



Daffodil
International
University

Faculty of Engineering

Department of Textile Engineering

Comparative Study on Development Sample for Various
Buyers

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A thesis submitted in partial fulfillment of the requirements for the degree of

Bachelor of Science in Textile Engineering

Advance in Apparel Manufacturing Technology

November 2021

Comparative study on Development Sample for Various Buyers

Comparative study on Development Sample for Various Buyers

LETTER OF APPROVAL

November 20, 2021

To

The Head

Department of Textile Engineering

Daffodil International University

Daffodil Smart City, Ashulia, Saver, Dhaka

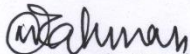
Subject: Approval of Project Report of B.Sc in TE Program

Dear Sir,

I am just writing to let you know that this Project report titled as **Comparative study on Development Sample for various buyer** have prepared by the student bearing ID: 173-23-5203, 173-23-5171 is completed for final evaluation. The whole report is prepared based on the proper investigation and interruption through critical analysis of empirical data with required belongings. The students were directly involved in their project activities and the report become vital to spark of many valuable information for the readers.

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

Yours Sincerely



Md. Mominur Rahman
21.11.2021

Assistant professor & Head

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

ACKNOWLEDGEMENT

First of all we are very grateful to God for completing the Thesis work properly. We are very thankful to those people who have made some significant amount of contribution to complete this thesis report. Our office and factory people, their contribution, advices and suggestion helped us a lot.

We are very grateful and we want to express our heartiest thanks to our respected supervisor Sir **Mr. Md. Mominul Rahman, Assistant Professor, Department of Textile Engineering** for guiding us about our project.

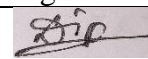

We would like thank the management of Norban Comtex Ltd, for giving me opportunity to do the industrial training successfully and also their valuable suggestions. We would like to thank Mr. Krishno Gopal Saha(Merchandising manager) at Norban Comtex Ltd. To give us the valueable information for our project.

Finally, we must acknowledge with due respect the constant support and patients of our parents.

DECLARATION

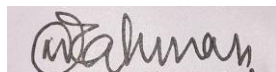
We hereby declare that the work which is being presented in this thesis entitled, **Comparative Study on Development Sample for Various Buyers** is original work of our own, has not been presented for a degree of any other university and all the resource of materials uses for this thesis have been duly acknowledged.

Prepared by:

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This is to certify that above declaration made by the candidate is correct to the best of my knowledge.

Supervisor



.....

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ABSTRACT

The project is on Comparative study on development sample for various buyer. We know the large and most important section in garments industry is sample development. We made a study on 3 buyers development sample to know about their activities and requirments for approving a sample. We analysis about their samples, fabrication, accessories, requirements, comments on developing their sample. We found the differents types of sample requirements of different buyers. We have observe what types of comments buyer do for approve the sample. At last we knew about different types of stages and requirements of different buyers for development a sample to start the bulk production.

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CHAPTER– 1
INTRODUCTION

1.1 Introduction

Sample development is the very first stage of introduction of new style. After the receipt of specification sheet (tech pack), the merchandisers have to organize the information provided in the specification sheet in a single format by categorizing different product styles and their details. Consequently, the apparel merchandiser should provide proper instructions to the junior merchandiser about the product style and hence he or she could assist the sample coordinators to prepare the development samples from the sampling department.

Product development is the process where that sketch or design is converted in to a 3D form garment, with all technical and aesthetic approach keeping in mind. In garment industry, there is a close relation between garment merchandisers and sample section. In garment buying house, sampling section is known as product development section. Apparel merchandisers have to involve in every stage in product development. In the apparel export business normally the product development is handled by design department. But apparel merchandiser has to play a vital role in product development if design section exists or not in any garment industry.

1.2 Objectives of the Study

- Different types of buyers activity for develop the sample.
- Analysis the what types of difference between different buyers.
- How to develop a sample from a yarn to a finish garment.
- How to make final approval of a sample from the buyer before starting the bulk production.

1.3 Scope of the Study

We think this study has a great scope to implement in textile industry. By these methods a proper document must be maintained. Here there are many techniques and methods are provided which is so much necessary. Here we introduces the 3 buyers garments developing methods by which a superior quality product can be produced.

1.4 Limitation

During our thesis period we have faced some problems which are mentioned below:

- We can't collect data due to some restrictions.
- Without permissions of higher authority we can't bring some necessary inner documents.
- Due to the limitation of time we couldn't able to collect all necessary data.

CHAPTER-2
LETERATURE REVIEW

1.4 Garments Sample

The garments which we need to develop as buyer requirement for buyer approval before bulk production is called the Garments Sample.

1.5 Introduction of development sample

First of all sample need to develop for starting bulk production. In garment sampling at first need to develop proto sample which is called the first sample. Development merchandisers develop the proto sample first.

1.6 Merchandising

Merchandising is the entire process from receiving order from the buyer to make the shipment of that garment as buyer requirement and approval by dealing with buyer. And follow up and managing the entire garment production at a time.

1.7 Duties and responsibilities of a merchandiser

Developing a sample: Developing a sample is the most important part in garments. Its a long term process from a yarn to a finish garment. In merchandising the first process is develop a sample. Samples need to make first for buyer approval. Buyer can want any types of sample. First of all buyer sent us tech pack of different styles of garments to us. All their requirement are included in tech pack. In Techpack which fabrication would be used, fabric colour, which accessories would be used in the garment, what types of sticker would be used, all details are includes in the tachpack. Buyer sent pdf of the tech pack to the development merchandiser. After receiving the tech pack from the buyer first of all we need to print the tech pack and make a hard copy in the office file. The we make a summery of the tech pack first for useful to our work. Then we need to style wise requisition in the companies software for all the styles of the techpack. Then we attach the requisition number with the techpack file and sent it to pattern master. At that time we book the fabric and give the colour swatch to the RND section. After dyeing the fabric it sent to dyeing and finishing section. Then RND delivery the fabric to our sample cutting section. The pattern of the style become ready at that time. Pattern master sent the pattern with techpack to the cutting section. If buyer want the strike off then the cutting man sent some strike off fabric to the print master. The print master sent the After print the srikeoff fabric we sent the strike off to the buyer for approval. And at that time the cutting man cut the fabric pattern wise. If there any style have print then the cutting man sent the body fabric part to the print master for print. After printing the front part print master sent it to the cutting man. Then the cutting man handover the all body part to the sample incharge. Sample incharge man sent it to sewing section for sewing. In that time we merchandisers give all the accessories and sewing thread style wise to the sewing incharge. He guide the sewing man with all these. And the sewing man sewing it properly in a little time. After complete the sewing the sewing incharge sent the sample to the Iron section. The iron man iron the samples properly by waching the measurement chart from the techpack. Then the sewing supervisor sent the samples with techpack to the QC section to check and packing it finally. At a time Merchandiser give all the accessories, card, measurement chart which is requird for samples give that to the QC man. He check all the samples measurement wise properly. If everything is ok then

Comparative study on Development Sample for Various Buyers

he pack samples for delivery. An then merchandisers keep some samples as counter and sent some to the buyer as buyers requird quantity.

1.8 Sample section:

Sample is a product which represents a group of product or lot or a batch in order to assess their quality, style or design or any other characteristic of the product. Based on the samples, the buyer will give approval or comments for any alteration in design or style or quality. Samples will reflect the quality and workmanship of the exporter or manufacturer.

Broadly garment samples are categorized as development samples and production samples.

1.9 Types of Sample

There are many types of samples are required for completing a garments order:

1. **Proto sample:** Proto sample is the first sampling stage. Here we made 5 or 6 pieces of sample. And sent to buyer 1 or 2 piece of sample.
2. **Salesman sample:** Buyer want salesman sample or SMS sample after approve the proto sample to see their market value. In salesman sample we sent 25 pieces of sample.
3. **Size set sample:** If salesman sample is done then buyer want some size set sample. Here we sent some sizeset sample of several size to buyer.
4. **Counter sample:** Counter sample is for Merchandiser.
5. **Fit sample:** Buyer wants fit sample just before the preproduction sample to see the fitness of the garments.
6. **Pre-production sample (PPS):** Preproduction sample need to sent just before the bulk order. If the pp sample ok the buyer submit the bulk order. Buyer wise pp sample named by GSS sample, SEAL sample etc.
7. **Top over production sample (TOP):** Top over production sample is a set of sample which is taken off from the line during the first production run. Top over production is the final sample stage which happens during production.
8. **Shipment sample:** This sample is referred for packing details, all detailing attached to the finished garment.

2.1 Sample Development:

Garments sampling is the 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. And this process is properly done by the development merchandisers. The Buyers generally places 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:

Comparative study on Development Sample for Various Buyers

- 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 the samples are to be made according to the buyers price ranges and quality levels, merchandiser has to advise.

2.2 Purpose of sample development:

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

2.3 The details attached to the garments sample

After conformation 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 department varies continuously, and the development process will covers 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.

Samples that are made in development stage are as following:

- Proto sample
- Fit sample
- Photo shot sample
- Size set sample
- Pre-production sample

In production stage factory need to submit few more samples that includes:

- Top of production sample
- Shipment sample

2.5 Process Flow Chart after receiving new style in development stage:

1. Tech pack Received From Buyer
2. Make File and study thus file
3. Need to check Sample Color Standard
4. Make a summary for easy work
5. Create Fabric Requisition and send file to sample section
6. Create Accessories booking for Proto Sample and SMS Sample
7. Need to book sewing thread for Proto Sample and SMS Sample
8. Need to book fabric for Proto and S/off Sample
9. After proto fabric booking need to book Fabric for SMS Sample
10. Follow up Pattern master to make proto sample pattern
11. Follow up R&D section for Proto sample fabric
12. Need to check Proto Sample Accessories
13. If everything in house then need to follow up sewing section.
14. Need to follow up related all section Every day for smooth working
15. Must be note down every step in summary.
16. After proto sample send need to work for SMS Sample.
17. After sent SMS Sample need to sent GSS/Seal sample for buyer approval just before bulk production.

Development merchandisers receive the sample request. They work on it. They analysis the ordersheet and sent the booking of the fabric and arrange the requird accessories for the garments. Then handover the ordersheet with proper measurement to the cad section for pattern making and fabric cutting

Comparative study on Development Sample for Various Buyers

There are many buyers exists in a industry such as S.Oliver, JackWills, Next, CupCake, Stuart peters, C&A, Vingino, Elleese, ZXY, OBEY, Mcneel.

We worked on buyer C&A ,S.Oliver, Jack wills, ZXY



2.6 Buyer: C&A

C&A is the mother buyer of the company. We have worked on C&A buyer develop stages. C&A buyers order quantity is very much. C & A is the German buyer. It has retail stores in many European countries. It only operates in the largest markets in Asia and the Americas. It was founded in 1841 and is head-quartered in Belgium. It has about 50000 employees. We are now worked on T- shirts, polo shirts, jacket in the season SS22. The brands we are working with at C&A buyers are Toddler Boy's, Toddler Girl's, Kid Boys, Kid Girls, Men's night wear, C&A Mens, Gv fashion. All the brands have running work. Here all the stages are discussed below.

2.6.1 C&A Buyer SOP:

C&A required sampling stages are-

1. Proto Sample
2. Revise buyer sample
3. Ret tag Sample
4. Test sample
5. E.com sample.
6. GSS sample.

All this stages of sample need to develop for C&A in sampling stage.

2.7 BUYER: ZXY

ZXY have more orders with hoodies, jakets and T – shirts. But more orders for hoodies and T-Shirts are coming this season. The sample quantity of ZXY buyers from C & A buyers is much higher. We are now working on T- shirts and hoodies this season. The brands we are working with

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at ZXY buyers are Bear, Admiral, Arena, Ellesse, Fila. All the brands here have running work. Here all the stages are discussed below.

2.7.1 Zxy Brands:

Brands of Buyer ZXY:

- Arena
- Bear
- Admiral
- Ellese
- Fila

2.8 Buyer: S.Oliver

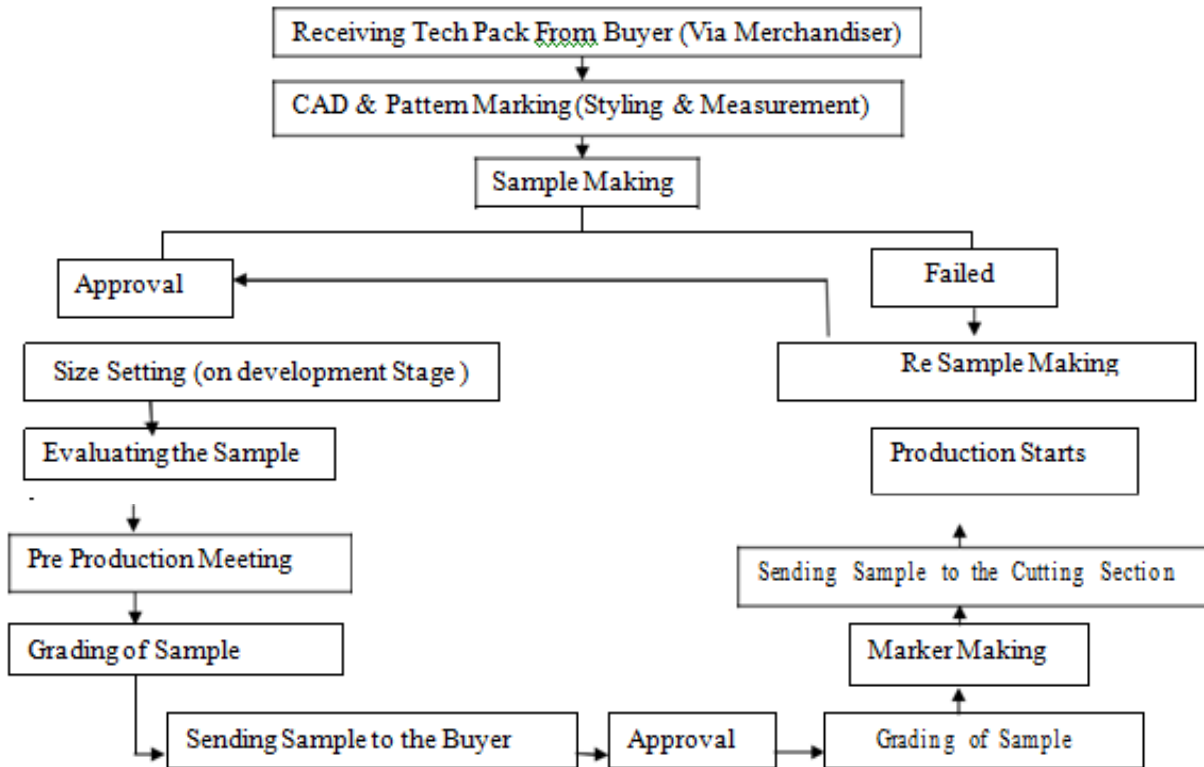
S.Oliver is a German buyer From a single retail store to one of the largest international fashion and lifestyle companies – from a small brand named »Sir Oliver« to a large brand family comprising the labels s.Oliver, Q/S by s.Oliver, comma, comma casual identity and LIEBESKIND Berlin. As of its long-standing company history, s.Oliver can now look back on numerous successes and milestones.

2.8 S.Oliver buyer SOP

S.Oliver required sampling stages are:

1. Proto/Development sample.
2. SMS(Salesman sample)
3. Fit Sample
4. Seal Sample(Pre-production sample)

2.9 Sampling process flow chart:



CHAPTER 3
EXPERIMENTAL DATA

3.1 Development Samples For Buyer C&A

3.1.1 Order 1

3.1.1(i) Order Details:

- Proto Sample
- Style: 2170479
- Division: Toddler Boys
- Style description: Toddler boys sweatshirt
- Order received date: 12/08/21

3.1.1(ii) Tech Pack

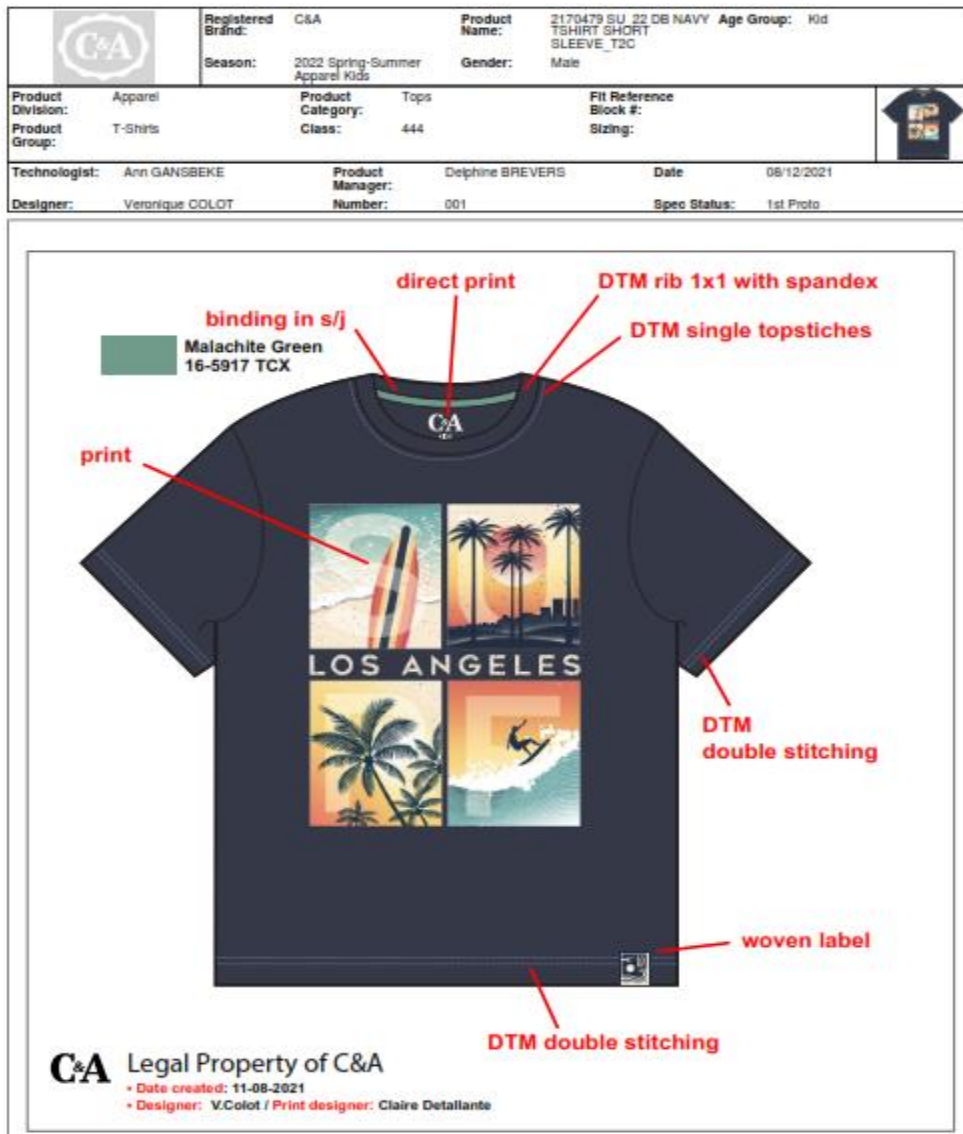


Fig3.1.1(ii): Sample details

Comparative study on Development Sample for Various Buyers

Front print:
 High res = REAL SIZE for sample 134/140
 Adjust the other sizes in proportion

Photo print CMYK process
 (if needed to keep fresh color,
 add a white printed layer
 under the photo print)

Colours direction only:

- Orange chiffon
14-1241 TCX
- Pearled Ivory
11-0907 TCX
- Malachite Green
16-5917 TCX
- Tigerlily
17-1456 TCX

11,6 cm

29,6 cm

23,5 cm

USE HIGH RESOLUTION FILES
ON TIFF

On the tiff you will find a body template design
to guide you for the placement.
Do not print it. do not use as real pattern.

Fig3.1.1(ii): Print details

		Registered Brand:	C&A	Product Name:	2170479 SU 22 DB NAVY TSHIRT SHORT SLEEVE_T2C	Age Group:	Kid													
		Season:	2022 Spring-Summer Apparel Kids	Gender:	Male															
Product Division:	Apparel	Product Category:	Tops	Fit Reference Block #:																
Product Group:	T-Shirts	Class:	444	Sizing:																
Technologist:	Ann GANGSBEKE	Product Manager:	Delphine BREVERS	Date:	08/12/2021															
Designer:	Veronique COLOT	Number:	001	Spec Status:	1st Proto															
Section: Fabrics																				
Placement	Article Name	Material Role	Article Part Name	Material	Supplier	Consumption	UOM	Sustainability Fiber Content	Supplier Material Status	Supplier Material Ref. No.	Reference No.	Material Color Status	BOM Comments	Comments	Supplier Comment	Negotiated Price	Price OVR	Total	Total Roll Up	1202 Dark Sapphire PAN TON E 19-4020 TCX
		Outer		108898 Knit 100% COTT CN 28gg 30"/1s Circular Knit Jersey 160.00 gsm	77534 Norban Comtex Ltd	0.00	kg	>= 95% Organic Cotton OCS			CK9 2S-O	Approved				\$5.5700	\$0.0000	\$0.0000	\$0.0000	1202 Dark Sapphire PAN TON E 19-4020 TCX

Fig3.1.1(ii): Fabrication

According to Tech pack body fabric type: 100% Cotton single jersey 160 GSM. Fabric body colour: Dark Sapphire 194020 tcx.

Comparative study on Development Sample for Various Buyers

	Registered Brand:	C&A	Product Name:	2170479 SU_22 DB NAVY	Age Group:	Kid
	Season:	2022 Spring-Summer Apparel Kids	Gender:	Male		
Product Division:	Apparel	Product Category:	Tops	Fit Reference Block #:		
Product Group:	T-Shirts	Class:	444	Sizing:		
Technologist:	Ann GANSBEKE	Product Manager:	Delphine BREVERS	Date:	08/12/2021	
Designer:	Veronique COLOT	Number:	001	Spec Status:	1st Proto	

Woven label:
intensive satin

	Dark Sapphire 19-4020 tcx
	Pearled Ivory 11-0907 TCX

Fig3.1.1(ii): Woven level

3.1.1(iii) Measurement Chart:

	Registered Brand:	C&A	Product Name:	2170479 SU_22 DB NAVY	Age Group:	Kid
	Season:	2022 Spring-Summer Apparel Kids	Gender:	Male		
Product Division:	Apparel	Product Category:	Tops	Fit Reference Block #:		
Product Group:	T-Shirts	Class:	444	Sizing:		
Technologist:	Ann GANSBEKE	Product Manager:	Delphine BREVERS	Date:	08/12/2021	
Designer:	Veronique COLOT	Number:	001	Spec Status:	1st Proto	

Measurement Set: 001 : 000KB dropped shoulder loose TSHIRT SHORT SLEEVE , Sample Size: 134/140 , UOM: cm

POM #	Name	Tol (+)	Tol (-)	122/128	134/140	146/152	158/164	170/176	182
A16	FRONT LENGTH from HPS-Garment	1.00	1.00	51.00	56.00	61.00	66.00	71.00	73.50
B01	Across Shoulder	1.00	1.00	34.50	38.00	41.50	45.00	48.50	50.25
A04	1/2 Chest @ 1 cm below underarm	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
A10	1/2 Hem	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
D01	Neckwidth Seam to Seam	0.50	0.50	15.50	16.00	16.50	17.00	17.50	17.75
C13	Sleeve Length from CB - SHORT SLEEVE	1.00	1.00	34.00	36.50	39.00	41.50	44.00	45.25
C4	Armhole Straight	0.50	0.50	16.50	18.00	19.50	21.00	22.50	23.25
C09	1/2 Sleeve Opening SHORT SLEEVE	0.50	0.50	13.50	14.00	15.50	17.00	18.50	19.25
D10	Front Neckdrop HPS to Seam - crew neck	0.50	0.50	6.50	7.00	7.50	8.00	8.50	8.75
D11a	Back Neckdrop HPS to Edge	0.50	0.50	2.00	2.00	2.00	2.00	2.00	2.00
C22a	Neckline Rib/Binding Height Crew Neck	0.20	0.20	1.30	1.30	1.30	1.30	1.30	1.30
D04	1/2 Neck Opening EXTENDED (minimum body)	1.00	0.00	28.00	28.00	28.00	29.00	29.00	29.00

Fig 3.1.1(iii): Measurement chart

Comparative study on Development Sample for Various Buyers

3.1.2 Booking For the Sample:

3.1.2(i) Fabric booking:



Norban Comtex Ltd

Tetuibari, Mouza, A, Kashimpur, Gazipur, 1346, Sarabo,
info@norbangroup.com, www.norbangroup.com

Sample Program Without Order

Approved By :
Approved Date :

System No. NCL-21-01757
 Booking No: NCL-SMN-21-01178 Style Ref: 2170360 Revise: Sample Sub Date: Style Desc: T- Shirt
 Buyer Name: CnA Buying Gmbh n Co. KG. Season: Spring-Summer-2022 BH Merchandiser: Remarks/Desc:
 Buyer Ref: Product Dept: Kids Supplier: Est. Ship Date
 Team Leader Krishna Saha Dealing Merchandiser: Ariful Islam Sample Stage Before Order Place

Required Fabric																	
SI	ALT / [C/W]	Sample Type	Gmt Color	Fab. Deli Date	Body Part	Fabric Desc & Composition	Color Type	Fab.Color	Item Size	GSM	Dia	Width/Dia	UOM	Grey Qty	P. Loss	Fin Fab Qty	Fabric Source
1		Proto Sample	DARK SAPPHIRE 19-4020 TCX		Neck	1x1 Rib Elastane [100% Cotton] 97% , [100% Elastane] 3% ,	Solid	DARK SAPPHIRE 19-4020 TCX		250	Any	Open Width	Kg	3.45	15	3.00	Production
					Body	Single Jersey [100% Cotton] 100% ,	AOP	DARK SAPPHIRE 19-4020 TCX		140	Any	Open Width	Kg	9.20	15	8.00	Production
Total														12.65		11.00	

Yarn details for this booking:

Yarn Required Summary

SI	Yarn Desc.	Req. Qty
1	40D, [100% Elastane], 3%,	0.10
2	30/1 Ne, [100% Cotton], 100%,	9.20
3	30/1 Ne, [100% Cotton], 97%,	3.35
Total		12.65

3.1.2(ii) Booking Accessories:

Collected the accessories for T-Shirt as per Tech Pack



Fig 3.1.2: Woven label

3.1.2(iii) Fabric in house:

The booked fabric for the T-Shirt:

Comparative study on Development Sample for Various Buyers

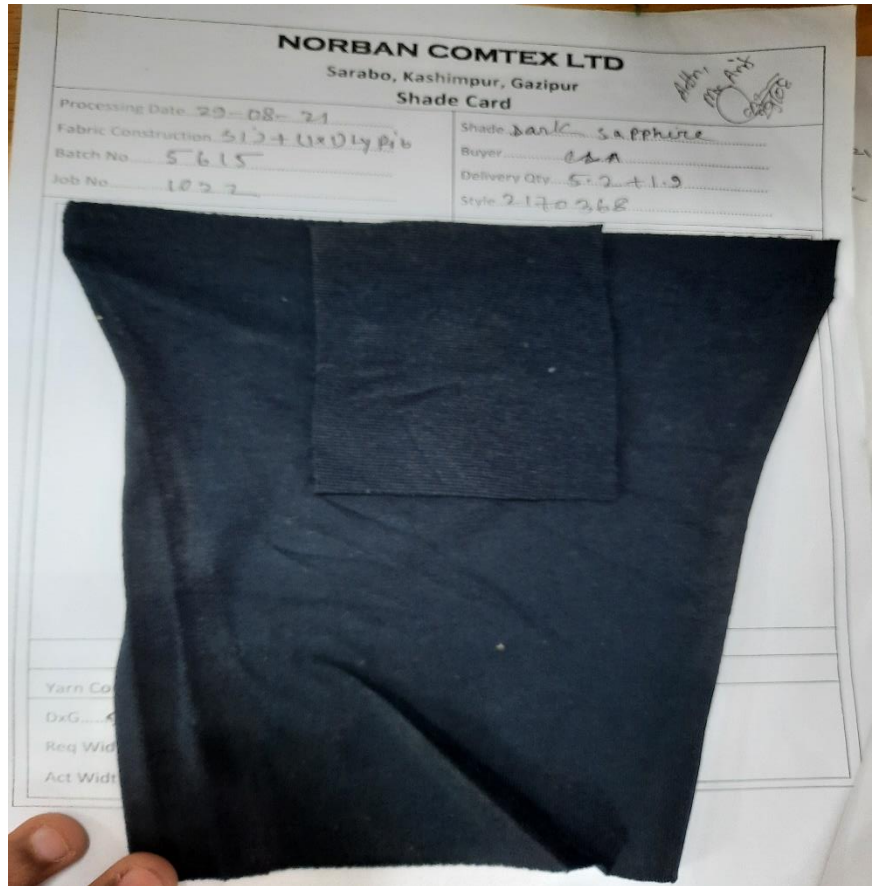


Fig 3.1.2: Fabric board

3.1.3 Cutting & Sewing:

Table 3.1.3: A Daily sample production report

Date: 28.10.21

Sl #	Buyer	Style	Item	Type of Sample	Cutting	Input Qty	Target Qty	Achieve Qty
1	C&A	2163768	JACKET	GSS	Ok	22	6	Ok
2	C&A	2166793	Long slv Tee	RTS	Ok	16	16	Ok
3	C&A	2160755	T-SHIRT	GSS	Ok	36		
4	C&A	2173255	TANK-TOP	MOCKUP	Ok	12	12	Ok
5	C&A	2170357	T-SHIRT	TEST	Ok	14		
6	C&A	2162697	POLO	PROTO	Ok	20	20	Ok
7	C&A	2170358	POLO	PROTO	Ok	8	8	Ok
8	C&A	2160897	LONG SLV. TEE	PROTO	Ok	10		
9	C&A	2170479	T-Shirt	PROTO	Ok	8	8	Ok

Comparative study on Development Sample for Various Buyers

10	C&A	2163463	SINGLET	GSS	Ok	7	7	Ok	
11	JACKWILLS	HWK-0023	POLO	DEV.	Ok	6	6	OK	
12	JACKWILLS	JACKW21X-007	SWEATSHIRT	DEV.	Ok	3	3		
13	JACKWILLS	HWK-008	POLO	DEV.	Ok	3	3		
14	S.OLIVER	2113569	T-SHIRT	SMS	Ok	2	2		
15	S.OLIVER	2113597	TSHIRT	SMS	Ok	2	2	OK	
16	S.OLIVER	2113470	JACKET	SMS	Ok	2	2	OK	
17	S.OLIVER	2112724	T-SHIRT	SMS	Ok	2	2	OK	
18	ZXY	AD 2808	T-SHIRT	SMS	Ok	25			
19	ZXY	AFW-802	TOP BOTTOM	SMS	Ok	50	10		
Grand Total=							309Pcs	220Pcs	125 Pcs

Table shows the per day sample production capacity. 240 pcs sample input a day. And here sample output quantity is 151 pcs a day.

C&A 2176448 style cutting and sewing date: 28/10/21. As proto sample quantity 8 pcs of sample cutting and sewing ok in 9/10/21.

3.1.4 Sample submission and comments:



Fig 3.1.8: Finish garment

Sample submission date: 29/10/21

Proto Sample comments from buyer:

1. Vero 07/10 Design comments on sample dated 29/10
outside label is ok, inside back neck print is ok, inside neck binding is ok.
Front print is ok for color, size and placement. Sample can be upgraded to GSS if fit is ok.
Will fit here



Celine 12.10.2021 Fitting comment : See fit picture and measurement chart-MOTHER STYLE

Comparative study on Development Sample for Various Buyers

3.1.4(i) Order 2:

1st Red tag sample

- Changes in measurement. Across shoulder: 39.00 against 38.00. And sleeve length from CB: 36. Against to 34.

		Registered Brand: C&A	Product Name: 2170479 SU 22 DB NAVY TSHIRT SHORT SLEEVE	Age Group: Kid					
		Season: 2022 Spring-Summer Apparel Kids	Gender: Male						
Product Division: Apparel	Product Category: Tops	Fit Reference Block #:							
Product Group: T-Shirts	Class: 444	Sizing:							
Technologist: Ann GANSBEKE	Product Manager: Delphine BREVERS	Date: 10/12/2021							
Designer: Veronique COLOT	Number: 001	Spec Status: 1st Red Tag							
Measurement Set: 001 : 000KB dropped shoulder loose TSHIRT SHORT SLEEVE- , Sample Size: 134-140 , UOM: cm									
POM #	Name	Tol (+)	Tol (-)	122-128	134-140	146-152	158-164	170-176	182
A16	FRONT LENGTH from HPS-Garment	1.00	1.00	51.00	56.00	61.00	66.00	71.00	73.50
B01	Across Shoulder	1.00	1.00	35.50	39.00	42.50	46.00	49.50	51.25
A04	1/2 Chest @ 1 cm below underarm	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
A10	1/2 Hem	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
D01	Neckwidth Seam to Seam	0.50	0.50	15.50	16.00	16.50	17.00	17.50	17.75
C13	Sleeve Length from CB - SHORT SLEEVE	1.00	1.00	33.00	36.00	39.00	42.00	45.00	46.50
C4	Armhole Straight	0.50	0.50	16.50	18.00	19.50	21.00	22.50	23.25
C09	1/2 Sleeve Opening SHORT SLEEVE	0.50	0.50	13.50	14.00	15.50	17.00	18.50	19.25
D10	Front Neckdrop HPS to Seam - crew neck	0.50	0.50	6.50	7.00	7.50	8.00	8.50	8.75
D11a	Back Neckdrop HPS to Edge	0.50	0.50	2.00	2.00	2.00	2.00	2.00	2.00
C22a	Neckline Rib/Binding Height Crew Neck	0.20	0.20	1.30	1.30	1.30	1.30	1.30	1.30
D04	1/2 Neck Opening EXTENDED (minimum body)	1.00	0.00	28.00	28.00	28.00	29.00	29.00	29.00

3.1.4(ii) Sample submission & Comments:

We submitted the 1st Red tag sample submission date: 18/10/21

3.1.4(iii) Comments on 1st Red tag sample:

Buyer comments:

Shamim Reza: 02-11-2021

RTS dt: 25-10-2021 Technically approved by Hub with comments added, please send RTS.

DB 9/11/21 SAMPLE DATE 25/10/21.

Pls be careful to respect the print colours of the proto sample which was nicer.

3.1.4(iv) Order 3

2nd Red tag Sample:

Table 3.1.9: Changes of measurements:

Comparative study on Development Sample for Various Buyers

Red Tag 705760 (Sample 1), Measurement Set: 001 : 000KB dropped shoulder loose TSHIRT SHORT SLEEVE-, Size: 134-140, UOM: cm									In Development
POM #	Name	Tol (+)	Tol (-)	Requested	Vendor Measurement	Vendor Measurement Delta	Actual	Actual Measurement Delta	New
A16	FRONT LENGTH from HPS-Garment	1.00	1.00	56.00	55.80	-0.20	55.60	-0.40	56.00
B01	Across Shoulder	1.00	1.00	39.00	39.00	0.00	39.00	0.00	39.00
A04	1/2 Chest @ 1 cm below underarm	1.00	1.00	41.00	41.00	0.00	40.60	-0.40	41.00
A10	1/2 Hem	1.00	1.00	41.00	41.00	0.00	41.00	0.00	41.00
D01	Neckwidth Seam to Seam	0.50	0.50	16.00	16.00	0.00	15.80	-0.20	16.00
C13	Sleeve Length from CB - SHORT SLEEVE	1.00	1.00	36.00	35.50	-0.50	35.50	-0.50	36.00
C4	Armhole Straight	0.50	0.50	18.00	18.00	0.00	18.00	0.00	18.00
C09	1/2 Sleeve Opening SHORT SLEEVE	0.50	0.50	14.00	14.00	0.00	14.00	0.00	14.00
D10	Front Neckdrop HPS to Seam - crew neck	0.50	0.50	7.00	7.00	0.00	7.00	0.00	7.00
D11a	Back Neckdrop HPS to Edge	0.50	0.50	2.00	2.00	0.00	2.00	0.00	2.00
C22a	Neckline Rib/Binding Height Crew Neck	0.20	0.20	1.30	1.30	0.00	1.30	0.00	1.30
D04	1/2 Neck Opening EXTENDED (minimum body)	1.00	0.00	28.00	28.00	0.00	28.00	0.00	28.00

3.1.4(v) Sample submission and comments:



Comparative study on Development Sample for Various Buyers

Fig 3.1.4(v): 2nd Red tag sample of Order 3

Comments:

<u>RTS Comments by Hub</u>	
• Product Usim	: 2170479
• Supplier /Country	: Fashion/ Norban Bangladesh
• Fabric content	: 100% Cotton, single Jersey 160 GSM
• Supplier GT/SGT	: Sushanta
• HUB GT/SGT	: Shamim Reza
• Sample card Date	: 25-10-2021
• Sample reviewed date	: 02-11-2021
• Production Start Date	:
• EU Technician Name	: Ann GANSBEKE

1) Measurements:
Bring back to spec all deviated measurement points.

2) FIT comments: Approved

- Overall Fit is acceptable on stand

(FIT images are attached below.)

3) Workmanship:

- Little folded at armhole s/b improve.
- Armhole shape little uneven s/b improve & both sides should be same shape.
- Front neck around stitched little uneven s/b control in bulk.
- Ensure both side shape is same for armholes, sleeve, shoulder, & neck.
- Side seam & stitching are not roping / puckering/stretch out.
- Bottom hem little uneven s/b improve in bulk.
- Please aware to needle damage it is completely not acceptable.

4) Constructions:

- Front artwork size to be proportion asper C&A requirements.
- Should be as tech pack & approved proto comments.

5) Safety:

- Must be meet C&A safety requirements. See ZIN site.

Notes-

- Sample status- Sample reviewed and technically approved with improve required. Please proceed GSS with following above & commercial comments.

3.1.4(vi) Order 5:

Gold Seal sample:



Table 3.1.4(vi): Changes for GSS:

Comparative study on Development Sample for Various Buyers

Graded Measurement: 001 : 000KB dropped shoulder loose TSHIRT SHORT SLEEVE-

001 : 1st Gold Seal Sample

Page 12 of

	Registered Brand: C&A Season: 2022 Spring-Summer Apparel Kids	Product Name: 2170479 SU_22 DB NAVY TSHIRT SHORT SLEEVE Gender: Male	Age Group: Kid						
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 444	Fit Reference Block #: Sizing:							
Technologist: Ann GANSBEKE Designer: Veronique COLOT	Product Manager: Delphine BREVERS Number: 001	Date: 11/02/2021 Spec Status: 1st Gold Seal Sample							
Measurement Set: 001 : 000KB dropped shoulder loose TSHIRT SHORT SLEEVE-, Sample Size: 134-140, UOM: cm									
POM #	Name	Tol (+)	Tol (-)	122-128	134-140	146-152	158-164	170-176	182
A16	FRONT LENGTH from HPS-Garment	1.00	1.00	51.00	56.00	61.00	66.00	71.00	73.50
B01	Across Shoulder	1.00	1.00	35.50	39.00	42.50	46.00	49.50	51.25
A04	1/2 Chest @ 1 cm below underarm	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
A10	1/2 Hem	1.00	1.00	37.50	41.00	44.50	48.00	51.50	53.25
D01	Neckwidth Seam to Seam	0.50	0.50	15.50	16.00	16.50	17.00	17.50	17.75
C13	Sleeve Length from CB - SHORT SLEEVE	1.00	1.00	33.00	36.00	39.00	42.00	45.00	46.50
C4	Armhole Straight	0.50	0.50	16.50	18.00	19.50	21.00	22.50	23.25
C09	1/2 Sleeve Opening SHORT SLEEVE	0.50	0.50	13.50	14.00	15.50	17.00	18.50	19.25
D10	Front Neckdrop HPS to Seam - crew neck	0.50	0.50	6.50	7.00	7.50	8.00	8.50	8.75
D11a	Back Neckdrop HPS to Edge	0.50	0.50	2.00	2.00	2.00	2.00	2.00	2.00
C22a	Neckline Rib/Binding Height Crew Neck	0.20	0.20	1.30	1.30	1.30	1.30	1.30	1.30
D04	1/2 Neck Opening EXTENDED (minimum body)	1.00	0.00	28.00	28.00	28.00	29.00	29.00	29.00

3.1.4(vii) GSS Sample Submission and comments:



Fig 3.1.4(vii): GSS Sample

GSS Sample comments:

Comparative study on Development Sample for Various Buyers

- Product Usim: 2170479
- Supplier /Country:Norban,Bangladesh
- Fabric content:100% Cotton, Single Jersey , 160gsm
- Supplier GT/SGT:Sushanta Sarker
- Sample card Date: 18-11-2021
- Sample revieweddate:
- Production Start Date:
- EU Technician Name:

1) Measurements :

Measurement within tolerance except
Bring back to spec all deviated measurement points.

2) FIT comments:

- Overall Fit is acceptable on stand

(FIT images are attached below.)

3) Workmanship :

Ensure both side size & shape are same for armholes, sleeve, shoulder, side seam & stitching are not roping / puckering/stretch out .

4) Constructions

- Same as per tech pack.

5) Safety : Okay as sample.

Notes-

- Sample status- Sample reviewed and send EU team approval with above comments
- GSS Sample Approved as buyer comments.

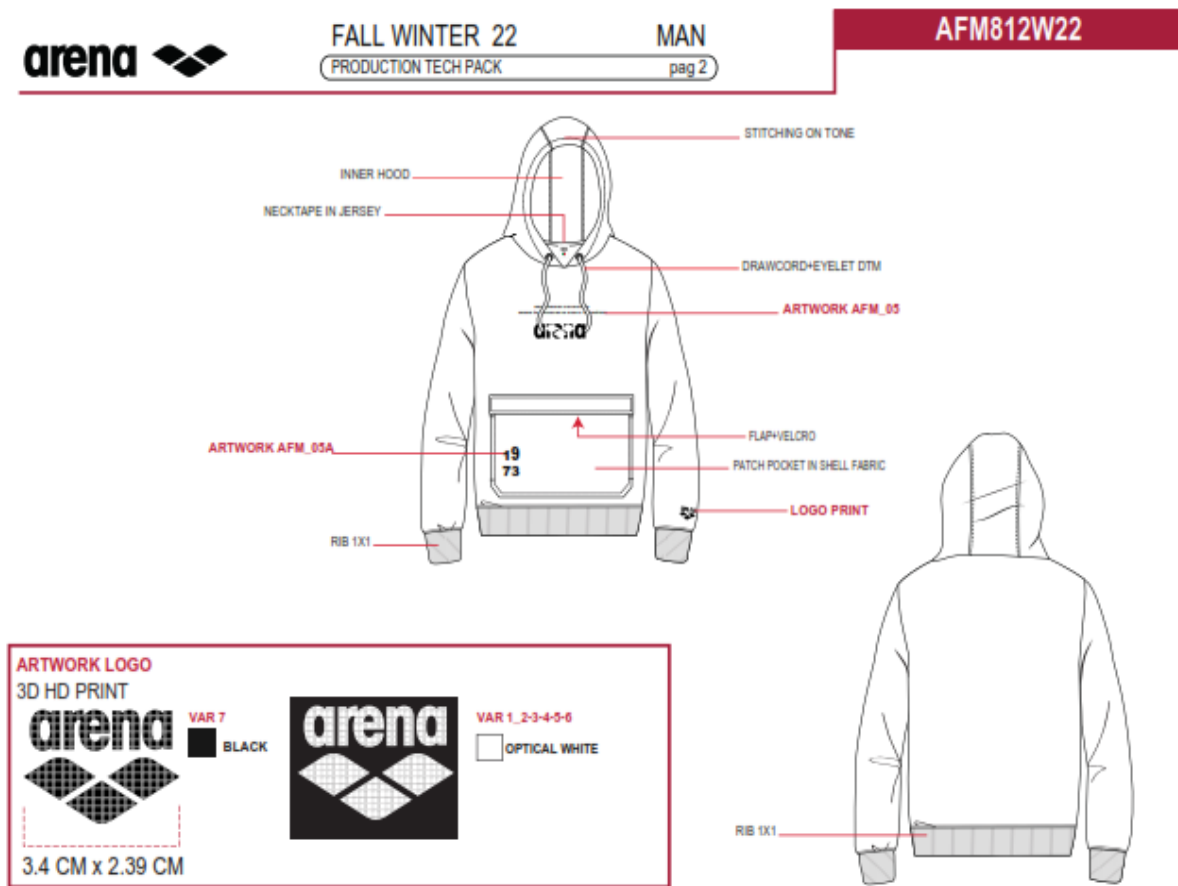
3.2 Development Samples For Buyer ZXY

3.2.1 Order 1:

3.2.1(i) Order Details:

- Style: AFM812W22
- Division: MAN
- Style description: Hoodie
- Order received date: 19/10/21

3.2.1(ii) Tech Pack File

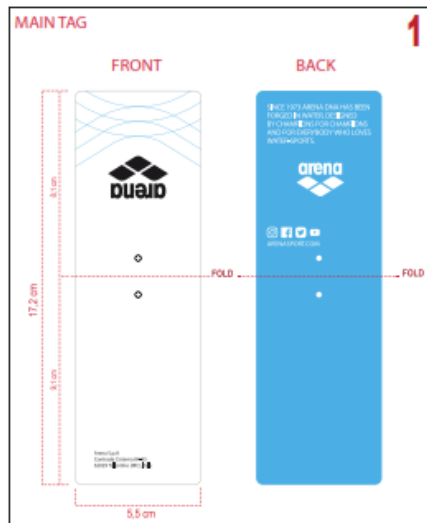
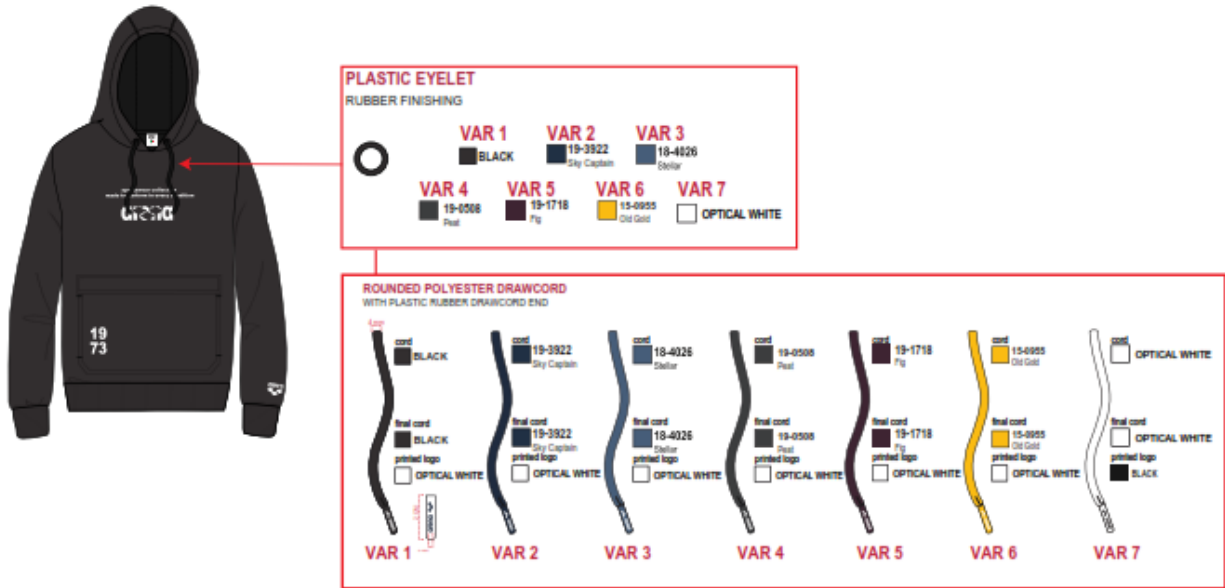


DESCRIPTION: HOODIE

MATERIALS: POLY FRENCH TERRY STRETCH 52% POLY 42% COTTON 6% LYCRA 325 GSM
CIRCULAR RIB 1X1, 95% COTTON 5%EA, 370 GSM
NECKTAPE: JERSEY 100% COTTON 160 GSM

Fig3.2.1(ii): Fabrication and Print details zxy

Comparative study on Development Sample for Various Buyers



■ CYAN
■ BLACK
□ WHITE

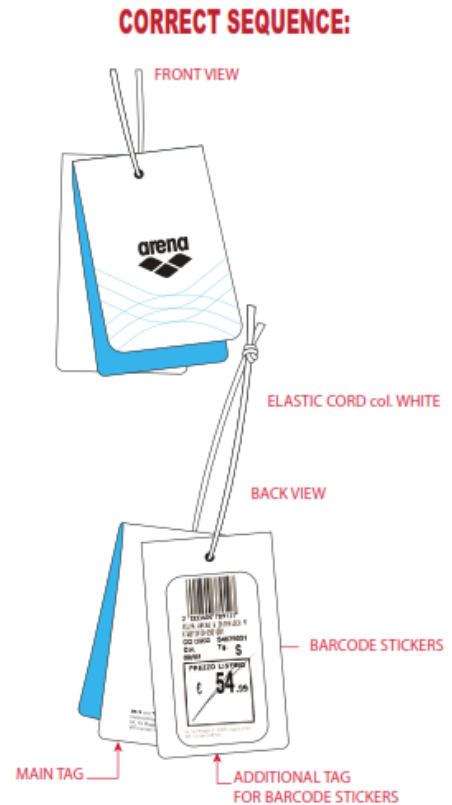
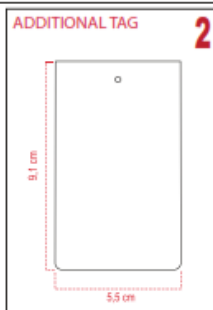
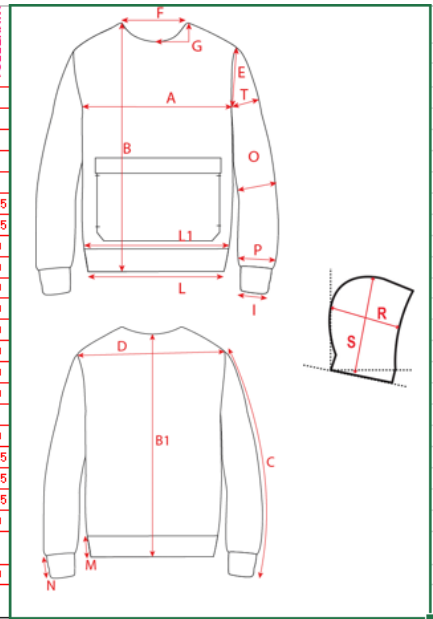


Fig3.2.1(ii): Accessoris details

Comparative study on Development Sample for Various Buyers

3.2.1(iii) Measurement chart:

ARENA	GRADING	AFM812W22												TOLERANCE	
		XS	SH	S	SH	M	SH	L	SH	XL	SH	XXL	SH		3XL
PAPER PATTERN REFERENCE AFM812W21 REV3															
A	HALF CHEST		54	56	58		60			63	66	68			1
B	FRONT LENGTH FROM HPS	2	66	68	70		72			74	76	78			1
B1	BACK LENGTH FROM CENTRE BAC	2	65	67	69		71			73	75	77			
C	SLEEVE LENGTH FROM SHOULDER	1	62	63	64		65			66	67	68			1
D	SHOULDER		45.5	47	48.5		50			52	54	56			1
E	ARMHOLE	1	20.5	21.5	22.5		24			24.5	26	26.5			0.5
F	BACK NECK WIDTH	1	20	21	22		23			24	25	26			0.5
G	FRONT NECK DROP FROM HPS	0.5	3	3.5	4		4.5			5	5.5	6			0
I	SLEEVE CUFF WIDTH AT CUFF EDGE	0.5	3.5	4	4.5		5			5.5	6	6.5			0
L	BOTTOM WIDTH RELAXED		43	45	47		49			52	55	57			0
L1	BOTTOM WIDTH RELAXED BEFORE RIB		47	49	51		53			56	59	61			0
M	WAISTBAND DEPTH	0	6	6	6		6			6	6	6			0
N	SLEEVE CUFF DEPTH	0	6	6	6		6			6	6	6			0
O	SLEEVE WIDTH AT 20 CM FROM AR	0.7	15.3	16.6	17.3		18			18.7	19	20.1			0
P	SLEEVE CUFF WIDTH BEFORE CUFF	0.5	12.5	13	13.5		14			14.5	15	15.5			0
Q	POCKET OPENING	0	18	19	19		19			19	19	19			0
T	BICEP	1	19	20	21		22			23	24	25			0
R	HOOD WIDTH	0.5	26.5	27	27.5		28			28.5	29	29.5			0.5
S	HOOD HEIGHT	0.5	37.5	38	38.5		39			39.5	40	40.5			0.5
S1	HOOD OPENING	0.5	39.5	40	40.5		41			41.5	42	42.5			0.5
	DRAW CORD EXIT LENGTH	0	20	20	20		20			20	20	20			0
	PRINT POSITION FROM CENTRAL FRONT COLLAR	1	8.5	9	9.5		10			10.5	11	11.5			0
	SLEEVE PRINT POSITION AT 3 CM FROM BOTTOM ABOVE RIB														0
	PRINT POSITION KANGAROO AT CM 2,5 FROM POCKET BOTTOM AND CM 2,5 FROM SIDE POCKET														0



3.2.2 Booking for the sample

3.2.2(i) Fabric booking:

Norban
Group of Companies

Norban Context Ltd

Tetuibari, Mouza, A, Kashimpur, Gazipur, 1346, Sarabo,
info@norbangroup.com, www.norbangroup.com

Sample Program Without Order

Approved By :
Approved Date :

System No. NCL-21-01492

Revise:

Booking No: NCL-SMN-21-01017

Style Ref: AFM824W22

Sample Sub
Date:

Style Desc:

Buyer Name: ZXY

Season: AW

BH
Merchandiser:

Remarks/Desc:

Buyer Ref:

Product Dept: Mens

Supplier

Est. Ship Date

Team Leader Krishno Saha

Dealing
Merchandiser:

Hasibur

Sample Stage Before Order
Place

Required Fabric																		
Sl	ALT / [C/W]	Sample Type	Gmt Color	Fab. Deli Date	Body Part	Fabric Desc & Composition	Color Type	Fab. Color	Item Size	GSM	Dia	Width/Dia	UOM	Grey Qnty	P. Loss	Fin Fab Qnty	Fabric Source	Remarks
1		SMS Sample	SKY CAPTAIN		Body	Loop Back Terry CVC 80/20 [80% Cotton-20% Polyester] 57% , [100% Polyester] 37% , [100% Lycra] 6% ,	Solid	SKY CAPTAIN		325	ANY	Open Width	Kg	19.55	15	17.00	Production	Fabric Reference NCL-SMN-21-608
						Single Jersey [100% Cotton] 100% ,	Solid	SKY CAPTAIN		160	ANY	Open Width	Kg	2.88	15	2.50	Production	Fabric Reference NCL-SMN-21-608
Total														22.43		19.50		

Comparative study on Development Sample for Various Buyers

SI	Yarn Desc.	Req. Qty
1	24/1 Ne,CVC 80/20 [80% Cotton-20% Polyester],57%,	11.14
2	40D,[100% Lycra],6%,	1.17
3	300D,[100% Polyester],37%,	7.23
4	20/1 Ne,[100% Organic Cotton],97%,	6.69
5	70D,[100% Lycra],3%,	0.21
6	28/1 Ne,[100% Cotton],100%,	2.88
Total		29.33

Fig3.2.2: Fabrication and yarn details of zxy style

3.2.2(ii) Booking Accessories:

According to tech pack, arranged required accessories are Hang tag, string, Drawsting.



Fig3.1.9(iv): Hang tag sticker and string Fig 3.1.9(iv): Drawsting

3.2.2(iii) Fabric receive:

Finish fabric for the body part, hood, sleeve, cuff.

Comparative study on Development Sample for Various Buyers

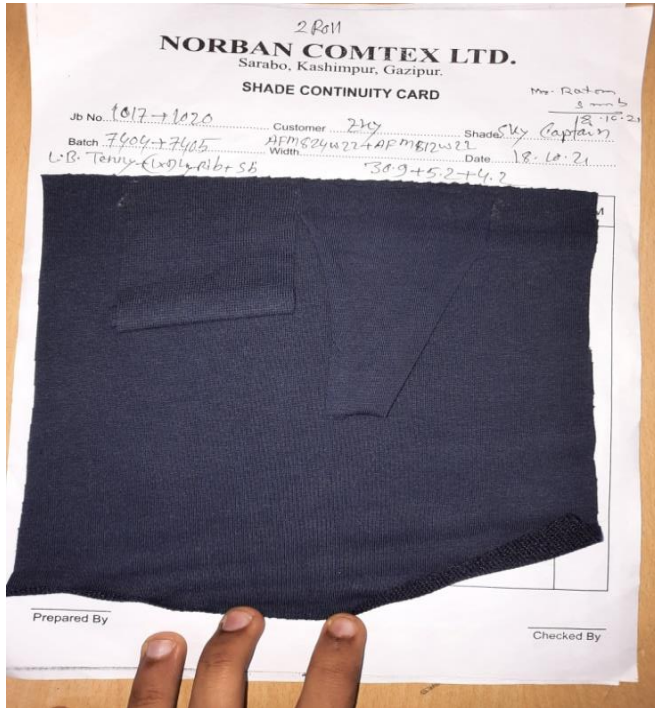


Fig 3.1.9(iii): Finish Fabric board of zxy

3.2.3 Cutting & Sewing:

Table 3.2.3: A Daily sample production report

Date: 2.11.21

Sl #	Buyer	Style	Item	Type of Sample	Cutting	Input Qty	Target Qty	Achieve Qty
1	C&A	2176984	T-Shirt	GSS	Ok	27	20	
2	C&A	2156788	Long slv Tee	RTS	Ok	20	16	Ok
3	C&A	2161567	Long sleeve Tee	PROTO	Ok	39	30	
4	C&A	2168782	Kid boys singlet	TEST	Ok	16	12	Ok
5	C&A	2178479	POLO	PROTO	Ok	18	15	Ok
6	C&A	2169065	POLO	PROTO	Ok	24	20	Ok
7	C&A	2163463	SINGLET	GSS	Ok	11	7	Ok
8	JACKWILLS	JMA221E-003	POLO	DEV.	Ok	8	8	
9	JACKWILLS	JACKW21X-080	SWEATSHIRT	DEV	Ok	8	5	Ok
10	S.OLIVER	2113332	T-SHIRT	Proto	Ok	9	9	

Comparative study on Development Sample for Various Buyers

11	S.OLIVER	2113364	TSHIRT	Proto	Ok	9	9	OK
12	S.OLIVER	2113463	JACKET	SMS	Ok	35	25	OK
13	ZXY	AD 4008	T-SHIRT	PROTO	Ok	8	6	Ok
14	ZXY	AFW-W58	SWEATSHIRT	PROTO	Ok	8	5	Ok
15	ZXY	AD 2801	T-SHIRT	SMS	Ok	25	15	
16	ZXY	AFM-W22	HOODIE	PROTO	Ok	8	8	Ok
17	ZXY	AFM-W24	SWEATSHIRT	PROTO	Ok	8	8	Ok
18	ZXY	AD 2809	T-SHIRT	SMS	Ok	25	18	Ok
19	ZXY	AFW-800	Long sleeve Tee	PROTO	Ok	8	8	Ok
Grand Total=						314 Pcs	244 Pcs	162 Pcs

Table 3.2.3 Shows a daily sample production report. Buyer zxy Style:AFM812W22 Cutting & Sewing done at 2/11/21

3.2.4 Finish garment:



Fig3.2.4: Finish garment of Arena

3.2.5 Sample submission and comments:

Sample submitted to ZXY at: 3.1121

Comments:

Measurement: Measurement and fittings literally ok.

WORKMANSHIP:

1. the top stitch, especially the single stitches have to be correct adjusted and nice elastic, they should not brake.
2. back neckline stitch has to end in a vertical stitch to neckline seam. take care the front neckline stitch will end clean at the back vertical stitch.
3. the crossing seam of undersleeve, side seam and armhole has to meet exact together.
4. patched pocket has to be symmetrical.
5. make sure top stitch on patched pocket is clean and straight sewn in even distance t edge.

FABRIC / ARTWORK / FINISH:

1. fabric weight has to be 330gsm for sms.
 2. the rib fabric is too flappy and easy to expand. pls increase the elasticity and make sure the rib will go back in shape after pulling.
- Here as buyer comments there is no changes in measurement. But Buyer mentions some problem with stitches in neckline seam, side seam.
 - And fabric GSM is not ok. It have to 330 GSM. And the rib fabric need to improve.

3.3 Development Samples For Buyer S.Oliver

3.3.1 Order 1:

3.3.1(i) Order Details:

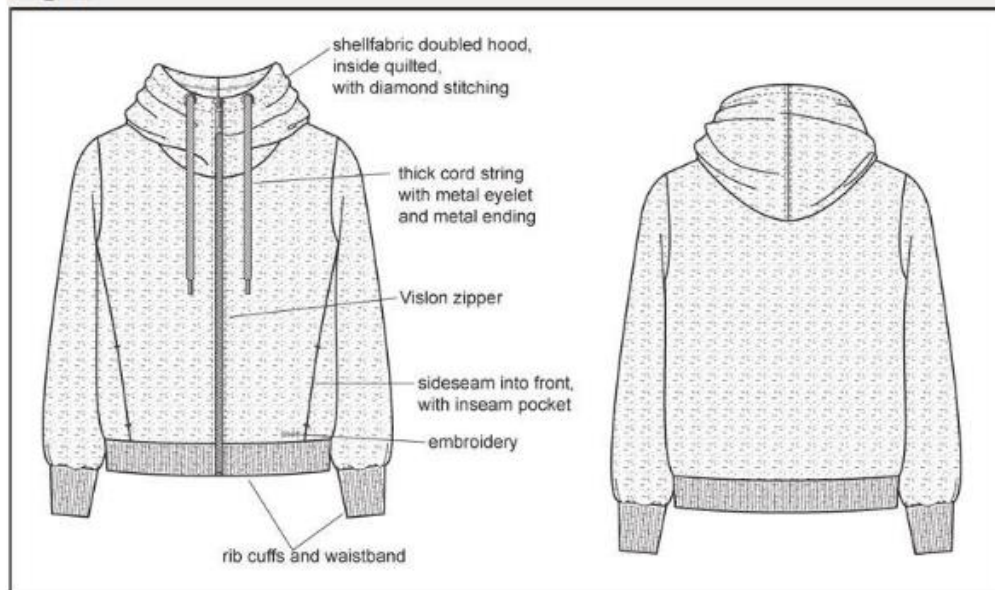
- Style: 210973
- Division: QS Mens
- Style description: Hooded Sweatshirt
- Order received date: 1/10/21

3.3.1(ii) Tech pack Overview:

Centric8 Production 2103973 Sourcing Worksheet 2/15/2021, 10:52 AM

Properties

Main_Sketch



Main Materials
Material Program
Shape REGULAR FIT
Model
Style Name
General Comment - Fabric and style group with Sweatshirt 2103971

Sizes XS, S, M, L, XL, XXL
Default Size S
Designer Anne-Christin Lange
Technician Henriette Bethmann
Pattern Option

Colorways


Colorway	Plan SMS	Actual SMS	Color Start Date	Color End Date	Stock Clearence Date	Active
02WO	✓					✓

Displaying 1 result







Colorway of the sample: 02WO (White, S.Oliver colour code)

Comparative study on Development Sample for Various Buyers

3.3.1(iii) Fabrication in details:

Material Class	Key Material Title	Image	Product	Print WS	Supplier Ref Code	Supplier Ref Code	Material Description	Composition	Weight	Weight Unit	Product Source	Size Unit of Measure	Consumption	Common Size	Usage	O2WO
Fabric (2)																
Circular Knit	Shell fabric (ERP)		FA-CK-1203077	✓			BCI-CO/PES Felpa, melange, inside brushed, outside peached	90% CO, 10% PES	350	g/m2	FA-CK-1203077:Not yet defined		0		- same shellfabric quality as orig. sample	BROS Vol.46 B1004
Circular Knit	Cuff/waistband		FA-CK-1015963	✓		FA-CK-1015963	Dummy Material from Local Supplier without Supplier and Materialdetails in PLM - pls do not change!	100% NYD	0		FA-CK-1015963:LOCAL - Country specific	yd	0		- same rib quality as orig. sample	BROS Vol.46 B1004

3.3.1(iv) Required accessories:

Zipper			TR-ZI-1000450	✓		LOCAL - Country specific / TR-ZI-1000450	Dummy Material from Local Supplier without Supplier and Materialdetails in PLM - pls do not change!	100% NYD			TR-ZI-1000450:LOCAL - Country specific		1	000#5	- Vision zipper at c.f., length acc. to meas.-chart	0200
Carelabel		LA-CL-1072160	✓		SML / Local (according approval) LA-CL-1072160	Second Carelabel	100% PES	0		LA-CL-1072160:Not yet defined	pcs	1	35 mm	- fix inside left side seam	white SRHMF100T	
Hangtags		LA-HT-1201407	✓	SEQSHNV001	SEQSHNV001	WE CARE Special Hangtag Q/S by s.Oliver in 'SEN PAPER Brown Senbo paper FSC'	100% Paper	175	g/m2	LA-HT-1201407:SML (Hong Kong) Limited	mm	1	76x33	- fix with label string as usual	cw:1/7610/brown (color of paper)	
Size label		LA-SL-1069963	✓		LA-SL-1069963	size label	100% CO	0		LA-SL-1069963:SML (Hong Kong) Limited	pcs	1		fix 0,2cm beside LA-WL-1201081 left side	cw:1/11-4202 TCX/black	
Woven Labels		LA-WL-1201081	✓		SEQSMPV00C		100% Cotton	0		LA-WL-1201081:SML (Hong Kong) Limited	pcs	1		- fix in middle of c.b. neckline as usual	cw:1/11-4202 TCX/9999	
Woven Labels		LA-WL-1087882	✓		cw:1-SEQSFWH01Q/cw:2-SEQSFWH01S	flaglabel	100% PES	0		LA-WL-1087882:SML (Hong Kong) Limited	pcs	1		- fix on left side seam 5cm from bottom hem edge	cw:2/0200/9999	
Ending			TR-EN-1000426	✓		TR-EN-1000426	Dummy Material from Local Supplier without Supplier and Materialdetails in PLM - pls do not change!	100% NYD			TR-EN-1000426:LOCAL - Country specific		2		- plain metal ending at hood string, matching size to string	silver antique
Eyelet		TR-EY-1201115	✓		TR-EY-1201115		100% MTF			TR-EY-1201115:Li Wai Metal Manufactory Ltd.	pcs	2	16.5	- at front hood tunnel like sketch	cw:2/silver antique/wording 11-4202 TCX	

Required accessories for this sample: Zipper, Carelabel, Hangtags, Size label, Woven label, Ending, Eyelets, We care Hangtag, Drawsting.

Comparative study on Development Sample for Various Buyers

3.3.1(v) Measurement chart:

Sort Order	Dim	Description	Special Description	POM Grouping	POM-X	Key Measurement	Comment	XS	S	M	L	XL	XXL
00000002	0002	body length at C.B				✓		62.0	65.0	67.0	69.0	72.0	74.0
00000003	0003	body length at C.F				✓		54.0	57.0	59.0	61.0	63.0	65.0
00000020	0020	chest, 2 cm under armhole				✓		51.5	53.5	56.5	59.5	63.5	67.5
00000021	0021	back width distance from C.B						10.0	11.0	12.0	13.5	14.9	16.3
00000022	0022	back width 1/1				✓		41.8	43.2	46.0	48.8	52.0	55.2
00000023	0023	breast width distance from high point shoulder						13.0	14.0	15.0	16.5	17.9	19.3
00000024	0024	breast width				✓		40.8	42.2	45.0	47.6	50.8	54.0
00000041	0041	waist distance from C.B.						38.0	39.0	40.0	41.5	42.9	44.3
00000043	0043	waist				✓		47.5	49.5	52.5	55.5	59.5	63.5
00000044	0044	waistband height						6.0	6.0	6.0	6.0	6.0	6.0
00000047	0047	distance from bottom edge						9.0	9.0	9.0	9.0	9.0	9.0
00000048	0048	width above waistband/bottom edge				✓		46.0	48.0	51.0	54.0	58.0	62.0
00000081	0081	bottom width straight				✓		37.5	39.5	42.5	45.5	49.5	53.5
00000090	0090	neck vertical				✓		8.0	8.0	8.0	8.0	9.0	9.0
00000091	0091	neck horizontal				✓		20.9	21.7	22.5	23.3	24.1	24.9
00000110	0110	shoulder				✓		42.6	44.0	47.0	50.0	53.0	56.0
00000120	0120	armhole along seamline						21.3	22.5	23.5	24.9	26.2	27.6
00000126	0126	armhole deep				✓		18.5	19.6	20.5	21.9	23.1	24.3
00000181	0181	sleeve length from shoulder				✓		64.0	65.0	66.0	67.0	67.5	68.0
00000182	0182	muscle width				✓		17.2	18.1	19.0	20.2	21.4	22.6
00000183	0183	armball height						11.5	12.2	12.5	13.2	13.8	14.3
00000192	0192	elbow distance from sleeve edge						18.0	18.0	18.0	18.0	18.0	18.0
00000193	0193	elbow width						12.8	13.4	14.0	14.7	15.4	15.7
00000210	0210	cuff width closed on edge				✓		9.0	9.5	10.0	10.5	11.0	11.0
00000213	0213	cuff height						6.0	6.0	6.0	6.0	6.0	6.0
00000290	0290	hood height front						35.0	35.0	36.0	36.0	38.0	38.0
00000291	0291	hood height from C.B						31.5	31.5	32.5	32.5	34.5	35.5
00000292	0292	hood width						26.9	27.7	28.5	29.3	30.7	31.5
00000294	0294	hood flap height						6.5	6.5	7.0	7.0	8.0	8.0
323010000	56L	pocket entry,length						15.0	15.0	15.0	15.9	15.9	16.8
343010000	58L	pocket patched,length						20.0	21.0	21.0	22.0	22.0	23.0
344020500	58WD	pocket patched,width,lower (down)						31.5	32.5	32.5	33.5	33.5	34.5
344020900	58WM	pocket patched,width,middle						37.0	38.0	38.0	39.0	39.0	40.0
344020600	58WU	pocket patched,width,upper						25.0	26.0	26.0	27.0	27.0	28.0
573010000	95L	string,length						26.0	26.0	26.0	26.0	27.0	27.0

Displaying 32 - 35 of 35 results

Units: CM Grade Rule Template Display: Absolute

Fig3.3.1(iv): Measurement chart

Default size of this garment is: M

Comparative study on Development Sample for Various Buyers

3.3.2 Booking For the samples:

3.3.2(i) Fabric booking



Norban Comtex Ltd
 Tetuibari, Mouza, A, Kashimpur, Gazipur, 1346, Sarabo,
 info@norbangroup.com, www.norbangroup.com

Sample Program Without Order

Approved By :
 Approved Date :

System No. NCL-21-00807 Revise:
 Booking No: NCL-SMN-21-00562 Style Ref: 2103973 Sample Sub Date:
 Buyer Name: S.Oliver Bernd Freier GMBH And Co.KG Season: Q1 [103] BH Merchant:
 Buyer Ref: S.OLIVER Product Dept: Women Supplier:
 Team Leader Dealing Merchant: Sample Stage: Before Order Place Est. Ship Date

Required Fabric																		
Sl	ALT / [C/W]	Sample Type	Gmt Color	Fab. Deli Date	Body Part	Fabric Desc & Composition	Color Type	Fab.Color	Item Size	GSM	Dia	Width/Dia	UOM	Grey Qty	P. Loss	Fin Fab Qty	Fabric Source	Remarks
1	2103973	Proto Sample	GREY MARL	26-04-2021	Body	Brush Back Fleece Ecru Melange [98% Cotton -2% Viscose] 52% , [100% Polyester] 14% , [100% Cotton] 34% ,	Solid	GREY MARL		320	ANY	Open Width	Kg	18.00	20	15.00	Production	
					Cuff+Hem	2x2 Rib Elastane Ecru Melange [98% Cotton -2% Viscose] 95% , [100% Elastane] 5% ,	Solid	GREY MARL		400	ANY	Open Width	Kg	7.20	20	6.00	Production	
Total														25.20		21.00		

3.3.2(ii) Booking accessories:

According to tech pack required accessories for this sweatshirt are: Carelabel, We care hangtag, Size label, Main label, Woven label, Hang tag, string, eyelets, drawstring.

Comparative study on Development Sample for Various Buyers



Fig 3.3.2(ii): Accessories of S.oliver.

3.3.3 Cutting & Sewing:

Table 3.3.3: A Daily sample production report

Sl #	Buyer	Style	Item	Type of Sample	Cutting	Input Qty	Target Qty	Achieve Qty
1	C&A	2177556	Long slv Tee	RTS	Ok	15	10	
2	C&A	2154546	Long slv Tee	PROTO	Ok	8	8	Ok
3	C&A	2164355	Long sleeve Tee	PROTO	Ok	39	30	

Comparative study on Development Sample for Various Buyers

4	C&A	2166888	Hoodie	GSS	Ok	12	12	Ok
5	C&A	2178542	POLO	GSS	Ok	18	12	
6	C&A	2166573	T-SHIRT	PROTO	Ok	32	20	Ok
7	S.OLIVER	2113536	SWEATSHIRT	Proto				
8	S.OLIVER	2115323	T-SHIRT	SMS	Ok	35	35	
9	S.OLIVER	2113364	TSHIRT	Proto	Ok	9	9	OK
10	S.OLIVER	2113332	T-SHIRT	Proto	Ok	9	9	
11	S.OLIVER	2103973	SWEATSHIRT	Proto	Ok	9	9	OK
12	S.OLIVER	2103456	JACKET	SMS	Ok	35	25	OK
13	JACKWILLS	JMA221E-003	Long slv polo	DEV.	Ok	8	8	
	ZXY	AFW-W23	SWEATSHIRT	DEV	Ok	8	8	
15	ZXY	AD 2801	T-SHIRT	SMS	Ok	25	15	
16	ZXY	AD 4020	HOODIE	SMS	Ok	8	8	Ok
17	ZXY	AFM-W11	SWEATSHIRT	DEV	Ok	8	8	Ok
Grand Total=						248 Pcs	159 Pcs	81 Pcs

Table 3.2.3 Shows a daily sample production report. Buyer ZXY Style: AFM812W22 Cutting & Sewing done at 28/10/21

3.3.4 Finish garment:



Fig 3.2.4: Finished sample of S.Oliver

3.3.5 Sample submission and comments:

Sample submission date:

Comments:

Hello all,

- pls find following the proto comment.
- pls note we add the new BCI Tag in the BOM

CHANGES:

1. Take care we BCI for this article. pls do the needed.
2. we want to start now to give the BCI information latest with proto already. so dont wonder. pls note the sms should only have the "we care" tag when the sms is really done in BCI fabric. if the sms is not BCI fabric dont attach the tag.
3. I create a new fabric code for the mealnge cw 9400, pls check and advise if this is not correct as we have to update correct for the sms carelabel and later also for bulk.
4. the fabric weight has to be 330 gsm for sms.
5. the zipper tape col, the string col and the loop label colours are changed, see BOM and take care for sms.
6. we have for sms the cw 9400 and we also add the col 5978 for sms, pls note we need swatches and take care of the sms requests.
7. the herring bone tape along the hood edge inside is cancelled.
8. pls flatten the upper back hood shape to get it closer to the head. you have already often done this in the past. pls do also here for sms.
9. the main label is the wrong one, I update the BOM already take care for sms to use the correct one.

MEASUREMENT AND FITTING:

1. pls keep measures at point.
2. the neckline has to be nice symmetrical round shaped, in proto it is not nice. take care of this.

WORKMANSHIP:

1. make sure the neckline will end on same level at cf.
2. take care of a symmetrical neckline.
3. the inside tape for zipper tape covering is o.k. and can be done same for sms and later for bulk too. pl let me know if we can use the base col for this tape or if this cause minimum problems, let me soonest know so we can check how we can proceed in which colours. I already update BOM, pls check and come back to me.
4. the main label has to be clean and safe in cb centered an straight attached.
5. take care the patched pocket is symmetrical and clean attached.
6. the seam allowance of pocket should not be visible at pocket entry, pls rework and take care for sms.
7. the waistband has to be in even width all around and end on same level at cf.
8. pls let the single jersey tape end at cf and not only in cb neckline, pls take care for sms and show me a pic before you start sms.

FABRIC / ARTWORK / FINISH:

1. fabric is so far o.k. pl check if the composition is correct in BOM and let me know if I have to update something.
2. the rib fabric is also o.k. here I did not create a new fabric code for col 9400 as I need first the info from you waht is corret so I can update it correct for sms and later for bulk.

ACC / TRIMS:

1. pls follow BOM for sms.

COLOURS:

1. col 9400 is o.k
- also rib col looks o.k.
- also the top stitch col for col 9400 is o.k. on proto, pls advise me how I should update in BOM.

pls send asap the asked infor regarding the composition of shellfabric and rib fabric.
send also asap a pic of improved neck tape fixing all around till cf before you start sms.

thanks
best rgds
Zoran

3.3.6 Order 2

As per proto comments we sent buyer revise proto sample:



Fig 3.2.6: Revise buyer sample

3.3.7 Buyer Comments on Revise buyer sample:

- It approved for SMS sample

CHAPTER-4
RESULT AND DISCUSSION

4.1 Analysis of development samples for buyer C&A:

4.1.1 Order 1: We received a order of buyer C&A for the style: 2170479. Here we develop the proto sample.

We submitted the proto sample and buyer sent some comments on this proto sample.

- Buyer said If the Sample fitting is ok then it can go for GSS(Pre-production) sample.

Then we sent the Fitting/RTS sample.

4.1.2 Order 2:

For 1st RTS sample Comments type:

- Changes in measurement: Across shoulder and sleeve length measurement changed a little bit.

After correction of the sleeve length and across shoulder measurement as buyers requirement we sent 2nd Red tag/fit sample.

4.1.3 Order 3

2nd red tag sample Comments:

- Changes in vendor measurement: In this sample Across shoulder and Sleeve length measurement buyer changed again.
- Fit Comments: Approved. Buyer said overall fit is acceptable on stand.
- Workmanship: Little folded at armhole s/b improve, bottom hem little uneven s/b improve in bulk.
- Constructions: Front artwork size to be proportion as per C&A requirements.

Sample status: Sample reviewed and technically approved with improve required. Buyer said to proceed GSS with following above and commercial comments.

4.1.4 Order 4:

GSS sample submission and comments from buyer:

- Measurement: Measurement within tolerance except bring back to spec all deviated measurement points.
- Fit Comments: Overall fit is acceptable on stand.
- Constractution: Same as per tech pack.

4.1.5 Analysis of types of comments of buyer C&A style:

Table 4.1.5: Analysis of fault percentage of buyer C&A style:

Style 2170479						
Comments on	Order 1	Order 2	Order 3	Order 4	Total	%
Measurement	2	2	2	2	8	34.4%
Body			1		1	4.5%
Sleeve		1			1	4.5%
Hem			1	1	2	9.0%
Armhole	1		1	1	3	13.6%
Neck			1	1	2	9.0%
Soulder			1		1	4.5%
Artwork	1	1			2	9.0%
Colour shade	1		1		2	9.0%
Total:					22	

We analysis another 4 styles of buyer C&A. C&A buyer comments most on the measurement and fitting issue.

4.2 Analysis of development samples for buyer zxy:

4.2.1 Order 1: We received a order of buyer ZXY for the style: AFM812W22. Here we develop the proto sample of a Hoodie.

After submit the proto sample buyer did some comments on some Stitch issues

As buyer comments.

- The back neckline stitch has to end in a vertical stitch to neckline seam.
- Patched pocket has to be symmetrical.
- Fabric GSM is not ok. It has to be 330 GSM in SMS sample.
- And rib fabric part is not ok.

We analysis another 5 orders of different styles to know about the comments type.

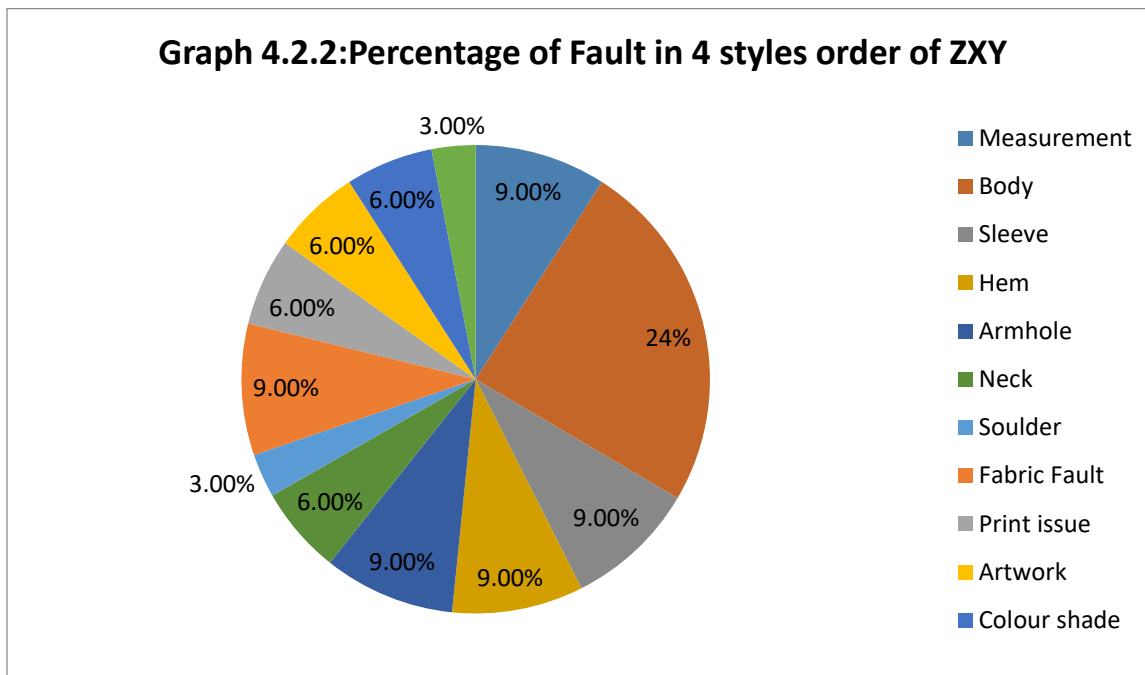
4.2.2 Analysis of types of comments of several styles of ZXY

Table 4.2.2: Types of comments of several styles of ZXY

Comparative study on Development Sample for Various Buyers

	Style 1	Style 2		Style 3		Style 4				
Comments on	Order 1	Order 1	Order 2	Order 1	Order 2	Order 1	Order 2	Order 3	Total	%
Measurement		1			1		1		3	9.0%
Body	1	1		2	1	1	1	1	8	24.2%
Sleeve	1	1		1					3	9.0%
Hem	1			1		1			3	9.0%
Armhole	1		1	1					3	9.0%
Neck	1			1			1		2	6.0%
Soulder						1			1	3.0%
Fabric Fault	1	1		1					3	9.0%
Print issue					1	1			2	6.0%
Artwork		1						1	2	6.0%
Colour shade			1				1		2	6.0%
Ironing				1					1	3.0%
Total:									33	

A graph based on the table:



Comparative study on Development Sample for Various Buyers

Graph 4.1 shows the percentage of fault of sample of 4 styles of ZXY. Here fault percentage as buyer comments in measurement is not much(9%). Fault percentage in body(24%). Buyer comments on sleeve(9.0%), Fault percentage in Hem(9.0%), In armhole fault percentage 9.0%, Neck fault percentages 6.0%, In shoulder fault percentage 9.0%. And fabric fault percentage(9.0%), Fault in print(6.0%), Artwork Fault(6.0%), Colour shade defects 6.0%.

4.3 Analysis of development samples for buyer S.Oliver:

4.3.1 Order 1: We work on a order of buyer S.Oliver of the style 210973. We work on development sample/proto sample of this style.

After submitting the proto sample buyer sent some comments on the sample about some changes Of fabric weight(GSM), Zipper tape colour, heaing bone tape, fabric colour etc

And In measurement and fittings the neckline has to be nice symentrical round shape. In proto it is not nice as buyer comments.

And some issues on Fabric artwork and finish.

4.3.2 Order 2: Revise buyer sample

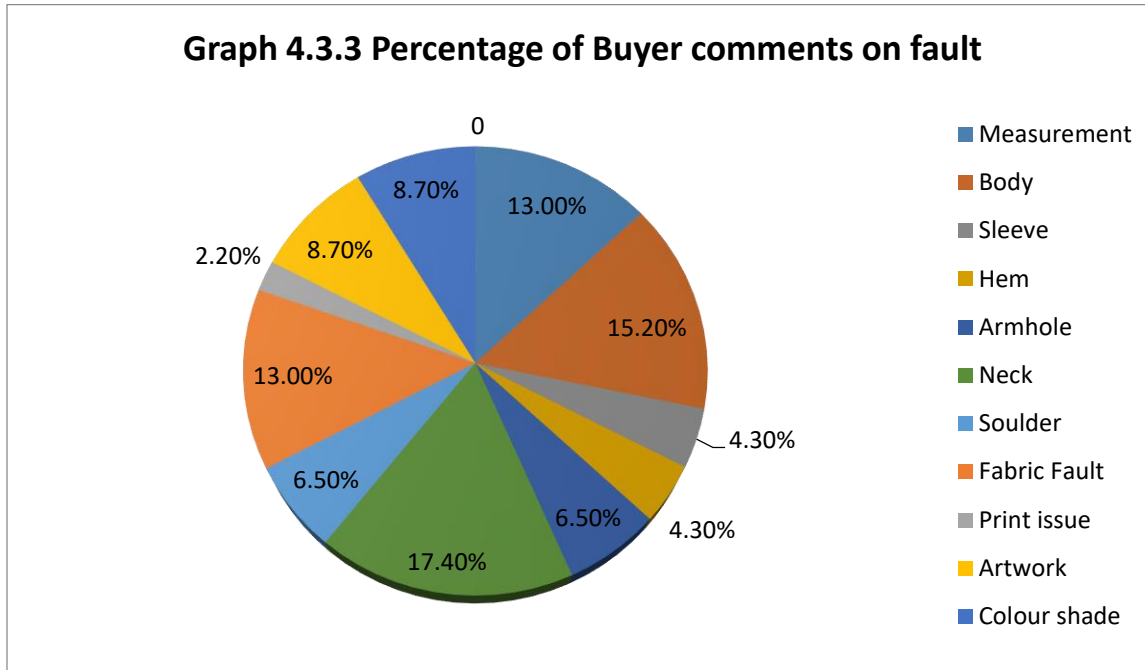
After submission of revise buyer sample sample approved for SMS sample.

4.3.3 Analysis of types of comments of several styles of S.Oliver

Table: 4.3.2: Types of comments of several styles of S.Oliver

Comments on	Style 1	style 2	Style 3			Total	%
	Order 1	Order 1	Order 1	Order 2	Order 3		
Measurement		2	1	2	1	6	13.0%
Body	3	1	2		1	7	15.2%
Sleeve		1		1		2	4.3%
Hem			1	1		2	4.3%
Armhole	1		1	1		3	6.5%
Neck	2	2	1	1	2	8	17.4%
Shoulder	1		1		1	3	6.5%
Fabric Fault	4		1	1		6	13.0%
Print issue		1				1	2.2%
Artwork	1	1			2	4	8.7%
Colour shade	1		1		2	4	8.7%
Total:						46	

A Graph based on the table:



Graph 4.3.3 shows the percentage of fault of sample of 4 styles of S.Oliver. Here fault percentage as buyer comments in measurement is (13.0%). Fault percentage in body(15.20%).Buyer comments on sleeve(4.3%), Fault percentage in Hem(4.3%), In armhole fault percentage 6.5%, Neck fault percentages 17.40%, In shoulder fault percentage 6.5%. And fabric fault percentage(13.0%), Fault in print(2.20%), Artwork Fault(8.70%), Colour shade defects 8.70%.

We observe the develop sample activity of several styles of buyer C&A, ZXY, S.Oliver.

And we found different types of activities of these buyers.

4.3.4 Analysis of Different types of changes of buyer C&A, S.Oliver, ZXY:

Table 4.3.4: Analysis of Different types of changes of buyer C&A, S.Oliver, ZXY:

Types	Buyer C&A	Buyer ZXY	Buyer S.Oliver
Fabrication	Generally fabric used 100% Cotton Single jersey, 160 GSM	Loop Back Terry, Brush back fleese- 330 GSM, 350 GSM, Single jersey 140 Gsm, 140 Gsm	Brush back fleese, Loop back terry 320, 330 GSM, 400 GSM rib

Comparative study on Development Sample for Various Buyers

Revise Comments	Mainly buyer do comments on measurements, Fitting issue	Buyer comments mainly on artwork, fabrication, print, design.	All types of comment buyer do like measurement issue, accessories, Fabrication, Neck, shoulder, armhole, print
Sample stages	<ol style="list-style-type: none"> 1. Proto sample 2. Fit/Red tag sample 3. Test sample 4. GSS sample 	<ol style="list-style-type: none"> 1. Proto/dev. Sample 2. SMS Sample 	<ol style="list-style-type: none"> 1. Proto sample 2. SMS sample 3. Fit sample 4. Seal sample
Accessories	Accessories not much used. Mainly woven level, sample card used.	Woven lebel, hang tag, strings, stickers are used in sample	All types of accessories used like Woven label, Carelabel, Sizelabel, Hangtag, Country lable all are used.

CHAPTER - 5
CONCLUSION

5.1 Conclusion:

The project was about on different types of buyers variation on sample development, Their requirements, sampling stages, fabrication, revise comments all about. We found the idea about buyers ordersheet, Fabrication, develop a sample in first stage, and how to make buyer approval of these sample for production.

This report is concluded as,

- For the buyer C&A it has been observe that buyer want the fit sample mainly and comments mostly on measurement. And accessories is very less.
- For ZXY buyer it has been observed that buyer comments mainly on artwork, fabrication, print, design. And 330,350 GSM of fabric used most in garment.
- For buyer S.Oliver it has been observed that all types of accessories is needed. Buyer do comments of proto stages but give the approval for SMS sample.
- It has been observed from the buyer C&A, ZXY & S.oliver that their fabrication, accessories requirements, sampling stages and comments variations all are different.
- By analyzing the sampling comments it has been observe that C&A buyer mostly comment on measurement issue which is up to 34%, Buyer Zxy sample comments mostly on sample body(24.2%) and Buyer S. Oliver mostly comments on Fabrication(13%),Neck measurement(17%), Measurement (13%), body(15.2%).

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1. <https://fashion2apparel.blogspot.com/2018/09/role-merchandiser-product-development.html>
2. <https://textileapex.blogspot.com/2014/10/sample-types.html?m=0>
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