Faculty of Engineering

Department of Textile Engineering

REPORT ON

Study on Different Types of Sewing Faults and Their Remedies

Course Title: Project (Thesis)
Course Code: TE-4214

Submitted By

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

Advance in Apparel Manufacturing Technology
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Letter of Approval

10-05-2021

To

The Head

Department of Textile Engineering

Daffodil International University

102, Shukrabad, Mirpur Road, Dhaka 1207

Subject: Approval of Project Report of B.Sc. In TE

Dear Sir,

I'm simply writing to tell you this task report named as study on Different kind of sewing flaws and their cures has been set up without help from anyone else bearing Md. Nahiyan khan ID:182-23-493 and Md. Emran Howlader ID:182-23-494 is finished for conclusive assessment. The entire report is arranged dependent on the legitimate examination and interference through basic investigation of observational information with required effects, I was straightforwardly engaged with my venture exercises and the report become fundamental to start of numerous important data for the peruses. Therefor it will exceptionally be valued on the off chance that you compassionately acknowledge this modern connection report and consider in for conclusive assessment.

Abdullah Al Mamun

Assistant Professor

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ACKNOWLEDGEMENT

Most importantly, first I because of Almighty Allah who give me capacity and ability to finish this postulation and examination work. With truthfulness, I expand my warm and profound appreciation and appreciation to my supervisor, Abdullah Al Mamun , Assistant Professor, Department of Textile Engineering of Daffodil International University for his direction and backing to think of this examination work. Been working with him, I have procured significant information, but on the other hand was motivated by his imaginativeness which assisted with improving my experience undeniably. His thoughts and method of working was genuinely momentous. I accept that this exploration couldn't be done in the event that he didn't help me consistently.

we might want to offer our heartiest thanks to 'Prof. Dr. Engr. MD. Mominur rahaman, Head of the

Office, Textile Engineering of Daffodil International University' for his thoughtful assistance to complete my venture and furthermore to other employees and the staffs of 'TE Department of Daffodil International University'.

I might want to thank our whole course mate in Daffodil International University, who participated in this talk about while finishing the course work.

The help and support delivered by, "HOP LUN BD." Stuffs and 'Muaz Hossain, IE Executive in Hop lun LTD' were essential in the culmination of this venture, their direction and consolation assumed a critical part in the arranging and finish of this task.

At last, I offer our earnest thanks to my folks for their consistent help, thoughts and love during my investigation.

DEDICATION

From the start we need to devote this report to Almighty Allah (ALHAMDULILLAH) for offering me the chance to substantiate myself. Without His assistance nothing would be conceivable. I likewise commit this report to my regarded instructors and adored guardians.

DECLARATION

We therefore proclaim that, this report has been done under the manager of Abdullah Al Mamun, Assistant Professor, Department of Textile, Daffodil International University. I likewise proclaim that neither this temporary position report nor any piece of this temporary job report has been submitted somewhere else for grant of any degree.

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ABSTRACT

This venture is 'Study on quality control in sewing segment of Hop Lun BD Garment fabricating is very not quite the same as some other ordinary assembling. It's anything but a persistent creation strategy. Each style is an alternate item that requires an alternate kind of texture, shading, catches, string, and so forth Sewing measure is perhaps the main stages in labor escalated instant apparel endeavors. Quality flaws happening during this interaction antagonistically influence the item quality and item proficiency, and furthermore increment the creation cost. The point of this examination is to explore whether the woven creation measure is leveled out in a woven creation endeavor and to identify the cycles with the most elevated paces of sewing flaws in sewing division lastly to make ideas for improving the quality control. Additionally, the cycles with most elevated measures of sewing flaws and the impacts of these cycles on deficiency rates were explored. Stopping point Inspection Report on the 10 days I recognize 792 pieces blames out of 15994 pieces examined articles of clothing missing, incorrectly situation, Broken stich, skip, lopsided, whole free treat, Raw edge, Puckering, High low, other deformity and so on shortcomings are found by investigation of articles of clothing in the sewing area. Whole free string is the serious issue in the sewing segment. Normal of Uncut free string 32%. At long last, I have discovered various kinds of sewing flaws by Sewing machine and administrator. I'm additionally referencing solutions for explicit reasons which all are remembered for this task report. I likewise incorporated some end line investigation report of "Hop LUN BD.".

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Chapter-1
Introduction

1.1 Background of the Study

The greatest and the most fundamental section in a piece of clothing industry is its sewing fragment. In this portion, every single sewing machine and occupations of machine overseers should be evaluated on an ordinary justification perceiving, modifying and controlling of blemishes and keeping up nature of things. To ensure the idea of the thing, quality control personnel need to control quality in a substitute region in garment industry, which are explicitly or indirectly needed with creation. Quality is the qualification between things. It is the honesty or unpleasantness in a thing. This definition stays steady till this date. The Garment furthermore expects to be a fundamental part in the overall population. For make incredible piece of clothing we need to keep up quality and quality depends after sewing game-plan of garment.

1.2 Objectives of the Study

- To think about legitimate quality administration framework.
- To make new technique for quality control.
- To realize how to examine an article of clothing adequately and proficiently.
- To distinguish the reasons for sewing blame and tackle this.
- To execute specialized arrangements toward string deserts.
- To show how specialized ability can build creation effectiveness.
- To limit sewing shortcoming from pieces of clothing.
- To improve nature of articles of clothing.

1.3 Importance of the Study

In this unit we can save our coast. This article explains the explanations behind sewing deficiencies in moment garments. Sewing deficiencies are an issue commonly looked by garment makers. Notwithstanding it being an outstandingly essential issue, it is amazingly difficult to discard it completely. A couple of parts of the sewing imperfection course of action, its causes, and affirmation and fixes are discussed in this article. The maker saw that it is incredibly difficult to get rid of defects completely. The requests if the level of a fault is satisfactory relies generally upon the kind of piece of clothing, space of the wrinkle, appearance. Quality blemishes occurring in the midst of this technique horribly impact the thing quality and thing capability, and moreover increase the age cost. The mark of the assessment is to explore how to control quality in garment age and make recommendations for improving the quality control. By this assessment,

we gave the idea that the assessment of each quality control cycle would make an important obligation to make a quality garment and prepare more convincing in the change plans.

Regardless, decline in sewing weaknesses will reliably be welcomed and would be a crucial point in the widespread publicizing of moment pieces of clothing.

1.4 Limitations of the Study

During the examination I had confronted the accompanying constraint:

o Limitation of time to investigate this point: Publication of this field not accessible and there were no association or office for keeping up legitimate data about the organization.

o Respondent reluctance: Some respondents were reluctant to react due to keeping up mystery about the organization.

o Input and yield issue.

o Lack of precise information: Respondents were reluctant to uncover their deficiency and quality check information. Along these lines, this sort of information utilized in this report isn't excessively legitimate.

o There is no extraordinary preparing division for study. o Changing the style and plan. o Shortage of time: At least eight months needed for consummation of the last report, however we have allowed just three months. So to secure a tremendous information, it is the main impediment for me.

Chapter- 2
Literature Survey

2.1 Sewing

The fundamental cycle of sewing includes affixing of textures, calfskin, hides or comparative other adaptable materials with the assistance of needle and strings. Sewing is basically used to produce garments and home goods. Truth be told, sewing is one of the significant cycles in clothing making. The majority of such mechanical sewing is finished by modern sewing machines. The cut bits of a piece of clothing are for the most part attached, or briefly sewed at the underlying stage. layers of the material and interlocks the string.

Figure 2. 1: Sewing Machine

2.2 Sewing Machine:

A sewing machine is a mechanical or electromechanical gadget outfitted with a needle (or needles) strung at the point-end, which cut the texture occasionally as it moves under the needle. Each line is made as the string circles onto itself (chain join) or bolts around a second strand of string (lock line), sewing the textures together.

Sewing machines are utilized in both the home and industry, however are planned distinctively for each setting. Those for the home will in general be more adaptable as far as the number and sorts of lines they can perform, however they work more gradually than mechanical machines, and have a more limited life expectancy. Mechanical machines are heavier, have an any longer life expectancy, are fit for a huge number of lines per inch, and might be intended for extremely specific assignments.

Figure 2. 2: Bar tack m/c

2.3 History of Sewing Machine:

Sewing is viewed as a workmanship for over 20.000 years, the principal needles being imagined in the XIV century, and later on in 1790 sewing by hand was supplanted by the sewing machines. The sewing machine is a perplexing gadget which gatherings at least two bits of texture together by sewing them and is typically utilized in apparel producing.

English Thomas Saint was the innovator of the idea of a sewing machine, however it isn't sure in the event that he was additionally the person who planned the principal model of the sewing machine. His work appeared to be only an endeavor of making it, however never figured out how to do as such.

The main working sewing machine was made by the French tailor Barthelemy Thimonnier, however the outcome didn't carry acclaim to him due to a gathering of tailors who torched the processing plant. Their conviction was that the sewing machine will leave them jobless and they will not have additional orders coming in at their tailor shops.

In 1834, Walter Hunt made the principal American sewing machine, yet he additionally didn't have any achievement in light of the assumption that machines cause joblessness in discount dress creation.

The primary really effective sewing machine was brought into consideration in 1850, when Isaac Singer tracked down an old sewing machine and restored it in just 11 days, making it the first economically recognized
sewing machine. Vocalist's machine was unique in relation to different ones since he supplanted the haggle with a pedal.

Beginning with 1858, the Singer brand sold 3.000 pieces every year, and in 1863 the deals went over 20.000 units. The year 1873 imprints the principal creation line in Canada and in 1889 their deals went up to 500.000 units, after 23 years, in 1903 they were recording deals of 1.305.000 units each year.

Today, unique brand sewing machines are accessible in market and they foster this machine step by step.

2.4 Types of Sewing Machine:

As per working framework there are two kinds of sewing machines are accessible in the clothing business. They are given underneath:

A. Manually worked sewing m/c

B. Electrically worked sewing m/c

Different kinds of Industrial sewing machines named are given beneath

- Bar tack sewing m/c (with programmed string trimmer)
- Button appending machine
- Button opening sewing m/c (for sew texture)
- Chain line sewing machine
- Collar and sleeve turning and hindering machine
- Double chain fasten m/c
- Double chain fasten sewing m/c (4-needle versatile embeddings m/c)
- Double chain fasten sewing machine (4-needle short)
- Interlock m/c (twin needle, 5-string over lock m/c)
- Label/versatile embeddings machine
- Lock fasten m/c (1-niddle with vertical trimmer wiper and opposite feed)

- Lock fasten m/c (2-needle with spilt needle bar sewing)
- Lock fasten m/c (single needle sewing m/c)
- Lock join m/c (single needle with programmed string trimmer)
- Over edging machine
- Over lock m/c (1-needle, 3-string)
- Over lock/Over edge sewing m/c (twin needle, 4-string m/c)
- Automatic multi-needle shirring machine
- Top and base cover join level lock machine (chamber bed and flatbed)

Figure 2. 3: plain sewing m/c

Figure 2. 4 : Bartack m/c

Figure 2. 5: Flat lock m/c

2.5 Defects in Apparel:

Prior to showcasing clothing producing is the last phase of assembling. Imperfection less items are more adequate to the purchaser. Therefore maker ought to know about deformity of item. In this each phase of assembling different sorts of mix-ups can be happened.

Deformity of clothing can be characterized as the shortfall of wanted highlights in the item or undesirable component in items. Defectives items lose its worth on the lookout. An item may contain various deformities. Another terms close to desert is called reject. An item turns into an oddball when it loses its soundness on the lookout. Dismissal of pieces of clothing is destructive for the makers. A solitary imperfection in the most noticeable space of an article of clothing may make it reject.

2.6 Types of defects:

As indicated by the articles of clothing workmanship and appearance pieces of clothing abandons are isolated in the three different ways a. Basic imperfections

b. Major surrenders

c. Minor surrenders

Reasons for abandons: There are two primary driver of imperfections

a. Non sewing surrenders

b. Sewing absconds

Deformities may happen in pieces of clothing industry delivered on mass scale. The wellsprings of imperfections are given beneath:

2.7 Non-sewing defects:

1. Defects due to interlining by wrong example making.
2. Defects because of wrong cutting of the texture.
3. Defects because of wrong stamping and wrong spreading measure.
4. Defects because of low treatment of merchandise.
5. Defects because of oil marks.
6. Defects because of wrong pressing.
7. Defects because of lopsided collapsing.
8. Defects because of helpless pressing.

2.8 Sewing defects

Sewing deformity can be delegated three Groups.

a. Stitch development issue.

b. Problem of crease pucker.

c. Fabric harm including the crease line/join line.

2.9 Problems of stitch formation:

1. Skip Stitch
2. Thread Breakage
3. Joint stich
4. Uneven stich
5. Broken stich
6. Open seam
7. Oil spot
8. Seam puckering
9. Joint uneven
10. Raw edge problem
11. Needle mark

1. Skip stitch:

Stitches in the crease are available in a standard shrewd. In the event that the interloping or interweaving between top and base string of line isn't occur or missed is known as skipped line. This is more hurtful if there should be an occurrence of chain join than lock stitch

Figure 2. 6: Skip Stich

Causes-

Failure of snare or looper and needle to enter circle at amazing time.

- Uneven string pressure on upper or lower circle.
- Due to needle evolving.
- If needle string circle size is excessively minuscule.

Remedies-

Observe the setting and timing among needle and snare or lopper.

- Adjusting the strain of string.
- Needle ought to be changed on schedule.
- Adjusting needle size and string size

2. Uncut loose thread:

Additional thread or free thread on crease line which called whole free thread.

Figure 2. 7: Uncut loose thread

Causes:

It occur because of inappropriate managing or wrapping up.

Due to sewing additional string remittance.

Remedies:

- Garments finishing should be well checked.
- Need to use sewing thread properly.

3. Joint Stitch:

At the point when joint two texture or fix line by sewing than have a line point that spot sewing is start and end of sewing. At some point this joint point isn't uniform that is called joint line deserts.

Figure 2. 8: Join stich

Causes:

- Lack of experience of workers.
- Lack of concentration of worker.
- Sometimes for the machine maintain problem.

Remedies:

- Seam is open and sewing process correctly.
- In case machine measurement problem then solve it.

4. Uneven Stitch:

In the event that any crease line isn't uniform and two line of join are not to be customary or genuine estimation are absent in the articles of clothing crease that called Uneven Stitch.

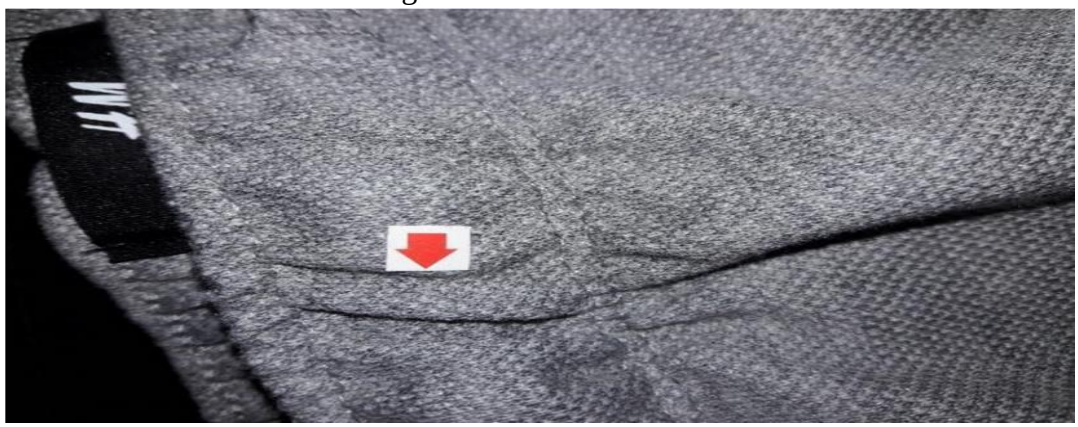


Figure 2. 9: uneven stich

Causes:

- Due to the shortfall of association or union of subject matter expert.
- At some point for the machine issue.

Remedies:

- Seam is open and sewing again correctly.
- If machine assessment issue by then tackle it.

5. Broken Stitch:

In case any line are broken in the wake of sewing, it known as broken line.

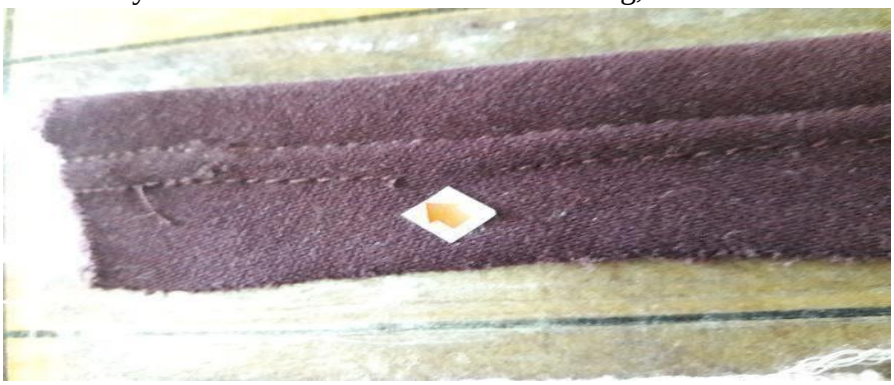


Figure 2. 10: broken stich

Causes:

- For using awful quality string.
- High string strain.
- Garments Washing strategy.
- Seam frustration issue.

Remedies:

- Using admirably quality sewing string.
- Maintain great sewing Process.
- Monitor the washing interaction, process durations, and temperatures.

6. Open Seam:

In the occasion that wrinkle line is open or lose the wrinkle and missing the attach in the wake of sewing measure that called Open wrinkle. It's a huge sewing distortion.

Figure 2. 11: Open seam

Causes:

- Failure of needle to enter circle.
- Needle diversion issue.
- Thread circle missing.
- Wrong sewing pressure in the needle.
- It's fundamentally mechanical issue.

Remedies:

- Check needles is embedded and adjusted appropriately Replace the needle.
- Reset the string strain.
- Re change in accordance with standard and check circle arrangement through run component.

7. Oil Spot:

At the point when the spot of oil and wax are found on the texture surface are called oil spot.

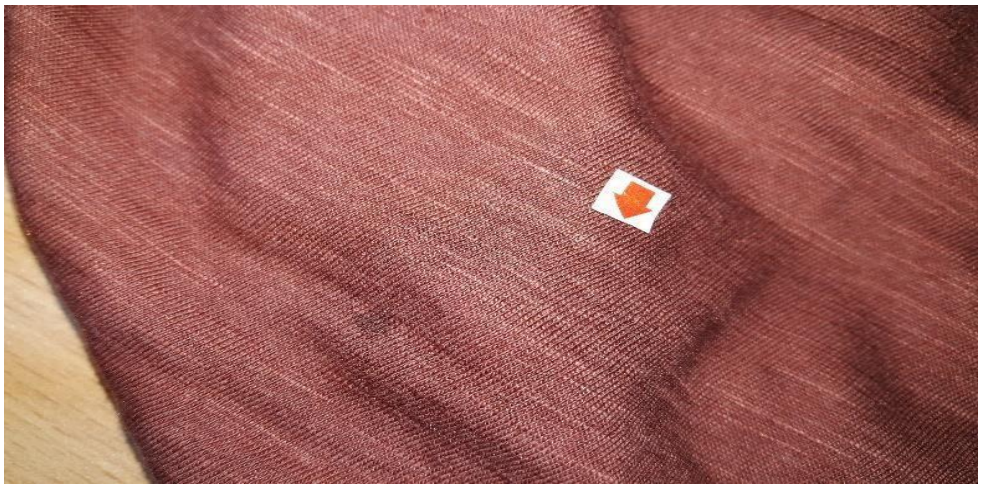


Figure 2. 12: Oil spot

Causes:

During sewing measure if oil and wax are store from the machine to the texture surface at that point oil spot is happened. It's making an unfear spot picture on the texture surface.

Remedies : Oil spot is taken out from the texture by an uncommon kind of splash named 'Spot lifter'. First its shower on the spot and afterward air passed up a machine named 'spot cleaning machine'.

8. Seam Puckering:

Wrinkle puckering is essential issue on woven or weaves surface. Wrinkle puckering notice to the get-together of a wrinkle during or resulting to washing, causing not real wrinkle appearance.

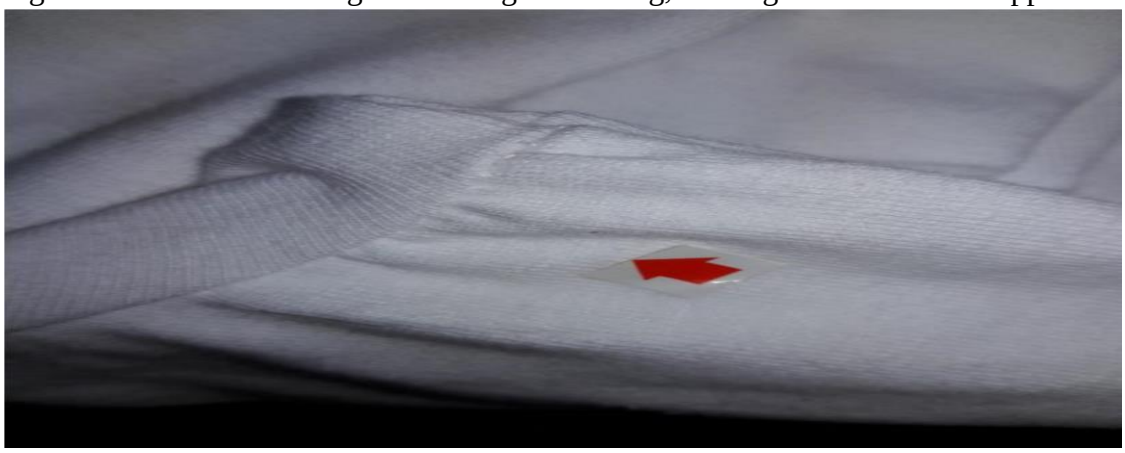


Figure 2. 13: Seam puckering

Causes:

- Spreading of sewing string.
- Construction of texture.
- Uneven designs.
- Shrinking sewing strings.

Remedies:

- Proper feed system ought to be utilized with equivalent handle stretch.
- Fabric shrinkage precisely should be practically comparable.
- Fabric and sewing string shrinkage presentence ought to be equivalent.
- Using less pressure to the string.

.9. Joint Uneven:

In the event that the all joint of the articles of clothing in sewing isn't comparable. Like imperfections in shoulder joint of pieces of clothing, deserts in Sleeve joint of pieces of clothing, surrenders in Neck Rib Joint and Curve at side Seam, Top fasten of pieces of clothing , absconds in Make of pieces of clothing and Collar

Joint Top sine, abandons in Shoulder to Shoulder Back Tape of pieces of clothing and so on

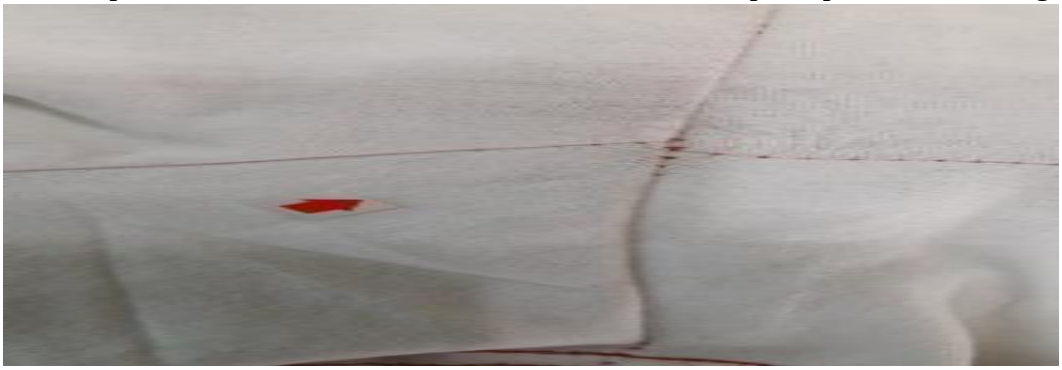


Figure 2. 14: Joint uneven

Causes:

- For the absence of involvement or convergence of specialist.
- Sometime for the machine look after issue.

Remedies:

Seam open and sewing again accurately.

If machine estimation issue at that point address it.

10. Raw Edge Problem:

Assuming unforeseen parts are appeared by the articles of clothing from sewing region, this issue is happened that called Raw edge issue.

Figure 2. 15: Raw edge

Causes:

- For the lack of experience or concentration of worker.

Remedies:

- The unexpected part is cut out precisely.
- Seam Open and Clear that part and sewing again.

11. Needle Mark:

Without sewing necessity assuming give the sewing at piece of clothing of texture, open the sewing however close up needle opening at the texture that called Needle mark.

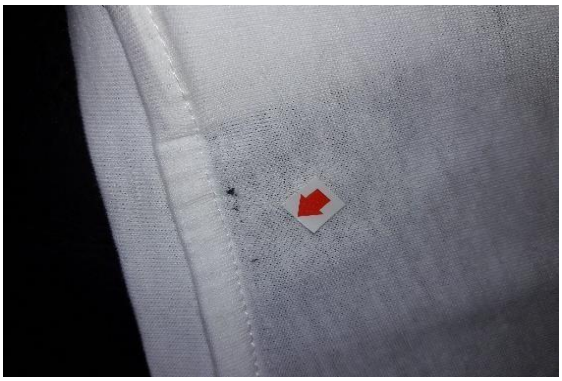


Figure 2. 16 Needle Mark

Causes:

•For lopsided line or any lopsided crease need to uniform at that point open that join or crease after that making this Needle mark.

•For the absence of involvement or consideration of laborer.

Remedies:

- To fix any sorts of sewing flaws.
- To pressing at great temperature and uniform.

Chapter-3
DATA ANALYSIS & PRESENTATION

3.1 Data Collection

I for one accumulate data on the sewing issues from the sewing area. There are an excessive number of lines in Hop lun LTD From these lines I go after 40 no sewing lines and accumulate some information measure of garments, buyer name, style no. of garments, no. of manager, All data are given which I found in sewing floor of Hop lun LTD

3.2 Data Analysis

In this part I appended data of sewing issue that I get from 40 sewing line of Hop lun LTD I show up here some significant information and sewing deficiencies like wrong position, crude edge, missing, whole free string and so on I'm attempting to discover the flaws actually and note down the data in a data table. Here is it which is so much useful to

3.3 Attachment of sewing report

Line inspection report 1

LINE (40) in Hoplun BD

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line

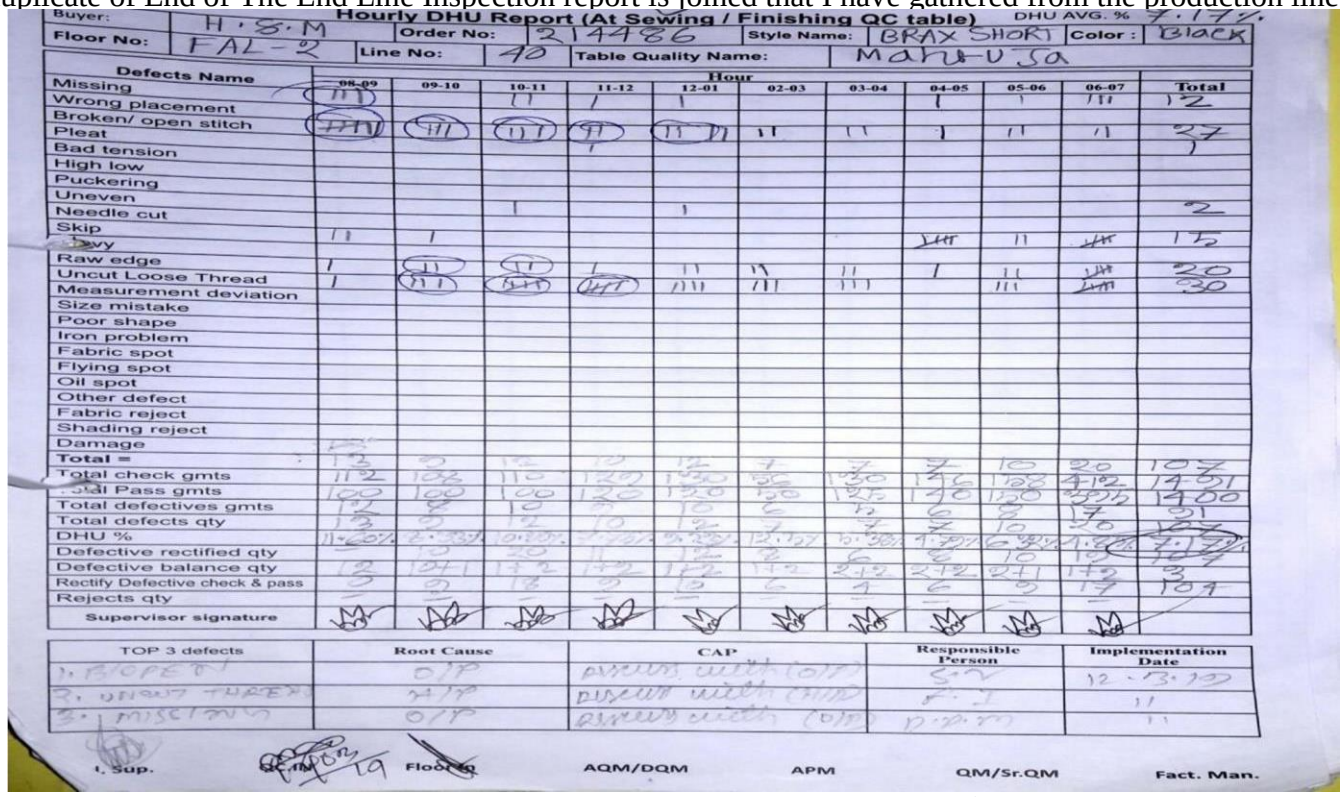


Figure 3. 1: Report on sewing section 1

100% End of the Line Inspection Report in Sewing Section 12/03/**2021**

Table 3. 1: Line inspection report 1

Hop Lun BD

DAILY END-LINE INSPECTION REPORT

Date: 12-03-2021 Order No: 331324 Color: Black

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing	3		2	1	1			1	1	3	12
Wrong placement											
Broken/ open stich	5	3	3	2	4	2	2	1	2	2	27
Pleat				1							1
Bad tension											
High low											
Puckering											

Uneven			1		1						2
Needle cut											
Skip	2	1						4	2	4	15
Wavy											
Raw edge	1	2	2	1	2	2	2	1	2	4	20
Uncut loose thread	1	3	4	4	4	3	3		3	5	30
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	13	9	12	10	12	7	7	7	10	20	107
Total check gmts	112	108	110	129	130	56	130	146	158	412	1491
Total pass gmts	100	100	100	120	120	50	125	140	150	395	1400
Total defectives gmts	12	8	10	9	10	6	5	6	8	17	91
Total Defects qty	13	9	12	10	12	7	7	7	10	20	107
DHU%	11.60 %	8.33 %	10.20 %	7.75 %	9.23 %	12.5 %	5.38 %	4.79 %	6.32 %	4.85 %	**7.17 %**
Defective rectified qty	_	10	20	11	12	8	6	8	10	19	**107**
Defective balance qty	12	10+1	1+2	1+2	1+2	1+2	2+2	2+2	2+1	1+2	**3**

Rectify defective check & pass	0	9	18	9	10	6	4	6	9	17	**104**
Rejecty	–	–	–	–	–	–	–	–	–	–	–

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 7.17\%$$

1st Highest Defects = Uncut loose treat 30pcs

2nd Highest Defects = Broken stich 27pcs

3rd Highest Defects = raw edge 20pcs

Total Pieces checked =1491

Total Defects =91

Here, at line (40) my perception date was 12/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 laborer with 13 assistant and 2 quality control administrator. I saw that line from 8-9am and they checked 112pcs of pieces of clothing and there was absolute 12 deformities.

Like thusly, complete 1491pcs of articles of clothing checked in 10hours perception. Here I completely discovered 91 laptops of inadequate articles of clothing and there is no dismissal.

Here, the list of defects below I found at line (40):

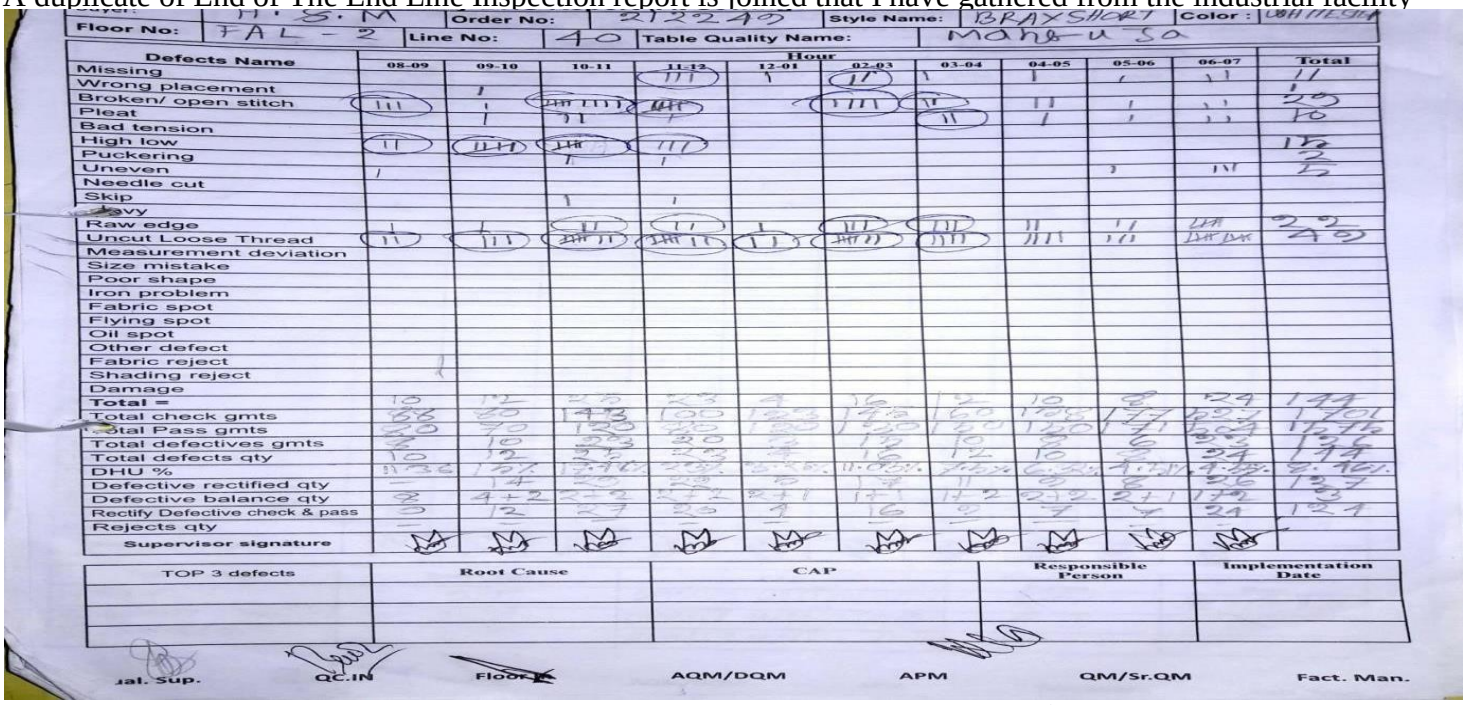
- Missing=13
- Broken stich=5
- Uneven=1
- Skip=18
- Raw edge=13
- Uncut loose treat=31

3.4 Attachment of sewing report

Line inspection report 2

LINE (40) in Hop LUN BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the industrial facility



Floor No:	FAL - 2	Line No:	40	Table Quality Name:	Mahsu Sa	Style Name:	BRAYSHORT	Color :	[illegible]

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing				III	1	II	1	1	1	II	11
Wrong placement		1									1
Broken/ open stitch	III	1	IIII IIII	IIII		IIII	II	II	1	II	29
Pleat		1	II	1			II	1	1	II	10
Bad tension											
High low	II	IIII	IIII	III							15
Puckering			1	1							2
Uneven	1								1	III	5
Needle cut											
Skip			1	1							
Slavy											
Raw edge	1	1	II	II	1	III	III	II	II	IIII	22
Uncut Loose Thread	II	III	IIII II	IIII II	II	IIII II	IIII	IIII	III	IIII IIII	49
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	10	12	25	23	4	16	12	10	8	24	144
Total check gmts	88	80	143	100	133	145	160	128	177	627	1701
Total Pass gmts	80	70	120	80	129	130	150	120	171	604	1576
Total defectives gmts	8	10	23	20	3	15	10	8	6	23	126
Total defects qty	10	12	25	23	4	16	12	10	8	24	144
DHU %	11.36	15%	17.46%	23%	3.25%	11.03%	7.5%	6.25%	4.51%	4.55%	8.46%
Defective rectified qty	—	14	29	22	5	17	11	9	8	26	127
Defective balance qty	8	4+2	2+2	2+2	2+1	1+1	1+2	2+2	2+1	1+2	3
Rectify Defective check & pass	9	12	27	20	4	16	9	7	7	24	124
Rejects qty	—	—	—	—	—	—	—	—	—	—	
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date

Jal. Sup. QC.IN Floor IN AQM/DQM APM QM/Sr.QM Fact. Man.

Figure 3. 2: Report on sewing section 2

100% End of the Line Inspection Report in Sewing Section 13/03/2021

Table 3. 2: Line inspection report 2

Hop Lun BD

DAILY END-LINE INSPECTION REPORT

Date: 13-03-2019 Order No: 212249 Color: White

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing				3	1	2	1	1	1	2	11
Wrong placement		1									1
Broken/ open stich	3	1	9	5		4	2	2	1	2	29
Pleat		1	2	1			2	1	1	2	10
Bad tension											
High low	2	5	4	3							15
Puckering			1	1							2
Uneven	1								1	3	5

Needle cut											
Skip			1	1							
Wavy											
Raw edge	1	1	2	2	1	3	3	2	2	5	22
Uncut loose thread	2	3	7	7	2	7	4	4	3	10	49
Measurement t deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	10	12	25	23	4	16	12	10	8	24	144
Total check gmts	88	80	143	100	123	145	160	158	177	527	1701
Total pass gmts	80	70	120	80	120	130	150	150	171	504	1575
Total defectives gmts	8	10	23	20	3	15	10	8	6	23	126
Total Defects qty	10	12	25	23	4	16	12	10	8	24	140
DHU%	11.36 %	15 %	17.46 %	23 %	3.28 %	11.03 %	7.5 %	6.32 %	4.51 %	4.55 %	**8.46 %**
Defective rectified qty	_	14	29	22	5	17	11	9	8	26	**127**
Defective balance qty	8	4+2	2+2	2+2	2+1	1+1	1+2	2+2	2+1	1+2	**3**
Rectify defective check & pass	0	12	27	20	4	16	9	7	7	24	**124**

Rejecty	–	–	–	–	–	–	–	–	–	–	–

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 8.46\%$$

first Highest Defects = Uncut free treat 49pcs
second Highest Defects = Broken stich 29pcs third Highest Defects = Raw edge 22pcs
Absolute Pieces checked =1701
All out Defects =126

• Here, at line (40) my discernment date was 13/03/21.At this time the buyer was H and M. The thing was BRAX SHORT. In this line there was 18 worker with 13 accomplice and 2 quality control executive. I saw that line from 8-9am and they checked 88pcs of garments and there was supreme 8 defects.

Like subsequently, supreme 1701pcs of garments checked in 10hours discernment. Here I totally found 126 PCs of lacking pieces of clothing and there is no dismissal.Here, the rundown of imperfections underneath I found at line (40):

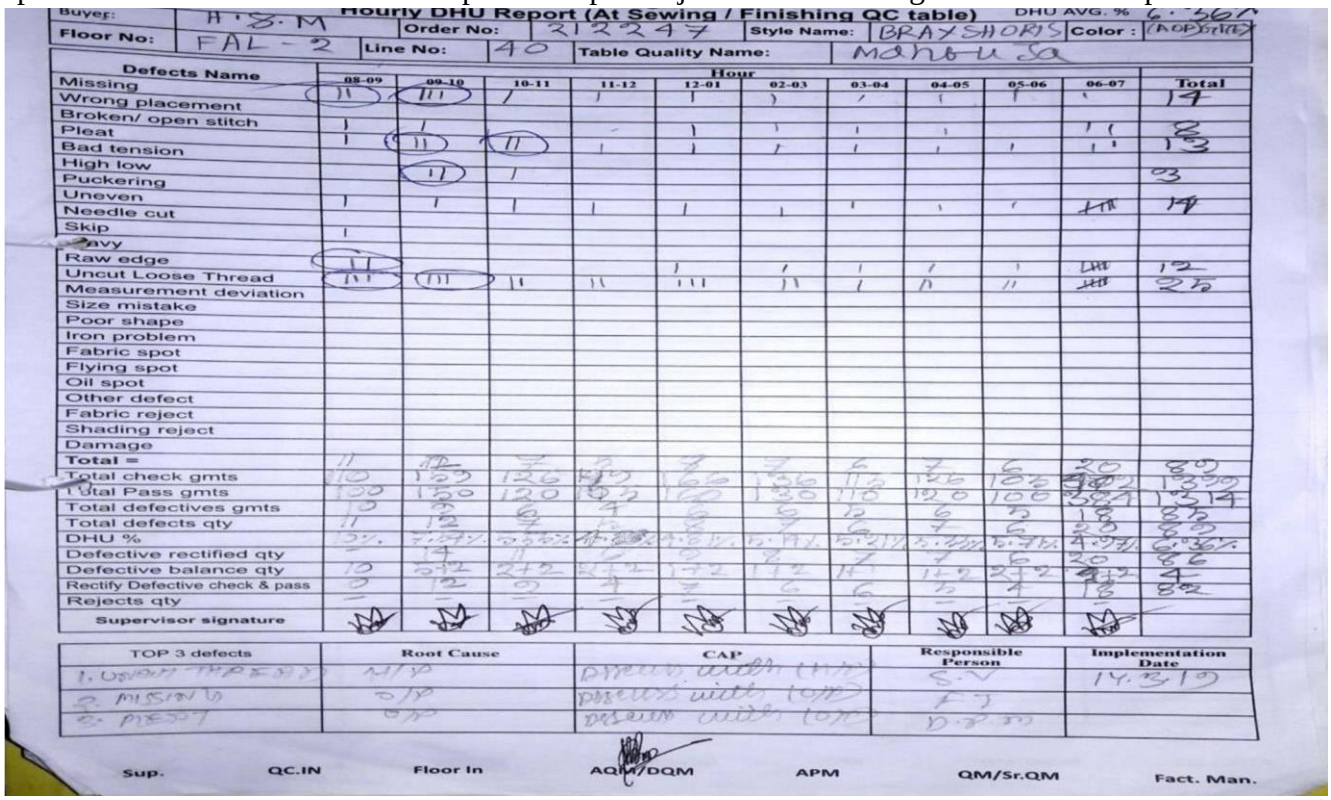
- High low=15
- Puckering=2
- Uneven=5
- Raw edge=22
- Uncut loose treat=49
- Missing=11
- Wrong placement=1
- Broken stich=29
- Pleat=10

3.5 Attachment of sewing report

Line inspection report 3

LINE (40) in Hop Lun BD

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table)

Buyer:	H&M			Order No:	212247	Style Name:	BRAYSHORTS	Color :	
Floor No:	FAL - 2	Line No:	40	Table Quality Name:	Manobu Sa				

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing	II	III	I	I	I	)	/	I	I	'	14
Wrong placement											
Broken/ open stitch	I	I									
Pleat	I	II	II		I	I	I	I		I (	8
Bad tension				I	I	I	I	I	I	I '	13
High low		II	I								03
Puckering											
Uneven	I	I	I	I	I	I	'	'	'	+II	14
Needle cut	I										
Skip											
Navy											
Raw edge	II										
Uncut Loose Thread	III	III	II	II	III	II	I	II	II	+++	25
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	11									20	
Total check gmts	120	120	126								
Total Pass gmts	100	120	120								
Total defectives gmts	20										
Total defects qty	11	12									
DHU %											
Defective rectified qty											
Defective balance qty											
Rectify Defective check & pass											
Rejects qty											
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. USIDE THREAD	M/P	DIScuss with (M/P)	S.V	14.3.21
2. MISSING	O/P	DIScuss with (O/P)	F.J	
3. PUCKER	O/P	DIScuss with (O/P)	D.F.J	

Sup. QC.IN Floor In AQM/DQM APM QM/Sr.QM Fact. Man.

Figure 3. 3: Report on sewing section 3

100% End of the Line Inspection Report in Sewing Section 14/03/2021

Table 3. 3: Line inspection report 3

Hop Lun BD

DAILY END-LINE INSPECTION REPORT

Date: 14-03-2019 Order No: 212247 Color: (AOP) Gray

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing	2	3	1	1	1	1	1	1	1	1	14
Wrong placement											
Broken/ open stich	1	1			1	1	1	1		2	8
Pleat	1	2	2	1	1	1	1	1	1	2	13
Bad tension											
High low		2	1								3
Puckering	1	1	1	1	1	1	1	1	1	3	14
Uneven											
Needle cut											
Skip	1										

Wavy											
Raw edge	2				1	1	1	1	1	4	123
Uncut loose thread	3	3	2	2	3	3	1	2	2	4	25
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	11	12	7	5	8	7	6	7	6	20	89
Total check gmts	110	159	126	199	166	136	115	126	105	402	1399
Total pass gmts	100	150	120	105	160	130	110	120	100	384	1314
Total defectives gmts	10	9	6	4	6	6	5	6	5	18	85
Total Defects qty	11	12	7	5	8	7	6	7	6	20	89
DHU%	10 %	7.59 %	5.55 %	4.56 %	4.81 %	5.14 %	5.21 %	5.55 %	5.71 %	4.97 %	**6.36 %**
Defective rectified qty	_	14	11	6	9	8	7	7	6	20	**86**
Defective balance qty	10	5+2	2+2	2+2	1+2	1+2	1+1	1+2	2+2	1+2	**4**
Rectify defective check & pass	0	12	9	4	7	6	6	5	4	18	**82**
Reject	_	_	_	_	_	_	_	_	_	_	**_**

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{} \right) \times 100 = 6.36\%$$

Total no of checked products

1st Highest Defect s= Uncut loose treat 25pcs

2nd Highest Defects= Missing 14pcs 3rd

Highest Defects = Uneven 14pcs

Total Pieces checked =1399

Total Defects =85

• Here, at line (40) my perception date was 14/03/19.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 partner and 2 quality control administrator. I saw that line from 8-9am and they checked 110pcs of pieces of clothing and there was complete 10 imperfections.

Like along these lines, absolute 1399pcs of pieces of clothing checked in 10hours perception. Here I completely discovered 85 laptops of flawed pieces of clothing and there is no dismissal.

Here, the rundown of deformities underneath I found at line (40):

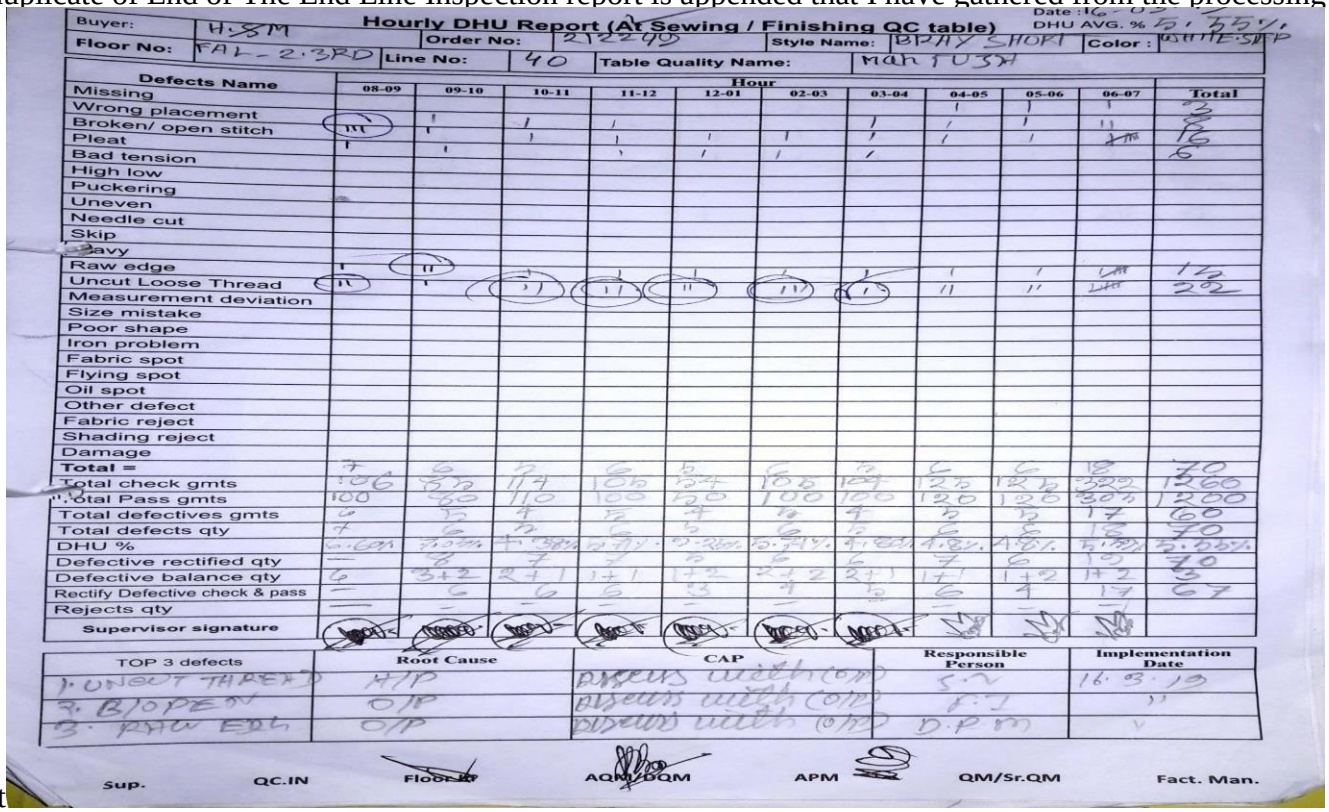
- Missing=14
- Broken stich=8
- Pleat=13
- High low=3
- Uneven=1
- Skip=1
- Raw edge=12
- Uncut loose treat=25

3.6 Attachment of sewing report

Line inspection report 4

LINE (40) in Hop Lun BD.

A duplicate of End of The End Line Inspection report is appended that I have gathered from the processing plant



Hourly DHU Report (At Sewing / Finishing QC table)

Date : 16-03-2
DHU AVG. % 5.55%

Buyer: H.&M
Order No: 212249
Style Name: BRAY SHORT
Color : WHITE SLEEP
Floor No: FAL-2.3RD
Line No: 40
Table Quality Name: Mah FUJH

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing											
Wrong placement											3
Broken/ open stitch											8
Pleat											16
Bad tension											6
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Savy											
Raw edge											15
Uncut Loose Thread											22
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	7	6	5	6	5	6	5	6	6	18	70
Total check gmts	106	85	114	105	54	105	104	125	125	322	1260
Total Pass gmts	100	80	110	100	50	100	100	120	120	305	1200
Total defectives gmts	6	5	4	5	4	5	4	5	5	17	60
Total defects qty	7	6	5	6	5	6	5	6	6	18	70
DHU %	6.60%	7.05%	4.38%	5.71%	5.25%	5.71%	4.80%	4.8%	4.8%	5.59%	5.55%
Defective rectified qty	—	8	7	7	5	6	6	7	6	19	70
Defective balance qty	6	3+2	2+1	1+1	1+2	2+2	2+1	1+1	1+2	1+2	3
Rectify Defective check & pass	—	6	6	6	3	4	5	6	4	17	67
Rejects qty	—	—	—	—	—	—	—	—	—	—	
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	H/P	Discuss with (O/P)	S.N	16.3.19
2. B/OPEN	O/P	Discuss with (O/P)	F.I	"
3. RAW EDG	O/P	Discuss with (O/P)	D.P.M	"

Sup. QC.IN Floor AQM/DQM APM QM/Sr.QM Fact. Man.

Figure 3. 4: Report on sewing section4

100% End of the Line Inspection Report in Sewing Section 16/03/2021

Table 3. 4: **Line inspection report 4**

FAKIR APPARELS LTD

DAILY END-LINE INSPECTION REPORT

Date: 16-03-2021 Order No: 212249 Color: Whitestep

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	**1st**	**2nd**	**3rd**	**4th**	**5th**	**6th**	**7th**	**8th**	**9th**	**10th**	**Total**
Missing								1	1	1	3
Wrong placement		1	1	1			1	1	1	2	8
Broken/ open stich	3	1	1	1	1	1	1	1	1	5	16
Pleat	1	1		1	1	1	1				6
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											

Skip											
Wavy											
Raw edge	1	2	1	1	1	1	1	1	1	5	15
Uncut loose thread	2	1	2	2	2	3	1	2	2	5	22
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	7	6	5	6	5	6	5	6	6	18	70
Total check gmts	106	85	114	105	54	105	104	125	125	322	1260
Total pass gmts	100	80	110	100	50	100	100	120	120	305	1200
Total defectives gmts	6	5	4	5	4	5	4	5	5	17	60
Total Defects qty	7	6	5	6	5	6	5	6	6	18	70
DHU%	6.60%	7.05%	4.38%	5.11%	9.25%	5.74%	4.80%	4.8%	4.8%	5.59%	**5.55%**
Defective rectified qty	_	8	7	7	5	6	6	7	6	19	**70**
Defective balance qty	4	3+2	2+1	1+1	1+2	2+2	2+1	1+1	1+2	1+2	**3**
Rectify defective check & pass	_	6	6	6	3	4	5	6	4	17	**67**
Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 5.55\%$$

first Highest Defects= Uncut free treat 22pcs
second Highest Defects= Open stich 16pcs
third Highest Defects= Raw edge 15pcs
All out Pieces checked =1260
Complete Defects=60

Here, at line (40) my perception date was 16/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 assistant and 2 quality control administrator. I saw that line from 8-9am and they checked 106pcs of articles of clothing and there was all out 6 deformities.

Like along these lines, complete 1260pcs of articles of clothing checked in 10hours perception. Here I completely discovered 60 computers of blemished pieces of clothing and there is no dismissal.

Here, the list of defects below I found at line (40):

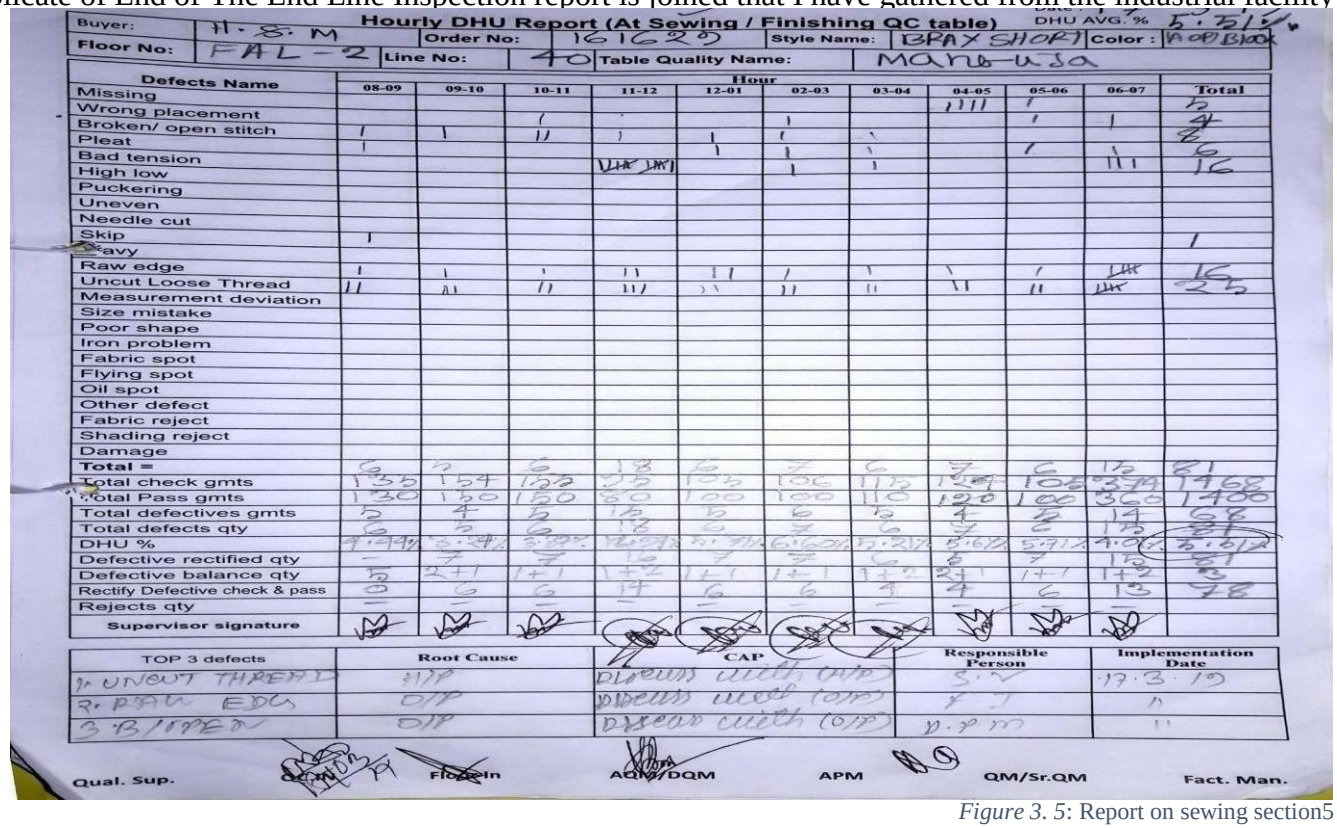
- Missing=3
- Wrong placement=8
- Broken stich=16
- Pleat=6
- Raw edge=15
- Uncut loose treat=22

3.7 Attachment of sewing report

Line inspection report 5

LINE (40) in Hop lun BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the industrial facility



Hourly DHU Report (At Sewing / Finishing QC table)

Buyer:	H. S. M	Order No:	161629	Style Name:	BRAX SHORT	Color :	A OD BLOCK
Floor No:	FAL-2	Line No:	40	Table Quality Name:	Manu-usa	DHU AVG. %	5.51%

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing											
Wrong placement											
Broken/ open stitch											
Pleat											
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Gravy											
Raw edge											
Uncut Loose Thread											
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	6	5	6	18	6	7	6	7	6	15	81
Total check gmts	135	154	155	95	105	106	115	124	105	374	1468
Total Pass gmts	130	150	150	80	100	100	110	120	100	360	1400
Total defectives gmts	5	4	5	15	5	6	5	4	5	14	68
Total defects qty	6	5	6	18	6	7	6	7	6	15	81
DHU %	4.44%	3.24%	3.89%	16.97%	5.71%	6.60%	5.21%	5.61%	5.71%	4.01%	5.51%
Defective rectified qty	–	7	7	16	7	7	6	5	7	15	81
Defective balance qty	5	2+1	1+1	1+2	1+1	1+1	1+2	2+1	1+1	1+2	3
Rectify Defective check & pass	0	6	6	14	6	6	4	4	6	13	78
Rejects qty	–	–	–	–	–	–	–	–	–	–	
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	H/P	Discuss with (O/P)	S.V	17.3.19
2. RAW EDG	O/P	Discuss with (O/P)	F.J	"
3. B/OPEN	O/P	Discuss with (O/P)	D.P.M	"

Qual. Sup. QC.IN Floor In AQM/DQM APM QM/Sr.QM Fact. Man.

Figure 3. 5: Report on sewing section5

100% End of the Line Inspection Report in Sewing Section 17/03/2021

Table 3. 5: **Line inspection report 5**

Hop Lun BD

DAILY END-LINE INSPECTION REPORT

Date: 17-03-2021 Order No: 331330 Color: (AOP) Black

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing								4	1		5
Wrong placement			1			1			1	1	4
Broken/ open stich	1	1	2	1	1	1	1				8
Pleat	1				1	1	1		1	1	6
Bad tension				10		1	1			3	16
High low											
Puckering											
Uneven											
Needle cut											
Skip	1										1

Wavy											
Raw edge	1	1	1	2	2	1	1	1	1	5	16
Uncut loose thread	2	2	2	3	2	2	2	2	2	5	25
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	6	5	6	18	6	7	6	7	6	15	81
Total check gmts	135	154	155	95	105	106	115	124	105	374	1468
Total pass gmts	130	150	150	80	100	100	110	120	100	360	1400
Total defectives gmts	5	4	5	15	5	6	5	4	5	14	68
Total Defects qty	6	5	6	18	6	7	6	7	6	15	81
DHU%	4.44 %	3.24 %	3.37 %	18.91 %	5.71 %	6.60 %	5.21 %	5.61 %	5.71 %	4.0 %	**5.51 %**
Defective rectified qty	_	7	7	16	7	7	6	5	7	15	**81**
Defective balance qty	5	2+1	1+1	1+2	1+1	1+1	1+2	2+1	1+1	1+2	**3**
Rectify defective check & pass	0	6	6	14	6	6	4	4	6	13	**78**
Rejecty											

$DHU\% = (\frac{Total}{no\ of\ defective\ products}) \times 100 = 5.51\%$

$$Total\ no\ of\ checked\ products$$

first Highest Defects = Uncut free string 25pcs
second Highest Defects = Bad strain 16pcs
third Highest Defects = Law edge 16pcs
All out Pieces checked =1468
Complete Defects =68

Here, at line (40) my perception date was 17/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 aide and 2 quality control administrator. I saw that line from 8-9am and they checked 135pcs of pieces of clothing and there was all out 5 deformities.

Like along these lines, all out 1468pcs of articles of clothing checked in 10hours perception. Here I completely discovered 68 computers of faulty pieces of clothing and there is no dismissal.

Here, the list of defects I found at line (40):

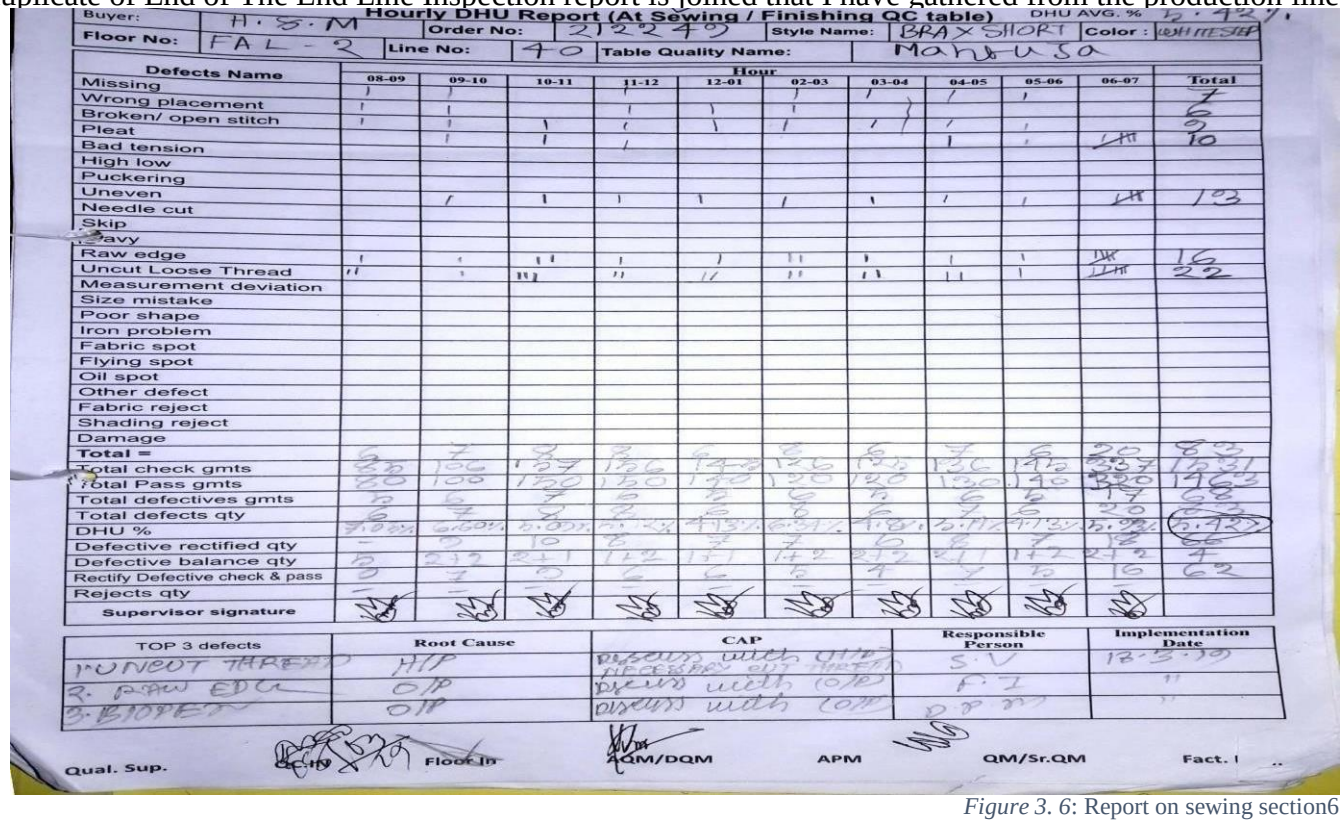
- Missing=5
- Wrong placement=4
- Broken stich=8
- Pleat=6
- Bad tension=16
- Skip=1
- Raw edge=16
- Uncut loose thread=25

3.8 Attachment of sewing report

Line inspection report 6

LINE (40) in Hop Lun BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table)

Buyer: H.S.M | Order No: 212249 | Style Name: BRAX SHORT | Color: WHITE STEP | DHU AVG. % 5.42%

Floor No: FAL-2 | Line No: 40 | Table Quality Name: Mahfuja

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing	1	1		1		1	1	1	1		7
Wrong placement	1	1		1	1	1					6
Broken/ open stitch	1	1	1	1	1	1	1	1	1		9
Pleat		1	1	1				1	1	1	10
Bad tension											
High low											
Puckering											
Uneven		1	1	1	1	1	1	1	1	1	13
Needle cut											
Skip											
Wavy											
Raw edge	1	1	11	1	1	11	1	1	1	1	16
Uncut Loose Thread	11	1	11	11	11	11	11	11	1	1	22
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	6	7	8	8	6	8	6	7	6	20	83
Total check gmts	85	106	157	156	145	126	125	136	145	337	1531
Total Pass gmts	80	100	150	150	140	120	120	130	140	320	1463
Total defectives gmts	5	6	7	6	5	6	5	6	5	17	68
Total defects qty	6	7	8	8	6	8	6	7	6	20	83
DHU %	7.05%	6.60%	5.09%	5.12%	4.13%	6.34%	4.8%	5.14%	4.13%	5.93%	5.42%
Defective rectified qty	–	9	10	8	7	7	6	8	7	18	66
Defective balance qty	5	2+2	2+1	1+2	1+1	1+2	2+2	2+1	1+2	2+2	4
Rectify Defective check & pass	9	7	9	6	6	5	4	7	5	16	62
Rejects qty	–	–	–	–	–	–	–	–	–	–	
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	H/P	Discuss with (H/P) NECESSARY CUT THREAD	S.V	18.3.19
2. RAW EDGE	O/P	Discuss with (O/P)	F.I	"
3. BIOPEN	O/P	Discuss with (O/P)	D.P.M	"

Qual. Sup. | QC-IN | Floor In | AQM/DQM | APM | QM/Sr.QM | Fact. I

Figure 3. 6: Report on sewing section6

100% End of the Line Inspection Report in Sewing Section 18/03/2019

Table 3. 6: **Line inspection report 6**

Hop Lun BD

DAILY END-LINE INSPECTION REPORT

Date: 18-03-2021 Order No: 331423 Color: Whitestep

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	**1st**	**2nd**	**3rd**	**4th**	**5th**	**6th**	**7th**	**8th**	**9th**	**10th**	**Total**
Missing	1	1		1		1	1	1	1		7
Wrong placement	1	1		1	1	1	1				6
Broken/ open stich	1	1	1	1	1	1	1	1	1		9
Pleat		1	1	1				1	1	5	10
Bad tension											
High low											
Puckering											
Uneven		1	1	1	1	1	1	1	1	4	13
Needle cut											
Skip											
Wavy											

Raw edge	1	1	2	1	1	2	1	1	1	5	16
Uncut loose thread	2	1	3	2	2	2	2	2	1	5	22
Measurement t deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	6	7	8	8	6	8	6	7	6	20	83
Total check gmts	85	106	157	156	145	126	125	136	145	337	1531
Total pass gmts	80	100	150	150	140	120	120	130	140	320	1463
Total defectives gmts	5	6	7	6	5	6	5	6	5	17	68
Total Defects qty	6	7	8	8	6	8	6	7	6	20	83
DHU%	7.03 %	6.60 %	5.09 %	5.12 %	4.13 %	6.34 %	4.8 %	5.14 %	4.13 %	5.93 %	**5.42 %**
Defective rectified qty	_	9	10	8	7	7	6	8	7	18	**66**
Defective balance qty	5	2+2	2+1	1+2	1+1	1+2	2+2	2+1	1+2	2+2	**4**
Rectify defective check & pass	0	7	9	6	6	5	4	7	5	16	**66**
Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 5.42\%$$

first Highest Defects = Uncut free string 22pcs
second Highest Defects = Raw edge 16pcs

third Highest Defects = Uneven 13pcs
All out Pieces checked =1531
Complete Defects =68

Here, at line (40) my perception date was 18/03/21. At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 laborers with 13 assistants and 2 quality control administrator. I saw that line from 8-9am and they checked 85pcs of articles of clothing and there were absolute 5 imperfections.

Like along these lines, complete 1531pcs of pieces of clothing checked in 10hours perception. Here I completely discovered 68 laptops of imperfect pieces of clothing and there is no dismissal.

Here, the list of defects below I found at line (40):

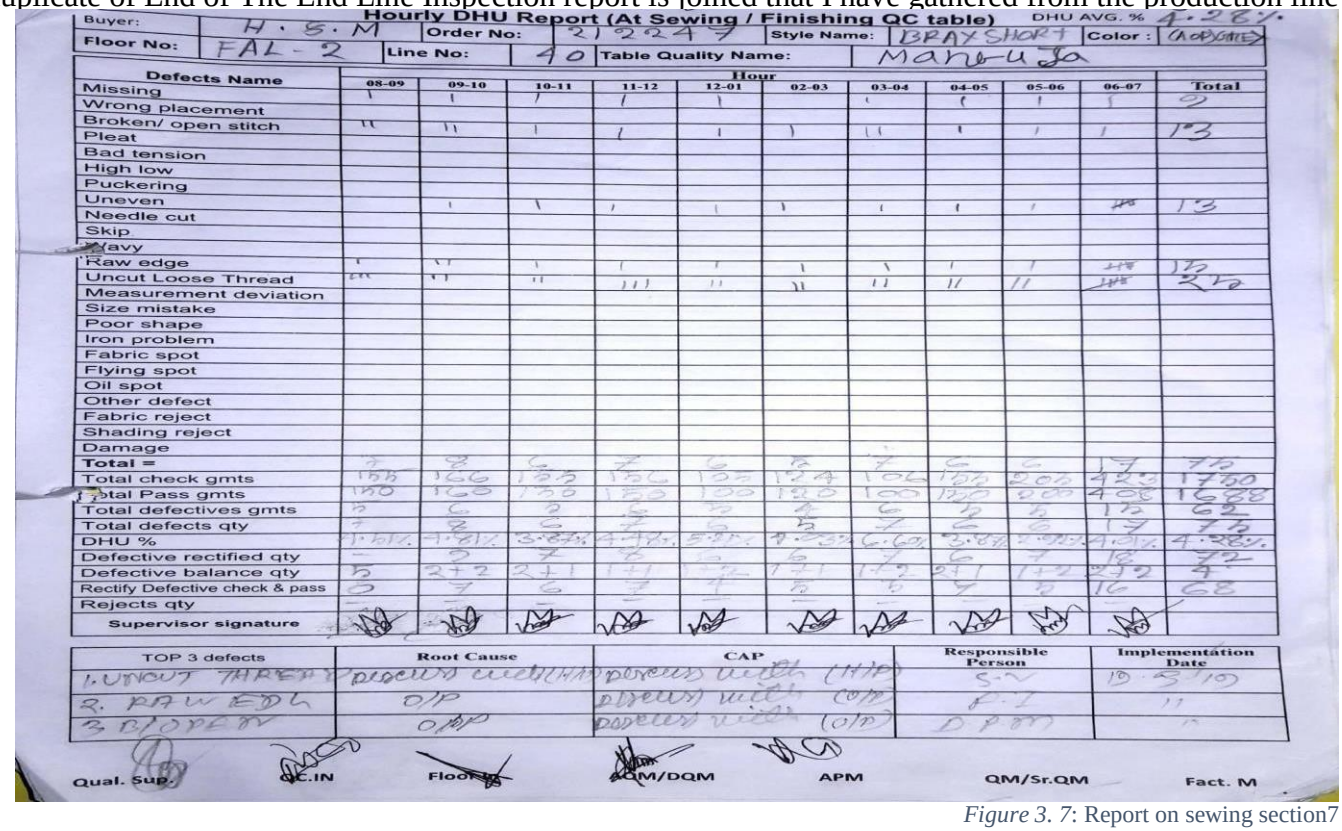
- Missing=7
- Wrong placement=6
- Broken stich=9
- Pleat=10
- Uneven=13
- Raw edge=16
- Uncut loose thread=22

3.9 Attachment of sewing report

Line inspection report 7

LINE (40) in Hop Lun BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table)

Buyer: H.S.M | Order No: 212247 | Style Name: BRAX SHORT | DHU AVG. % 4.28%

Floor No: FAL-2 | Line No: 40 | Table Quality Name: Manbuja | Color: (A OR) GREY

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing	1	1	1	1	1		1	1	1	1	9
Wrong placement											
Broken/ open stitch	11	11	1	1	1	1	11	1	1	1	13
Pleat											
Bad tension											
High low											
Puckering											
Uneven		1	1	1	1	1	1	1	1	1	13
Needle cut											
Skip											
Wavy											
Raw edge	1	11	1	1	1	1	1	1	1	1	15
Uncut Loose Thread	111	11	11	111	11	11	11	11	11	11	25
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	7	8	6	7	6	5	7	6	6	17	75
Total check gmts	155	166	155	156	155	124	106	155	205	423	1750
Total Pass gmts	150	160	150	150	100	120	100	150	200	408	1688
Total defectives gmts	5	6	5	6	5	4	6	5	5	15	62
Total defects qty	7	8	6	7	6	5	7	6	6	17	75
DHU %	4.51%	4.81%	3.87%	4.48%	5.21%	4.03%	6.60%	3.87%	2.92%	4.01%	4.28%
Defective rectified qty	–	9	7	8	6	6	7	6	7	18	72
Defective balance qty	5	2+2	2+1	1+1	1+2	1+1	1+2	2+1	1+2	2+2	4
Rectify Defective check & pass	5	7	6	7	4	5	5	7	5	16	68
Rejects qty	–	–	–	–	–	–	–	–	–	–	
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	Discuss with (H/P)	Discuss with (H/P)	S.V	19.3.19
2. RAW EDG	O/P	Discuss with (O/P)	P.I	11
3. B/OPEN	O/P	Discuss with (O/P)	D.P.M	11

Qual. Sup. | QC.IN | Floor In | AQM/DQM | APM | QM/Sr.QM | Fact. M

Figure 3. 7: Report on sewing section7

100% End of the Line Inspection Report in Sewing Section 19/03/2021

Table 3. 7: **Line inspection report 7**

Hop LUN BD

DAILY END-LINE INSPECTION REPORT

Date: 19-03-2021 Order No: 212247 **Color: (AOP) Grey**

Buyer: H. &.M **Sewing Line: 40**

Style No: BRAX SHORT **Inspector: MAHFUJA**

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing	1	1	1	1	1		1	1	1	1	9
Wrong placement											
Broken/ open stich	2	2	1	1	1	1	2	1	1	1	13
Pleat											
Bad tension											
High low											
Puckering											
Uneven		1	1	1	1	1	1	1	1	5	13
Needle cut											
Skip											
Wavy											

Raw edge	1	2	1	1	1	1	1	1	1	5	15
Uncut loose thread	3	2	2	3	2	2	2	2	2	5	25
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	7	8	6	7	6	5	7	6	6	17	75
Total check gmts	155	166	155	156	105	124	106	155	205	423	1750
Total pass gmts	150	160	150	150	100	120	100	150	200	408	1688
Total defectives gmts	5	6	5	6	5	4	6	5	5	15	62
Total Defects qty	7	8	6	7	6	5	7	6	6	17	75
DHU%	4.51 %	4.81 %	3.87 %	4.48 %	5.21 %	4.03 %	6.60 %	3.87 %	2.92 %	4.01 %	**4.28 %**
Defective rectified qty	_	9	7	8	6	6	7	6	7	18	**72**
Defective balance qty	5	2+2	2+1	1+1	1+2	1+1	1+2	2+1	1+2	2+2	**4**
Rectify defective check & pass	0	7	6	7	4	5	5	4	5	16	**68**
Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 4.28\%$$

first Highest Defects = Uncut free string 22pcs
second Highest Defects = Raw edge 16pcs
third Highest Defects = Uneven 13pcs
All out Pieces checked =1531
Complete Defects =68

Here, at line (40) my perception date was 19/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 assistant and 2 quality control administrator. I saw that line from 8-9am and they checked 155pcs of articles of clothing and there was absolute 5 deformities.

Like thusly, all out 1750pcs of pieces of clothing checked in 10hours perception. Here I completely discovered 62 computers of deficient articles of clothing and there is no dismissal.

Here, the list of defects below I found at line (40):

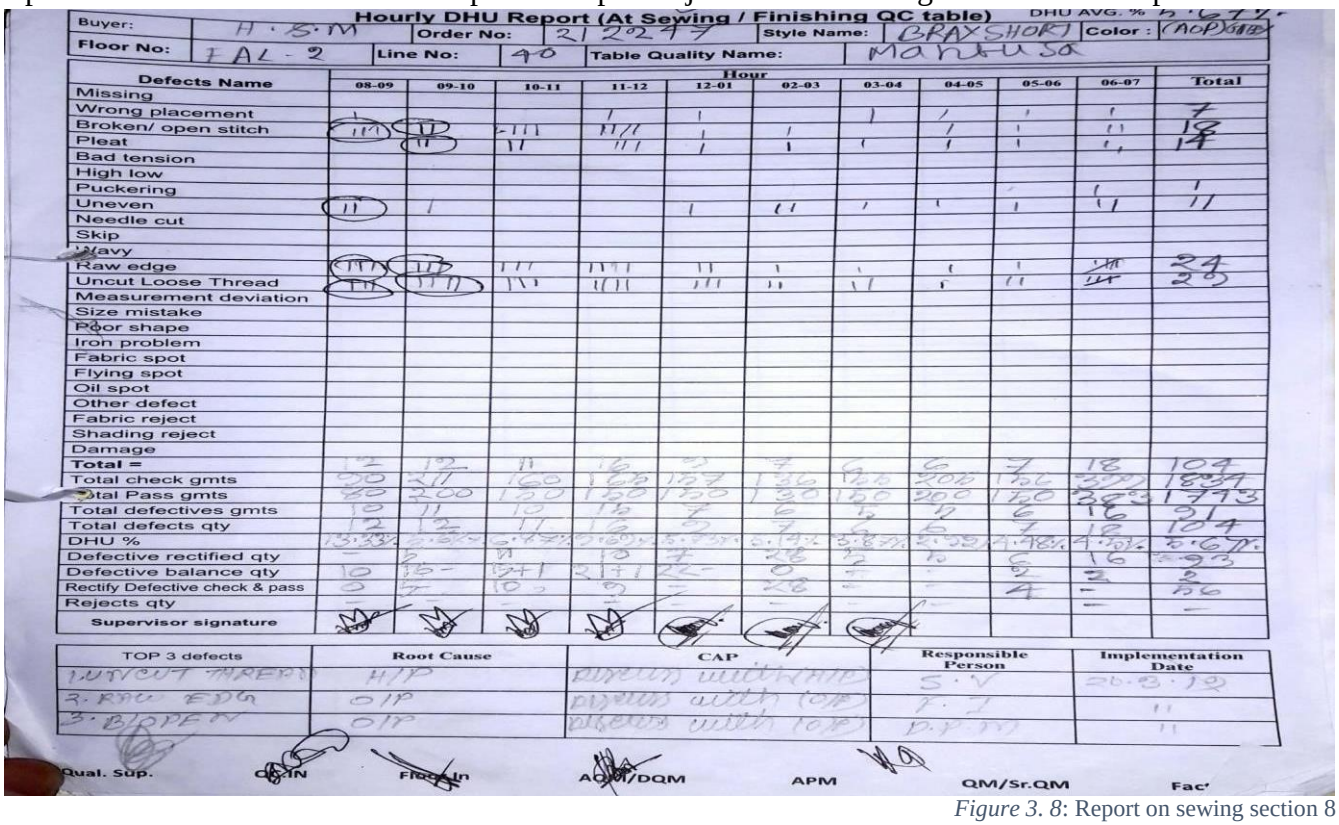
- Missing=9
- Broken stich=13
- Uneven=13
- Raw edge=15
- Uncut loose treat=25

3.10 Attachment of sewing report

Line inspection report 8

LINE (40) in Hop Lun BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table)

Buyer:	H·B·M	Order No:	21202497	Style Name:	GRAYSHORT	Color :	(NOP)				
Floor No:	FAL-2	Line No:	40	Table Quality Name:	Manusa						

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing											
Wrong placement											
Broken/ open stitch											
Pleat											
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Wavy											
Raw edge											
Uncut Loose Thread											
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =											
Total check gmts											
Total Pass gmts											
Total defectives gmts											
Total defects qty											
DHU %											
Defective rectified qty											
Defective balance qty											
Rectify Defective check & pass											
Rejects qty											
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	HIP			
2. RAW EDG	OIP			
3.	OIP			

Qual. Sup. | QA/IN | Floor In | AQM/DQM | APM | QM/Sr.QM | Fac'

Figure 3. 8: Report on sewing section 8

100% End of the Line Inspection Report in Sewing Section 20/03/2019

Table 3. 8: **Line inspection report 8**

Hop LUN BD

DAILY END-LINE INSPECTION REPORT

Date: 20-03-2019 Order No: 212247 **Color: (AOP) Grey**

Buyer: H. &.M **Sewing Line: 40**

Style No: BRAX SHORT **Inspector: MAHFUJA**

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing											
Wrong placement	1			1	1		1	1	1	1	7
Broken/ open stich	3	2	3	4	1	1	1	1	1	2	18
Pleat		2	2	3	1	1	1	1	1	2	14
Bad tension											
High low											
Puckering										1	1
Uneven	2	1			1	2	1	1	1	2	11
Needle cut											

Skip											
Wavy											
Raw edge	3	3	3	4	2	1	1	1	1	5	24
Uncut loose thread	3	4	3	4	3	2	2	1	2	4	29
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	12	12	11	16	9	7	6	6	7	18	104
Total check gmts	90	211	160	165	157	136	155	205	156	399	1834
Total pass gmts	80	200	150	150	150	130	150	200	150	383	1743
Total defectives gmts	10	11	10	15	7	6	5	5	6	16	91
Total Defects qty	12	12	11	16	9	7	6	6	7	18	104
DHU%	13.33 %	5.61 %	6.87 %	9.69 %	5.73 %	5.14 %	3.87 %	2.92 %	4.48 %	4.57 %	**5.67 %**
Defective rectified qty	_	5	11	10	7	28	5	5	6	16	**93**
Defective balance qty	10	16	15+1	21+1	22	0	_	_	2	2	**2**
Rectify defective check & pass	0	5	10	9	_	28	_	_	4	_	**56**

Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 5.67\%$$

first Highest Defects = Uncut free string 29pcs
second Highest Defects = Raw edge 24pcs
third Highest Defects = Uneven 18pcs
All out Pieces checked =1816
Complete Defects =58

Here, at line (40) my perception date was 20/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 partner and 2 quality control administrator. I saw that line from 8-9am and they checked 90pcs of articles of clothing and there was all out 10 imperfections.

Like thusly, all out 1834 computers of articles of clothing checked in 10hours perception. Here I completely discovered 91 computers of imperfect pieces of clothing and there is no dismissal.

Here, the rundown of deformities beneath I found at line (40):

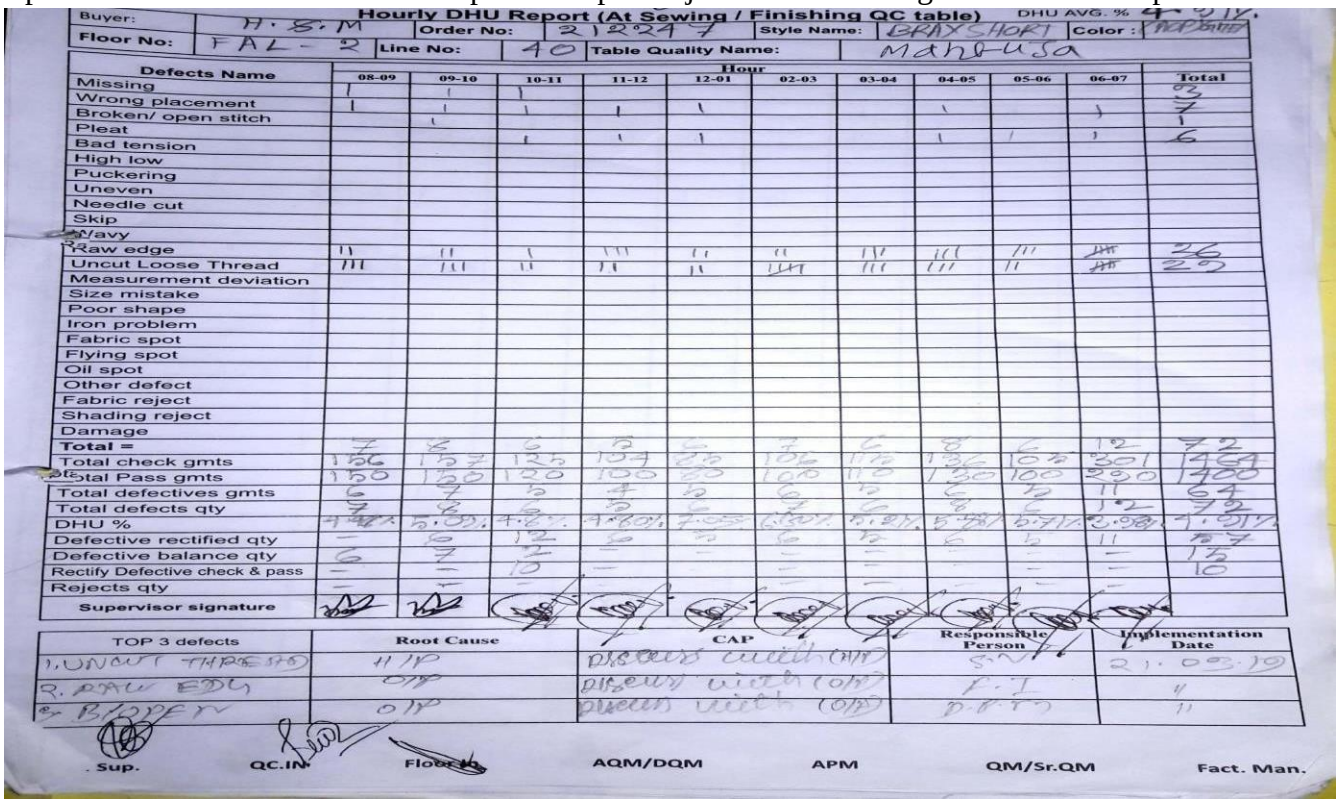
- Wrong placement=7
- Broken stich=18
- Uneven=11
- Raw edge=24
- Uncut loose treat=29

3.11 Attachment of sewing report

Line inspection report 9

LINE (40) in Hop Lun BD.

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table) DHU AVG. % 4.91%

Buyer:	H.S.M	Order No:	212247	Style Name:	BRAX SHORT	Color :	[illegible]
Floor No:	FAL-2	Line No:	40	Table Quality Name:	Mahbusa		

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing	1	1	1								3
Wrong placement	1	1	1	1	1			1		1	7
Broken/ open stitch		1									1
Pleat			1	1	1			1	1	1	6
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Wavy											
Raw edge	11	11	1	111	11	11	111	111	111	卌	26
Uncut Loose Thread	111	111	11	11	11	卌	111	111	11	卌	22
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	7	8	6	5	6	7	6	8	6	12	72
Total check gmts	156	157	125	104	85	106	115	136	105	301	1464
Total Pass gmts	150	150	120	100	80	100	110	130	100	290	1400
Total defectives gmts	6	7	5	4	5	6	5	6	5	11	64
Total defects qty	7	8	6	5	6	7	6	8	6	12	72
DHU %	4.48%	5.09%	4.8%	4.80%	7.05%	6.60%	5.21%	5.88%	5.71%	3.98%	4.91%
Defective rectified qty	—	6	12	5	5	6	5	6	5	11	57
Defective balance qty	6	7	7	—	—	—	—	—	—	—	15
Rectify Defective check & pass	—	—	10	—	—	—	—	—	—	—	10
Rejects qty	—	—	—	—	—	—	—	—	—	—	
Supervisor signature	[signature]	[signature]	[signature]	[signature]	[signature]	[signature]	[signature]	[signature]	[signature]	[signature]	

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	H/P	Discuss with (H/P)	S.N	21.03.19
2. RAW EDG	O/P	Discuss with (O/P)	F.I	"
3. B/OPEN	O/P	Discuss with (O/P)	D.P.T	"

Sup. QC.IN Floor In AQM/DQM APM QM/Sr.QM Fact. Man.

Figure 3. 9: Report on sewing section 9

100% End of the Line Inspection Report in Sewing Section 21/03/2021

Table 3. 9: **Line inspection report 9**

Hop LUN BD

DAILY END-LINE INSPECTION REPORT

Date: 21-03-2021 Order No: 331423 Color: (AOP) Grey

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	**1st**	**2nd**	**3rd**	**4th**	**5th**	**6th**	**7th**	**8th**	**9th**	**10th**	**Total**
Missing	1	1	1								3
Wrong placement	1	1	1	1	1			1		1	7
Broken/ open stich		1									1
Pleat			1	1	1			1	1	1	6
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											

Skip											
Wavy											
Raw edge	2	2	1	3	2	2	3	3	3	4	26
Uncut loose thread	3	3	2	2	2	4	3	3	2	4	29
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	7	8	6	5	6	7	6	8	6	12	72
Total check gmts	156	157	125	104	85	106	115	136	105	301	1464
Total pass gmts	150	150	120	100	80	100	110	130	100	290	1400
Total defectives gmts	6	7	5	4	5	6	5	6	5	11	64
Total Defects qty	7	8	6	5	6	7	6	8	6	12	72
DHU%	4.48 %	5.09 %	4.8 %	4.80 %	7.05 %	6.60 %	5.21 %	5.88 %	5.71 %	3.98 %	**4.91 %**
Defective rectified qty	_	6	12	6	5	6	5	6	5	11	**57**
Defective balance qty	6	7	2	_	_	_	_	_	_	_	**15**
Rectify defective check & pass	_	_	10	_	_	_	_	_	_	_	**10**
Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 4.91\%$$

first Highest Defects = Uncut free string 29pcs
second Highest Defects = Raw edge 26pcs
third Highest Defects = Uneven 7pcs
All out Pieces checked =1416
Complete Defects =58

Here, at line (40) my observation date was 21/03/21.At this time the buyer was H & M. The item was BRAX SHORT. In this line there was 18 worker with 13 helper and 2 quality control operator. I observed that line from 8-9am and they checked 155pcs of garments and there was total 5 defects.

Like this way, total 1750pcs of garments checked in 10hours observation. Here I totally found 62 pcs of defective garments and there is no rejection.

Here, the list of defects below I found at line (40):

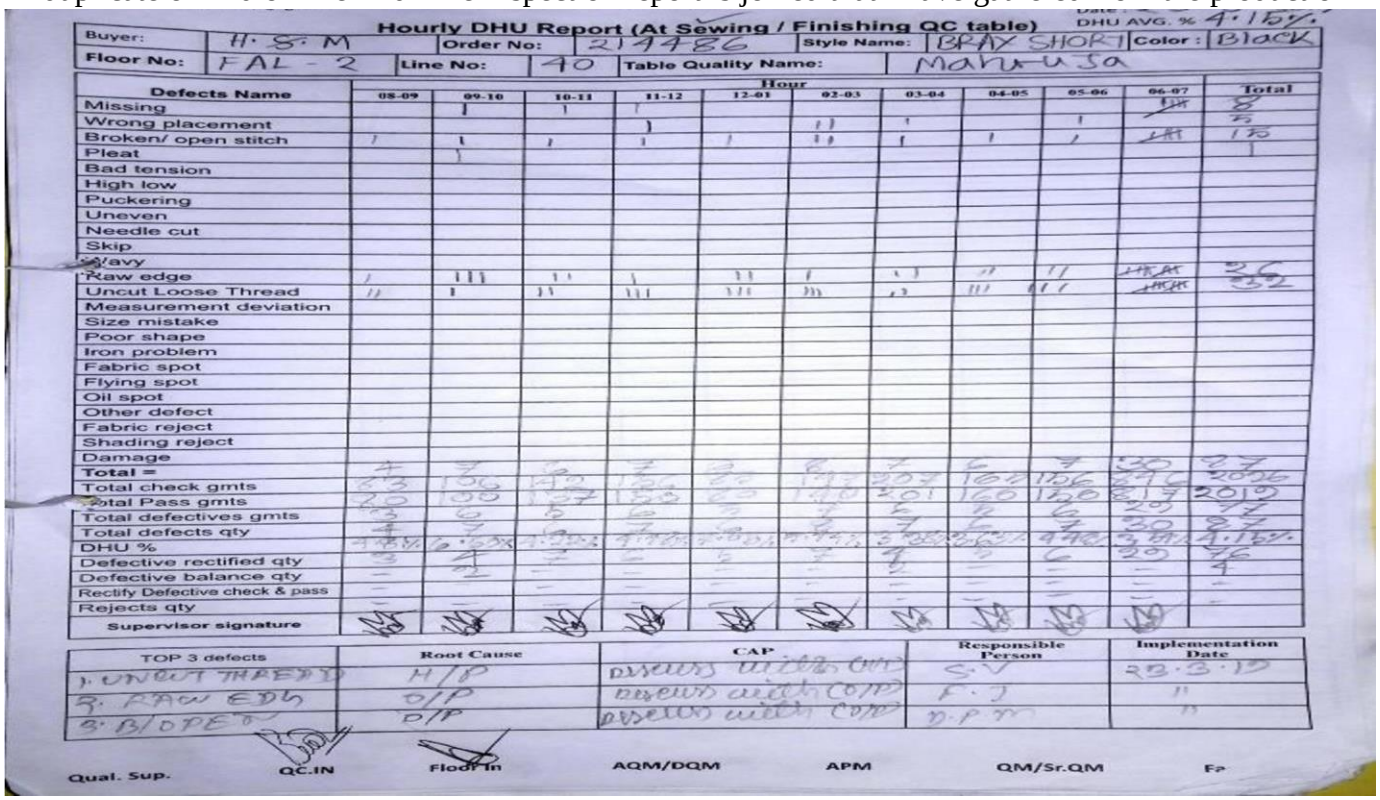
- Missing=3
- Wrong placement=7
- Broken stich=1
- Pleat=6
- Raw edge=26
- Uncut loose treat=29

3.12 Attachment of sewing report

Line inspection report 10

LINE (40) in Hop lun LTD

A duplicate of End of The End Line Inspection report is joined that I have gathered from the production line



Hourly DHU Report (At Sewing / Finishing QC table)

DHU AVG. % 4.15%

Buyer: H·S·M | Order No: 219486 | Style Name: BRAX SHORT | Color: BLACK

Floor No: FAL - 2 | Line No: 40 | Table Quality Name: MANUJA

Defects Name	Hour 08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Missing		1	1	1						1111	8
Wrong placement				1		11	1		1		5
Broken/ open stitch	1	1	1	1	1	11	1	1	1	1111	170
Pleat		1									1
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Wavy											
Raw edge	1	111	11	1	11	1	11	11	11	1111 1111	36
Uncut Loose Thread	11	1	11	111	111	111	11	111	111	1111 1111	52
Measurement deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying spot											
Oil spot											
Other defect											
Fabric reject											
Shading reject											
Damage											
Total =	4	7	4	7	20	9	7	5	4	30	27
Total check gmts	63	156	140	126	120	140	207	160	156	246	2056
Total Pass gmts	20	100	127	122	120	140	201	160	120	219	2019
Total defectives gmts	3	6	5	6	6	6	6	6	6	27	77
Total defects qty	4	7	5	7	7	7	7	5	6	30	87
DHU %	6.35%	4.48%	3.57%	5.55%	5.83%	5%	3.38%	3.12%	3.84%	12.19%	4.15%
Defective rectified qty	3	4	3	5	5	5	4	3	6	20	76
Defective balance qty	—	2	—	—	—	—	—	—	—	—	4
Rectify Defective check & pass	—	—	—	—	—	—	—	—	—	—	—
Rejects qty	—	—	—	—	—	—	—	—	—	—	—
Supervisor signature											

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
1. UNCUT THREAD	M/P	DISCUSS WITH COMP	S.V	23.3.21
2. RAW EDG	O/P	DISCUSS WITH COMP	F.J	11
3. B/OPEN	O/P	DISCUSS WITH COMP	D.P.M	11

Qual. Sup. | QC.IN | Floor In | AQM/DQM | APM | QM/Sr.QM | Fa

Figure 3. 10: Report on sewing section 10

100% End of the Line Inspection Report in Sewing Section 23/03/2021

Table 3. 10: **Line inspection report 10**

Hop LUN BD

DAILY END-LINE INSPECTION REPORT

Date: 23-03-2021 Order No: 214486 Color: Black

Buyer: H. &.M Sewing Line: 40

Style No: BRAX SHORT Inspector: MAHFUJA

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Missing		1	1	1						5	8
Wrong placement				1		2	1		1		5
Broken/ open stich	1	1	1	1	1	2	1	1	1	5	15
Pleat		1									1
Bad tension											
High low											
Puckering											
Uneven											
Needle cut											
Skip											
Wavy											

Raw edge	1	3	2	1	2	1	2	2	2	8	26
Uncut loose thread	2	1	2	3	3	3	2	3	3	9	32
Measurement t deviation											
Size mistake											
Poor shape											
Iron problem											
Fabric spot											
Flying Spot											
Damage											
Total=	4	7	6	7	6	8	7	6	7	30	87
Total check gmts	83	106	142	156	85	47	207	165	156	846	2096
Total pass gmts	80	100	137	150	80	40	201	160	150	817	2019
Total defectives gmts	3	6	5	6	5	7	6	5	6	29	77
Total Defects qty	4	7	6	7	6	8	7	6	7	30	87
DHU%	4.81 %	6.60 %	4.22 %	4.98 %	7.05 %	5.44 %	3.38 %	3.63 %	4.48 %	3.54 %	**4.15 %**
Defective rectified qty	3	4	7	6	5	7	4	5	6	29	**76**
Defective balance qty	_	2	_	_	_	_	_	2	_	_	**4**
Rectify defective	_	_	_	_	_	_	_	_	_	_	**_**
check & pass											
Rejecty											

$$DHU\% = \left(\frac{Total\ no\ of\ defective\ products}{Total\ no\ of\ checked\ products}\right) \times 100 = 4.15\%$$

first Highest Defects = Uncut free string 32pcs

second Highest Defects = Raw edge 26pcs
third Highest Defects = Uneven 15pcs
All out Pieces checked =2096
Complete Defects =77

Here, at line (40) my perception date was 23/03/21.At this time the purchaser was H and M. The thing was BRAX SHORT. In this line there was 18 specialist with 13 aide and 2 quality control administrator. I saw that line from 8-9am and they checked 83 laptops of pieces of clothing and there was complete 3 deformities.

Like along these lines, absolute 2096 computers of pieces of clothing checked in 10hours perception. Here I completely discovered 77 laptops of inadequate articles of clothing and there is no dismissal.

Here, the list of defects below I found at line (40):

- Missing=8
- Wrong placement=5
- Open stich=15
- Pleat=1
- Raw edge=26
- Uncut loose treat=32

Chapter-4

RESULT AND DISCUSSION

4.1 Analysis Data Collection

I have investigated the sewing region in "Hop lun LTD". I additionally discover some sewing flaws which are frequently happens, for example, Missing, Broken stich, Pleat, Raw-Edge, Uneven, Skip, Uncut free string and I tracked down that Uncut free string which is the most likely most noteworthy from different shortcomings.

4.1.1 Different Sewing defects are shown from table no: 3.1

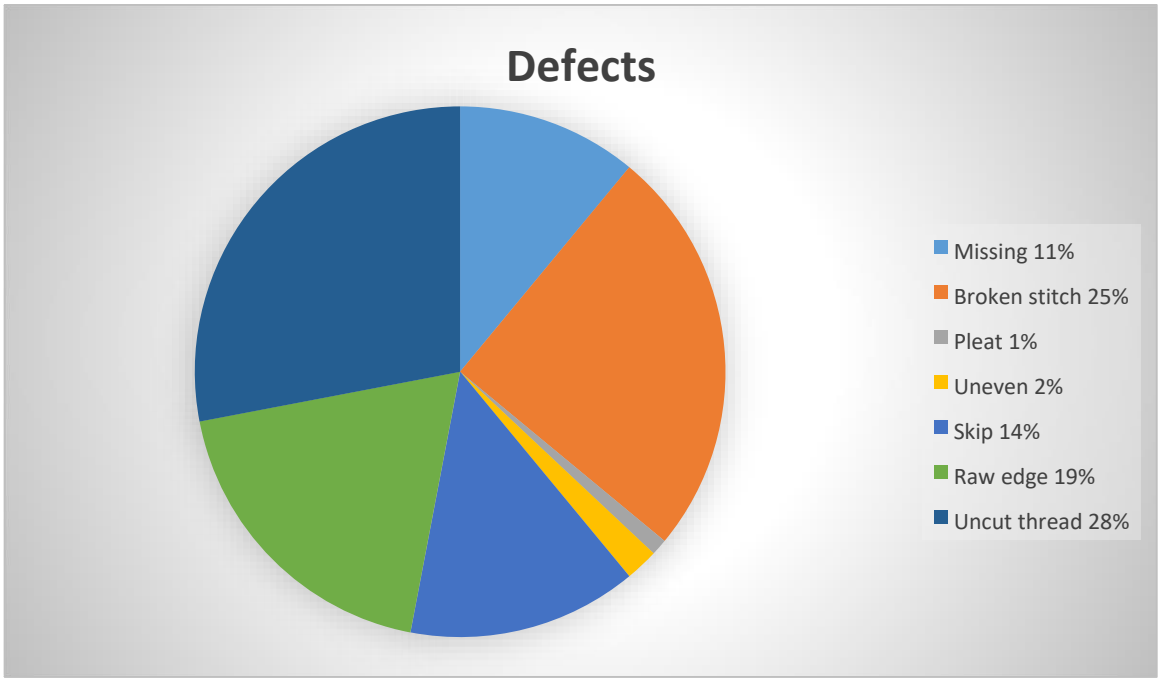


Chart4.1. 1: Line Inspection report 1(12/03/2021)

I have investigated the sewing territory in "Hop lun LTD". I additionally discover some sewing shortcomings which are frequently happens, for example, Missing, Broken stich, Pleat, Raw-Edge, Uneven, Skip, Uncut free string and I tracked down that Uncut free string which is the most presumably most noteworthy from different deficiencies.

4.1.2 Different Sewing defects are shown from table no: 3.2

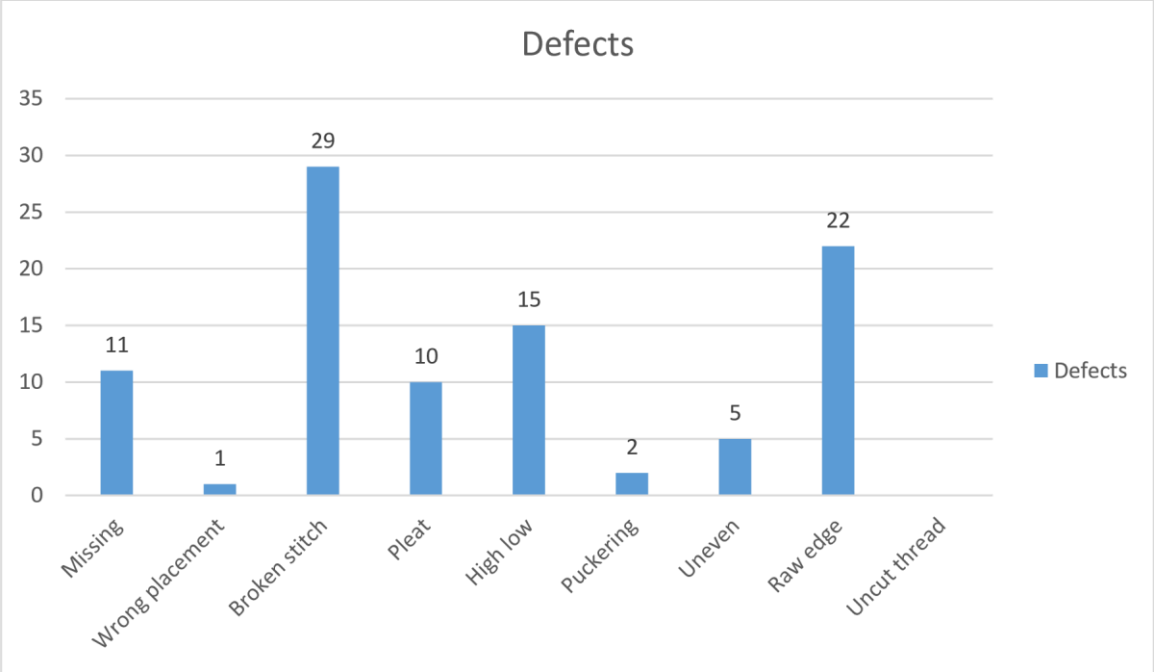


Chart4.1. 2: Line Inspection report 2(13/03/2021)

At the point when I see the report 3.2 I discovered whole free string is the fundamental flaw. I saw tenth hour's creation and discovered 49 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 10 bits of issue pieces of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of issue. It shows up because of ill-advised managing or wrapping up. In sewing measure additional string stipend. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.3

Chart4.1.3: Line Inspection report 3(14/03/2021)

At the point when I see the report 3.2 I discovered whole free string is the fundamental flaw. I saw tenth hour's creation and discovered 49 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 10 bits of issue pieces of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of issue. It shows up because of ill-advised managing or wrapping up. In sewing measure additional string stipend. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.4

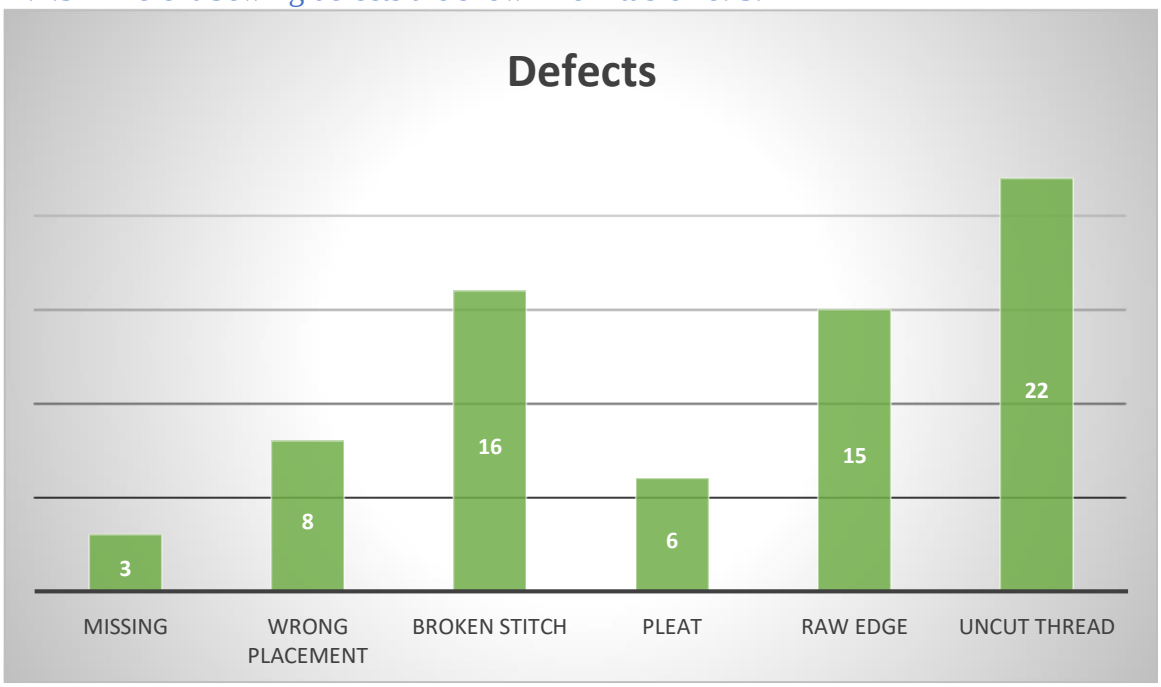


Chart4.14: Line Inspection report 4(16/03/2021)

At the point when I see the report 3.4 I discovered whole free string is the primary issue. I saw tenth hour's creation and discovered 22 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 5 bits of flaw pieces of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of shortcoming. It shows up because of ill-advised managing or wrapping up. In sewing measure additional string recompense. Pieces of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.5

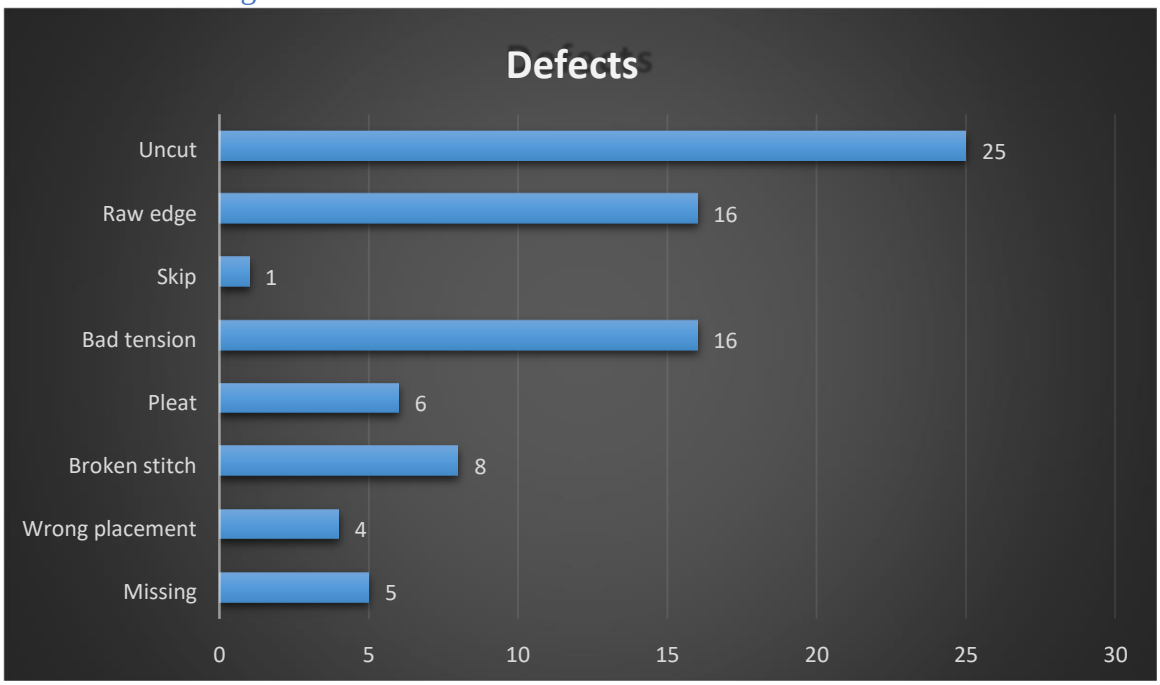


Chart4.1.5: Line Inspection report 5(17/03/2021)

At the point when I see the report 3.5 I discovered whole free string is the principle issue. I saw tenth hour's creation and discovered 25 whole free string, at any rate all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 5 bits of shortcoming articles of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of deficiency. It shows up because of ill-advised managing or wrapping up. In sewing measure additional string stipend. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.6

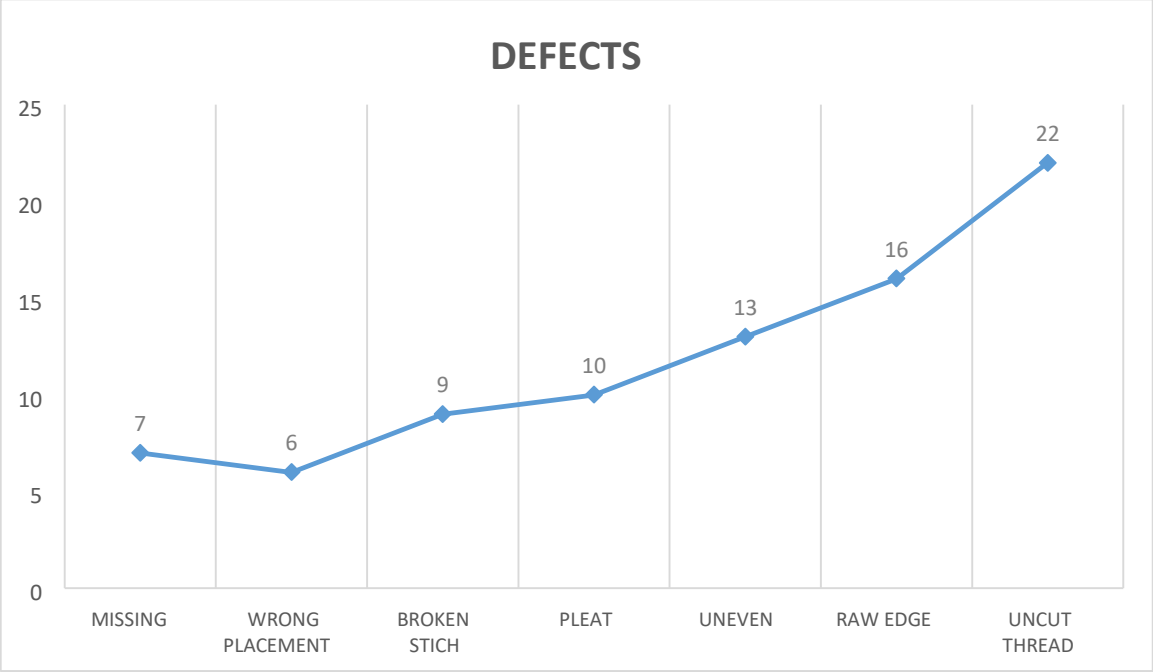


Chart4.1.6: Line Inspection report 6(18/03/2021)

At the point when I see the report 3.6 I discovered whole free string is the principle issue. I saw tenth hour's creation and discovered 22 whole free string, at any rate all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 6 bits of deficiency articles of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of issue. It shows up because of inappropriate managing or wrapping up. In sewing measure additional string stipend. Pieces of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.7

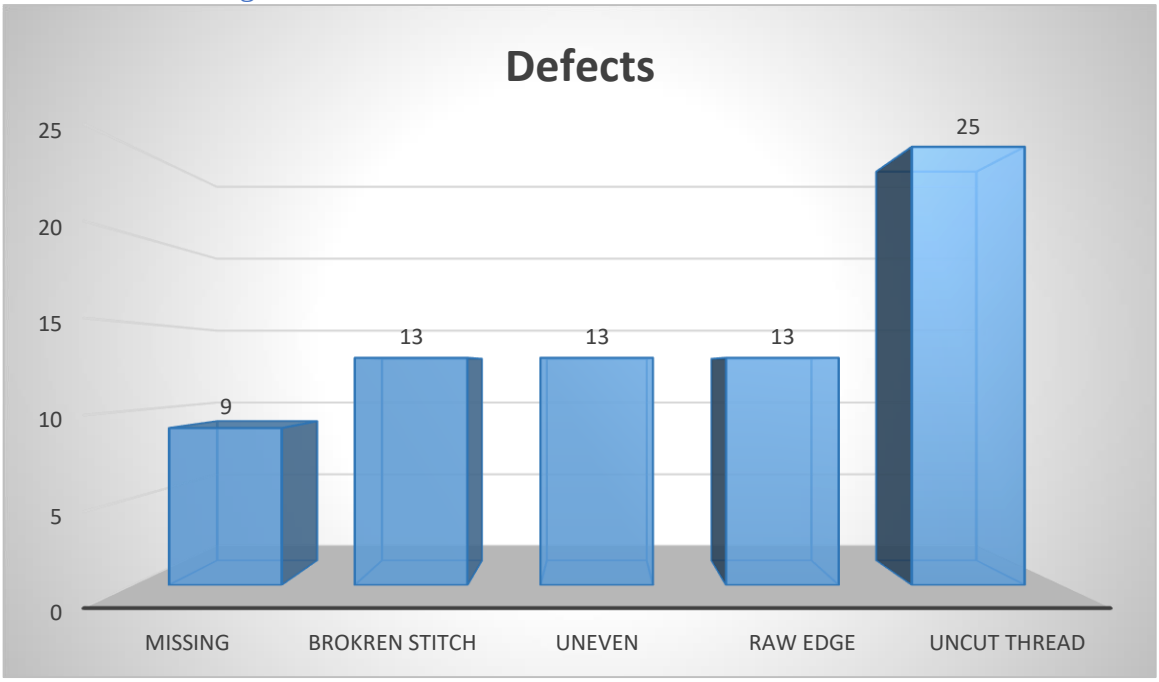


Chart4.1.7: Line Inspection report 7(19/03/2021)

At the point when I see the report 3.7 I discovered whole free string is the fundamental issue. I saw tenth hour's creation and discovered 25 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 6 bits of issue articles of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of deficiency. It shows up because of inappropriate managing or wrapping up. In sewing measure additional string stipend. Pieces of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.8

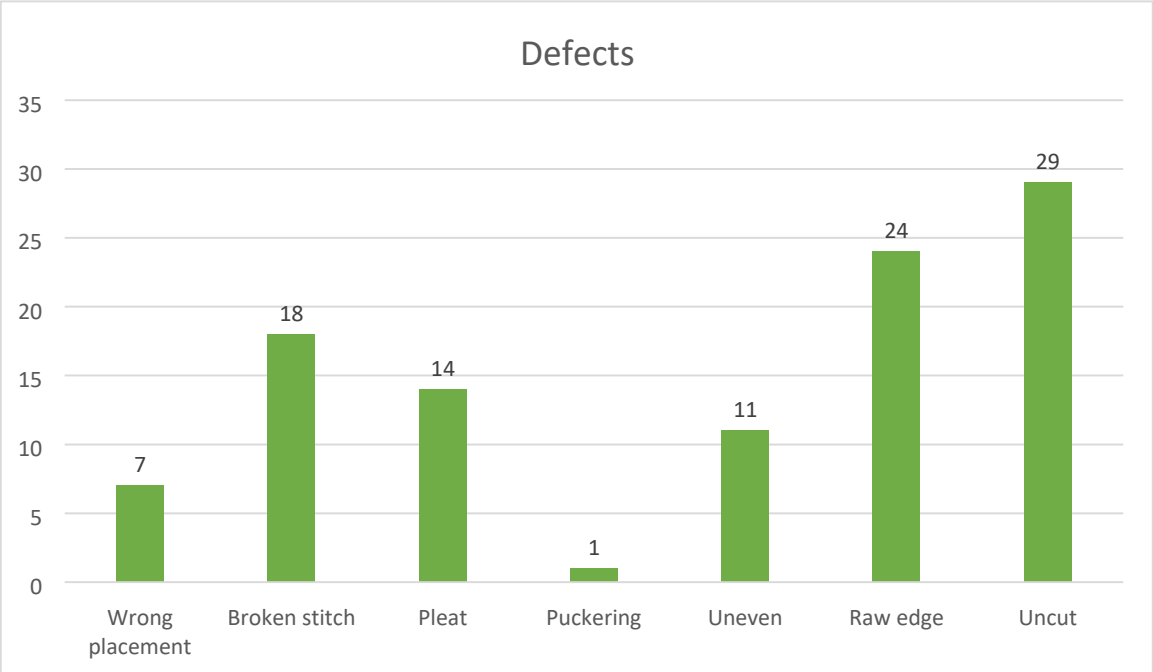


Chart4.1.8: Line Inspection report 8(20/03/2021)

At the point when I see the report 3.8 I discovered whole free string is the principle deficiency. I saw tenth hour's creation and discovered 29 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 4 bits of shortcoming articles of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of shortcoming. It shows up because of inappropriate managing or wrapping up. In sewing measure additional

string remittance. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.3 Different Sewing defects are shown from table no: 3.9

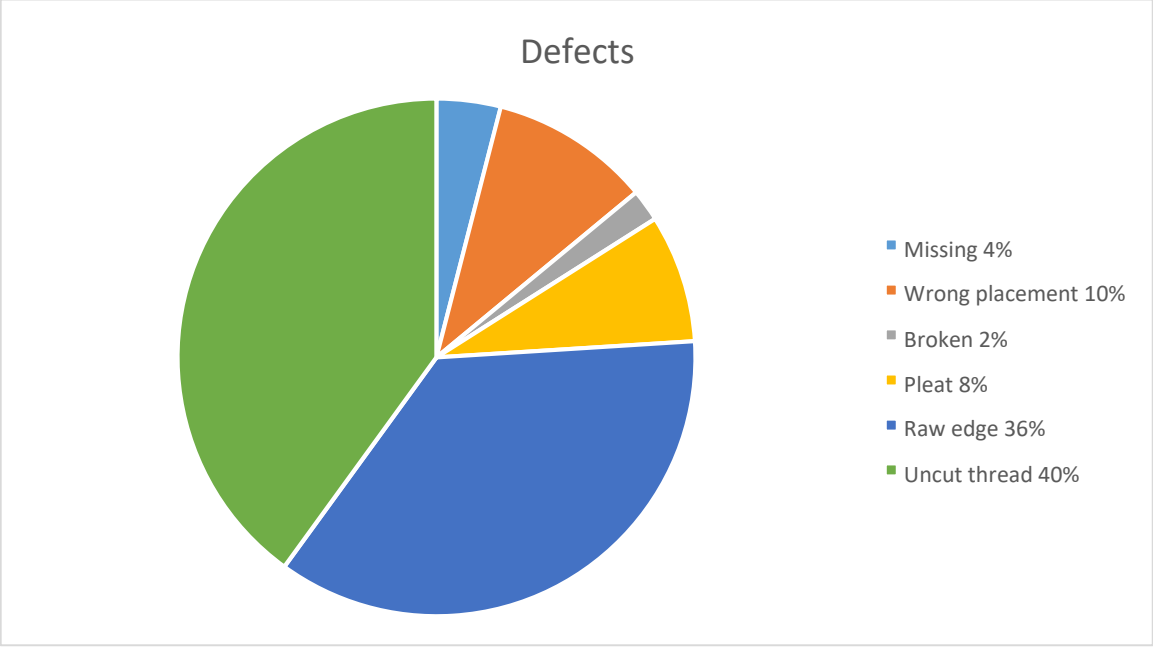


Chart4.1.9: Line Inspection report 9(21/03/2021)

At the point when I see the report 3.9 I discovered whole free string is the principle flaw. I saw tenth hour's creation and discovered 29 whole free string, at any rate all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 5 bits of deficiency articles of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of flaw. It shows up because of ill-advised managing or wrapping up. In sewing measure additional string remittance. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.

4.1.10 Different sewing defects are shown from table no: 3.10

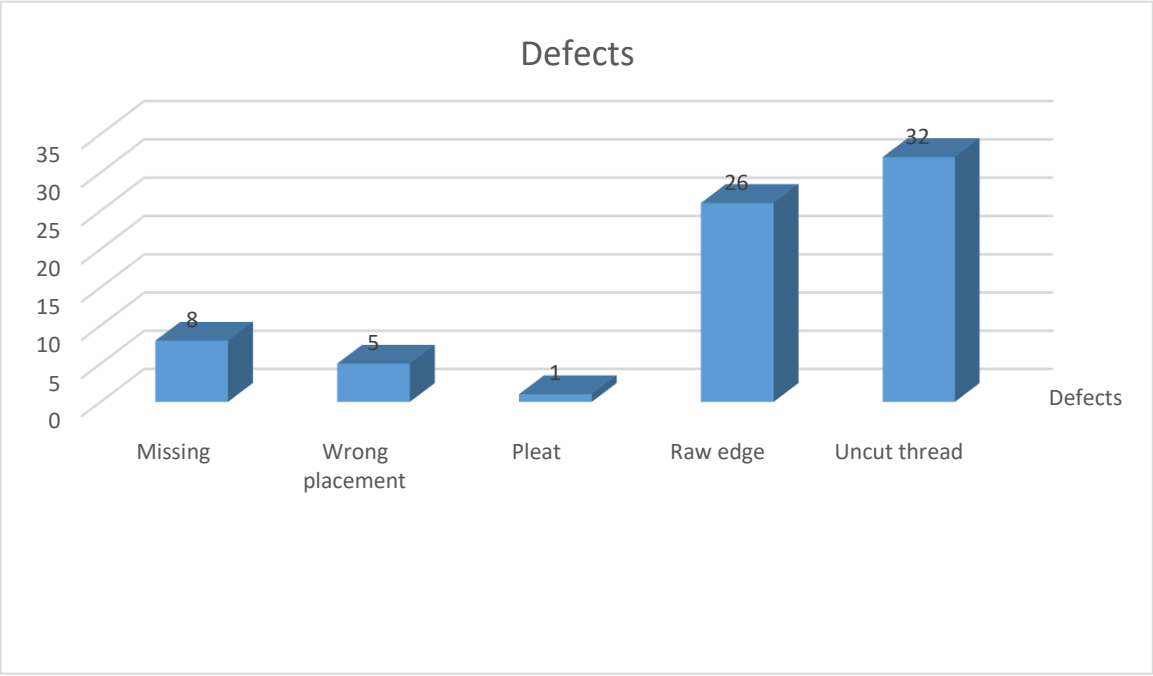


Chart4.1.10: Line Inspection report 10(23/03/2021)

At the point when I see the report 3.10 I discovered whole free string is the fundamental flaw. I saw tenth hour's creation and discovered 32 whole free string, in any case all pieces were changed. Whole free string sewing issue happen an hour ago working time. In this hour there was 8 bits of flaw pieces of clothing.

For this sewing issue, I have taken notes of information from Q.A.D for genuine causes and fixes of this sort of flaw. It shows up because of inappropriate managing or wrapping up. In sewing measure additional string recompense. Articles of clothing completing ought to be checked appropriately. Sewing string use appropriately.4.2 Comment

Stopping point investigated 10 Days Report 15994pieces of sewing SHORTS lastly I got the followings shortcomings which are more happens than different deficiencies,

- Missing=64
- Wrong placement=33
- Broken stich=129
- High low=18
- Uneven=45
- Skip=17
- Raw edge=166
- Uncut free treat=256
- Pleat=51
- Puckering=2
- Bad tension=16

Stopping point reviewed 10 Day Report 792 flaws.

Serious issue of this report is Uncut free string, which End of the Line assessed 10 Day Report got 792 shortcoming out of piece articles of clothing.

4.2.1 Sewing Defects Percentage Measurement

***Table 3. 11*Sewing Defects Percentage Measurement**

Defect name	Defect Number	Defect %
Missing	64	8%
Wrong placement	33	4%
Broken stich	129	16%
High low	18	2%
Uneven	45	6%
Skip	17	2%
Raw edge	166	21%

Uncut loose treat	256	32%
Pleat	51	6%
Puckering	2	1%
Bad tension	16	2%
Total =	792	100%

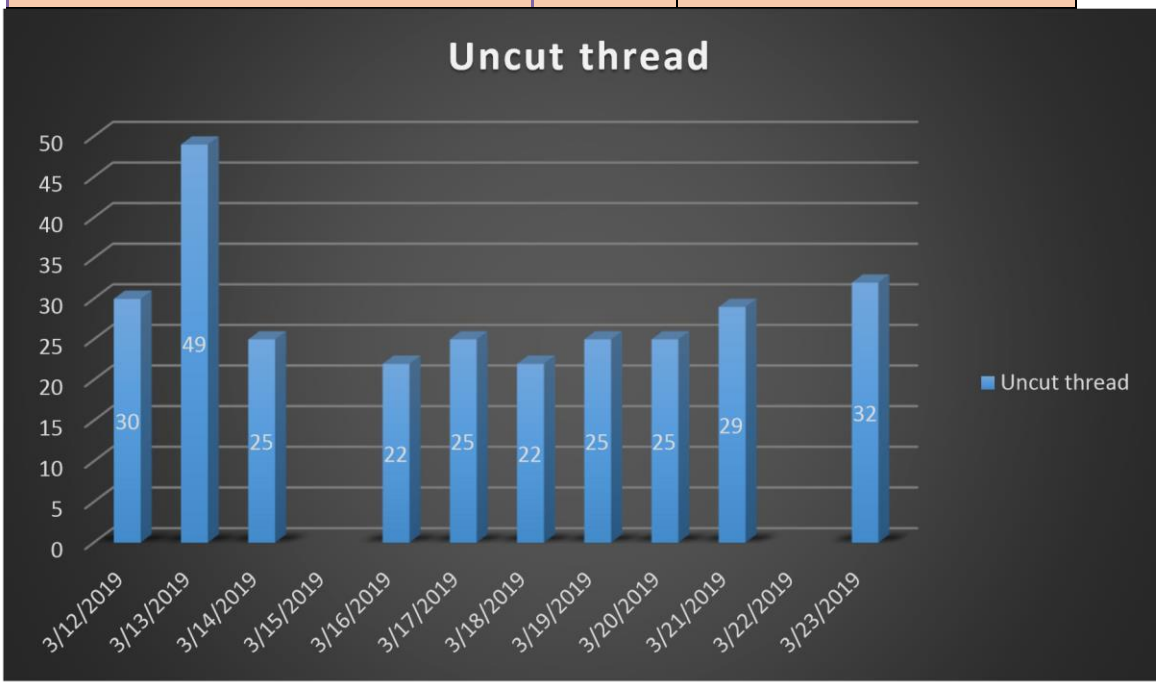


Chart: 4.2.1: Major problem occur in the sewing section

Here a comparison of Pass goods and sewing defects quantity for "**HOP LUN BD**." are given below

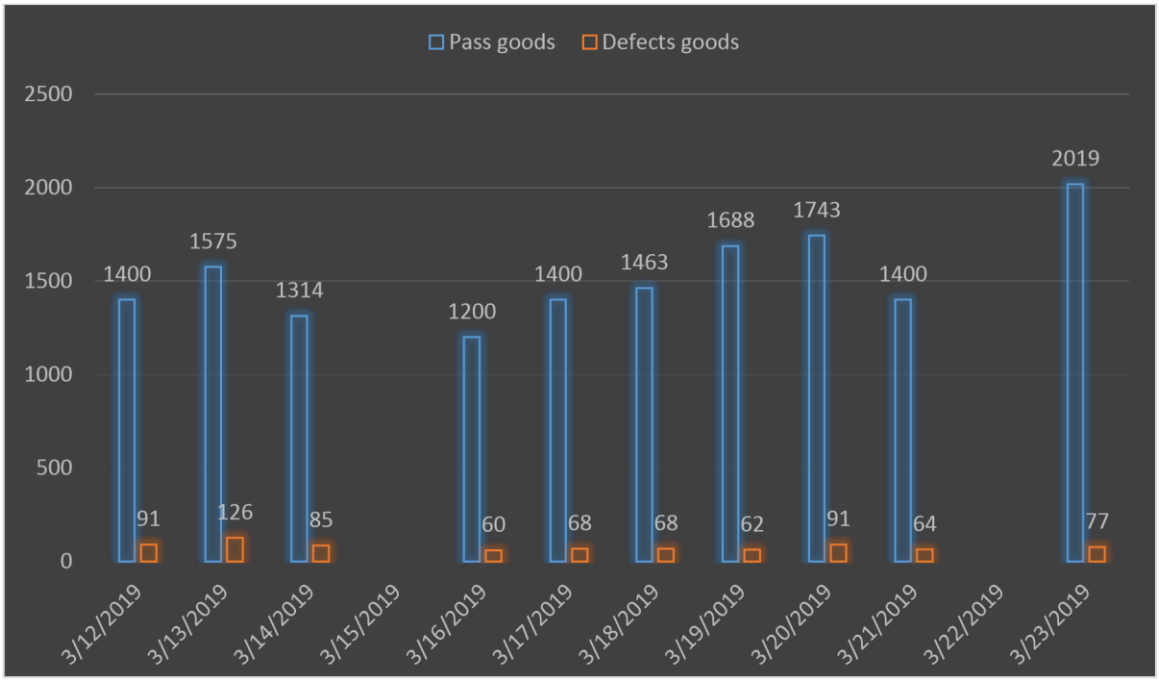


Chart: 4.2.2: Day wise Pass Goods vs. Defects Goods

Here, in this graph shows percentages of Here, in this chart shows rates of Pass merchandise and deformities products for 10 working days.

Pass merchandise and deformities products for 10 working days.

Blue tone specifies "Pass Goods" and Orange tone designate "Imperfections Goods".

Here a level of Pass products and sewing deserts amount for "Jump LUN BD." are given underneath

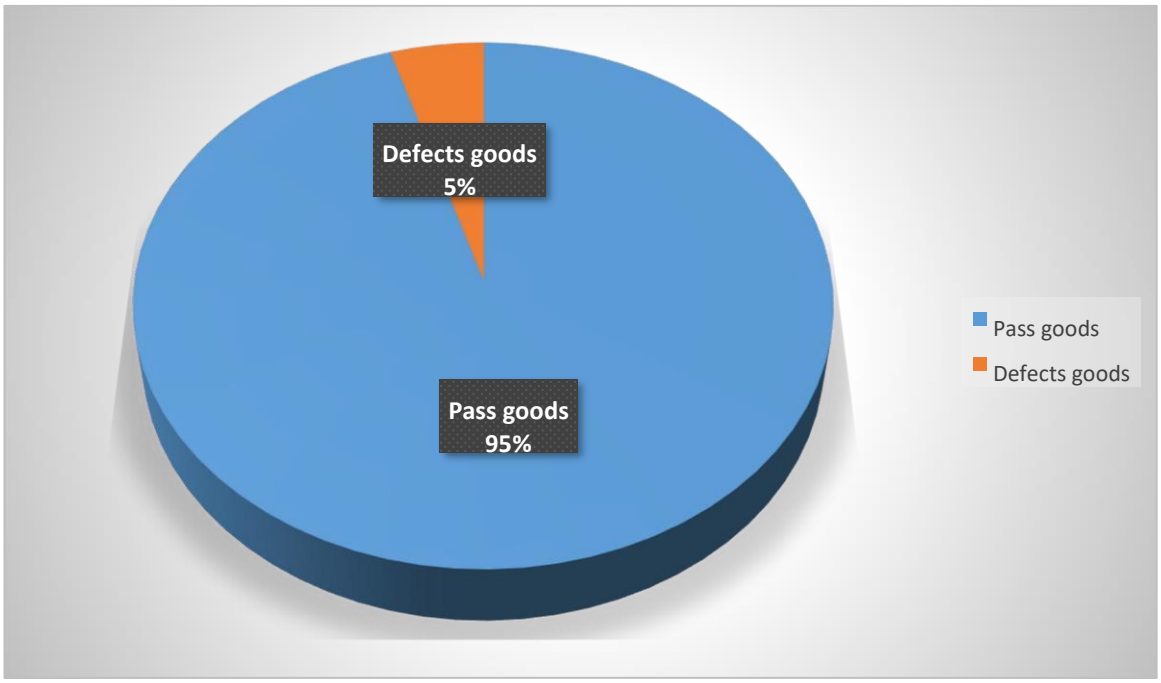


Chart: 4.2.3 : Percentage of Pass Goods and Defects Goods

Blue color indicates “Pass Goods” and Orange color indicate “Defects Goods”.

Chapter-5
Conclusion

5.1Conclusion

After heaps of review, try and conversation I have finished my proposition. I have accumulated colossal experience about this area. I can acquire information about sewing, think about the issues which happened in this part and expertise those issues will be settled. This postulation utilized an assortment of article of clothing tests which were gathered by the finished result classes. This task is tied in with sewing measure in an instant apparel plant and the improvement of the sewing shortcomings. To guarantee a decent quality framework in processing plant, need accomplished stuffs and laborers. By great and experienced stuffs, material quality ought to be controlled for fine yield. For best quality level need to improve the laborers ability and for this reason, customary trainings ought to be set up in the plant.

References

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3. http://sewing.about.com/od/sewingmachineindex
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