



Faculty of Engineering

Department of Textile Engineering

Comparative Study on Different Types of Sewing Faults
for Different Factories.

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LETTER OF APPROVAL

March-12-2022

To

The Head

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Daffodil International University

Daffodil Smart City, Dhaka

Subject: Approved of Project (Thesis) Report of B.Sc. in TE Program.

Dear Sir

I am just writing to let you know that this report titled as “**Comparative Study on Different Types of Sewing Faults for Different Factories**” has been Prepared by the student bearing ID 181-23-409,181-23-412,181-23-413 and 181-23-424 is completed for final evaluation. The whole report is prepared based on the factory data with required belongings. The students were directly involved in their industrial attachment 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 report and consider it for final Evaluation.

Yours Sincerely



Md. Mominur Rahman

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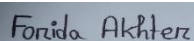
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DECLARATION

We hereby declare that, the work which is being presented in this entitled Study on Different Types of Sewing Faults and their Remedies is original work of my 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.



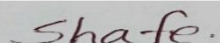
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-The Authors

ABSTRACT

Now a days Garments defect is one of the most important factors of the apparel manufacturing industry because it creates a negative effect on actual productivity. This paper aims with Different types of Defects which are the common term in the garment industry. In this research we have found that it is very essential to know about different types of Garments Defects. In garments industry these defects are dependent upon the classification of defects and an inspector's ability to make decisions. If there is no idea of garments defects identification then it will be a tough job, but if it is known properly then it is an easy task to identify defects. So must know all types of Garments defects if we are involved with the apparel industry. It is the responsibility of the garments manufacturers to maintain a required Garments quality standard for each and every product they are offering or delivering to the buyers. After reading this project we have found that the idea about all types of garments defects sewing defects.

TABLE OF CONTENTS

Chapter-1 Introduction	01
1.1 Background of the study.....	01
1.2 Objectives of the Study.....	01
1.3 Importance of the study.....	01
Chapter- 2 Literature Review	02
2.1 Sewing.....	02
2.2 Defects in sewing section	02
2.3 Mainly there are three types of garments defect:-.....	02
2.4 Non sewing defects.....	02
2.5 Sewing defect.....	03
2.6 Defects of stitch Formation.....	03
Chapter-3 DATA ANALYSIS AND PRESENTATION.....	16
3.0 Data Collection.....	16
3.1 Line Inspection Report -1.....	16
3.1.2 Line Inspection Report -2.....	20
3.1.3 Line Inspection Report -3.....	24
3.1.4 Line Inspection Report -4.....	28
3.2.1Line Inspection Report -5.....	32
3.2.2 Line Inspection Report -6.....	36
3.2.3 Line Inspection Report -7.....	40
3.2.4 Line Inspection Report -8.....	44
3.2.5 Line Inspection Report -9.....	47
3.2.6 Line Inspection Report -10.....	50
3.2.7 Line Inspection Report -11.....	52

3.2.8 Line Inspection Report -12.....	55
3.2.9 Line Inspection Report -13.....	57
Chapter – 4 Result and Discussion.....	59
4.1.0 Inspection Analysis of Jamuna Apparels Ltd.....	59
4.1.1 End Line inspection analysis of Jamuna Apparels Ltd.....	59
4.1.2 End Line inspection analysis of QC pass and rejected % in Jamuna Apparels Ltd.....	60
4.1.3 Comp. of Sewing Defects % Measurement –Report (1-4) at Jamuna Apparels Ltd	61
4.2.0 Inspection Analysis of Shad Fashion Apparels Ltd.....	63
4.2.1 Analysis of End Line Inspection Of Shad Fashion Ltd.....	63
4.2.2 End Line Inspection Analysis of QC pass and Rejected % at Shad Fashion Ltd.....	64
4.2.3 Comp.Sewing Defects % Measurement –Report (6-14) of Shad Fashion Ltd	66
4.3.1 DHU% Compare in jamuna Apparels Ltd.....	69
4.3.2 DHU% Compare in Shad Fashion Ltd.....	70
4.3.3 Compare DHU% Between Jamuna Apparels Ltd and Shad Fashion Ltd.....	71
Chapter -5 Conclusion.....	73
5.1 Conclusion.....	73
Reference	74

LIST OF TABLE

Table: 3.1-End Line Inspection Report- 1.....	18
Table: 3.2-End Line Inspection Report- 2.....	22

Table: 3.3-End Line Inspection Report- 3.....	26
Table: 3.4-End Line Inspection Report- 4.....	30
Table: 3.5-End Line Inspection Report- 5.....	35
Table: 3.6-End Line Inspection Report- 6.....	39
Table: 3.7-End Line Inspection Report- 7.....	43
Table:4.1- Comp. Sewing Defects % Measurement Report (1-4) at Jamuna Apparels Ltd.....	61
Table:4.2- Comp. Sewing Defects % Measurement Report (6-14) at Shad Fashion Ltd.....	66

LIST OF FIGURE

Fig: 2.6.1- Seam puckering.....	4
Fig: 2.6.2- Open Seam.....	5
Fig: 2.6.3-Broken Stitch.....	6
Fig: 2.6.4- Skipped stitch.....	7
Fig: 2.6.5- Loose thread.....	7
Fig: 2.6.6 - Seam slippage.....	8
Fig: 2.6.7- Thread breakage.....	9
Fig: 2.6.8 -Level missing.....	9
Fig: 2.6.9 -Needle hole.....	10
Fig-2.6.10-Pleating.....	11
Fig: 2.6.11 -Arm hole joint problem.....	11
Fig: 2.6.12-Uneven stitch.....	12
Fig: 2.6.13 - Raw edge.....	13
Fig: 2.6.14-Oil sport.....	13
Fig: 2.6.15 - Needle mark.....	14
Fig:-2.6.16-Tension loose.....	15
Fig: 3.1.1-Design/Sketch for style no 330998.....	16
Fig: 3.1.2- Measurement Chart.....	17

Fig: 3.1.3- Line Wish Detect status, Report -1.....	17
Fig: 3.1.4 -Design/Sketch for style no HIM ESSENTIAL.....	20
Fig: 3.1.5 Measurement Char.....	21
Fig: 3.1.6- Line Wish Detect status, Report -2.....	21
Fig: 3.1.7 -Design/Sketch for style no 330924.....	24
Fig: 3.1.8 Measurement Chart.....	25
Fig: 3.1.9- Line Wish Detect status, Report	25
Fig: 3.1.10-Design/Sketch for style no 3305243.....	28
Fig: 3.1.11-Measurement Chart.....	29
Fig: 3.1.12- Line Wish Detect status, Report -4.....	32
Fig: 3.2.1-Design/Sketch for style no VA982.....	33
Fig: 3.2.2 Measurement Chart.....	33
Fig: 3.2.3- Line Wish Detect status, Report -5.....	34
Fig: 3.2.4-Design/Sketch for style ch hare top w.....	37
Fig: 3.2.5 Measurement Chart.....	37
Fig: 3.2.6- Line Wish Detect status, Report -6.....	38
Fig: 3.2.7 -Design/Sketch for style no AY68.....	41
Fig: 3.2.8 Measurement Chart.....	41
Fig: 3.2.9- Line Wish Detect status, Report -7.....	42
Fig: 3.2.10 -Design/Sketch for style no VA982.....	45
Fig: 3.2.11- Line Wish Detect status, Report -8.....	46

Fig: 3.2.12 -Design/Sketch for style no AVV9.....	47
Fig: 3.2.13 - Measurement Chart.....	48
Fig: 3.2.14- Line Wish Detect status, Report -1.....	49
Fig: 3.2.15 -Design/Sketch for style no KXA8.....	50
Fig: 3.2.16 - Measurement Chart.....	51
Fig: 3.2.17 - Line Wish Detect status, Report -11.....	51
Fig: 3.2.18 -Design/Sketch for style no CRXP	53
Fig: 3.2.19 -Measurement Chart.....	53
Fig: 3.2.20- Line Wish Detect status, Report -12.....	54
Fig: 3.2.21 -Design/Sketch for style no VJ1598.....	55
Fig: 3.2.22 - Measurement Chart.....	55
Fig: 3.2.23 - Line Wish Detect status, Report -13.....	56
Fig: 3.2.24 -Design/Sketch for style no 330937.....	57
Fig: 3.2.25 - Measurement Chart.....	57
Fig: 3.2.26 - Line Wish Detect status, Report -14.....	58

LIST OF GRAPH

Fig: 4.1.1 Graphically Show End Line inspection analysis of Jamuna Apparels Ltd.....	59
Figure 4.1.2 -Graphically Show Data Analysis of End Line Inspection report(1-4).....	60
Fig:4.2.1 Graphically Show Analysis of End Line Inspection Of Shad Fashion Ltd.....	63
Figure:- Graphically Show Data analysis report for report-6, 7,8,9,10,11,12,13,14.....	64
Fig: 4.3.1 – Graph.Show Area chart of Jamuna Apparels diff. Buyer DHU% Comparison.....	70

Fig: 4.3.2 Graph. Show Area chart of Shad Fashion Ltd. Diff. Buyer DHU% Comparison.....71

Fig: 4.3.3 Graph. Show Comparison of Jamuna Apparels Ltd and Shad Fashion Ltd. DHU%.....72

CHAPTER- 01

INTRODUCTION

1.1 Background of the Study

The old concept textile means to wave but modern concept textile means knitting, dyeing, weaving, finishing etc. The textile sector is divided into many sectors and all sectors have some or many faults in this thesis paper we will try to show sewing faults and their remedies. In this thesis paper we want to explain different sewing faults and their remedies.

1.2 Objective of the Study

- To know about sewing process.
- To know about sewing faults.
- To know about sewing faults remedies.
- To minimize sewing fault.

1.3 Importance of the Study

This thesis paper will very important for all textile engineer mainly who is working in sewing section. If a textile engineer who had no idea about different defect identification in sewing then it will be a tough job, but if it is known properly then it is an easy task to identify different types of sewing faults. So every textile student must know about different types of defect identification and remedies in textile industry. In our country garments industry is most important for our economy. In garments industry if we reduce sewing faults we will get more money. After reading this thesis paper we have found this idea how to identify different fault and their remedies in sewing department

CHAPTER -02

LITERATURE REVIEW

2.1 Sewing

Sewing section is the most important department of the garments manufacturing where join the different cut piece by the use of thread and needle of a garments and made a full garments. Industrial sewing is done by different sewing machine. Home furnishing also use sewing. In sewing section different type faults are found here. If sewing section fault increase then garments owner face so many problem and it will be continue one day garments owner lost her business. In this Article we will try to highlight different sewing faults and their remedies.

2.2 Defects in sewing section

Sewing section is the last stage of manufacturing before marketing. Every customer wants to get a product which is free any defects. For this reason manufacturer wants to ready without any defects of product. That's why manufacturer aware in every stage and try to reduce defect in different stage. Defective product lost its cost in market. A product may contained different defect. Another terms near defect is called reject. A product becomes a reject when its loses its stability in the market. Rejection garments is hazardous for manufacturers. A single defect in the most visible area of garment might also make it reject.

2.3 Mainly there are three types of garments defect:-

- Critical defect
- Major defect
- Minor defect

Causes of defect: There are mainly two causes of defect:-

- Non sewing defect.
- Sewing defect

2.4 Non sewing defects:- Non-sewing defect means the defect which is occur without

sewing department occur in another textile department like,

- Hole of the fabric
 - Oil stain of the fabric
- I. Shade variation
 - II. Garments and button shade is not match
 - III. Used wrong pattern
 - IV. Wrong cutting V. Button broken
 - VI. Main label sport
 - VII. Missing warp and weft yarn
 - VIII. Dyeing sport
 - IX. Color fastness (staining)
 - X. Chalk , pen , or pencil marks visible
 - XI. Water sports not dried

2.5 Sewing defect:-

The defect which is occurred in sewing section by using needle and thread is called sewing defect. In sewing section different defect are occurs. The sewing defect can be classified into three groups such as,

- Defects of stitch formation
- Puckering
- Fabric defects along with sewing line

2.6 Defects of stitch Formation:-

1. Slipped stitch
2. Staggered stitch
3. Unbalanced stitch
4. Variable stitch density
5. Frequent thread breakage
6. Skip stitch

7. Broken stitch
8. Staggered stitch
9. Puckering
10. Uneven
11. Uncut thread
12. Dirt mark
13. Open seam ETC.

1. Seam puckering – Seam puckering is the common defect of sewing section. When two or more garments join together by sewing some wrinkle or waviness is occurred along the seam line is called seam pucker or seam puckering.



Fig: 2.6.1- Seam puckering

Causes of seam puckering:-

- Variable or uneven stretch on fabric piles.
- Yarn displace.
- Feeding puckering (pressure foot , feed dog and thread create mechanism is called feed mechanism)
- Excessive tension create seam puckering.
- Sewing thread shrinkage.
- Needle size(light fabric medium needle used or medium fabric light needle used) ➤ Wrong thread tension.

Remedies of seam puckering:- ➤

Remove excessive tension.

- Fabric shrinkage and sewing thread shrinkage should be equal.
- Must be used correct thread and proper needle size. (6 mm or more is best for medium to heavy sewing project).
- Reduce thread tension. Apply only enough tension.

2. Open seam - Seam means two part of fabric are join together when this two part fabric are not join correctly an open seam is occurred.



Fig: 2.6.2- Open Seam

Causes of open seam:-

- Operator did not work carefully.
- Wrong sizes needle use with compare of fabric and thread.
- Used sharp less needle.
- Used poor twisted yarn/thread.

Remedies of open seam:-

- Operator work must be carefully.
- Must used right sized needle with compare of fabric and thread.
- Used right needle.
- Before sewing must be confirm about twisting.

2. Broken stitch –

It is the common defects in any of sewing oriented manufacturing unit. If stitching thread broken after sewing and can't connect next stitch then its known as broken stitch.



Fig: 2.6.3-Broken Stitch

Causes of broken stitch:-

- Sewing tension is high.
- Thread quality is too poor.
- The machine used in over speed.
- Used thread sized is not correct.

Remedies of broken Stitch:-

- Used tension as machine adjustment.
- Used better quality thread.
- Used machine speed properly.

3. Skipped stitch –

When any lopper thread or bobbin thread fail to create loop in needle thread it's called skipped stitch. This is more harmful for chin stitch and lock stitch.



Fig: 2.6.4- Skipped stitch

Causes of skipped stitch:-

- Unsuitable thread.
- Defected needle.
- Wrong needle size.
- Needle thread loop size is too small.

Remedies of skipped stitch:-

- Observe the setting and timing between needle and hook/lopper.
- Used right thread.
- Replace defected needle.
- Used right needle size and thread size that are adjustable.
- Thread tension control.

5. Loose thread - The thread which is not cut after sewing is called loose thread.



Fig: 2.6.5-Loose thread

Causes of loose thread:-

- This fault is occur due to improper finishing.
- Unexperienced worker.

Remedies of loose thread:-

- Garments finishing check properly.
- Worker must have experienced.

- 6. Seam slippage** - Seam slippage is the separation or pulling apart of yarns in a fabric usually along a sewn seam or join.



Fig: 2.6.6 - Seam slippage

Causes of seam slippage:-

- When stress is applied to a seam, the yarns in the fabric slip out of the stitching causing an open seam.
- When stress is applied to a seam, the yarns in the fabric shift or slide in the weave construction causing seam grinning and fabric distortion.

Reduce of seam slippage:

- To avoid consider changing the seam construction to a French seam construction, increase the seam width or width of bite, optimize the stitches per inch and contact your fabric supplier.

7. Thread breakage - This defect occur more in sewing section. Needle thread breakage or bobbin/lopper thread breakage.

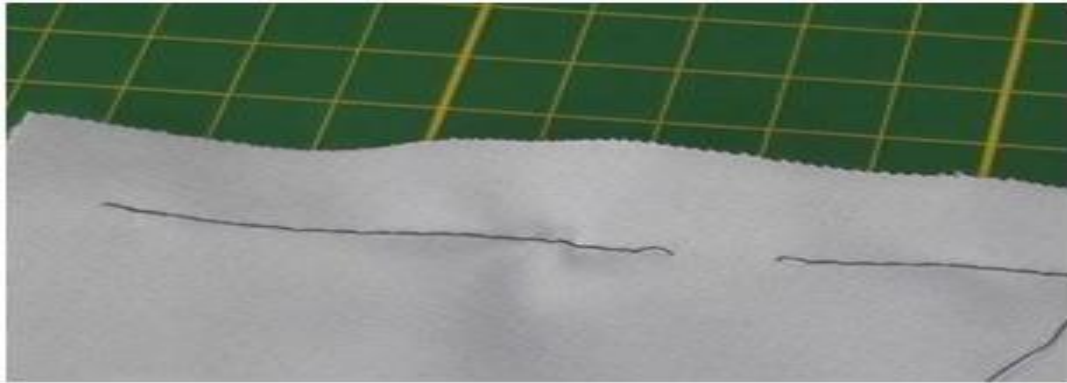


Fig:2.6.7- Thread breakage

Causes of needle thread breakage:-

- If threads fails to unwarp from thread package.
- If the metal surface of the hook point, bobbin case, needle hole, in throat plate etc with sharp.
- If the thread is prevented from going to the thread guide.
- Bobbin case fitting is wrong

Remedies of needle thread breakage:-

- Change the hook point bobbin case needle guard needle whole throated plate with sharp hole and to be smooth.
- Thread guide and thread package distance must above be 2.5.

8. Level missing - Care label are attached with sewing.



Fig: 2.6.8 -Level missing

Causes of level missing:-

- Worker Didn't work carefully
- Don't check ta garments carefully

Remedies of level missing:-

- Worker must work carefully ➤ Must the garments carefully.

9. Needle hole - In the seam line sometimes we see some hole which are create by needle in fabric is called needle hole.

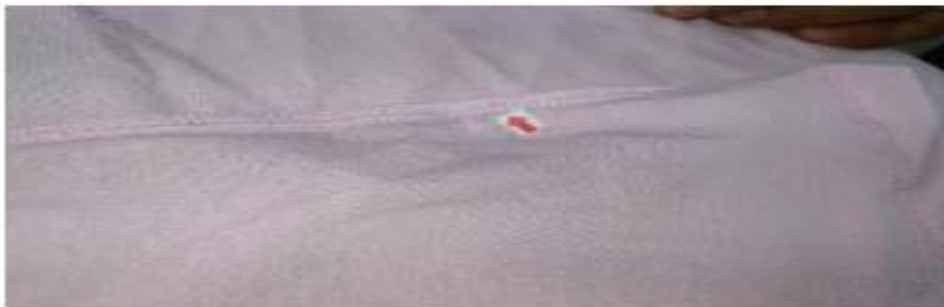


Fig: 2.9:-Needle holeFig

Causes of needle hole:-

- If don't used correct size needle.
- Used of damage needle.

Remedies of needle hole:-

- Used correct size needle.
- Must check needle before starting sewing.

10. Pleating –The Folder fabric in the seam line is called pleating defect.



Fig-2.6.10-Pleating

Causes of pleating:-

- Operator doesn't align both layer and feed properly.
- Operator handling problem.

Remedies of pleating:-

- Mechanics should be check all mechanics daily.
- Arrange daily training for operator.

11. Arm hole joint problem- Upper arm hole and lower arm hole is not joint properly.



Fig: 2.6.11 – arm hole joint problem

Causes of arm hole joint problem:-

- Worker Didn't work carefully.
- Tension is too high.

Remedies of arm hole joint problem: -

- Worker work must carefully.
- Tension must be control carefully.

12. Uneven stitch - When stitch don't follow a seam line, stitch displace on the seam line is called uneven stitch.



Fig:2.6.12-uneven stitch

Causes of uneven stitch:-

- Thread quality is not good.
- Operator did not work properly .
- Having machine problem.

Remedies of uneven stitch:-

- Used good quality thread.
- Operator must be experienced and work properly.
- If having any machine problem the at first solve this problem correctly.

13. Raw edge - If unexpected parts are shown by the garments from sewing area then this problem is occurred that called raw edge.



Fig: 2.6.13 - Raw edge

Causes of raw edge: -

- For the lack of experience or concentration of worker.

Remedies of raw edge:-

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

14. Oil sport - Sewing machine used oil for Mechanical purpose. Sometimes oil are sticks in garments. The oil sport are found in garments.



Fig: 2.6.14-oil sport

Causes of oil sport:-

- During sewing process if oil and wax are deposit from the machine to the fabric surface then oil spot is occurred.

Remedies of oil sport:-

- Oil spot is removed from the fabric by a special type of spray named 'Spot lifter'. First its Spray on the spot and then air blown on the spot by a machine named 'spot cleaning machine'.

15. Needle mark :- Without sewing requirement if give the sewing at garment of fabric then open the sewing but sew up needle hole at the fabric that called Needle mark.

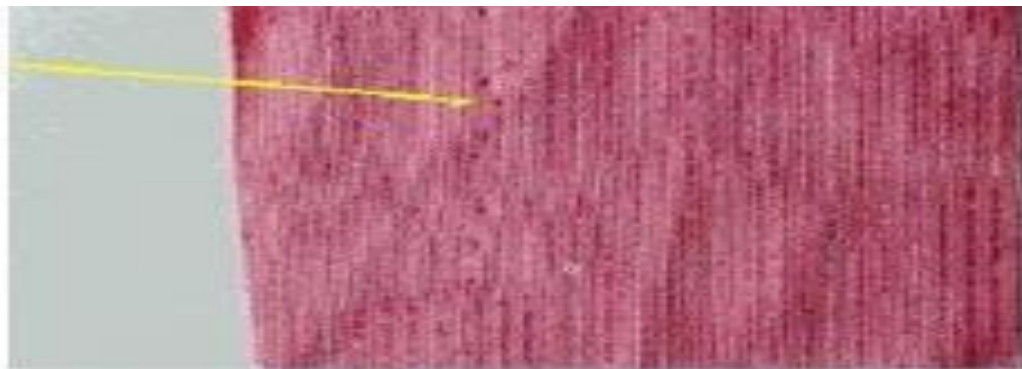


Fig: 2.6.15 - Needle mark

Causes of Needle Mark

- For uneven stitch or any uneven seam want to uniform then open that stitch or seam after that making this Needle mark.
- For the lack of experience or attention of worker.

Remedies of Needle mark ➤ To cure any types of sewing faults.

- To ironing at good temperature and uniform.

16. Tension Loose / Low:-As the defect name.

Recommended solution:-

- Thread placement of tension dice cant slipped out.
- Use minimum quality of thread.
- Same thread on needle and bobbin.
- Bobbin must correct.



CHAPTER-3

DATA ANALYSIS AND PRESENTATION

We have collected for 10 team data in “Jamuna Apparels Ltd.” and also 10 line data in “Shad Fashion Ltd.” And finally calculated defect percentage from different types of defects found in sewing line. A factory should set different modern quality procedures and quality management technique for the betterment of RMG sector. Broken stitch, skip stitch, drop stitch, Gathering Stitch, Uneven Stitch, Over Stitch, Uneven Seam Allowance, Open Seam, Puckering, Uneven Shape, Raw edge, Dirty Stain, Oil Stain, Incorrect Measurement, Shading, Bad Tension, Incorrect SPI, Twisted Banding, Incorrect Size Label, Missing Trims, Pleat, Crooked Label, Unmatched S Line, Reverse Attachment, Needle Hole, Cross Point Up Down, Without Barrack etc. are the most common defects found in sewing section.

3.1 Attachment of Line Wise Detect Status-Report of Jamuna Apparels Ltd.

Line Inspection Report- 1

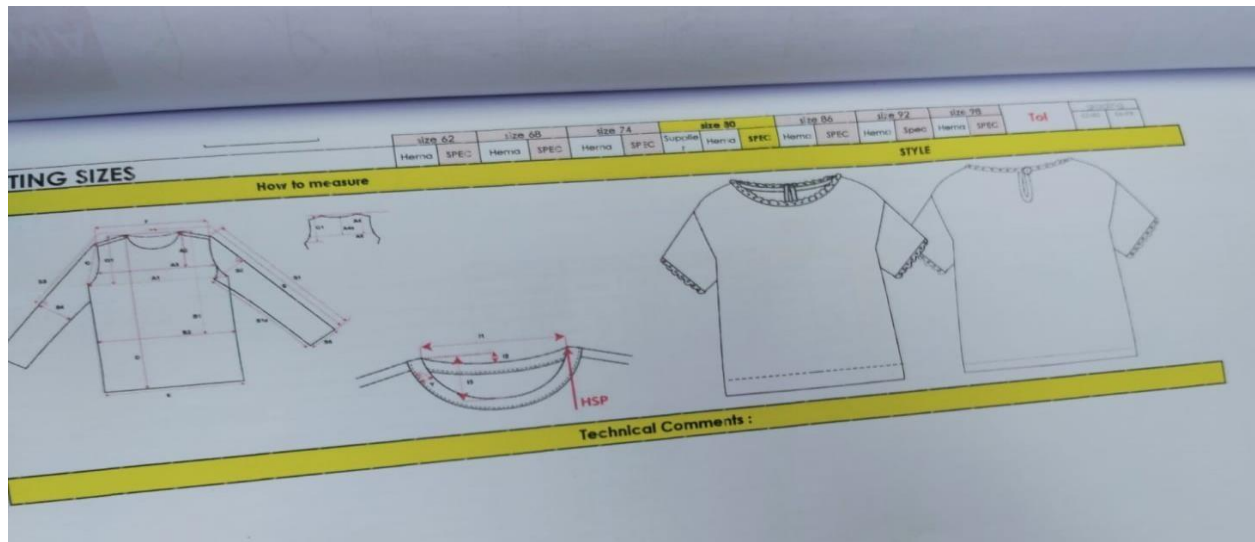




Fig: 3.1.1-Design/Sketch for style no 330998

 	DATE:	7/14/2021	MANUFACTURER:		STATUS:		Indication:
	DEPT:	Baby Girls	COUNTRY:		STANDARD:		
	ARTICLE NR:	330798	TECHNICIAN:	Hans	FABRIC:		
	ARTICLE:	Basic t-shirt ss	CM:	Rosemarin	COMPOSITION:		
	SEASON:	2022-	PM:	Marika	WEIGHT:		
FT:				MEASURED BY:	Marika	DATE:	11/22/2021

	size 62		size 68		size 74		size 80		size 86		size 92		size 98		Tol	22/20/24	
	Hema	SPEC	Hema	SPEC	Hema	SPEC	Hema	SPEC	Hema	SPEC	Hema	SPEC	Hema	SPEC		ASD	BS-18
Total front length, frm HSP	✓	30.5	✓	32	✓	33.5	✓	35	✓	36.5	✓	38	✓	39.5	1	1.0	1.0
Shoulder to shoulder	✓	21	+5	22	✓	23	✓	24	✓	25	✓	26	✓	27	0.5	1.0	1.0
1/2 chestwidth	+1	25	+5	26	+1	27	+1	28	+1	29	+1	30	+1	31	0.5	1.0	1.0
1/2 bottom width	✓	27	✓	28	+2	29	✓	30	✓	31	+5	✓	32	✓	33	0.5	1.0
Short sleeve																	
Armhole straight inside	+5	10	+5	10.5	✓	11	+5	11.5	+5	12	✓	12.5	+5	13	0.5	0.5	0.5
1/2 Bicep width	✓	8.5	✓	9	✓	9.5	✓	10	✓	10.5	✓	11	✓	11.5	0.5	0.5	0.5
1/2 sleeve opening SHORT	✓	8	✓	8.5	✓	9	✓	9.5	✓	10	✓	10.5	✓	11	0.5	0.5	0.5
Total sleeve frm CBN	+1	17.5	✓	18.5	+1	19.5	+1	20.5	+1	21.5	+1	22.5	+1	23.5	0.5	1.0	1.0
seam length sleeve	✓	2.1	✓	2.4	✓	2.7	✓	3	✓	3.3	✓	3.6	✓	3.9	0.5	0.5	0.5
Tape height	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	0	0.0	0.0
O-neck binding																	
Neckwidth inside msrd straight	-5	11.5	-5	11.5	-5	12	-5	12	-5	12.5	-5	13	-5	13.5	0.5	0.5	0.5
Neckdrop back inside msrd straight	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	0.2	0.0	0.0
Neckdrop front inside msrd straight	+5	4	✓	4	+5	4.5	+5	4.5	✓	4.5	✓	5	✓	5.5	0.2	0.5	0.5
Tape height	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	✓	1.5	0	0.0	0.0
1/2 Min. Neckstretchability	✓	25	✓	25	✓	25	✓	25	✓	27.5	✓	27.5	✓	27.5	0	0	0
Slit																	
Slit length	✓	8	-5	8.5	-5	8.5	✓	9	✓	9	+5	9.5	✓	9.5	0	0.5	0.5
Binding width slit	✓	0.7	✓	0.7	✓	0.7	✓	0.7	✓	0.7	✓	0.7	✓	0.7	0	0.0	0.0

MEASUREMENTS ARE IN FINISHED CMS. AFTER WASH / DYE / ETC
 Tolerance: 1/2 grading value with a maximum of 1 cm! No tolerance is accepted at the stand width msrd closed or at minimum neckstitch (neck circumference)

FOR SIZE SET SAMPLE
 DATE- 25-11-21
 OK

Fig: 3.1.2- Measurement Chart

Jamuna Apparels limited.(Unit-01,Unit-02) Line Wise Defect Status																												
Defect Code	001	002	003	004	005	006	007	008	009	010	011	012	013	014	015	016	017	018	019	020	021	022	023	024	025	026	027	028
Defect Name	Open Seam	Wrtt Blotch	Run Of Stitch	Unsewn Seam	Down Stitch	Broken Stitch	Stitch Overlap	Stitch Mark	Stitch Hole	Stitch Overlap/Under Stitch	Stitch Mark	Stitch Hole	Stitch Overlap	Stitch Mark	Stitch Hole	Stitch Overlap	Stitch Mark	Stitch Hole	Stitch Overlap	Stitch Mark	Stitch Hole	Stitch Overlap	Stitch Mark	Stitch Hole	Stitch Overlap	Stitch Mark	Stitch Hole	
Team-1				36																								
Team-2	2	20		18																								
Team-3				4																								
Team-4				8																								
Team-5				3																								
Team-6	16	23								10																		
Team-7																												
Team-8																												
Team-9																												
Team-10	16	23		10																								
Team-11				12																								
Team-12				8						10																		
Team-13				12																								
Team-14				10																								
Team-15				12																								
Team-16				10																								
Team-17				12																								
Team-18				10																								
Finishing-1				6																								
Finishing-2				10																								
Finishing-3				12																								

440 DIRTY SPOT- 13, 445 DARK IRON G, 440 BARTACK 2, 450 REJECTS- 2.
 4302 REJECTS- 4, 440 BARTACK- 15.
 446 DIRTY SPOT-

Fig: 3.1.3- Line Wish Detect status, Report -1

A copy of End of The End Line Inspection report is attached that we have collected from the “**Jamuna Apparels ltd**”.

BUYER	HEMA	STYLE	330998	Date:-9-1-22
Product name	T-shirt	Inspector	Md.Afzal	

Jamuna Apparels Ltd

DAILY END-LINE INSPECTION REPORT

Defect Name	Team 1	Team 2	Team 3	Team 4	Team 5	Team 6	Team 7	Team 8	Team 9	Team 10	Finishing1	Finishing2	Finishing3
Open Seam			2			16				16			
Skip Stitch		20	18			23			23	13	18	37	27
Uneven Stitch	54	29	4						10	16			
Down Stitch			8	9						17	6	39	9
Broken Stitch		15									15	38	12
Stitch Joint						10						43	9

Uncut Thread											22	85	41
Puckering											3		
Pleats	15	14	5	5					12	15			
Gathering													
Raw edge			5	23									
Uneven Stitch Width					20								
Up-Down	17								11				
Lop Show				12									
Insecure Bar tack	11		2										
Wrong placement				14	23								
Slanted		20		17	23								
Ruffing													
Dirty Spots			3										
Oil Mark										14			
Total	97	98	47	80	66	49	00	00	56	91	00	00	00

Table: 3.1-End Line Inspection Report- 1

$$\begin{aligned} \text{DHU} &= (\text{Total No of Defective Pieces}/\text{Total No of Pieces Checked}) * 100 \\ &= (584/12231) * 100\% \\ &= 4.77\% \end{aligned}$$

From The Table 3.1 we can see that, at sewing (team 1to 10) our observation date was 09-01-2022. The buyer was Hema. Total worker or operator worked at sewing (Team 1 to 10) was 105 with 20 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 12231 pcs of garments and there have been total 584 defects. In this way, total 12231pcs of garments checked in our 8hrs observation. Here we totally found 584 pitches of defective garments where 7 pitches are rejected.

3.1.2 Attachment of Line Wise Detect Status- Line Inspection Report- 2



Fig: 3.1.4 -Design/Sketch for style no HIM ESSENTIAL

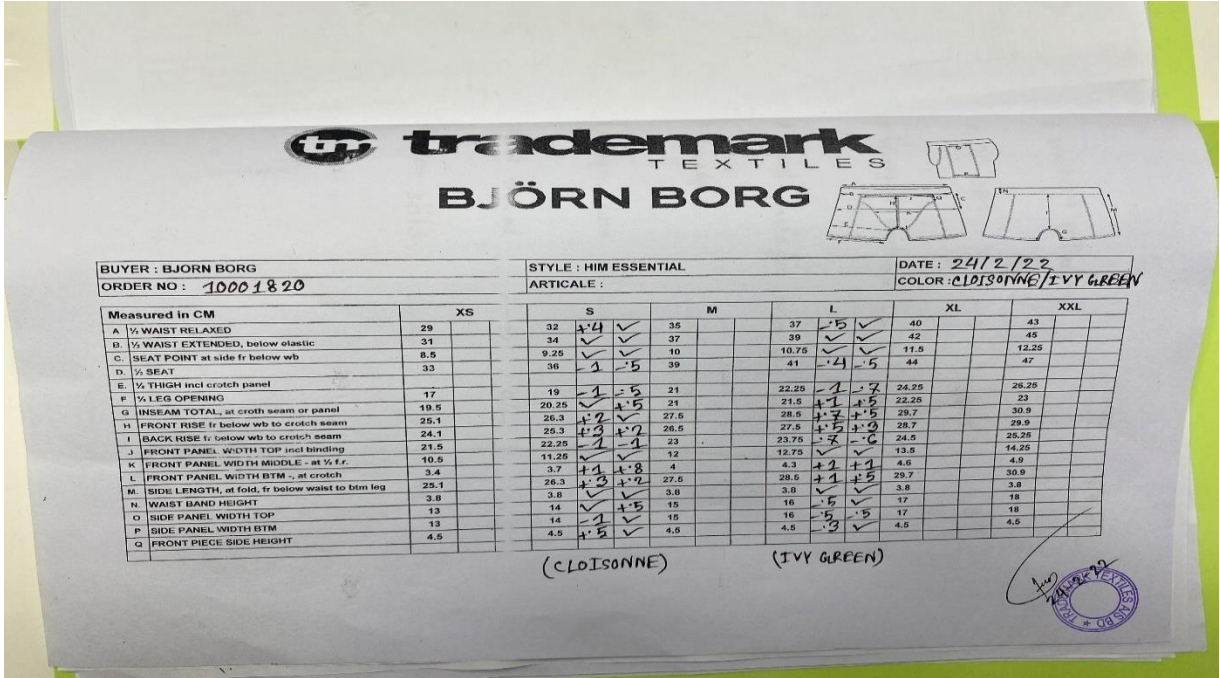


Fig: 3.1.5 Measurement Chart

Jamuna Apparels limited, (Unit-01, Unit-02)
Line Wise Defect Status

Date	10-07-2022																											
Defect Code	S01	S02	S03	S04	S05	S06	S07	S08	S09	S10	S11	S12	S13	S14	S15	S16	S17	S18	S19	S20	S21	S22	S23	S24	S25	S26	S27	S28
Defect Name	Open Seam	Stitch Break	Run Of Stitch	Unseen Stitch	Down Stitch	Broken Stitch	Stitch Overlap	Needle Mark	Stitch Jank	Stitch Loosen	Tangled/Lines/Tension	Stitch	Stitch	Wrong Thread	Unset Thread	Incorrect Point	Unset	Unset	Puckering	Flare	Coloring	Scouring	Fading	Printing	Unseen	Unseen	Unseen	Unseen
Team-1				48															12			17						9
Team-2		12		27	14														6			4						6
Team-3	2	15		10															26			7						27
Team-4																												
Team-5	9	16																		7			12					
Team-6																												
Team-7																												
Team-8																												2
Team-9																												
Team-10	17	135		23	11															6			7					8
Team-11		2																		8	8							9
Team-12	10																			11	6							
Team-13																												
Team-14				14																	63			23				12
Team-15				22																								
Team-16																												
Team-17						6																						
Finishing-1		10					14											205										
Finishing-2		24					27											34										
Finishing-3		25					16											41										

Defect Code	S29	S30	S31	S32	S33	S34	S35	S36	S37	S38	S39	S40	S41	S42	S43	S44	S45	S46	S47	S48
Defect Name	Strip/Clean Mark	Covering/Un	Incorrect	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong	Wrong
Team-1																				
Team-2																				
Team-3																				
Team-4																				
Team-5	10																			
Team-6																				
Team-7																				
Team-8																				
Team-9																				
Team-10																				
Team-11																				
Team-12																				
Team-13																				
Team-14																				
Team-15																				
Team-16																				
Team-17																				
Finishing-1	444	DIRTY SPOT			11															
Finishing-2	453	REFLECTS																		
Finishing-3	444	DIRTY SPOT																		

90
80
46
60
45
50

4
75
75
50
50

188
64

91
122
124

Fig: 3.1.6- Line Wish Detect status, Report -2

A copy of End of The End Line Inspection report is attached that we have collected from the “**Jamuna Apparels ltd**”

BUYER	Buyer: TRADE MARK	STYLE	HIM ESSENTIAL	Date:-10-1-22
Product name	BOXER	Inspector	Md.Afzal	

Jamuna Apparels Ltd

DAILY END-LINE INSPECTION REPORT

Defect Name	Team 1	Team 2	Team 3	Team 4	Team 5	Team 6	Team 7	Team 8	Team 9	Team 10	Finishing1	Finishing2	Finishing3
Open Seam			2			9				17			
Skip Stitch		17	15			10			2	13	19	34	25
Uneven Stitch	48	27	10							23			
Down Stitch		14								11	6		9
Broken Stitch											14	37	10
Stitch Joint													11
Loose tension				3									

Uncut Thread											23	34	41
Puckering		9									3		
Pleats	12		6	26		7							
Gathering													
Raw edge	11		4	5		12							
Uneven Stitch Width					21								
Up-Down	9		6						2				
Lop Show				10									
Insecure Bar tack	10												
Wrong placement					21								
Slanted		13		8	23	12							
Ruffing													
Dirty Spots			3										
Oil Mark										11			
Reject				8									
Total	90	80	46	60	65	50	00	00	4	75			

Table: 3.2- Line Wish Detect status, Report -2

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (470/9606) * 100\%$$

$$= 4.89\%$$

From The Table 3.2 we can see that, at sewing (team 1 to 10) our observation date was 10-01-2022. The buyer was Hema. Total worker or operator worked at sewing (Team 1 to 10) was 105 with 20 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 9606 pcs of garments and there have been total 470 defects. In this way, total 9606 pcs of garments checked in our 8hrs observation. Here we totally found 470 pitches of defective garments where 3 pitches are rejected.

3.1.3 Attachment of Line Wise Detect Status- Line Inspection Report- 3

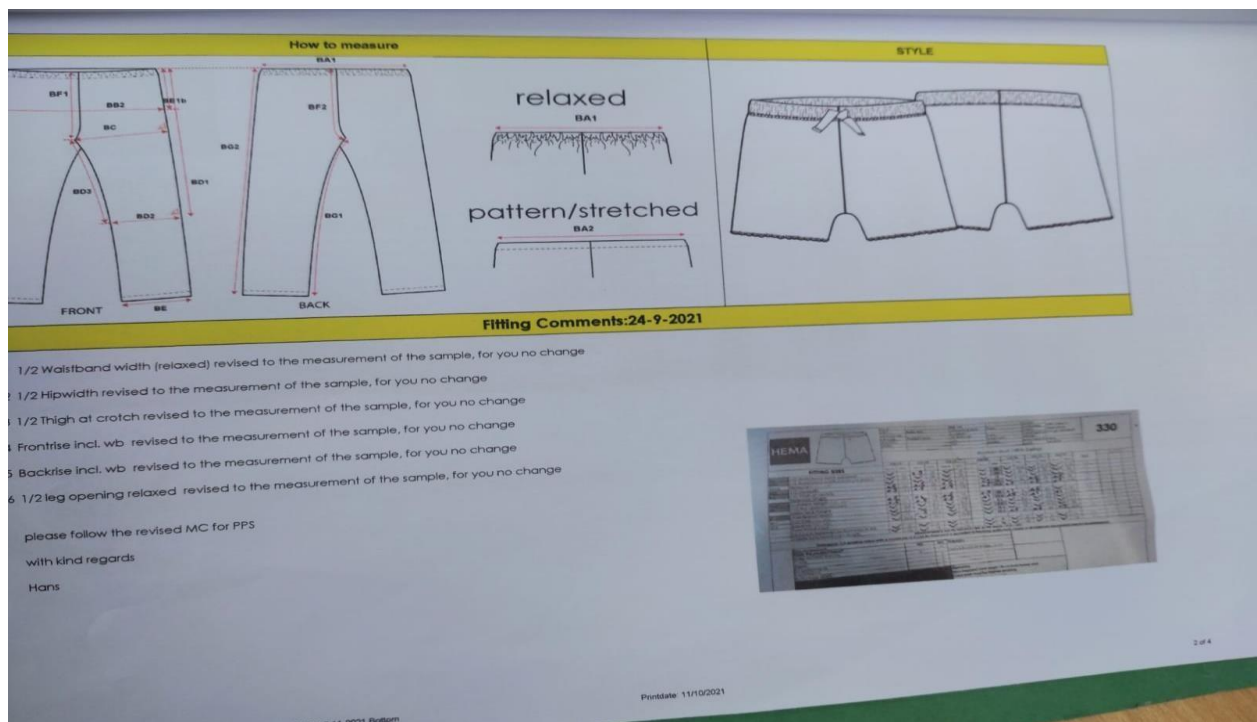


Fig: 3.1.7 -Design/Sketch for style no 330924

Product name	BOXER	Inspector	Alom Mondol
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Jamuna Apparels Ltd

DAILY END-LINE INSPECTION REPORT

Defect Name	Team 1	Team 2	Team 3	Team 4	Team 5	Team 6	Team 7	Team 8	Team 9	Team 10	Finis hing1	Finis hing2	Finis hing3
Open Seam	3	8	17			8				18			
Skip Stitch		10	9			12				10	24	32	28
Uneven Stitch	31	23		16						25			
Down Stitch	5		5	10						17	08	37	11
Broken Stitch											21	32	09
Stitch Joint												44	10
Uncut Thread											29	33	42
Puckering											2		
Pleats		28		09		21				17			
Raw edge	17		9	4									
Fraying													

Uneven Stitch Width					19								
Up-Down	13					06							
Wrong placement		09		16	19								
Slanted				10	20	07							
Dirty Spots			09										
Oil Mark	18				12					28			
Reject													
Total	87	78	49	65	70	54	00	00	00	115			

Table:- 3.3 Line Wish Detect status, Report -3

$$\begin{aligned}
 \text{DHU} &= (\text{Total No of Defective Pieces}/\text{Total No of Pieces Checked})*100 \\
 &= (538/9035)*100\% \\
 &=5.95\%
 \end{aligned}$$

From The Table 3.3 we can see that, at sewing (team 1to 10) our observation date was 11-01-2022. The buyer was Hema. Total worker or operator worked at sewing (Team 1 to 10) was 105 with 20 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 9035 pcs of garments and there have been total 538 defects. In this way, total 9035pcs of garments checked in our 8hrs observation. Here we totally found 538 pitches of defective garments where 6 pitches are rejected.

3.1.4 Attachment of Line Wise Detect Status- Line Inspection Report- 4

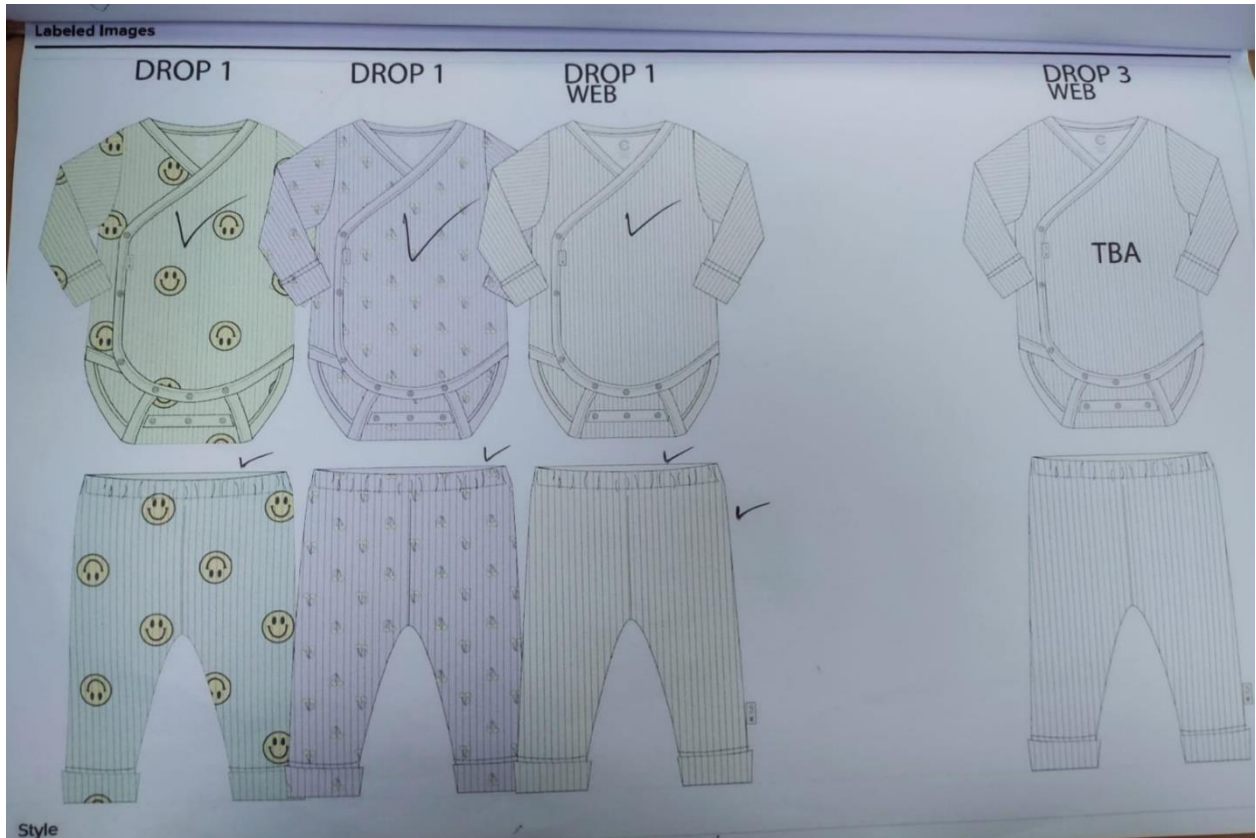


Fig: 3.1.11-Design/Sketch for style no 3305243

BUYER	Auchan	STYLE	3305243	Date:-12-1-22
Product name	Brief	Inspector	Alom Mondol	

Jamuna Apparels Ltd

DAILY END-LINE INSPECTION REPORT

Defect Name	Team 1	Team 2	Team 3	Team 4	Team 5	Team 6	Team 7	Team 8	Team 9	Team 10	Finis hing1	Finis hing2	Finis hing3
Open Seam						10				17			
Skip Stitch		13	6			22				16	23	33	26
Uneven Stitch	35	23								18			
Down Stitch			6							16	8	34	10
Broken Stitch			6								24	37	10
Stitch Joint												36	11
Loose tension				5									
Uncut Thread											30	33	41
Pleats	14	33	2	2		10				11			

Gathering													
Raw edge			11	25		11							
Uneven Stitch Width					21								
Up-Down	8					7							
Lop Show				2									
Insecure Bar tack	22		8										
Wrong placement		17		26	22								
Slanted				32	27								
Ruffing													
Dirty Spots			22										
Oil Mark	3									20			
Total	82	86	61	92	70	60	00	00	00	98			

Table 3.4 Line Wish Detect status, Report -4

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (518/8275)*100\%$$

=6.25%

From The Table 3.4 we can see that, at sewing (team 1to 10) our observation date was 12-01-2022. Total worker or operator worked at sewing (Team 1 to 10) was 105 with 20 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 8275 pcs of garments

and there have been total 518 defects. In this way, total 8275pcs of garments checked in our 8hrs observation. Here we totally found 518 pitches of defective garments where 3 pitches are rejected.

**3.2.1 Attachment of Line Wise Detect Status-
Line Inspection Report- 5**



Fig: 3.2.1-Design/Sketch for style no VA982

next										BODYSUIT 01 - 100% COTTON INTERLOCK		
Size Specification Basic Block date										Fitted Sample Image to be updated by the supplier at white seal stage		
MANUFACTURER: 0										PHASE: 0	SEASON: 0	Fitted Sample Image to be updated by the supplier at white seal stage
NEXT ITEM NUMBER(S): 0										MANUFACTURER REF: 0	Fitted Sample Image to be updated by the supplier at white seal stage	
DESCRIPTION: Bodysuit 01 - Long & Short Sleeve (Shoulder opening or Envelope neck) 100% COTTON INTERLOCK ONLY (no single jersey)										Fitted Sample Image to be updated by the supplier at white seal stage		
Refer to Childrenswear Measuring Points and How to Measure Diagram CMP17 and Childrenswear Product Requirements CPR13										Fitted Sample Image to be updated by the supplier at white seal stage		
NEXT TECHNOLOGIST: 0										ISSUE DATE: 8.11.17		
APPROVED BY: Approved by name										UPDATED: 8.11.17		
This information is confidential and belongs exclusively to Next Plc. And the purchase conditions apply												
	SIB BABY	FIRST SIZE	UP TO 1 MTH	UP TO 3 MTH	3-6 MTHS	6-9 MTHS	9-12 MTHS	12-18 MTHS	1 1/2 - 2 YRS	2-3 YRS	Tol +/-	
A	27	30	33	36	39	41	43	45	47	49	1	
B	11.5	13	14.5	16	17.5	19	20.5	22	23.5	25	1	
C	19	20	21	22	23	24	25	26	27	28	1	
D	19	20	21	22	23	24	25	26	27	28	0.5	
E	9	9.5	10	10.5	11	11.5	12	12.5	13	13.5	0.5	
F	8	8.5	9	9.5	10	10.5	11	11.5	12	12.5	0.5	
G	5.5	5.5	6	6	6.5	6.5	7	7	7.5	7.5	0.5	
H	7	7	7.5	7.5	8	8	8.5	8.5	9	9	0.5	
I	15	16	17	18	19	20	21	22	23	24	0.5	
J	13.5	14.5	15.5	16.5	17.5	18.5	19.5	20.5	21.5	22.5	0.5	
K	14	15	16	17	18	19	20	21	22	23	0.5	
L	22	24	26	28	31	34	37	40	43	46	1	
M	5.5	6	6.5	7	7.5	8	8.5	9	9.5	10	0.5	
N	9.5	9.5	9.5	10	10.5	11	11.5	12	12.5	13	0.5	
O	4	4	4	4.5	4.5	5	5	5.5	5.5	5.5	0.5	
P	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	0	
Q	8.5	9	9.5	10	10.5	11	11.5	12	12.5	13	0.5	
R	3	3	3	3	3	3.5	3.5	3.5	3.5	3.5	0.5	
S	1	1	1	1	1	1	1	1	1	1	0	
T	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0	
U	27	27	27	27	27	27	27	28	28	28	min	
V	2	2	2	2	3	3	3	3	3	3	0	
W	0	0	0	0	11	11.5	12	12.5	13	13.5	0.5	
X	9	10	10	11	0	0	0	0	0	0	0.5	
Y	0	0	0	0	19	19.5	20	21.5	22	22.5	0.5	
Z	14	15	16	17	0	0	0	0	0	0	0.5	
1a	0	15	16	17	18	19	20	21	22	23	0.5	
2a	15	0	0	0	0	0	0	0	0	0	0.5	

next										BODYSUIT 01 - 100% COTTON INTERLOCK		
Size Specification Basic Block date										Fitted Sample Image to be updated by the supplier at white seal stage		
MANUFACTURER: 0										PHASE: 0	SEASON: 0	Fitted Sample Image to be updated by the supplier at white seal stage
NEXT ITEM NUMBER(S): 0										MANUFACTURER REF: 0	Fitted Sample Image to be updated by the supplier at white seal stage	
DESCRIPTION: Bodysuit 01 - Long & Short Sleeve (Shoulder opening or Envelope neck) 100% COTTON INTERLOCK ONLY (no single jersey)										Fitted Sample Image to be updated by the supplier at white seal stage		
Refer to Childrenswear Measuring Points and How to Measure Diagram CMP17 and Childrenswear Product Requirements CPR13										Fitted Sample Image to be updated by the supplier at white seal stage		
NEXT TECHNOLOGIST: 0										ISSUE DATE: 8.11.17		
APPROVED BY: Approved by name										UPDATED: 8.11.17		
This information is confidential and belongs exclusively to Next Plc. And the purchase conditions apply												
	SIB BABY	FIRST SIZE	UP TO 1 MTH	UP TO 3 MTH	3-6 MTHS	6-9 MTHS	9-12 MTHS	12-18 MTHS	1 1/2 - 2 YRS	2-3 YRS	Tol +/-	
1	4	4.5	4.5	4.5	5	5	5	5.5	5.5	5.5	0.25	
2					0	0	0	0	0	0	0	
3					0	0	0	0	0	0	0	
4					0	0	0	0	0	0	0	
5					0	0	0	0	0	0	0	
6					0	0	0	0	0	0	0	
7					0	0	0	0	0	0	0	
8					0	0	0	0	0	0	0	
9					0	0	0	0	0	0	0	
10					0	0	0	0	0	0	0	
11					0	0	0	0	0	0	0	
12					0	0	0	0	0	0	0	
13					0	0	0	0	0	0	0	
14					0	0	0	0	0	0	0	
15					0	0	0	0	0	0	0	
16					0	0	0	0	0	0	0	
17					0	0	0	0	0	0	0	
18					0	0	0	0	0	0	0	
19					0	0	0	0	0	0	0	
20					0	0	0	0	0	0	0	

MULTIPLE BODYSUIT PACKS:-
1. ALL MEASUREMENTS MUST BE WITHIN TOLERANCE TO SPEC
2. ALL GARMENTS WITHIN A PACK MUST BE THE SAME MEASUREMENTS.

next										BODYSUIT 01 - 100% COTTON INTERLOCK		
Size Specification Basic Block date										Fitted Sample Image to be updated by the supplier at white seal stage		
MANUFACTURER: 0										PHASE: 0	SEASON: 0	Fitted Sample Image to be updated by the supplier at white seal stage
NEXT ITEM NUMBER(S): 0										MANUFACTURER REF: 0	Fitted Sample Image to be updated by the supplier at white seal stage	
DESCRIPTION: Bodysuit 01 - Long & Short Sleeve (Shoulder opening or Envelope neck) 100% COTTON INTERLOCK ONLY (no single jersey)										Fitted Sample Image to be updated by the supplier at white seal stage		
Refer to Childrenswear Measuring Points and How to Measure Diagram CMP17 and Childrenswear Product Requirements CPR13										Fitted Sample Image to be updated by the supplier at white seal stage		
NEXT TECHNOLOGIST: 0										ISSUE DATE: 8.11.17		
APPROVED BY: Approved by name										UPDATED: 8.11.17		
This information is confidential and belongs exclusively to Next Plc. And the purchase conditions apply												
	SIB BABY	FIRST SIZE	UP TO 1 MTH	UP TO 3 MTH	3-6 MTHS	6-9 MTHS	9-12 MTHS	12-18 MTHS	1 1/2 - 2 YRS	2-3 YRS	Tol +/-	
3a	11	11.5	12	12.5	13	13.5	14	14.5	15	15.5	0.5	
4a	12	12.5	13	13.5	14	14.5	15	15.5	16	16.5	0.5	
5a	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	0	
6a	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	0	
7a	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	0	
8a	1	1	1	1	1	1	1	1	1	1	0	
9a	2	2	2	2	2	2	2	2	2	2	0	
0	0	0	0	0	0	0	0	0	0	0	0	
0	0	0	0	0	0	0	0	0	0	0	0	
0	0	0	0	0	0	0	0	0	0	0	0	

Fig: 3.2.2 Measurement Chart

DAILY END-LINE INSPECTION REPORT

Defect Name	Line 1	Line 2	Line 3	Line 4	Line 5	Line 6	Line 7	Line 8	line 9	Line 10
Broken Stitch				4	9	12	13	12	14	9
Skip Stitch		10		8			16	7	17	4
Open seam			9		12	12	12	11	6	
Pleated									17	
Reject	3	0	7	12	6	8	4	2	5	9
Point up down					12					
Hi low								7		
Uneven Stitch			12			8				
Oil							26	1		
Un cut thread	27	11	14	20	13	15	19	16	29	10
Tack wrong side				10						
Poor neck shape		12								
Join stitch							18			
loops	17									

Total	44	33	45	42	46	47	78	62	83	27
Total check	2018	731	1067	1470	1450	1217	873	776	1558	330
DHU%	2.18%	4.51%	4.22%	2.86%	3.17%	3.86%	8.93%	7.99%	5.33%	8.18%

Table 3.5- Line Wish Detect status, Report -5

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (507/11490)*100$$

=4.41%

From The Table 3.5 we can see that, at sewing (line 1 to 10) our observation date was 02-10-2021. The buyer was NEXT SCOURING 4 pack body suit style VA982 it is a combo pack 4 pieces combo 4 pics bodysuit. Total worker or operator worked at sewing (line 1 to 10) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 2018 pcs of garments and there have been total 44 defects. In this way, total 2018pcs of garments checked in our 8hrs observation. Here we totally found 44 pitches of defective garments where 56 pitches are rejected.

3.2.2 Attachment of Line Wise Detect Status- Line Inspection Report- 6

A copy of End of The End Line Inspection report is attached that we have collected from the “**Shad Fashion ltd**”.

BUYER	Varner	STYLE	Ch hare top W	Date:3-10-2021
Product name	SWIM TOP	Inspector	Abdul Aziz	

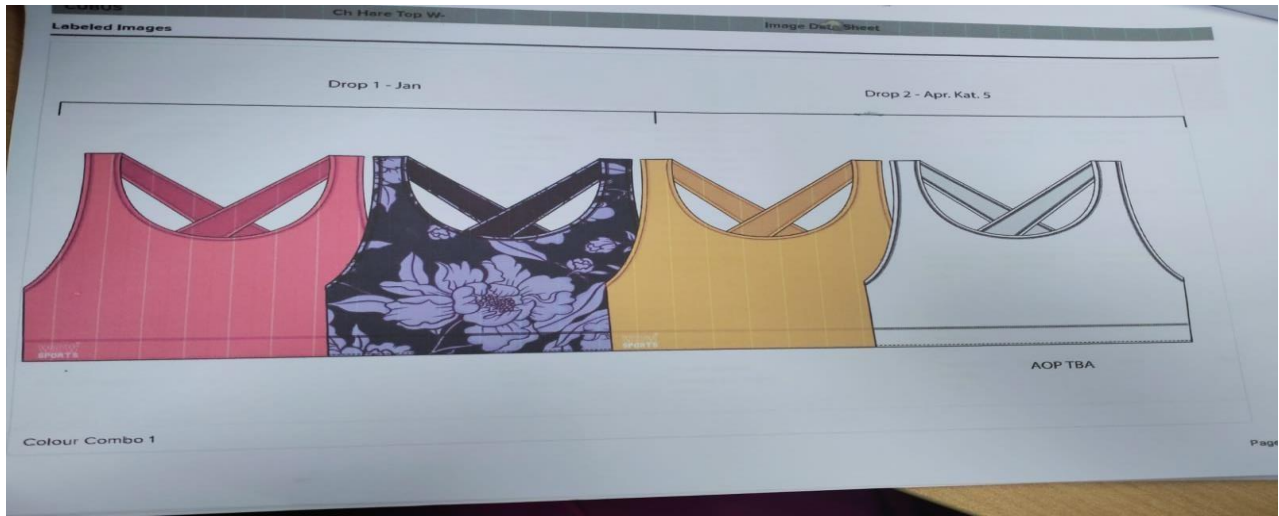


Fig: 3.2.4-Design/Sketch for style ch hare top w

CUBUS		Ch Hare Top W		Mmchart_Ch Hare Top W_Varner Girls Big - Swim top - Multisize - NEW					Mmchart_Ch Hare Top W_Varner Girls Big - Swim top - Multisize - NEW	
Image		Size Range	CHILDREN MULTI - 122/128 - 158/164, 170					Size Chart		
Front & Back		Sizes	122/128, 134/140, 146/152, 158/164, 170							
		Base Size	146/152							
Dimensions										
Description	Tol (+)	Tol (-)	122/128	134/140	146/152	158/164	170	Comment		
1/2 Chest	-0.50	0.50	28.00	30.00	32.00	34.00	35.00	Based on Ninni swim top 5521		
1/2 Underbust (at hem)	-0.50	0.50	27.00	29.00	31.00	33.00	34.00			
Shoulder width (incl. trim)	-0.30	0.30	3.00	3.00	3.00	3.00	3.00			
Measured at HPS.										
Neck width -Underwear	-0.50	0.50	17.00	17.50	18.00	18.50	18.75			
Neck drop front (from HPS)	-0.50	0.50	11.00	11.50	12.00	12.50	12.75			
Neck drop back (from HPS)	-0.50	0.50	18.50	18.50	18.50	18.50	18.50			
Measured from HPS to main body.										
Center front height (incl. elastic trim)	-0.50	0.50	13.50	15.25	17.00	18.75	19.55			
Center back height (incl. elastic trim)	-0.50	0.50	6.50	8.50	10.50	12.50	13.50			
Center back width position (from HPS)	0.00	0.00	9.00	9.75	10.50	11.25	11.65			
Armhole depth (from HPS)	-0.50	0.50	16.50	17.50	18.50	19.50	20.00			
Side height (incl. elastic trim)	-0.50	0.50	9.50	10.00	10.50	11.00	11.25			
Elastic height	-0.20	0.20	3.50	3.50	3.50	3.50	3.50			
Displaying 1 - 12 of 14 results								Units: CM Increment Display: Absolute		

Pattern ok *[Signature]*
9-12-21 Page 1

Fig: 3.2.5 Measurement Chart

DAILY END-LINE INSPECTION REPORT

Defect Name	Line-41	Line-42	Line-43	Line-44	Line-45	Line-46	Line-47	Line-48	Line-49	Line-50
Broken Stitch			9	8					12	15
Skip Stitch	7		15				18		3	5
Without tack										
Open seam			20			2	12	7	6	15
Slanted	10									
Pleated			5			5	17	20		
Reject	8	0	4	0	0	2	2	0	6	10
Point up down			9			7	17	15	9	
Uneven Stitch	7									
Oil	21						9			
Un cut thread	24		13	14		9	16	11	16	40
Label wrong side										
Tack wrong side						4				11
Neck rib width uneven								8		
Join stitch		13			15					
Needle hole					5					
Raw edge	16							11		

Total	64	13	71	22	20	27	80	72	46	86
Total Check	543	0	690	850	0	350	882	1137	1392	1360
DHU%	11.79 %	0	10.29 %	2.59%	0	7.71%	9.07%	6.63%	3.30%	6.32%

Table 3.6- Line Wise Detect status, Report -6

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (501/7240)*100$$

=6.95%

From The Table 3.6 we can see that, at sewing (line 41to 50) our observation date was 03-10-2021. The buyer was Varner style Ch hare top W different color swim top. Its order quantity is 300000. Total worker or operator worked at sewing (line 1 to 10) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 7240 pcs of garments and there have been total 501 defects. In this way, total 7240pcs of garments checked in our 8hrs observation. Here we totally found 501 pitches of defective garments where 32 pitches are rejected.

3.2.3 Attachment of Line Wise Detect Status- Line Inspection Report- 7

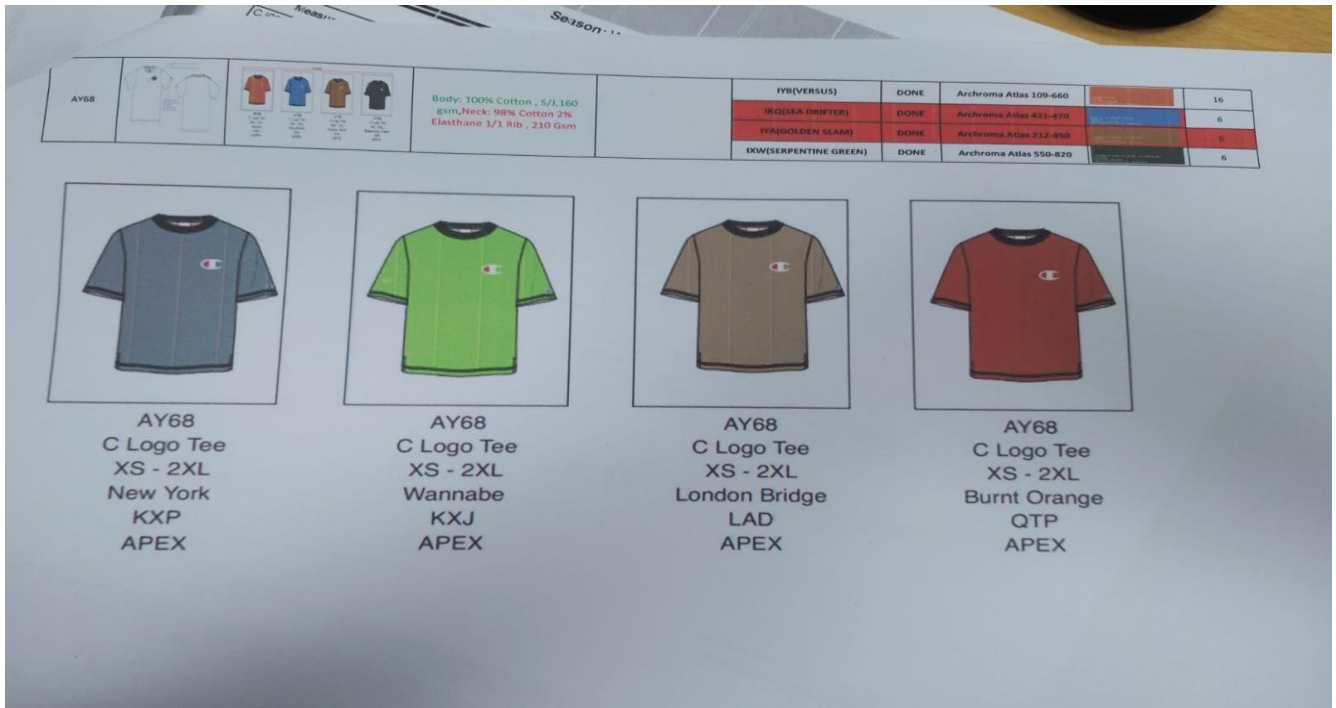


Fig: 3.2.7 -Design/Sketch for style no AY68

Specification Type: Development
 Range: CHAMPION ATHLETICS W231
 Development Style: AY68

Division: UW
 Line Plan: Champion Athletics Mens W231
 Sell Style:

Create Date: 1/13/2022 3:05:16 PM
 Description: CHAMPION SCRIPT TEE
 Version: 1
 Status: Concept
 Season: W231

Measurement Chart: CM002C Champion Mens Short Sleeve Tee with Neck Band (XS-2XL)
 Block Name: CM002C Champion Mens Short Sleeve Tee with Neck Band (XS-2XL)

Grading	Incremental	Base Size M					S	M	L	XL	XXL
		Finished Measurement in inches	Image Ref.	QC	Tol +/-						
POM100115		SLEEVE LENGTH FROM SLEEVE HEAD (449A) 袖长从袖山高度		Yes	-0.39 / +0.39	8.86	9.25	9.65	10.04	10.43	
POM101080		SHOULDER TO SHOULDER		Yes	-0.39 / +0.39	18.31	18.9	19.49	20.08	20.67	
POMP302		1/2 CHEST - 2cm BELOW 1/2胸围		Yes	-0.39 / +0.39	20.08	21.06	22.05	23.03	24.02	
POMP307		1/2 HEM 1/2下摆		Yes	-0.39 / +0.39	20.08	21.06	22.05	23.03	24.02	
POMP318		NECK WIDTH 领宽		Yes	-0.2 / +0.2	7.68	7.87	8.07	8.27	8.46	
POMP322		FRONT NECK DROP 前领深		Yes	-0.2 / +0.2	4.33	4.53	4.72	4.92	5.12	
POMP323		BACK NECK DROP 后领深		Yes	-0.2 / +0.2	1.18	1.18	1.18	1.18	1.18	
POMP436		FRONT LENGTH FROM HSP 前幅长从肩最高点度		Yes	-0.39 / +0.39	28.74	29.33	29.92	30.51	31.1	
POMP446		1/2 ARMHOLE CURVE FRONT 1/2袖笼前面弯量		Yes	-0.39 / +0.39	10.24	10.63	11.02	11.42	11.81	

Measurement Chart (Inches)
 Page 12 of 16
 Print Date: 2022-01-13 14:11
 Last Modified Date: 1/13/2022

Fig: 3.2.9- Line Wish Detect status, Report -7

A copy of End of The End Line Inspection report is attached that we have collected from the “**Shad Fashion ltd**”.

BUYER	Hanes Champion	STYLE	AY68	Date:4-10-2022
Product name	T-shirt	Inspector	Md.Kalam Ali	

Shad Fashion ltd

DAILY END-LINE INSPECTION REPORT

Defect Name	Line-1	Line-2	Line-3	Line-4	Line-5	Line-6	Line-7	Line-8	Line-9	Line-10
Broken Stitch			10		16	11	13	14	10	13
Skip Stitch									7	
Without tack				9						
Open seam		2	7		12		9	13		10
Pleated						10			6	
Button half stitch				8						
Reject	7	2	8	8	10	10	5	3	12	7
Oil		16					30	3		
Down Stitch										
Un cut thread	29	11	12	24	17	13	22	20	3	21

Join stitch		15					13			
loops										
Raw edge				6						
Loose button				6						
Total	29	28	29	53	45	34	57	47	26	44
Total Check	1144	567	1254	1894	1731	1245	905	1484	1183	1806
DHU%	2.53%	4.94%	2.31%	2.80%	2.60%	2.73%	6.30%	3.17%	2.20%	2.44%

Table 3.7 -Line Wish Detect status, Report -7

$$\begin{aligned}
 \text{DHU} &= (\text{Total No of Defective Pieces}/\text{Total No of Pieces Checked}) * 100 \\
 &= (392/13221) * 100 \\
 &= 2.96\%
 \end{aligned}$$

From The Table 3.7 we can see that, at sewing (line 1 to 10) our observation date was 04-10-2021. The buyer was HANES AUSTRILA style AY68 Here different color of single jersey t shirt is sewing .Per color order quantity was 5000. Total order quantity is 20000. Total worker or operator worked at sewing (line 1 to 10) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 13221 pcs of garments and there have been total 392 defects. In this way, total 13221pcs of garments checked in our 8hrs observation. Here we totally found 392 pitches of defective garments where 67 pitches are rejected

3.2.4 Attachment of Line Wise Detect Status- Line Inspection Report- 8



Fig: 3.2.10 -Design/Sketch for style no VA982

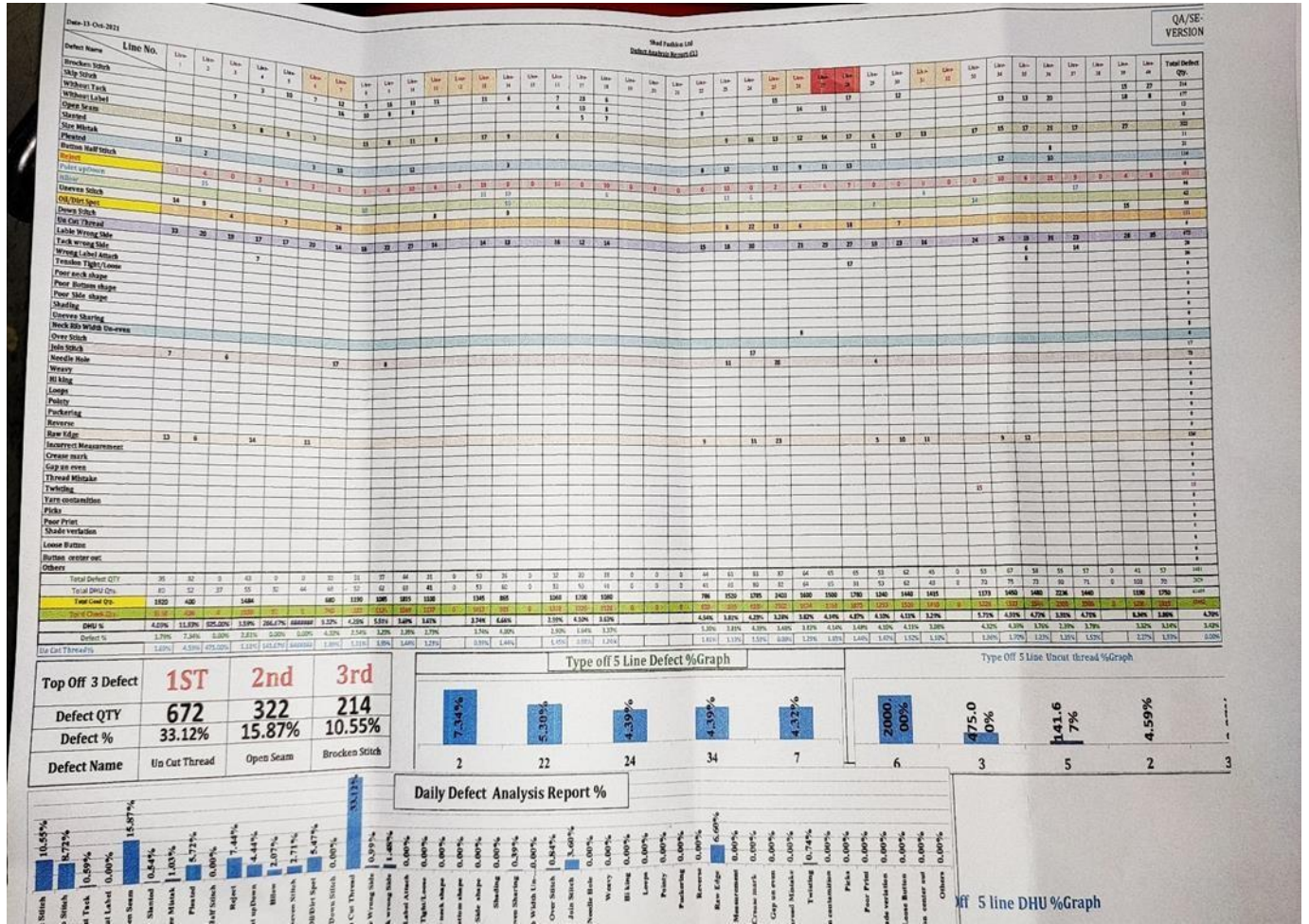


Fig: 3.2.11- Line Wish Detect status, Report -8

A copy of End of The End Line Inspection report is attached that we have collected from the “Shad Fashion Ltd”.

BUYER	Next sourcing	STYLE	VA982	Date: 05-10-2021
Product name	Sleep suit	Inspector	Md. Hannan	

$$\begin{aligned}
 \text{DHU} &= (\text{Total No of Defective Pieces}/\text{Total No of Pieces Checked}) * 100 \\
 &= (552/8574) * 100 \\
 &= 6.44\%
 \end{aligned}$$

From The fig we can see that, at sewing (line 1to 10) our observation date was 05-10-2021. The buyer was Varner, style W22 BAB UDW 0024.Total order quantity is 300000.Total worker or operator worked at sewing (line 1 to 10) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 8574 pcs of garments and there have been total 552 defects. In this way, total 7991pcs of garments QC passed in our 8hrs observation. Here we totally found 36 pitches are rejected garments.

3.2.5 Attachment of Line Wise Detect Status- Line Inspection Report- 9



Fig: 3.2.12 -Design/Sketch for style no AVV9

measurement Chart (Inches)											
Specification Type: Development			Division: UW			Create Date: 7/9/2021 1:45:05 PM			Version: 1		
Range: CHAMPION ATHLETICS S221			Line Plan: Champion Athletics Mens S221			Status: Concept			Season: S221		
Development Style: AVV9			Sell Style:			Description: ZIP FRONT HOODIE			Measurement Chart: AVV9 - ZIP FRONT HOODIE (SIZES XS-XXL)		
Grading Incremental		Base Size M		Block Name:							
Finished Measurement in inches 成品尺寸 (inches)	Image Ref.	QC	Tol +/-	XS	S	M	L	XL	XXL		
PMN-J G1	Back Length from high point shoulder	K	Yes	-0.39 / +0.39	26.97	27.56	28.15	28.74	29.33	29.92	
PMN-J G2	Front length from high point shoulder	J	Yes	-0.39 / +0.39	26.97	27.56	28.15	28.74	29.33	29.92	
PMN-J I5	Armhole drop	G	Yes	-0.2 / +0.2	10.93	11.22	11.52	11.81	12.11	12.4	
PMN-K O	Front neck drop from high point shoulder	L	Yes	-0.2 / +0.2	3.74	3.74	3.74	3.74	3.74	3.74	
PMN-K O2	Back Neck drop from high point shoulder	M	Yes	-0.2 / +0.2	1.18	1.18	1.18	1.18	1.18	1.18	
POM100105	CHEST CIRC at underarm points (428B) 胸围在夹底处度	A	Yes	-0.79 / +0.79	41.34	43.31	45.28	47.24	49.21	51.18	
POM100110	WAIST CIRC 40cm below HSP (432A) 腰围从最高肩点位下40CM处度	C	Yes	-0.79 / +0.79	39.76	41.73	43.7	45.67	47.64	49.61	
POM100111	HEM CIRC RELAXED (433A) 下摆围松度	B	Yes	-0.79 / +0.79	35.43	37.4	39.37	41.34	43.31	45.28	
POM100115	SLEEVE LENGTH FROM SLEEVE HEAD (449A) 袖长从袖山高量	H	Yes	-0.39 / +0.39	25.98	26.38	26.77	27.17	27.56	27.95	

measurement Chart (Inches)											
Specification Type: Development			Division: UW			Create Date: 7/9/2021 1:45:05 PM			Version: 1		
Range: CHAMPION ATHLETICS S221			Line Plan: Champion Athletics Mens S221			Status: Concept			Season: S221		
Development Style: AVV9			Sell Style:			Description: ZIP FRONT HOODIE			Measurement Chart: AVV9 - ZIP FRONT HOODIE (SIZES XS-XXL)		
Finished Measurement in inches 成品尺寸 (inches)	Image Ref.	QC	Tol +/-	XS	S	M	L	XL	XXL		
POM100116	BICEP CIRC at UNDERARM (451B) 袖肥	X	Yes	-0.39 / +0.39	15.75	16.34	16.93	17.52	18.11	18.7	
POM100119	NECK WIDTH SEAM TO SEAM (456A) 领宽骨至骨	F	Yes	-0.2 / +0.2	9.45	9.65	9.84	10.04	10.24	10.43	
POM100208	FRONT OR BACK POCKET HEIGHT THRU CENTRE (4452) 前或后口袋高度(中间度)	R	Yes	-0.2 / +0.2	8.46	8.46	8.46	8.46	8.86	8.86	
POM100242	POCKET WIDEST WIDTH EDGE TO EDGE (4425A)	T	Yes	-0.39 / +0.39	15.55	15.55	15.55	15.55	15.94	15.94	
POM100243	POCKET BOTTOM WIDTH EDGE TO EDGE OR FROM CF TO EDGE (4427A) 口袋底部宽边至边或前中至口袋底边度	U	Yes	-0.39 / +0.39	14.76	14.76	14.76	14.76	15.16	15.16	
POM100244	POCKET TOP WIDTH FROM EDGE TO EDGE OR FROM CF TO EDGE (4458) 口袋宽边至边, 或前中到边	S	Yes	-0.2 / +0.2	9.65	9.65	9.65	9.65	10.04	10.04	
POM101080	SHOULDER TO SHOULDER	D	Yes	-0.39 / +0.39	17.76	18.23	18.7	19.17	19.65	20.12	
POM102061	1/2 Circ. 4cm above cuff or band seam.	W	Yes	-0.79 / +0.79	38.58	40.55	42.52	44.49	46.46	48.43	
POM102103	1/2 Elbow Circumference at half underarm seam	Y	Yes	-0.39 / +0.39	12.6	13.19	13.78	14.37	14.96	15.55	

Measurement Chart (Inches)

Specification Type: Development **Division:** UW **Create Date:** 7/9/2021 1:45:05 PM **Version:** 1
Range: CHAMPION ATHLETICS S221 **Line Plan:** Champion Athletics Mens S221 **Status:** Concept
Development Style: AVV9 **Sell Style:** **Description:** ZIP FRONT HOODIE **Season:** S221

Line No.	Finished Measurement in inches 成品尺寸 (Inches)	Image Ref.	QC	Tol +/-	Size					
					XS	S	M	L	XL	XXL
POM102242	Hood WIDTH 15CM FROM TOP EDGE (466B)	O	Yes	-0.39 / +0.39	20.47	20.67	20.87	21.06	21.26	21.46
POM102360	HEM BAND WIDTH (2229)	V	Yes	-0.12 / +0.12	3.15	3.15	3.15	3.15	3.15	3.15
POM102468	HOOD OPENING	N	Yes	-0.39 / +0.39	30.71	30.71	30.71	30.71	30.71	30.71
POMP453	CUFF WIDTH - CUFF OPENING RELAXED 袖口宽(松量)	I	Yes	-0.39 / +0.39	7.48	7.87	8.27	8.66	9.06	9.45
POMP455	CUFF DEPTH	V	Yes	-0.12 / +0.12	3.15	3.15	3.15	3.15	3.15	3.15
POMP467	HOOD HEIGHT	P	Yes	-0.2 / +0.2	13.39	13.39	13.39	13.39	13.39	13.39
POMP472	HOOD DRAWCORD	Z	Yes	-0.79 / +0.79	47.24	47.24	47.24	47.24	47.24	47.24
POMP477	CENTRE FRONT ZIPPER LENGTH 前中拉链长		Yes	0 / 0	23.03	23.62	24.21	24.8	25.39	25.98
POMP491	CURVE POCKET OPENING	Q	Yes	-0.2 / +0.2	6.3	6.3	6.3	6.3	6.3	6.3

Print Date: 2021-07-09 16:27:59 GMT+10
Last Modified Date: 7/9/2021 4:27:58 PM

Fig: 3.2.13 - Measurement Chart

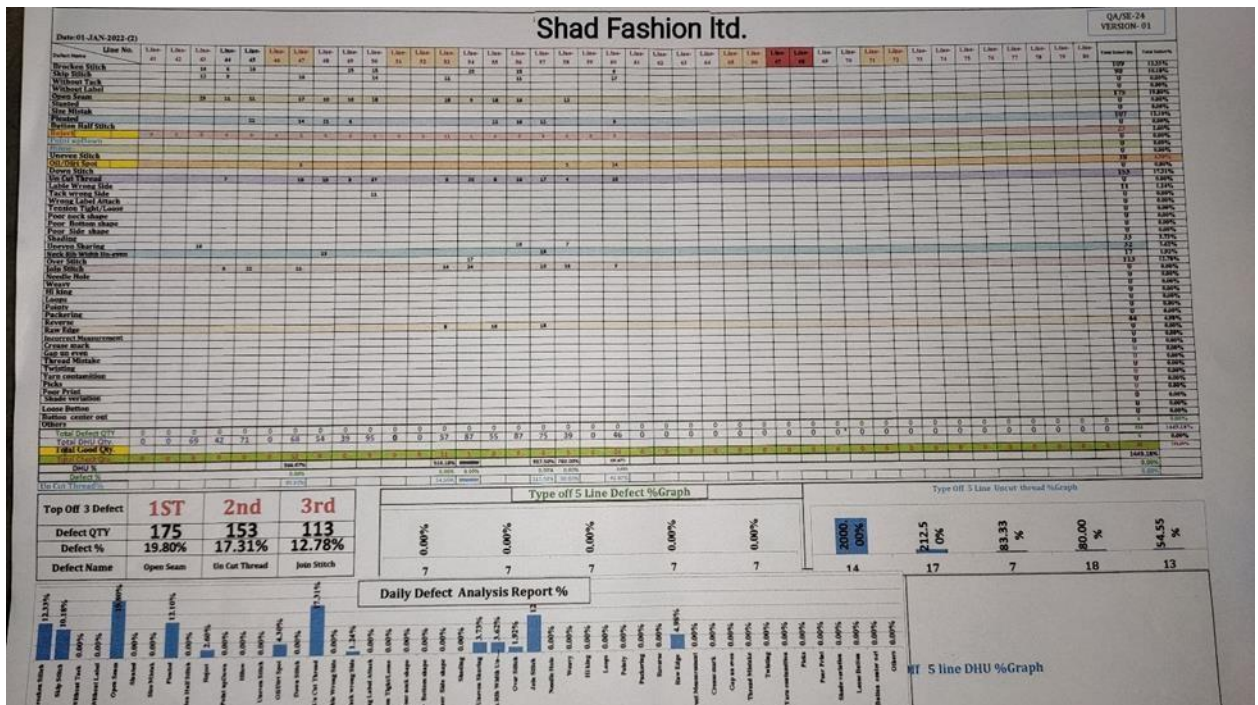


Fig: 3.2.14- Line Detect status, Report -1

A copy of End of The End Line Inspection report is attached that we have collected from the “**Shad Fashion ltd**”.

BUYER	Hanes Champion	STYLE	AVV9	Date: 07-10-2021
Product name	Hoody	Inspector	Zafor Ali	

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (487/8667)*100$$

$$=5.67\%$$

From The fig we can see that, at sewing (line 1to 10) our observation date was 07-10-2021. The buyer was HANES CHAMPION style AY77N. Total order quantity is 300000.Total worker or operator worked at sewing (line 41 to 50) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 8667 pcs of garments and there have been total 487 defects. In this way, total 9561pcs of garments QC passed in our 8hrs observation. Here we totally found 7 pitches are rejected garments

3.2.6 Attachment of Line Wise Detect Status- Line Inspection Report- 10

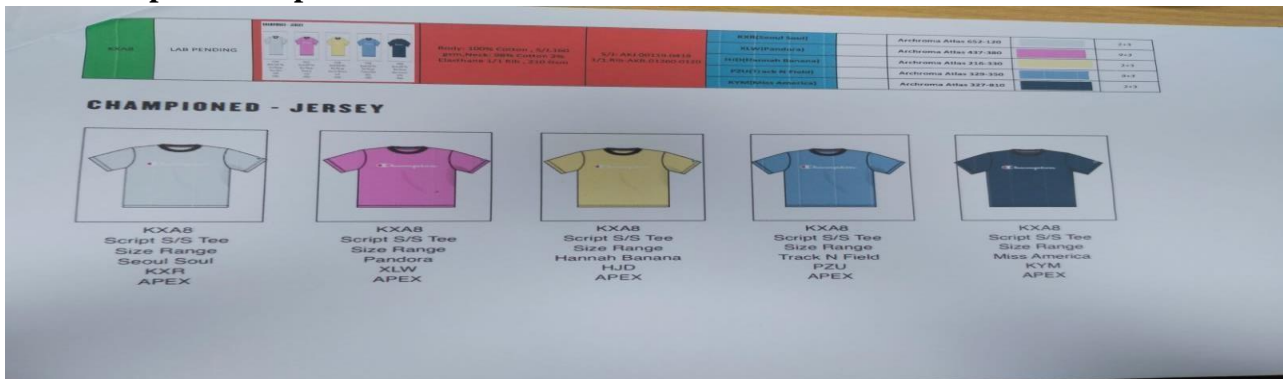


Fig: 3.2.15 -Design/Sketch for style no KXA8

Development Style: CJ001 Champion Junior Short Sleeve Tee (8-16) Description: Kids Script Tee Season: WZ31

Block Name: CJ001 Champion Junior Short Sleeve Tee (8-16)

Grading Incremental Base Size 10

Image Ref.	QC	Tol +/-	4	6	8	10	12	14	16
POM100115	Yes	-0.39 / +0.39	4.53	4.92	6.5	6.89	7.28	7.68	8.07
POM100200	Yes	-0.39 / +0.39	13.19	13.98	15.35	16.14	16.93	17.72	18.5
POMP318	Yes	-0.2 / +0.2	4.85	4.84	5.04	5.43	5.63	5.83	6.22
POMP429	Yes	-0.39 / +0.39	13.19	13.98	15.35	16.14	16.93	17.72	18.5
POMP436	Yes	-0.59 / +0.59	17.17	18.74	20.28	21.06	22.24	23.43	24.21
POMP446	Yes	-0.39 / +0.39	6.5	6.89	7.58	8.07	8.46	8.86	9.25
POMP452	Yes	-0.2 / +0.2	4.41	4.8	5.2	5.59	5.98	6.38	6.77
POMP457	Yes	-0.39 / +0.39	7.13	7.52	7.72	8.11	8.31	8.5	8.9
POMP458	Yes	-0.2 / +0.2	11.02	11.02	11.42	11.42	12.2	12.2	12.2

Measurement Chart (inches)

Print Date: 2022-01-13 11:34
Last Modified Date: 4/13/22

Development Style: KXA8 Line Plan: Champion Athletics Kids WZ31 Status: Concept

Sell Style: Description: Kids Script Tee Season: WZ31

Image Ref.	QC	Tol +/-	4	6	8	10	12	14	16
POMP488	Yes	-0.39 / +0.39	10.16	10.75	11.46	12.05	12.64	13.23	13.82

Finished Measurement in inches
成品尺寸 (inches)

SHOULDER TO SHOULDER
肩到肩

Fig: 3.2.16 - Measurement Chart

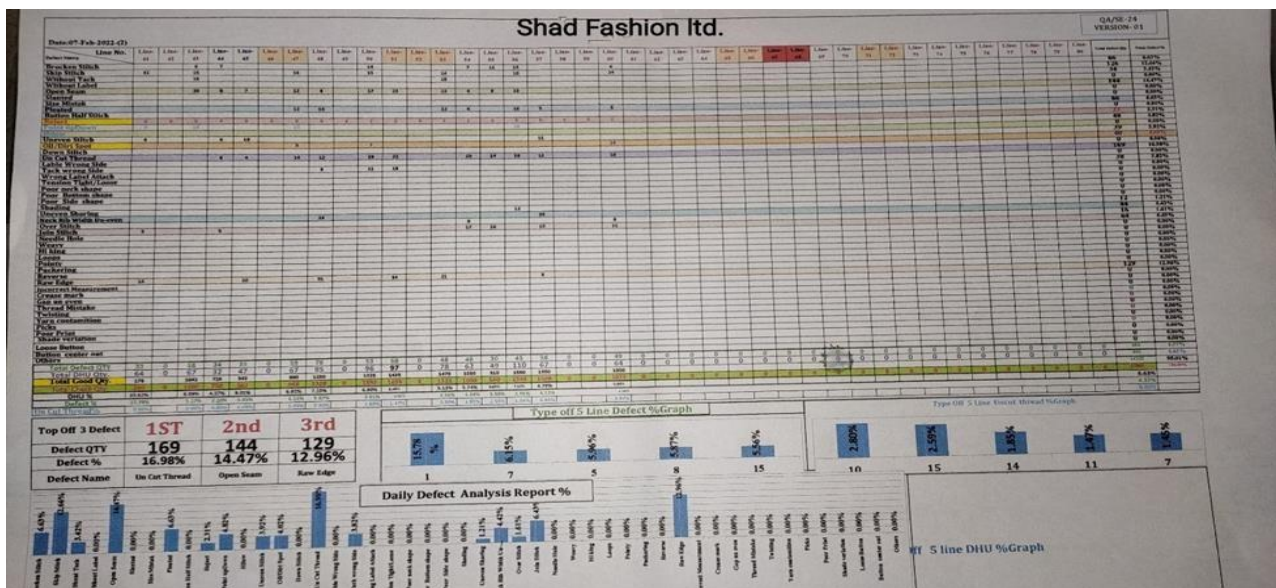


Fig: 3.2.17 - Line Wish Detect status, Report -11

A copy of End of The End Line Inspection report is attached that we have collected from the “**Shad Fashion ltd**”.

BUYER	Hanes Champion	STYLE	KXA8	Date: 09-10-2021
Product name	T-Shirt	Inspector	Abdul Alim	

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (705/10433)*100$$

$$=6.76\%$$

From The fig we can see that, at sewing (line 1to 10) our observation date was 09-10-2021. The buyer was HANES CHAMPION style KXA8. Total order quantity is 300000.Total worker or operator worked at sewing (line 41 to 50) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 10435 pcs of garments and there have been total 705 defects. In this way, total 9707pcs of garments QC passed in our 8hrs observation. Here we totally found 21 pitches are rejected garments

3.2.7 Attachment of Line Wise Detect Status- Line Inspection Report- 11

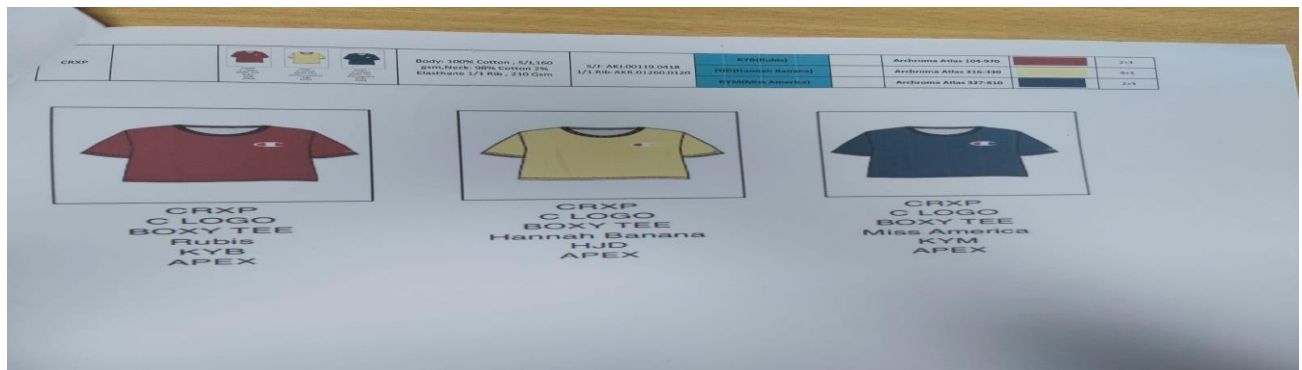


Fig: 3.2.18 -Design/Sketch for style no CRXP

Development Style: CRXP		Line Plan: Champion Athletics Womens W231		Status: Concept						
Sell Style:		Description: Boxy C Logo Tee		Season: W231						
Measurement Chart: CW011 Champion Womens Crop Tee (Sizes XS-XXL)			Block Name: CW011 Champion Womens Crop Tee (Sizes XS-XXL)							
Grading	Incremental	Base Size	S	M	L	XL	XXL			
POM100115	SLEEVE LENGTH FROM SLEEVE HEAD (449A) 袖长从袖山高量	Image Ref.	Yes	-0.39 / +0.39	6.89	7.09	7.28	7.48	7.68	7.87
POM100119	NECK WIDTH FROM EDGE TO 领宽骨至骨		Yes	-0.2 / +0.2	5.71	5.91	6.1	6.3	6.5	6.69
POM100197	BACK NECK DROP FROM SIDE NECK (4441) 后领深从侧领量		Yes	-0.2 / +0.2	0.79	0.79	0.79	0.79	0.79	0.79
POM100198	FRONT NECK DROP FROM SIDE NECK (4442) 前领深从侧领量		Yes	-0.2 / +0.2	4.23	4.33	4.43	4.53	4.63	4.72
POM100199	1/2 CHEST CIRC AT 3CM BELOW UNDERARM (4443) 1/2胸阔(夹圈下3cm量)		Yes	-0.39 / +0.39	20.08	21.06	22.05	23.03	24.02	25
POM100200	1/2 HEM CIRC 3CM ABOVE HEM (4444) 1/2下脚阔(下脚3cm上度)		Yes	-0.39 / +0.39	20.87	21.85	22.83	23.82	24.8	25.79
POMP436	FRONT LENGTH FROM HSP 前幅长从肩最高高度		Yes	-0.39 / +0.39	22.44	23.03	23.62	24.21	24.8	25.39
POMP446	1/2 ARMHOLE CURVE FRONT 1/2袖笼前面弯量		Yes	-0.39 / +0.39	8.86	9.25	9.65	10.04	10.43	10.83
POMP452	1/2 SLEEVE HEM 1/2袖口		Yes	-0.39 / +0.39	6.5	6.89	7.28	7.68	8.07	8.46

Page 12 of 16

Specification Type: Development		Division: UW		Create Date: 1/13/2022 5:13:25 PM		Version: Concept				
Range: CHAMPION ATHLETICS W231		Line Plan: Champion Athletics Womens W231		Description: Boxy C Logo Tee		Season: W231				
Development Style: CRXP		Sell Style:								
POMP457	1/2 NECK 1/2领圈	Image Ref.	Yes	-0.39 / +0.39	8.8	9.06	9.31	9.56	9.81	10.06
POMP488	SHOULDER TO SHOULDER 肩到肩		Yes	-0.39 / +0.39	15.55	15.94	16.34	16.73	17.13	17.52

Page 13 of 16

Fig: 3.2.19 -Measurement Chart

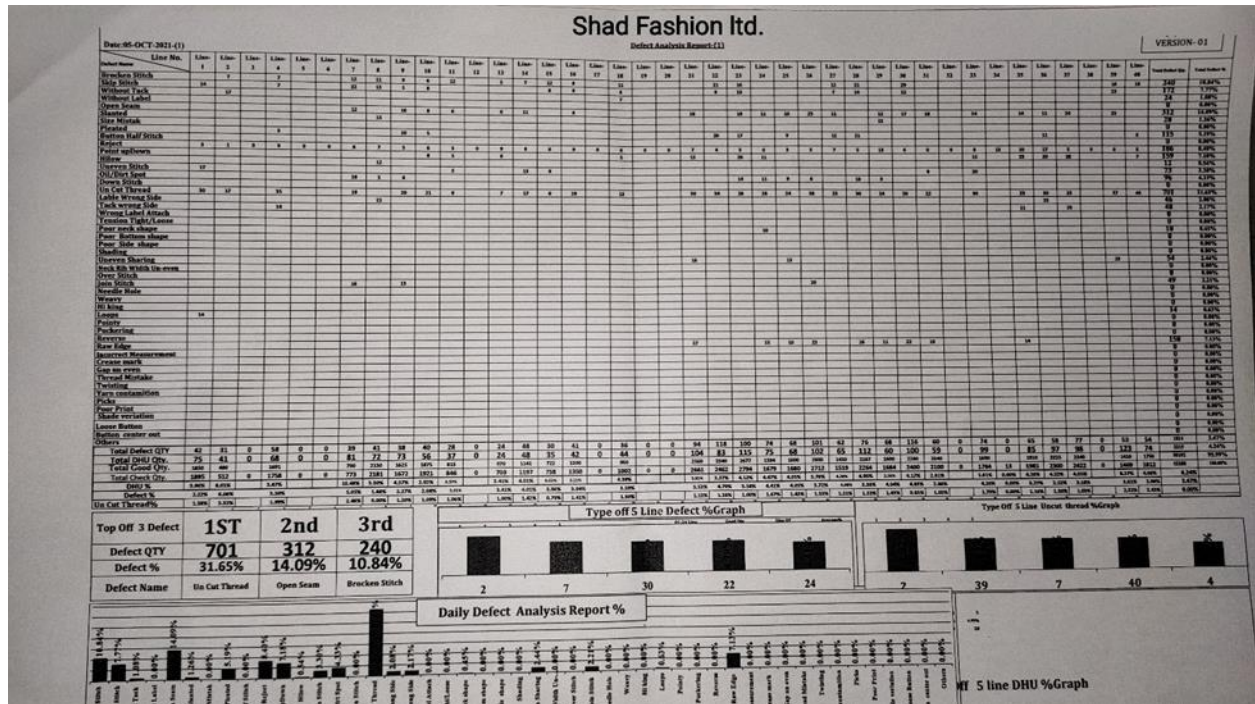


Fig: 3.2.20- Line Wish Detect status, Report -12

A copy of End of The End Line Inspection report is attached that we have collected from the “Shad Fashion Ltd”.

BUYER	Hanes Champion	STYLE	CRXP	Date:10-10-2021
Product name	JERSEY	Inspector	Md.Mizananur Rahman	

HU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (625/13458)*100$$

$$=4.65\%$$

From The fig we can see that, at sewing (line 1to 10) our observation date was 10-10-2021. The buyer was HANES CHAMPION style CRXP. Total order quantity is 300000.Total worker or operator worked at sewing (line 1 to 10) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 13458 pcs of garments and there have been total 625 defects. In this way, total 12778pcs of garments QC passed in our 8hrs observation.

Here we totally found 55 pitches are rejected garments

3.2.8 Attachment of Line Wise Detect Status-Line Inspection Report- 12



Fig: 3.2.21 -Design/Sketch for style no VJ1598

BASIC PATTERN CODE: 886
 SHOP NAME: TOLUJALUJUVI
 Order no:
 Supplier: SHIJI FASHION LTD.

Auchan

3-DXK
DATE: / /

ITEM	TOLU	OC	REQ		IS		IS		REQ		IS		REQ		IS	
			QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY
1/2 CHEST	41.0	OC	23	+3	+3	24	+3	+3	28	-5	0	28	-5	-1	0	0
1/2 HIP	41.0	OC	23	+5	+5	24	+5	-5	28	0	-1	28	-5	-1	0	0
SHOULDER BREADTH	41.0	OC	23	+1	+1	24	+1	-5	28	0	-1	28	-5	-1	0	0
FRONT BREADTH	41.0	OC	23	+1	+1	24	+1	-5	28	0	-1	28	-5	-1	0	0
BACK BREADTH	41.0	OC	23	0	0	24	0	-6	28	0	-1	28	-6	-1	0	0
FRONT NECKLINE WIDTH	41.0	OC	23	+3	+3	24	+3	-6	28	0	-1	28	-6	-1	0	0
FRONT NECKLINE DEPTH	41.0	OC	23	+1	+1	24	+1	-3	28	0	-1	28	-3	-1	0	0
BACK NECKLINE DEPTH	41.0	OC	23	0	0	24	0	-2	28	0	-1	28	-2	-1	0	0
SHOULDER LENGTH	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
SHORT SLEEVE LENGTH	41.0	OC	23	+3	+3	24	+3	-2	28	0	-1	28	-2	-1	0	0
1/2 UPPER ARM WIDTH	41.0	OC	23	+2	+2	24	+2	-4	28	0	-1	28	-4	-1	0	0
1/2 BOTTOM SLEEVE	41.0	OC	23	0	0	24	0	-4	28	0	-1	28	-4	-1	0	0
ARMHOLE HEIGHT	41.0	OC	23	0	0	24	0	-4	28	0	-1	28	-4	-1	0	0
US HEIGHT	41.0	OC	23	+4	+4	24	+4	-6	28	0	-1	28	-6	-1	0	0
FRONT TROUS LENGTH	41.0	OC	23	+1	+1	24	+1	-1	28	0	-1	28	-1	-1	0	0
BOTTOM WIDTH	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
TOTAL FRONT HEIGHT AT SHOULDER	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
SIDE HEIGHT	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
SLOPE SHOULDER IN DEGREES	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
BINDING HEIGHT	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
SHIPS QUANTITY 2	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
1/2 NECKLINE STRETCH	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0

Fundamentals measurements AQL level: (2.5), Accepted = Found =
 Complementary measurements AQL level: (4.0), Accepted = Found =
 Inspected by: Signature: Factory represented by: Signature:

BASIC PATTERN CODE: 886
 SHOP NAME: TOLUJALUJUVI
 Order no:
 Supplier: SHIJI FASHION LTD.

Auchan

3-DXK
DATE: / /

ITEM	TOLU	OC	REQ		IS		IS		REQ		IS		REQ		IS	
			QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY
1/2 CHEST	41.0	OC	23	+5	+5	24	+5	0	28	0	0	28	0	0	0	0
1/2 HIP	41.0	OC	23	+5	+5	24	+5	0	28	0	0	28	0	0	0	0
SHOULDER BREADTH	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
FRONT BREADTH	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
BACK BREADTH	41.0	OC	23	0	0	24	0	-6	28	0	-1	28	-6	-1	0	0
FRONT NECKLINE WIDTH	41.0	OC	23	+3	+3	24	+3	-6	28	0	-1	28	-6	-1	0	0
FRONT NECKLINE DEPTH	41.0	OC	23	+1	+1	24	+1	-3	28	0	-1	28	-3	-1	0	0
BACK NECKLINE DEPTH	41.0	OC	23	0	0	24	0	-2	28	0	-1	28	-2	-1	0	0
SHOULDER LENGTH	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
SHORT SLEEVE LENGTH	41.0	OC	23	+3	+3	24	+3	-2	28	0	-1	28	-2	-1	0	0
1/2 UPPER ARM WIDTH	41.0	OC	23	+2	+2	24	+2	-4	28	0	-1	28	-4	-1	0	0
1/2 BOTTOM SLEEVE	41.0	OC	23	0	0	24	0	-4	28	0	-1	28	-4	-1	0	0
ARMHOLE HEIGHT	41.0	OC	23	0	0	24	0	-4	28	0	-1	28	-4	-1	0	0
US HEIGHT	41.0	OC	23	+4	+4	24	+4	-6	28	0	-1	28	-6	-1	0	0
FRONT TROUS LENGTH	41.0	OC	23	+1	+1	24	+1	-1	28	0	-1	28	-1	-1	0	0
BOTTOM WIDTH	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
TOTAL FRONT HEIGHT AT SHOULDER	41.0	OC	23	+1	+1	24	+1	0	28	0	0	28	0	0	0	0
SIDE HEIGHT	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
SLOPE SHOULDER IN DEGREES	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
BINDING HEIGHT	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
SHIPS QUANTITY 2	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0
1/2 NECKLINE STRETCH	41.0	OC	23	0	0	24	0	0	28	0	0	28	0	0	0	0

Fundamentals measurements AQL level: (2.5), Accepted = Found =
 Complementary measurements AQL level: (4.0), Accepted = Found =
 Inspected by: Signature: Factory represented by: Signature:

Fig: 3.2.22 - Measurement Chart

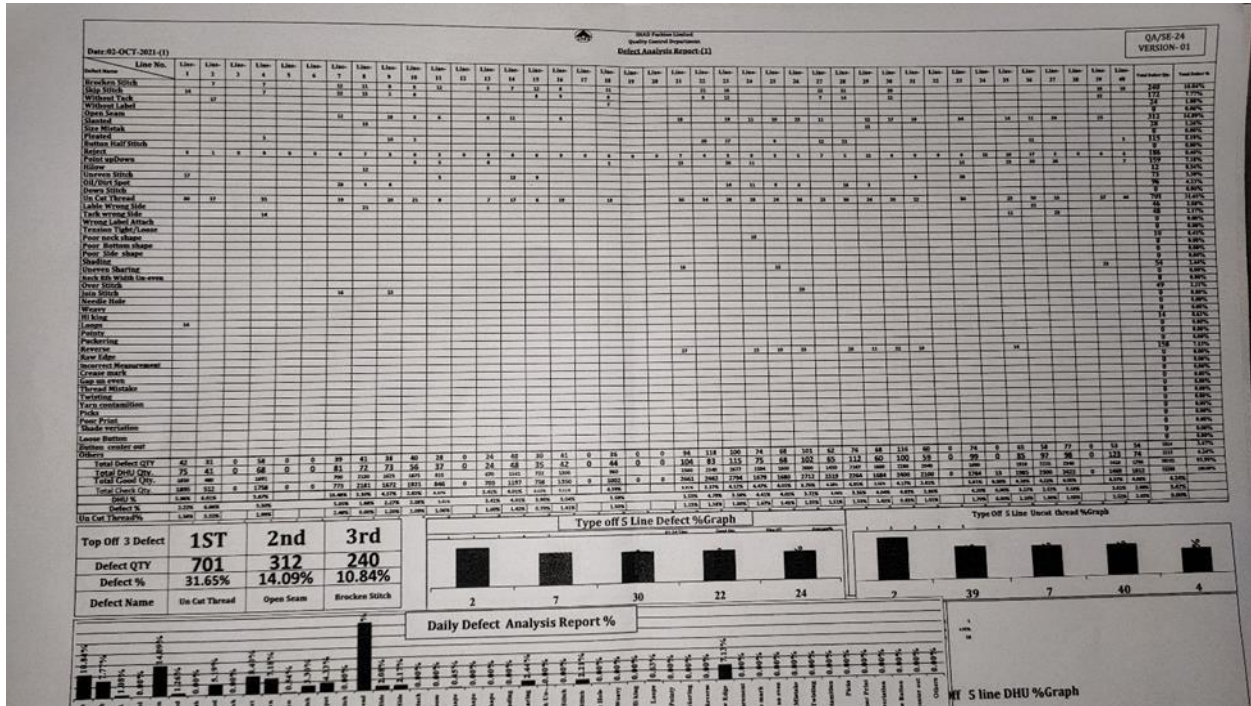


Fig: 3.2.23 - Line Wish Detect status, Report -13

A copy of End of The End Line Inspection report is attached that we have collected from the “Shad Fashion Ltd”.

BUYER	Two point zero	STYLE	VJ1598	Date:11-10-2021
Product name	Baby Suit	Inspector	Md.Hakim	

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

= (593/15452)*100

=3.84%

From The fig we can see that, at sewing (line 11to 20) our observation date was 11-10-2021. The buyer was Next sourcing style VJ1598. Total order quantity is 300000.Total worker or operator worked at sewing (line 41 to 50) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 15452 pcs of garments and there have been

total 593 defects. In this way, total 14804pcs of garments QC passed in our 8hrs observation. Here Here we totally found 55 pitches are rejected garments.

3.2.9 Attachment of Line Wise Detect Status- Line Inspection Report- 13

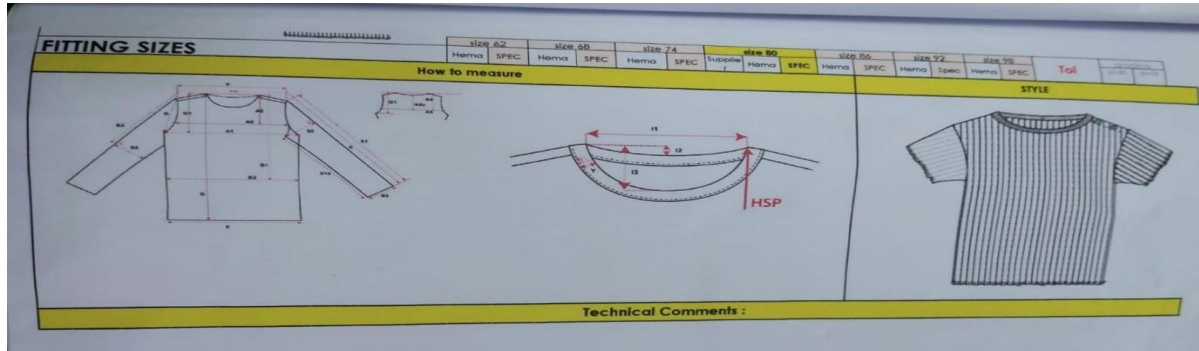


Fig: 3.2.24 -Design/Sketch for style no 330937

FITTING SIZES		size 62	size 68	size 74	size 80	size 86	size 92	size 98	Tol
D	Total front length, frm HSP	30.5	32	33.5	35	36.5	38	39.5	1
F	Shoulder to shoulder	17	18	19	20	21	22	23	0.5
A1	1/2 chestwidth	21	22	23	24	25	26	27	0.5
B2	1/2 waistwidth	21	22	23	24	25	26	27	0.5
E	Short sleeve	9	9.5	10	10.5	11	11.5	12	0.5
G	Armhole straight inside	8.5	9	9.5	10	10.5	11	11.5	0.5
S2	1/2 Bicep width	8	8.5	9	9.5	10	10.5	11	0.5
S5	1/2 sleeve opening SHORT	17.5	18.5	19.5	20.5	21.5	22.5	23.5	0.5
S	Total sleeve frm CBN	2.1	2.4	2.7	3	3.3	3.6	3.9	0.5
S	ream length sleeve	9	9	9.5	10	10.5	11	11.5	0.5
	O-neck binding	1	1	1	1	1	1	1	0.5
I1	Neckwidth inside msrd straight	3.5	3.5	4	4	4	4.5	5	0.2
I2	Neckdrop back inside msrd straight	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0
I3	Neckdrop front inside msrd straight	2.5	2.5	2.5	2.5	2.5	2.5	2.5	0
Y	Binding height	6.5	6.5	7	7	7.5	8	8.5	0.5
	1/2 Min. Neckstretchability	6.5	6.5	7	7	7.5	8	8.5	0.5
I1	Slit length from top binding CBN	1	1	1	1	1	1	1	0.2
I2	Binding width slit	1	1	1	1	1	1	1	0.2

MEASUREMENTS ARE IN FINISHED CMS. AFTER WASH / DYE / ETC
Tolerance: 1/2 grading value with a maximum of 1 cm! No tolerance is accepted at the stand width msrd closed or at minimum neckstretch (neck circumference)

P.P SAMPLE
DATE: 27.11.21
STY: 330937
OK

Fig: 3.2.25 - Measurement Chart

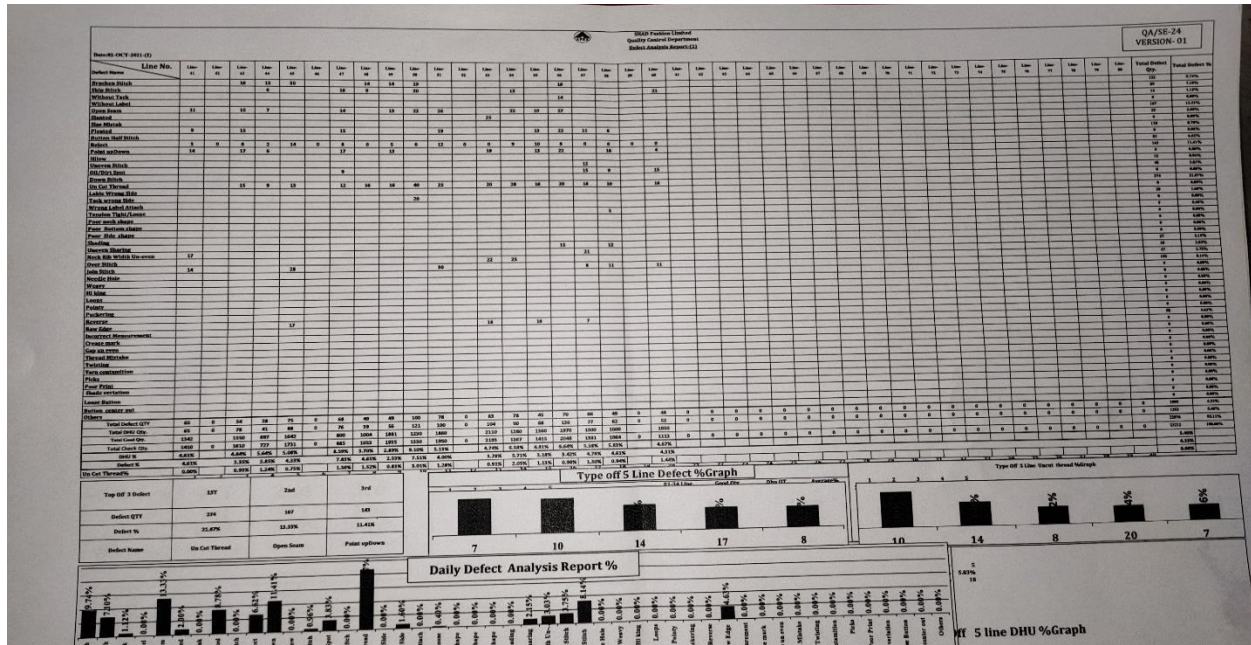


Fig: 3.2.26 - Line Wish Detect status, Report -14

A copy of End of The End Line Inspection report is attached that we have collected from the “**Shad Fashion ltd**”.

BUYER	HANES CHAMPION	STYLE	330937	Date:12-10-2021
Product name	T-shirt	Inspector	Md.Hannan	

DHU= (Total No of Defective Pieces/Total No of Pieces Checked)*100

$$= (872/15191)*100$$

$$=5.75\%$$

From The fig we can see that, at sewing (line 51 to 60) our observation date was 12-10-2021. The buyer was HEMA style 330937 Total order quantity is 300000.Total worker or operator worked at sewing (line 41 to 50) was 200 with 40 helpers and 10 QC operators. From our observation we found that from 8am-9am they check 15192 pcs of garments and there have been total 873 defects.

In this way, total 14264pcs of garments QC passed in our 8hrs observation Here we totally found 54 pitches are rejected garments.

CHAPTER - 4

RESULT AND DISCUSSION

4.1.0 Inspection Analysis of Jamuna Apparels Ltd.

4.1.1 End Line inspection analysis of Jamuna Apparels Ltd.

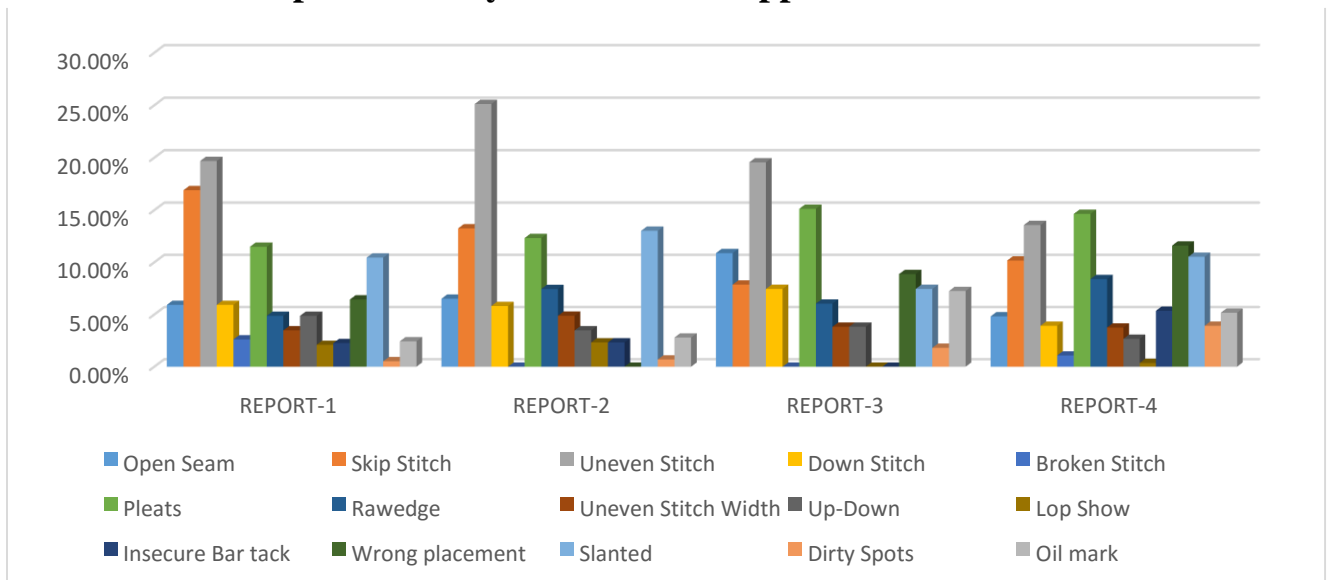


Fig: 4.1.1 Graphically Show End Line inspection analysis of Jamuna Apparels Ltd.

In JAMUNA APPARELS LTD we work 3 buyer garments in sewing line the buyer are HEMA (BOXER), Trade mark (BOXER), Auchan (Baby suit).

In report-1 buyer was Hema ,in report-2 buyer was trade mark ,in report-3 buyer was Auchan and in report-4 buyer was Hema .

The bar chart show that different sewing defect in jamuna apparels Ltd.From this bar chat we see that in report-1 highest defect is uneven stitch. uneven stitch is common for this 4 report and its minimum 76 and maximum 113. Skip stitch is the 2nd common fault in this graph most of the time its passes 40 to 97. Pleats is the 3rd common defect in four report its found minimum 53 and maximum 82.

Overall it can be see that we found different defect in different repots its verify depends on different items.

4.1.2 End Line inspection analysis of QC pass and rejected percentage in Jamuna Apparels Ltd

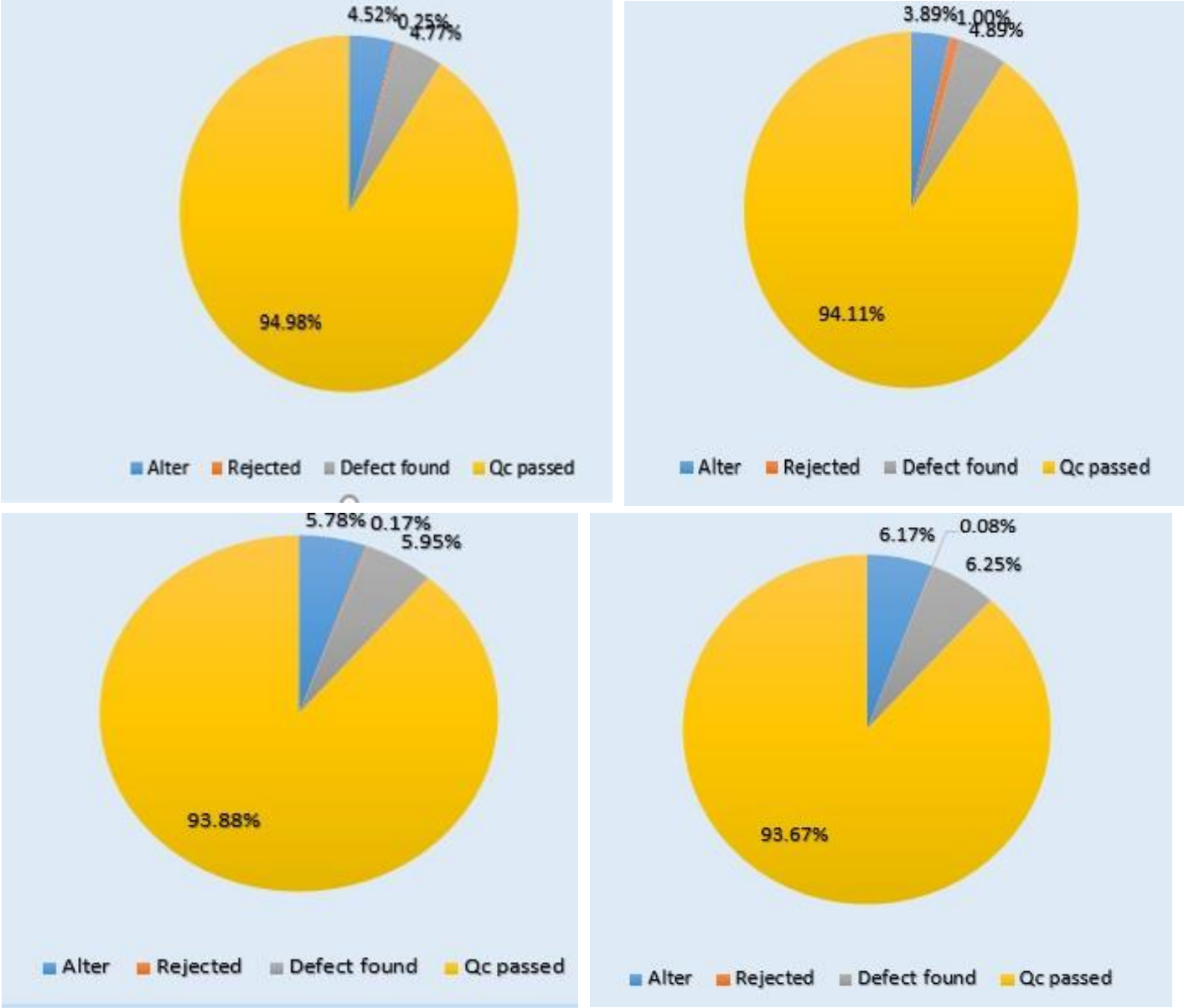


Figure 4.1.2 -Graphically Show Data Analysis of End Line Inspection report(1-4)

Discussion

For graph 1 (report-1) After 10 Team line inspection inspector inspect Total 12231 pitches of garments and 11640 pitches quality passed.

Here, QC Passed percentage 94.98% .Defects percentage 4.77% and Reject percentage 0.25%.

For Graph-2(report-2) line inspection inspector inspect Total 9606 pitches of garments and 9133 pitches quality passed. Here, QC Passed percentage 94.11%, Defects percentage 4.89%,Reject percentage 1%.

For graph-3(report-3) After line inspection inspector inspect Total 9035 pitches of garments and 8491 pitches quality passed. Where, QC Passed percentage 93.88% ,Defects percentage 5.95%. Reject percentage 0.17%.

For graph-4(report-4) After line inspection inspector inspect Total 8273 pitches of garments and 7752 pitches quality passed. Where, QC Passed percentage 93.67%,Defects percentage 6.25% and Reject percentage 0.08%

4.1.3 Comparison of Sewing Defects Percentage Measurement –Report (1-4) at Jamuna Apparels Ltd .

Defect Name	REPORT-1	REPORT-2	REPORT-3	REPORT-4
Open Seam	5.92%	6.51%	10.88%	4.82%
Skip Stitch	16.90%	13.25%	7.86%	10.17%
Uneven Stitch	19.68%	25.11%	19.55%	13.57%
Down Stitch	5.92%	5.81%	7.45%	3.92%
Broken Stitch	2.61%	0	0	1.07%
Pleats	11.49%	12.32%	15.12%	14.64%
Raw edge	4.87%	7.44%	6.04%	8.39%
Uneven Stitch Width	3.48%	4.88%	3.83%	3.75%
Up-Down	4.87%	3.48%	3.83%	2.67%
Lop Show	2.09%	2.32%	0	0.35%
Insecure Bar tack	2.26%	2.32%	0	5.35%
Wrong placement	6.44%	0	8.87%	11.60%
Slanted	10.45%	13.02%	7.45%	10.53%
Dirty Spots	0.52%	0.69%	1.81%	3.92%
Oil mark	2.43%	2.79%	7.25%	5.17%

Table:4.1- Comparison Sewing Defects Percentage Measurement –Report (1-4) of Jamuna Apparels Ltd

From the table we see the different percentage of different defect. The defect percentage is verify for different buyer. Here Line Inspection Report 1 in this report buyer was HEMA product was Boxer and this day total production capacity in 10 team is 12231.and 574 pieces are defected fabric is found. In this defected fabric The highest defective percentage is 19.69% the defect is uneven stitch,2nd defect percentage is 16.9% the defect is skip stitch,3rd highest percentage is 11.5 % defect is plate,4th highest defect is 6.45% the defect is wrong placement ,and 5th highest defect is 5.92% the defect is open seam.

Line Inspection Report- 2 in this report buyer was TRADE MARK product was Boxer and this day total production capacity is 9606 in 10 team and 430 pieces are defected fabric is found. In this defected fabric. The highest defective percentage is 25.11% the defect is uneven stitch, 2nd defect percentage is 13.25% the defect is skip stitch,3rd highest percentage is 13.02 % defect is Slanted,4th highest defect is 12.32% the defect is wrong pleats ,and 5th highest defect is 6.51% the defect is open seam.

Line Inspection Report-3 in this report buyer was HEMA product was Boxer and this day total production capacity in 10 team is 9035.and 496 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 19.55% the defect is uneven stitch, 2nd defect percentage is 15.12% the defect is Pleats,3rd highest percentage is 10.88% defect is Open seam,4th highest defect is 8.87% the defect is wrong placement ,and 5th highest defect is 7.86% the defect is Skip stitch.

Line Inspection Report- 4 in this report buyer was AUCHAN product was Brife and this day total production capacity in 10 team is 8275.and 560 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 14.64% the defect isPleats,2nd defect percentage is 13.57% the defect is Uneven stitch,3rd highest percentage is 11.60% defect is Wrong placement,4th highest defect is 10.53% the defect is Slanted ,and 5th highest defect is 8.39% the defect is Raw edge.

4.2.0 Inspection Analysis of Shad Fashion Apparels Ltd.

4.2.1 Analysis of End Line Inspection Of Shad Fashion Ltd.

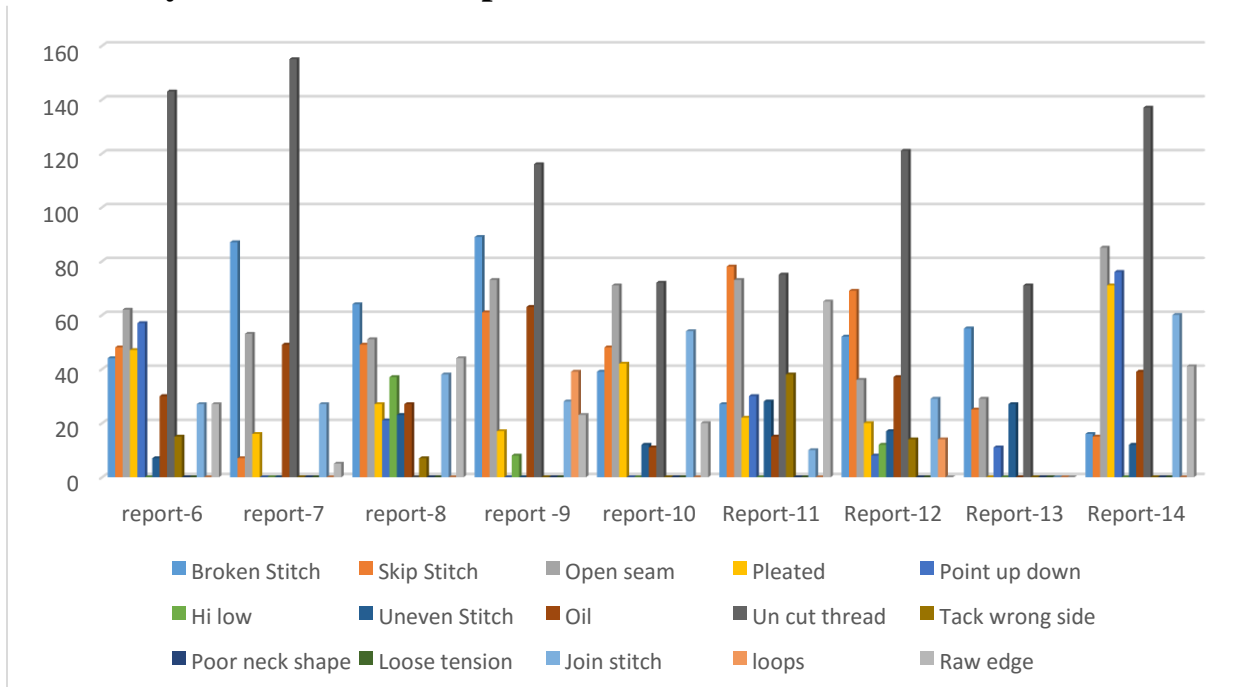


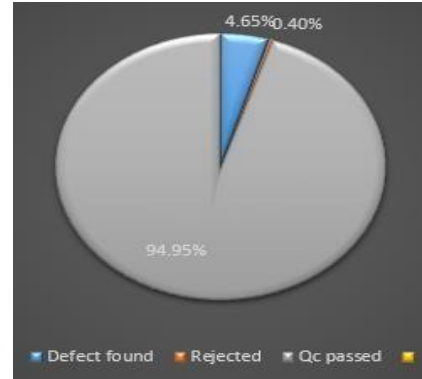
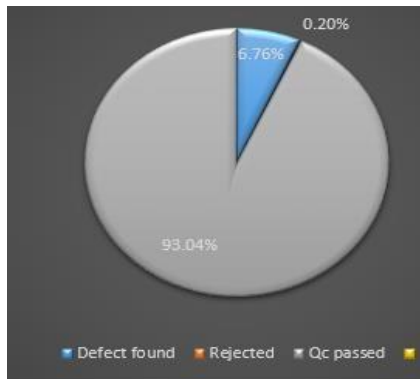
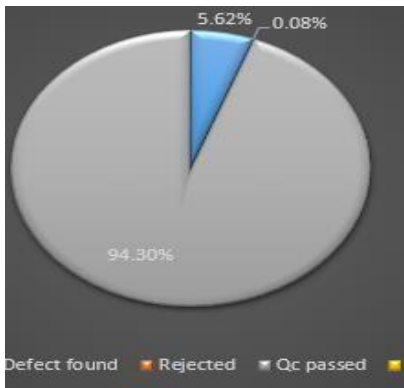
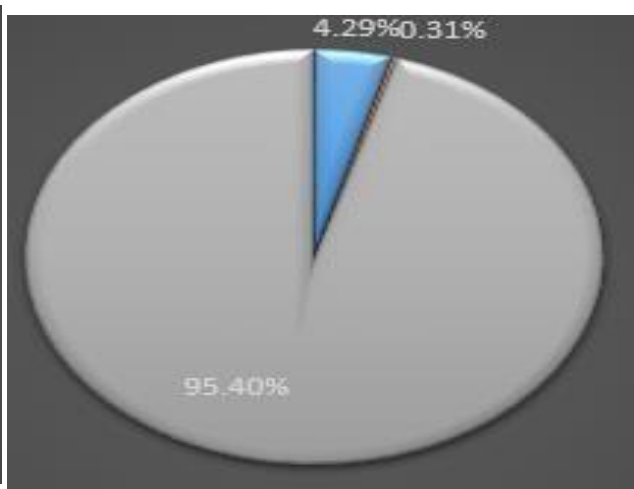
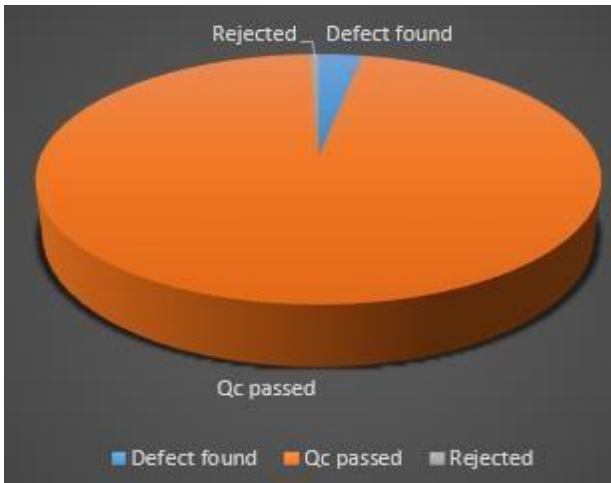
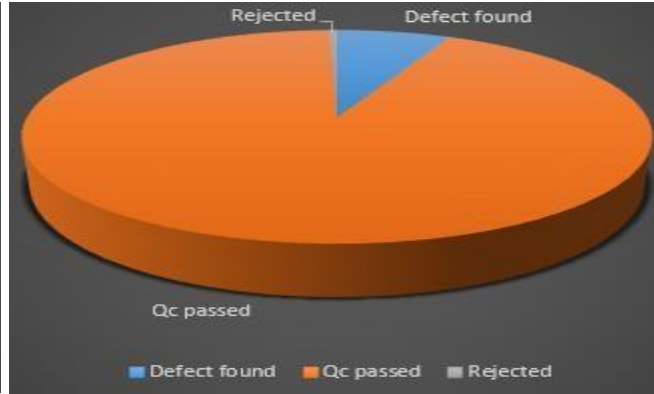
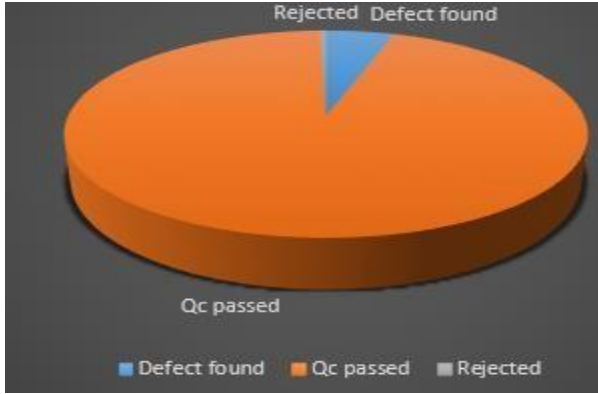
Fig:4.2.1 Graphically Show Analysis of End Line Inspection Of Shad Fashion Ltd

From SHAD FASHION LTD we work with 5 buyer garments in sewing line the buyer are TWOPOINT ZERO (BOXER), Hanes Champion (T-SHIRT), Next Sourcing (Baby suit) , Varner (swim top), TRADE MARK.

The bar chart shows that different sewing defects exist in Shad Fashion Ltd. From this bar chart we see that in report-1 the highest defect is uneven stitch. Uneven stitch is common for these four reports, with a minimum of 76 and a maximum of 113. Skip stitch is the 2nd most common fault in this graph, most of the time it passes 40 to 97. Pleats is the 3rd most common defect in four reports, found with a minimum of 53 and a maximum of 82.

Overall, it can be seen that we found different defects in different reports, which vary depending on different items.

4.2.2 End Line Inspection Analysis of QC pass and Rejected percentage at Shad Fashion Ltd.



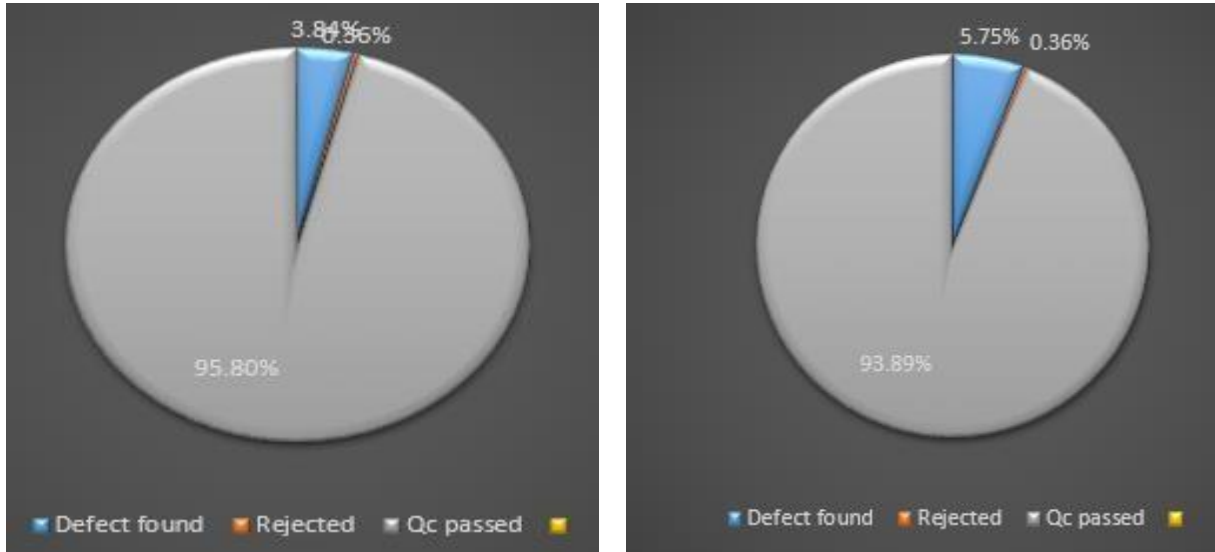


Figure:- Graphically Show Data analysis report for report-6, 7,8,9,10,11,12,13,14

Discussion

For analysis report 6 from the pie chart we see that after 10 line inspection inspector inspect Total 7240 pitches of garments and 6704 pitches quality passed. Where QC Passed percentage 92.59%, Defects percentage 6.92% Reject percentage 0.49%

For analysis report 7 from the pie chart we found that After 10 line inspection inspector inspect Total 13213 pitches of garments and 12752 pitches quality passed. QC Passed percentage 96.49% Defects percentage 2.97% Reject percentage .54%

When analysis report 8 from the pie chart we see that After 10 line inspection inspector inspect Total 8574 pitches of garments and 7991 pitches quality passed. Where QC Passed percentage 93.2% Defects percentage 6.44%, Reject percentage 0.36%.

For analysis report 9 from the pie chart we see that after 10 line inspection inspector inspect Total 11452 pitches of garments and 10926 pitches quality passed. QC Passed percentage 95.40% Defects percentage 4.29% Reject percentage 0.31%

For analysis report 10 from the pie chart from the pie chart we see After 10 line inspection inspector inspect Total 8667 pitches of garments and 7561 pitches quality passed. QC Passed percentage 94.3% , Defects percentage 5.62%. Reject percentage 0.08%.

For analysis report 11 from the pie chart from the pie chart we see after 10 line inspection inspector inspect Total pitches 10433 of garments and 9707 pitches quality passed. QC Passed percentage 93.04% , Defects percentage 6.76%, Reject percentage 0.20%.

For analysis report 12 from the pie chart from the pie chart we see after 10 line inspection inspector inspect Total 13458 pitches of garments and 12778 pitches quality passed, QC Passed percentage 94.95%, Defects percentage 4.65% Reject percentage 0.40%.

For analysis report 13 from the pie chart from the pie chart we see After 10 line inspection inspector inspect Total 15452 pitches of garments and 14804 pitches quality passed. QC Passed percentage 95.80%, Defects percentage 3.84%, Reject percentage 0.36%.

For analysis report 14 from the pie chart from the pie chart we see after 10 line inspection inspector inspect Total 15191 pitches of garments and 14264 pitches quality passed. QC Passed percentage 93.89%, Defects percentage 5.75%, Reject percentage 0.36%.

4.2.3 Comparison Sewing Defects Percentage Measurement –Report (6-14) of Shad Fashion Ltd .

Table:4.2- Comparion Sewing Defects Percentage Measurement –Report (6-14) of Shad Fashion Ltd

Defect name	report-5	report-6	report-7	report-8	report-9	Report-10	Report-11	Report-12	Report-13	report -14
Broken Stitch	15.93%	8.67%	21.80%	16.49 %	17.21 %	10.56%	12.12%	12.12%	25.22%	2.89%
Skip Stitch	11.90%	9.46%	1.75%	12.62 %	11.79 %	13.00%	16.08%	16.08%	11.46%	2.71%
Open seam	11.90%	12.22%	13.28%	13.14 %	14.11 %	19.24%	8.39%	8.39%	13.30%	15.39%
Pleated	3.26%	9.27%	4.01%	6.95%	3.28%	11.38%	4.66%	4.66%	0	12.86%

Point up down	2.30%	11.24%	0	5.41%	0	0	1.86%	1.86%	5.04%	13.76%
Hi low	1.34%	0	0	9.53%	1.54%	0	2.79%	2.79%	0	0
Uneven Stitch	3.83%	1.38%	0	5.92%	0	3.25%	3.96%	3.96%	12.38%	2.17%
Oil	5.18%	5.91%	12.28%	6.95%	12.18%	2.98%	8.62%	8.62%	0	7.06%
Un cut thread	33.39%	28.20%	38.84%	0	22.43%	19.51%	28.20%	28.20%	32.56%	24.81%
Tack wrong side	1.91%	2.95%	0	1.80%	0	0	3.26%	3.26%	0	0
Poor neck shape	2.30%	0	0	0	0	0	0	0	0	0
Loose tension	0	0	0	0	0	0	0	0	0	0
Join stitch	3.45%	5.32%	6.76%	9.79%	5.41%	14.63%	6.75%	6.75%	0	10.86%
loops	3.26%	0	0	0	7.54%	0	3.26%	3.26%	0	0
Raw edge	0	5.32%	1.25%	11.34%	4.44%	5.42%	0	0	0	7.42%

From the table we see the different percentage of different defect. The defect percentage is verify for different buyer.

From SHAD FASHION LTD we work with 5 buyer garments in sewing line the buyer are TWOPOINT ZERO (BOXER), Hanes Champion (T-SHIRT), Next Sourcing (Baby suit) , Varner(swim top),TRADE MARK.

Line Inspection Report- 5 in this report buyer was Next Sourcing product was Body Suit and this day total production capacity in 10 team is 2018 and 521 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 33.39% the defect is Un cut thread, 2nd defect percentage is 15.93% the defect is Broken stitch, 3rd highest percentage is 11.90% defect is SkipStitch, 4th highest defect is 11.90% the defect is Open seam, and 5th highest defect is 5.18% the defect is Oil.

Line Inspection Report- 6 in this report buyer was Varner product was Swim top and this day total production capacity in 10 team is 7240 and 501 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 28.20% the defect is Un cut thread, 2nd defect percentage is 12.22% the defect is Open seam, 3rd highest percentage is 11.24% defect is Point Up Down, 4th

highest defect is 9.27% the defect is Pleated and 5th highest defect is 8.63% the defect is Broken stitch.

Line Inspection Report- 7 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 team is 13221 and 392 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 38.84% the defect is Un cut thread, 2nd defect percentage is 21.80% the defect is Broken stitch, 3rd highest percentage is 13.28% defect is Open seam, 4th highest defect is 12.28% the defect is Oil and 5th highest defect is 6.76% the defect is Join stitch.

Line Inspection Report-8 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 line is 8574 and 552 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 16.49% the defect is Broken stitch, 2nd defect percentage is 13.14% the defect is Open seam, 3rd highest percentage is 12.62% defect is Skip stitch, 4th highest defect is 9.79% the defect is Join stitch and 5th highest defect is 6.95% the defect is Oil.

Line Inspection Report-9 in this report buyer Varner product was swim top and this day total production capacity in 10 line is 11452 and 495 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 22.43% the defect is Un cut thread, 2nd defect percentage is 17.21% the defect is Broken stitch, 3rd highest percentage is 14.11% defect is Open seam, 4th highest defect is 12.18% the defect is Oil and 5th highest defect is 11.79% the defect is Skip stitch

Line Inspection Report-10 in this report buyer was product was T-shirt and this day total production capacity in 10 line is 8667 and 487 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 19.51% the defect is Un cut thread, 2nd defect percentage is 14.63% the defect is Join stitch, 3rd highest percentage is 13% defect is Join stitch, 4th highest defect is 11.38% the defect is Pleated and 5th highest defect is 10.56% the defect is Broken stitch.

Line Inspection Report-11 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 line is 10433 and 705 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 16.91% the defect is Skip stitch, 2nd defect percentage is 16.26% the defect is Un cut thread, 3rd highest percentage is 15.83% defect is Open

seam,4th highest defect is 14.09% the defect is Raw edge and 5th highest defect is 8.24% the defect is Tack wrong side.

Line Inspection Report-12 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 line is 12458 and 625 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 28.20% the defect is Un cut thread, 2nd defect percentage is 16.08% the defect is Skip stitch,3rd highest percentage is 12.12% defect is Broken stitch,4th highest defect is 8.62% the defect is Oil and 5th highest defect is 8.39% the defect is Open seam .

Line Inspection Report-13 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 line is 15452 and 593 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 32.56% the defect is Un cut thread, 2nd defect percentage is 25.22% the defect is Broken stitch,3rd highest percentage is 13.30% defect is Open seam,4th highest defect is 12.38% the defect is Uneven stitch and 5th highest defect is 11.46% the defect is Skip stitch.

Line Inspection Report-14 in this report buyer was Hanes Champion product was T-shirt and this day total production capacity in 10 line is 15191 and 873 pieces are defected fabric is found. In this defected fabric the highest defective percentage is 24.81% the defect is Un cut thread, 2nd defect percentage is 15.39% the defect is Open seam,3rd highest percentage is 13.76% defect is Point up down,4th highest defect is 12.86% the defect is Pleated and 5th highest defect is 10.86% the defect is Join stitch

4.3.1 DHU% Compare in jamuna Apparels Ltd.

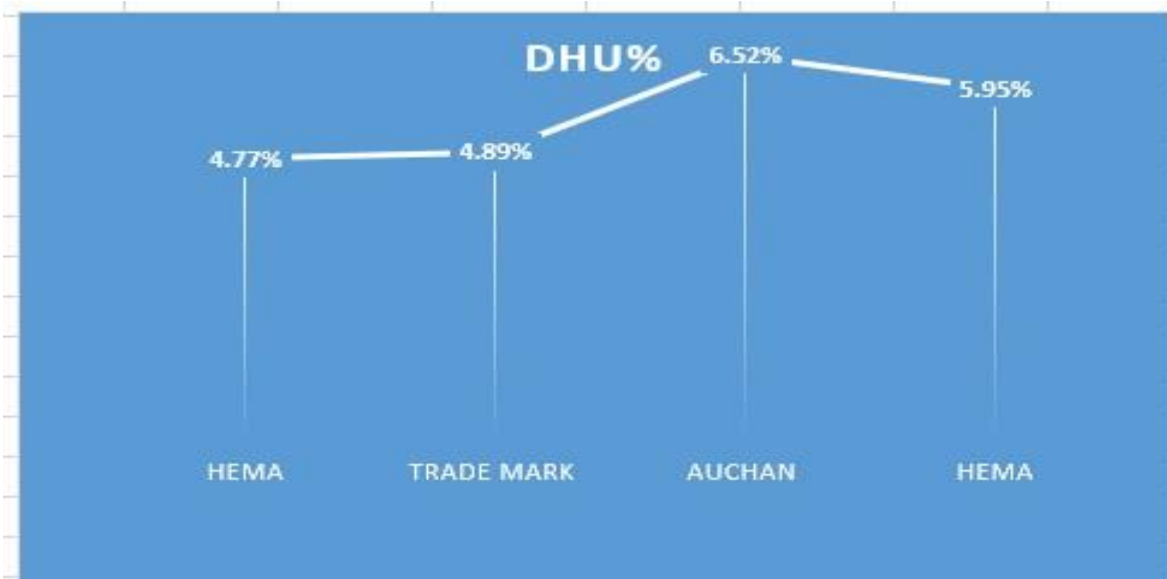


Fig: 4.3.1 - Graphically Show Area chart of Jamuna Apparels different Buyer DHU% Comparison

From this area chart we see that 3 buyer DHU% compare for different style Hema Buyer DHU% is 4.77% when its product is T-shirt, also this buyer DHU% is 5.95% when its item is Boxer. For different item DHU% is verify. For Trade mark DHU% is 4.89% and Auchan Buyer DHU% is high which is 6.52% item was baby suit.

4.3.2 DHU% Compare in Shad Fashion Ltd.

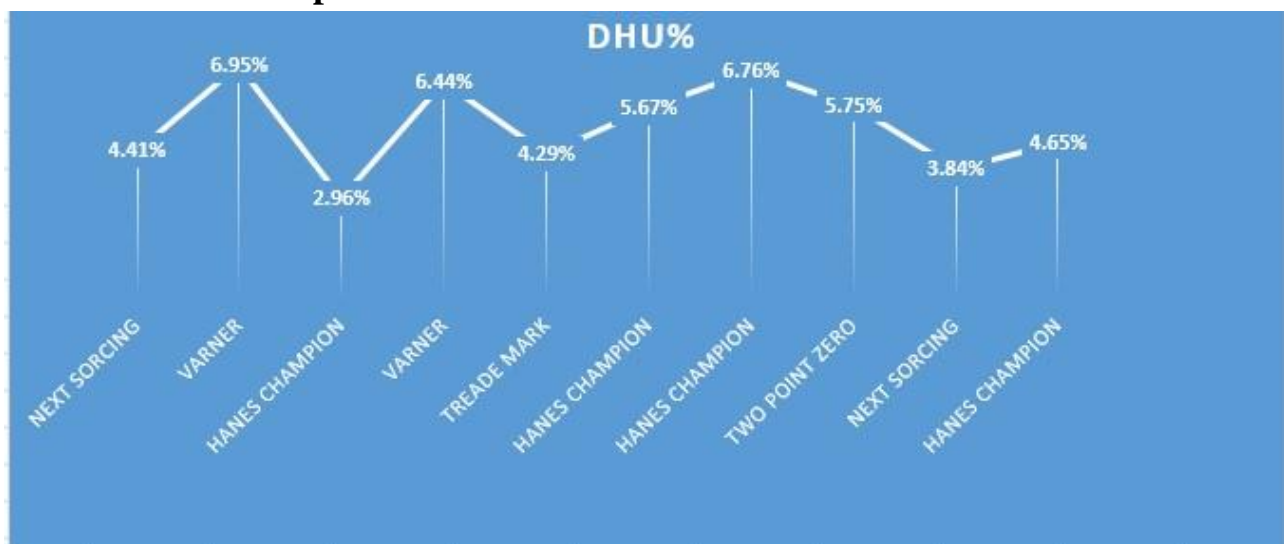


Fig: 4.3.2 Graphically Show Area chart of Shad Fashion Ltd. different Buyer DHU% Comparison

From this area chart we see that 5 buyer DHU% compare for different style Next Sourcing Buyer DHU% is 4.41% when its product is body suit, also this buyer DHU% is 3.84% when its item is sleep suit. For different item DHU% is verify. For Varner DHU% is 6.95% & 6.44%. Hanes champion Buyer DHU% is 2.96%,5.67%,6.76%,4.65% item was t-shirt ,Hoody, jersey .

From this area chart the top DHU% found in varner Buyer which is 6.95%.

4.3.3 Compare DHU% Between Jamuna Apparels Ltd and Shad Fashion Ltd.

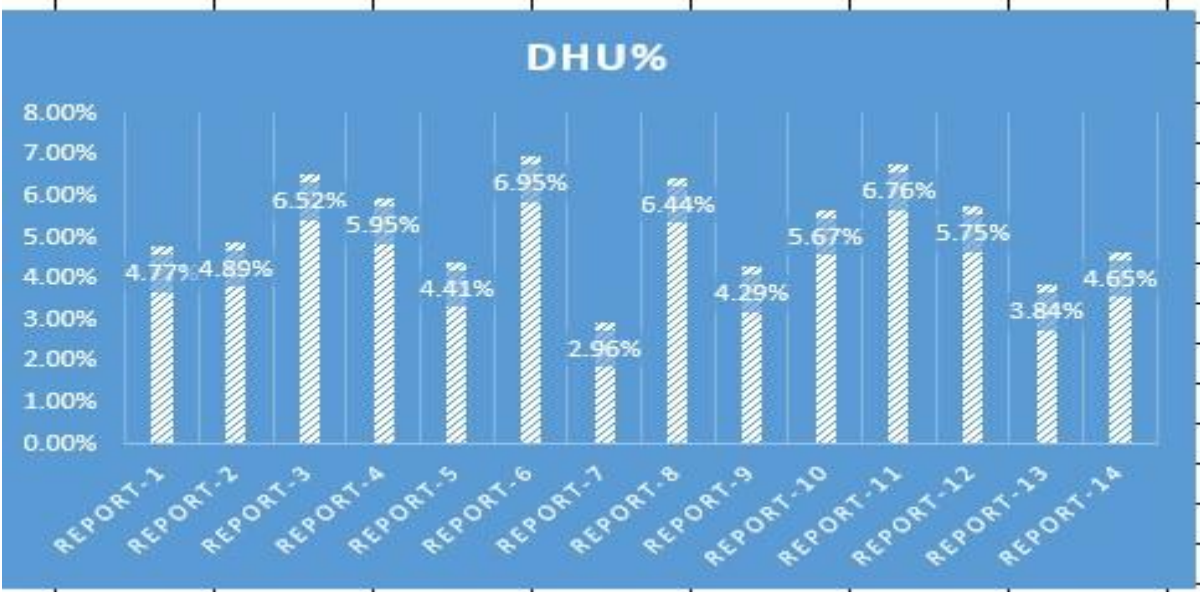


Fig: 4.3.3 Graphically Show Comparison of Jamuna Apparels Ltd and Shad Fashion Ltd. DHU%

From this graph compare two factory DHU%. Here 1st four report is collected from Jamuna Apparels Ltd. And others report is collected from Shad Fashion Ltd. The highest DHU% is found in Shad Fashion Ltd which is 6.95% in report 6 buyer was Varner item was swim top combo 3 color. 2nd highest DHU% found is shad fashion its which is 6.76% in report 11 buyer was Hanes and item is T-shirt. And 3rd highest DHU% found in Jamuna apparels Ltd which is 6.52% in report 3 buyer was Auchan item was Baby suit. For different buyer different item DHU% always changeable.

CHAPTER-5

CONCLUSION

At last we are completed Our thesis paper. We are done our thesis a lot of experiment, analysis, discussion. After doing this thesis, we were gather a big experience. We also increase knowledge about different types of faults and their causes and how to remove or reduce those problem. If we overcome those kind of defect, garments sector is getting a lot of profit. In Jamuna apparels Ltd, Highest defect is uneven stitch which percentage is 25.11% and Highest DHU% is 6.52%. In shad fashion Ltd, Highest defect is uncut thread which percentage is 38.84% and Highest DHU% is 6.95%. We can conclude from our project work that all sewing are accountable for various types of machine flaws. We have completed project work with great attention and success. We discovered that everyone in the factory is really helpful and has a positive attitude. Finally, we can say that this project will be really beneficial in our educational & professional life

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