industry is adding to the decrease in joblessness issue in Bangladesh. So here we can appreciate from this exploration that in case we can lessen this kind of sewing flaws, at that point we can decrease our proficient dangers and addition our creation. Besides, our generation will be quality full. Quality level should be always improved and consequently, standard training should be set up in the endeavor.

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