



Daffodil
International
University

Faculty of Engineering
Department of Textile Engineering

REPORT ON
Industrial Attachment
At
Robintex Group
Vulta, Rupgonj, Narayangonj

Course Title: Industrial Attachment
Course code: TE-431

Submitted By

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Tanver Ahmed Chowdhury ID: 113-23-2707

Supervised By

Md. Mominur Rahman
Senior Lecturer, Dept. of TE

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

Advance in Apparel Manufacturing Technology

Duration: From May 23, 2015 to July 23, 2015

DECLARATION

We hereby declare that, this report has been done under the supervision of Md. Mominur Rahman, Senior Lecturer, Department of Textile, Daffodil International University. We also declare that neither this internship report nor any part of this internship report has been submitted elsewhere for award of any degree.

Submitted By

Student Name	ID	Signature
Shafiqul Islam	113-23-2697	
Tanver Ahmed Chowdhury	113-23-2707	

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

Supervisor:

Md. Mominur Rahman
Senior Lecturer,
Department of Textile Engineering
Daffodil International University

Internship Period: 23 May – 23 July, 2015

Letter of Approval

August 2, 2015

To

The Head

Department of Textile Engineering

Daffodil International University

102, Shukrabad, Mirpur Road, Dhaka 1207

Subject: Approval of Industrial Attachment of B.Sc. in TE Program

Dear Sir

I am just writing to let you know that this industrial attachment has been prepared by the student bearing ID 113-23-2697 and ID 112-23-2707 is completed. The whole report is prepared based on the proper investigation and interruption through critical analysis of empirical data with required belongings. The students were directly involved in their 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 industrial attachment and consider it for final evaluation.

Yours Sincerely



Md Mominur Rahman

Senior Lecturer

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

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ACKNOWLEDGMENT

At first our gratefulness goes to almighty Allah to give me strength and ability to complete the industrial training and this report. You have made our life more beautiful. May you name be exalted, honored and glorified.

Now we wish to take this excellent opportunity to thank a lot of people who have assisted and inspired us in the completion of our training period:

MD. Mahmudul Hasan, Our industrial supervisor, to whom we are extremely indebted for his tremendous support and guidance throughout our training period. Being working with him we have not only earned valuable knowledge but was also inspired by his innovativeness which helped enrich us experience to a greater extends. His ideas and way of working was truly remarkable.

At the begging we would like to pay our gratitude to **Professor Dr. Mahbubul Haque**, HEAD, Department of Textile Engineering, Daffodil International University, **Prof. Dr. S.M. Mahbub-Ul Haque Majumder**, Dean, Faculty of Science & Information Technology, Daffodil International University & Our Academic Supervisor **Senior Lecturer Md. Mominur Rahman** for giving us all the academic facilities we needed.

We would like to thank all the management of the Robintex Group for giving us the opportunity to do the industrial training successfully and also their valuable suggestion. Our deepest appreciation goes to **Mr. A.J.M Abdul Wazed, Mr. Tipu, Mr. Zulfikar, Mr. Masud, Mr. Mizanur Rahman Gazi, Mr. Iqbal, Mr. Shamim, Mr. Milon (Manager)**, Comptex Bangladesh Ltd & Robintex Bangladesh Ltd for their permission to conduct our industrial training without which it would be uncompleted . The generous support is greatly appreciated. We would also like to thanks all Asst. Manager, Sr. Executive, Executive and other officials of Robintex Group for helping us to complete industrial training successfully. Our gratute also goes to all the employers of Robintex Group for their sincere co-operation, support and valuable advice.

DEDICATION

Our parents are our life. We love them very much. For completing our study they place very important role. It's a great pleasure for us. Without their help it is quite impossible for us to complete. So we are very grateful to them. Our parents were very helpful to ready this attachment. And also our honorable teacher & academic supervisor, Senior Lecturer, Md. Mominur Rahman, Department of Textile Engineering, Daffodil International University, give us a very good support & guideline to ready this attachment. We dedicate this report to our beloved parents.

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1.0 EXECUTIVE SUMMARY

The Industrial Attachment is the most effective way for Textile Engineering student to be achieved the knowledge about the practical field of the Textile Manufacturing. It brings an opportunity to all the learners to enrich their academic knowledge by practicing with the experts of the practical field of textile.

It is my pleasure that I had an opportunity to complete my two months internship at Robintex Group which is one of the most modern industries of the country.

Robintex Group is one of the major garments manufacturing organization in Bangladesh. This organization increasingly reducing its rejection and rework rate in-process and final garments in order to ensure product quality and delivery time as per buyer requirement and increase profitability. It will ensure sufficient training and suitable work to increase productivity and skills of the employee. Now Robintex Group has a 50 Acres. Its production capacity is around Knitting – 18 tons/day, Dyeing-24ton/day, Finishing-24ton/day, Sewing-1,00,000 pcs. Number of employees at least 8000.

In this report I tried to cover a short profile of this factory and major customers of Robintex Group and their different activities.



2.0 INFORMATION ABOUT FACTORY:

2.1 Introduction

The term “TEXTILE” derived from the Latin Textiles and the French Textiles “to weave” and it originally referred only to woven fabrics. It has however , come to include fabrics produced by other methods. Thus, threads, cords, ropes, braids, lace, embroidery, nets and fabrics made by weaving, knitting, bonding, felting or tufting are textiles. Some definitions of term textile would also include those products obtained by the papermaking principle that have many of the properties associated with conventional fabrics. In addition to clothing and home furnishings, textile are used for such industrial products as filters to air condoners, life rafts, conveyer belts, tents, automobile tires, swimming pools, safety helmets and mine ventilators.




From fiber to fabric, Robintex Group is truly integrated undertaking. The Robintex Group has the capability to offer a complete product range for the export textile markets. The goal of Robintex Group is to become the preferred partner for sourcing high quality fabrics and clothing from Bangladesh. With highly advanced technology and an emphasis on developing local human resources. Robintex Group has the potential to make an important contribution to the nation’s growing ready made garments export sector.

The rational behind the existing structure and future expansion of Robintex Group is to capture value-added at each stage of textile manufacturing process. Despite Bangladeshi’s lack of indigenous cotton production capability. Robintex Group has leveraged Bangladeshi’s labor cost advantages and export competitiveness to the maximum.



2.2 History of the Factory

In 1994 Mr. Firoz-Al Hasan & Shakawat Abu Khair Mohammed establishes the Robintex Knit Dyeing Industry. After then 1st June 2000 they were establish Comptex BD Ltd. In 2005 they were divided into two groups. Mr. Firoz-Al Hasan Youth Group Ltd. & Shakawat Abu Khair Mohammed bought the share of Comptex BD Ltd from Mr. Firoz-Al-Hasan. Then he becomes only one owner of the company. Periodically 2006 establish Printing Section of Robintex Group. And in 2008 new Comptex BD Ltd.

robintex	comptex	robin knitwear (special uni
		
Year of Establishment : 1996	Year of Establishment : 2003	Year of Establishment : 2002
Manpower : 3500	Manpower : 4000	Manpower : 150
Floor Space : 300.000 SFT	Floor Space : 400.000 SFT	Floor Space : 10.000 SFT
Capacity : 40.000 pcs per Day or 12t of Fabrics	Capacity : 60.000 pcs per Day or 12t of Fabrics	Capacity : 5.000 pcs of fashionable garments per

2.3 Founder & Directors

01. Founder & Chairman : Sakhawat Abu Khair Mohammed

02. Managing Director : Sakhawat Abu Khair Mohammed

03. Director : Robin Razon Sakhawat



Managing Director



Director



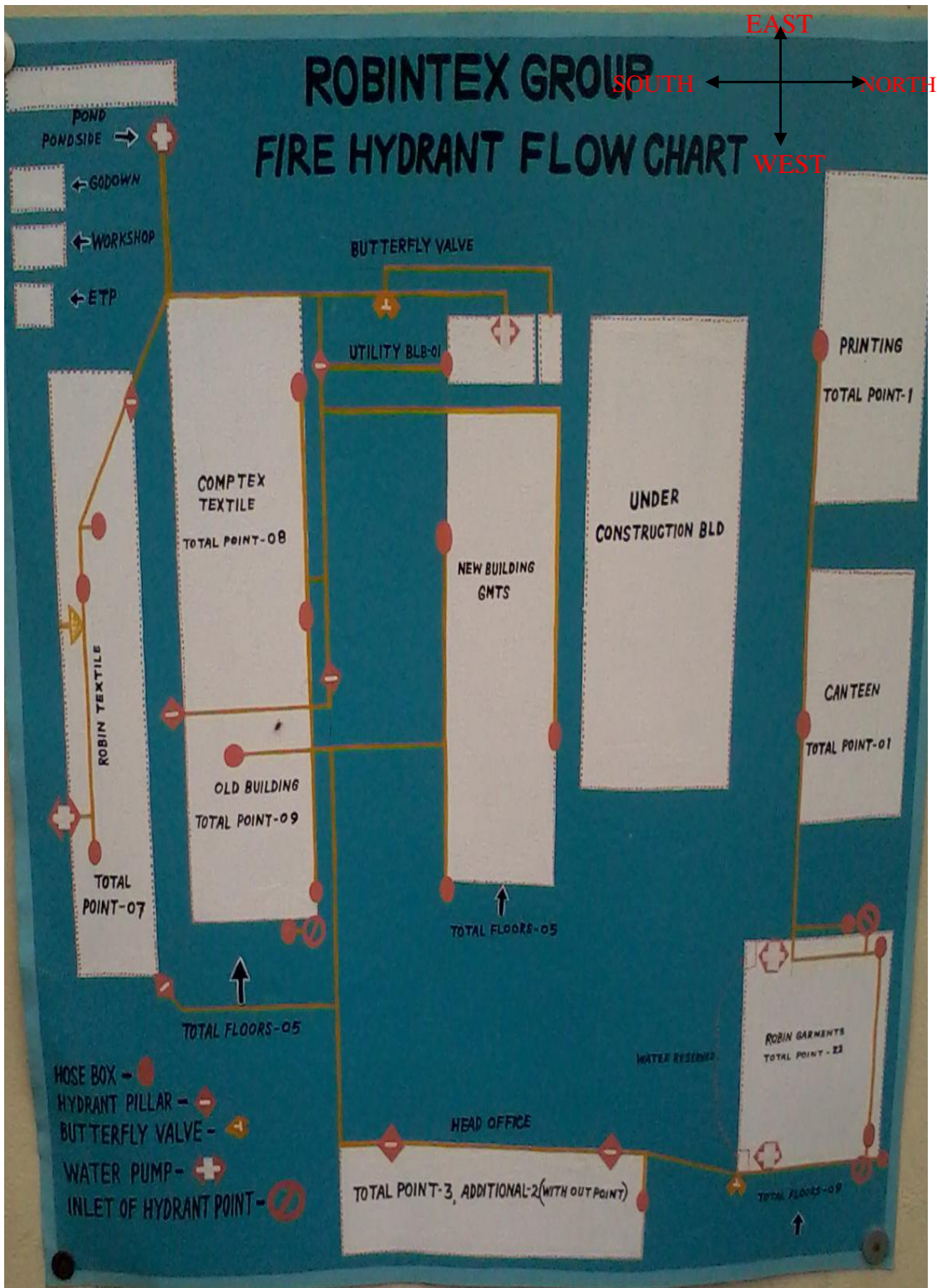
Other members

2.4 General Information about Factory

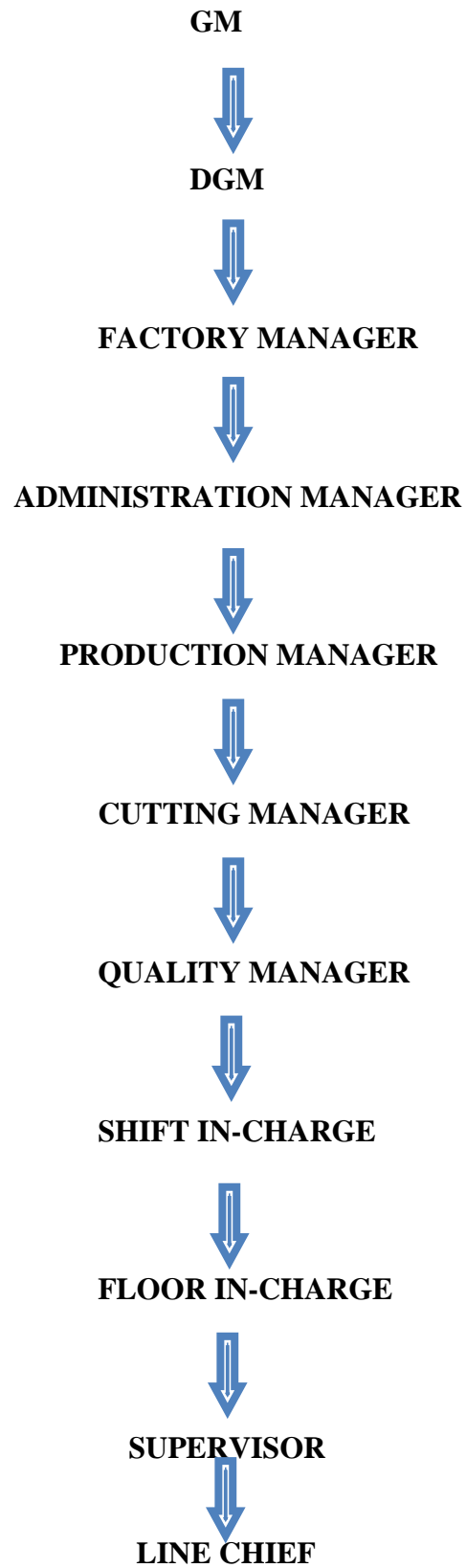
Robintex Bd. Ltd. the very first concern of the Group. The company currently employs over 8000 skilled employees. In all the different production with the workers have to go through a process of continuous and rigorous training to maintain a high standard of production set by the management. The group also caters this driving force by ensuring facilities that exceed the minimum set by international regulators. It maintains medical and day care services, scholarship programs and other benevolent initiatives for the employees and their family members. As part of their commitment towards the society, the group has established a medical service station open for all. Robintex Group distributes relief materials including cash to the victims in any part of the country during natural adversities.



2.5 Layout

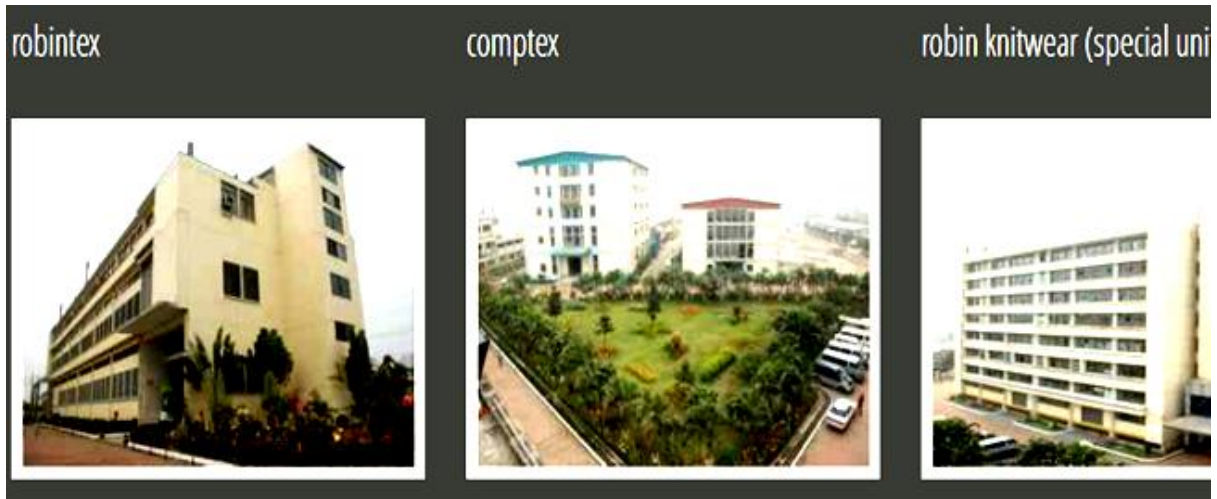


2.6 Organogram

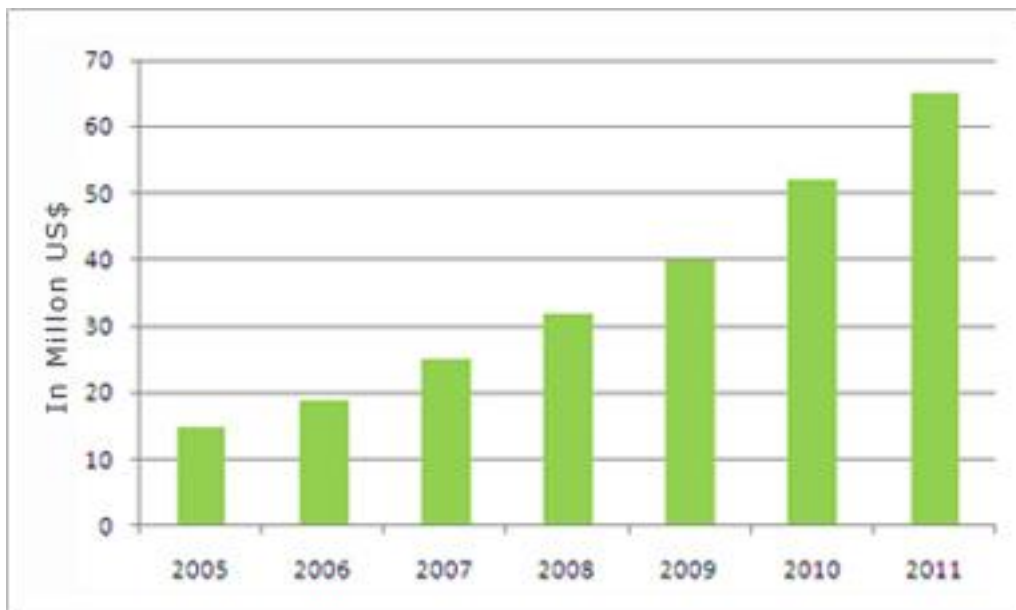


2.7 Sister Concerns:

- Robintex Bd. Ltd.
- Robintex Knitwear Ltd.
- Comptex Bd. Ltd.



2.8 Export Growth by Graph:



Export growth of Robintex Group

2.9 Product Mix

- Basic T-Shirt
- Tank Top
- Long Sleeve
- T-Shirt
- Polo Shirt
- Trouser
- Ladies, kids Knitwear all kinds of knit garments & knit fabric.

2.10 Factory Profile

Name of the Company	:	Robintex Group (Comptex BD Ltd. & Robintex BD Ltd.)
Address	:	
Head office	:	TK Bhavan (8 th Floor) 13, Karwan Bazar, Kazi Nazrul Islam Avenue, Dhaka-1215, Bangladesh. Tel : +88-02-9138162 Fax: +88-02-9117751 E-mail : mail@robintex.com info@comptexbd.com www.robintexbd.com
Factory	:	Vulta, Rupgonj, Narayongonj.
Type of the project	:	100% Export Oriented Composite Knit Industry (German-Bangladesh Joint Venture).
Year of Establishment	:	Robintex 1994 Comptex 2004
Investor	:	Sakhawat Abu Khair Mohammed
Factory Area	:	50 Acres

Total Employees : 8000 person

Annual Turnover : 120 core Tk

Certification & Awards : ISO 9001 Certified; Control Union Certificate;
OEKOTEX Certificate; Organic Cotton Certificate

Main Product : Basic T-Shirt, Tank Top , Long Sleeve, T-Shirt, Polo
Shirt,
Trouser, Ladies & Kids Knitwear all kinds of knit
garments & knit fabric.

Production Capacity : Knitting – 18 tons/day
Dyeing-24ton/day
Finishing-24ton/day
Sewing-1,00,000 pcs

2.11 Main Buyers





TEMA MAĞAZACILIK

- H & M
- HEMA
- ITPS
- Slazenger
- Tom-tailor
- PUMA


2.12 Certification

- ISO 9001 Certified
- Control Union Certificate
- OEKOTEX Certificate
- Organic Cotton Certificate





B.I.D. Business Initiative Directions
Principles of the QC100 Total Quality Management Model




Commitment of Robintex (Bangladesh) Ltd. to Quality

Our company accepts quality as a factor of development to become more competitive. Robintex (Bangladesh) Ltd. is committed to publicizing this Quality Culture with employees, suppliers, clients and the community, supported by the QC100 Total Quality Management Model, the principles of which are the following:

- 1** Quality is a consequence of valuing customer satisfaction and obtaining positive business results.
- 2** Meet the quality levels established in the company in accordance with the QC100 Points of Quality.
- 3** Encourage participation and teamwork for decision making.
- 4** Satisfy the needs of our clients and meet their expectations.
- 5** Provide human resources, both technical and economic, to achieve continuous improvement and respect for the environment.
- 6** Manage human resources in our company to achieve the maximum potential.
- 7** Make employees aware of the importance of concentration on the most profitable areas of activity, to achieve the best business results.

The achievement of these seven principles by Robintex (Bangladesh) Ltd. will foster improvement for clients, employees, suppliers and all of the other persons who make up the company.

Paris, October 29, 2012



General Manager
Robintex (Bangladesh) Ltd.

The criteria expressed in this document is the ideological support of the International World Quality Commitment, administered by B.I.D. Business Initiative Directions and endorsed by the QC100 Total Quality Management Model. General Yagüe, 11 - 28920 Madrid-Spain - T. +34 91 597 33 69 - www.bid.org.com



2.13 Mission & Vision

Mission: Robintex Group believe that the final analysis it is accountable to each of constituents with whom it interact, namely , its employees , customer, business associates, fellow and citizens.

Vision: To be one of the best leading composite mill in Bangladesh. To build a true marketing lead enterprise with motivates workforce, innovative mission and understanding global market.

03 DESCRIPTION OF THE ATTACHMENT

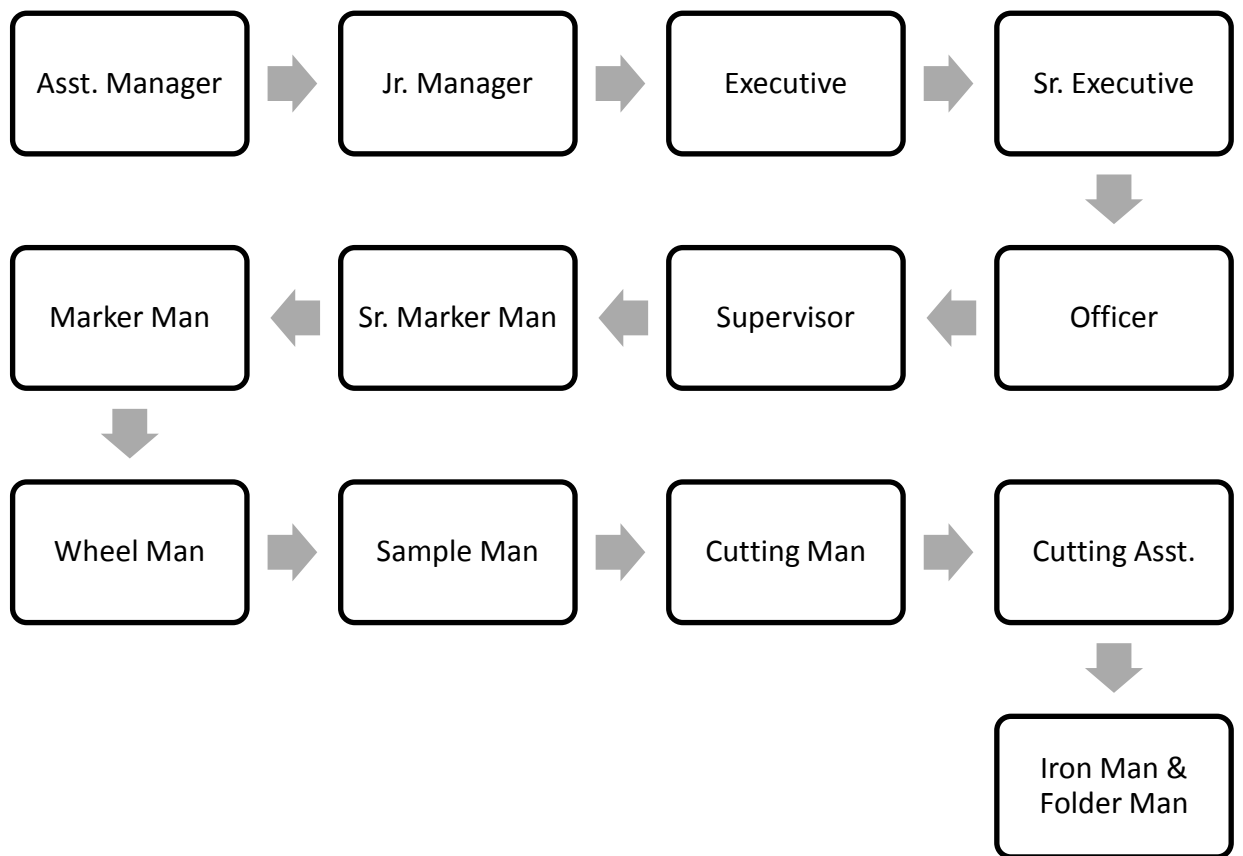
3.1 Sampling

3.1.1 Layout:

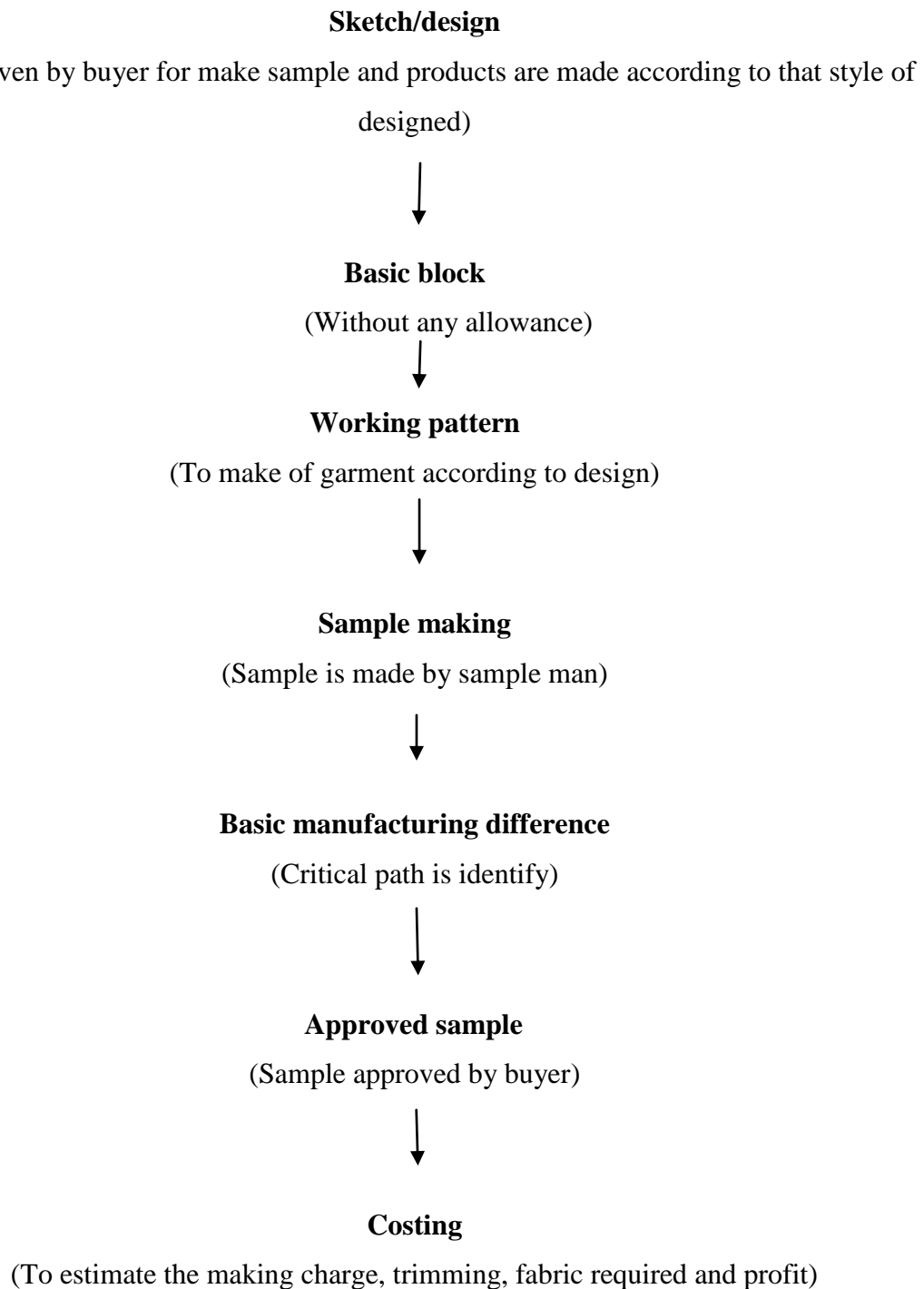


Fig: Layout plan of sample section

3.1.2 Organogram:



3.1.3 Process Flow Chart:



3.1.4 Machineries:

- CAD
- CAM
- Marker printing machine



Fig: Marker printing machine



Fig: CAD software

3.1.5 Major operations:

Design or Sketch:

It is nothing but one kind of engineering art including all measurement of particular style.

Basic Block:

It is an individual component of garments without any design or style.

Working Pattern:

To make pattern for a particular style with net dimension. .

Problem of Production or Production Related Matter:

Production related problems should be eliminated in this step.

Approved Sample:

The sample which is approved by buyer is called approved sample.

Send to Buyer:

When all process is done, then the garments are sent to buyer.

Production Pattern:

To make pattern for a particular style with net dimension along with allowance.

3.1.6 Product evaluation process:

- Gain a full understanding of the sample development process.
- Able to plan a development process suitable for your company.
- Awareness of reducing development and company costs and improve customer service.
- Find ways of minimizing risk factors and maximizing quality parameters.
- Economic/market place needs are identified.
- Forming first concepts/ideas.
- Developing concepts into prototype sample
- Modifying prototype until approved.
- Amendments to specification.
- Finalized first sample & specification to retailing.

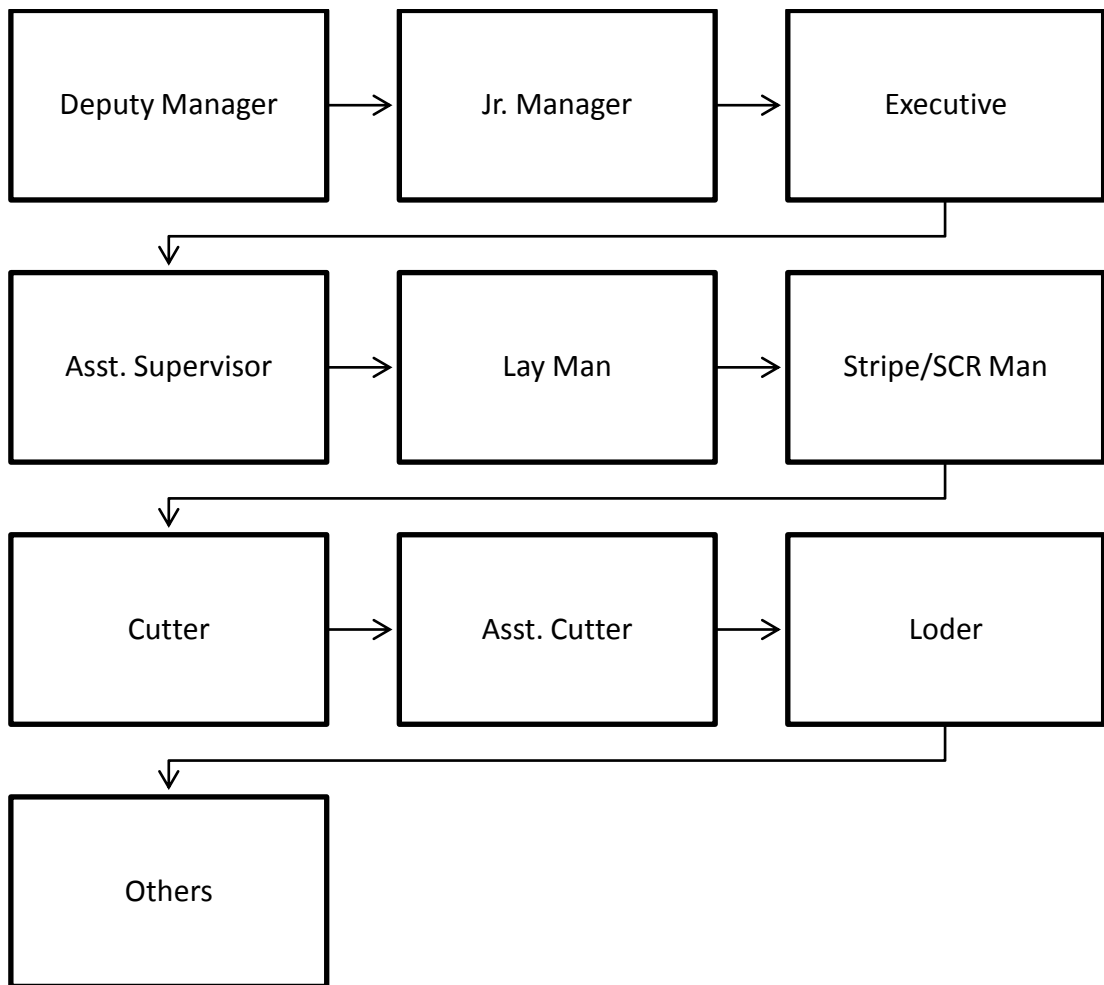
3.2 Cutting

3.2.1 Layout:

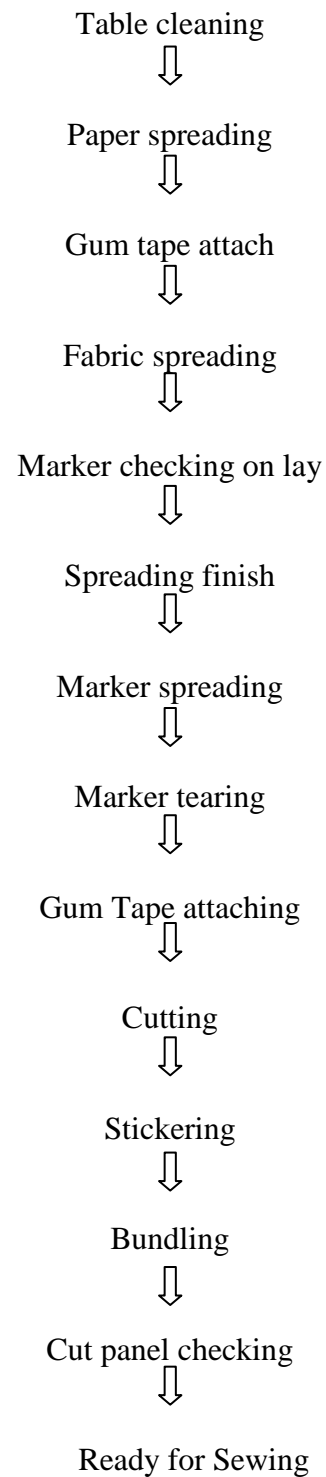


Fig: Layout plan of cutting section

3.2.2 Organogram:



3.2.3 Process Flow Chart:



3.2.4 Machineries:

1. Cutting machine:

a) Manual cutting machine-

- i) Straight knife cutting machine
- ii) Hand operated cutting scissor



Fig: Straight knife cutting machine

b) Computerize cutting machine-

- i) Gerber auto cutting machine
- ii) EMM auto cutting machine



Fig: Computerized cutting machine

2. Fabric spreading machine

- i) Gerber auto spreading machine
- ii) EMM auto spreading machine



Fig: Auto spreading machine

3. Fabric spreading table

4. Numbering machine



Fig: Numbering machine

3.2.5 Major Operations:

- All documents check-
 - a) Shade approval
 - b) 4 point inspection report
 - c) GSM report
 - d) Shrinkage test report
 - e) Country plane
 - f) Relaxation sticker

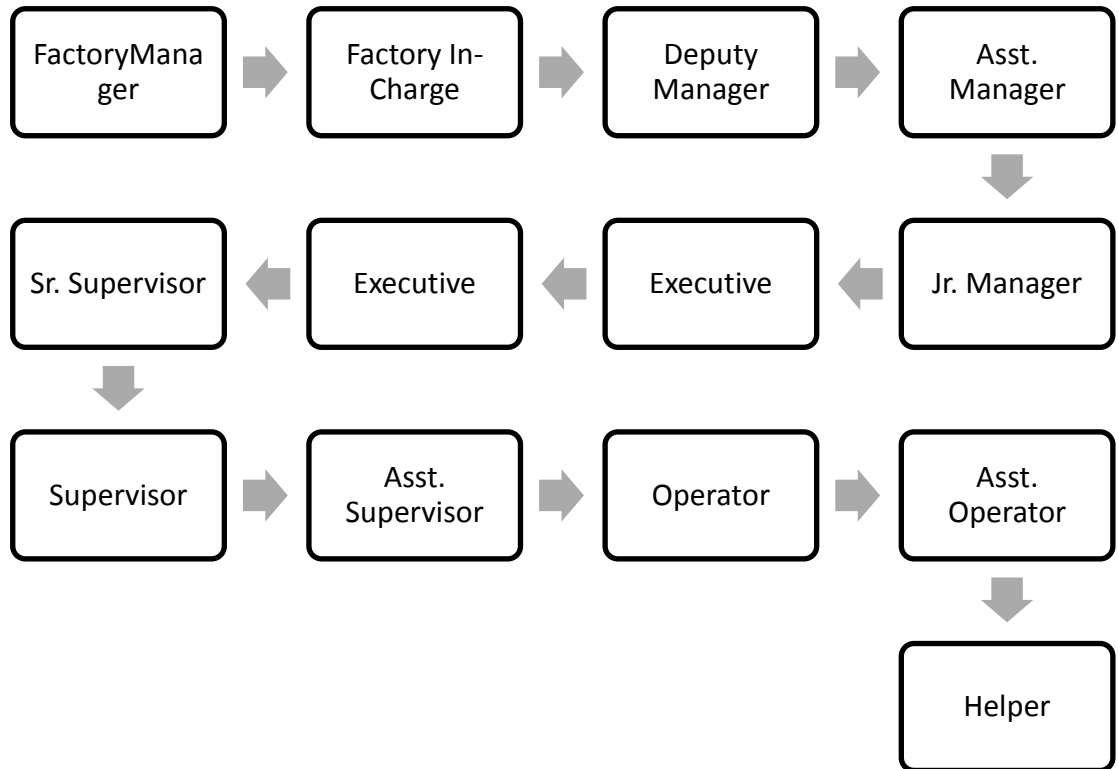
- Fabric spreading
- Marker check
- Fabric cutting
- Block check by pattern
- Cut panel check

3.2.6 Product Evaluation process:

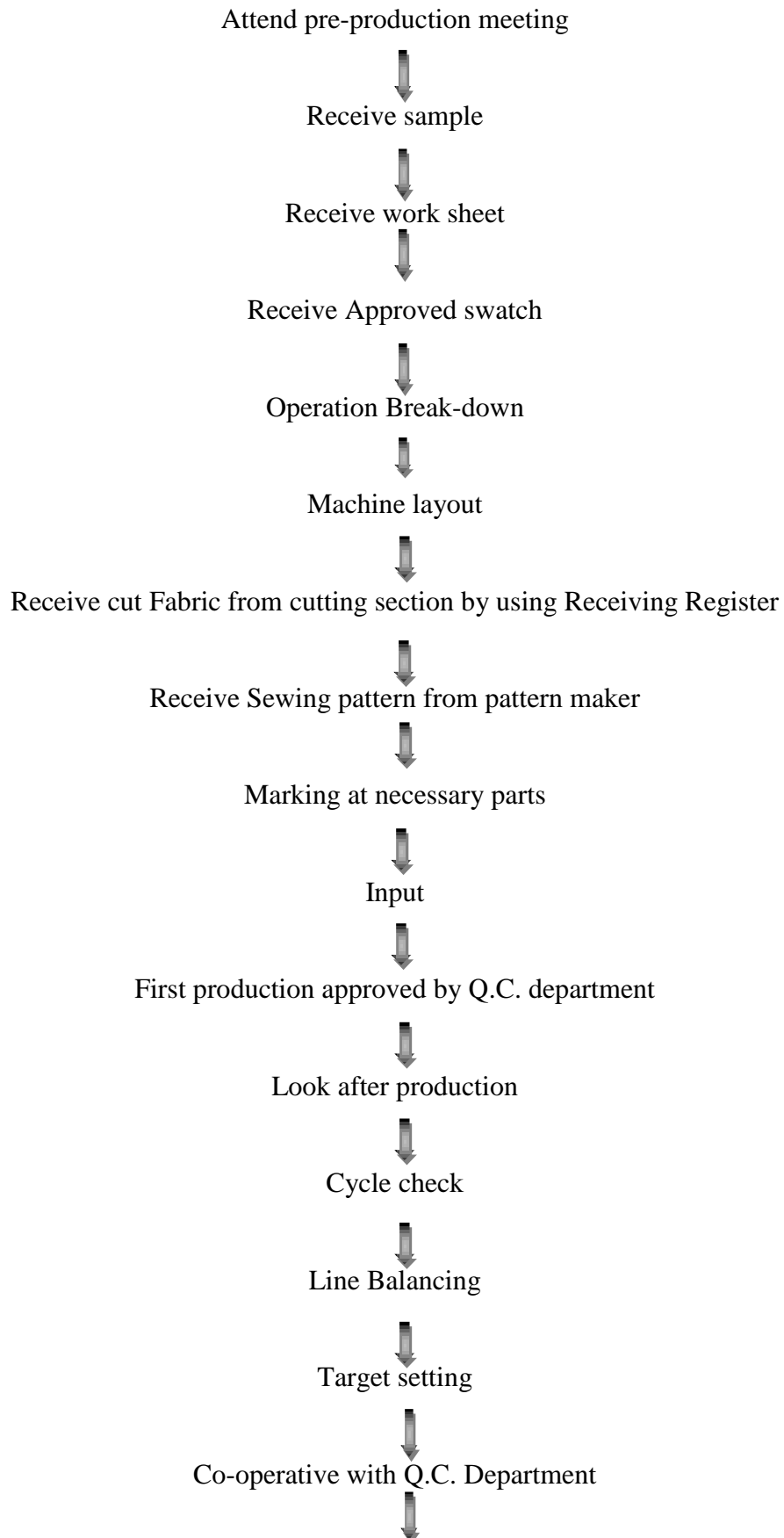
- Shade check with buyer approved swatch
- Check GSM
- Running shade check
- Roll wise shade check
- Batch to batch shade check
- Shrinkage test
- Marker check
- Cutting panel check
- Pattern check
- Shape check of different parts
- Measurement check
- Check number of different parts in bundle

3.3 Sewing

3.3.1 Organogram:



3.3.2 Process Flow Chart:



Hand over complete Garments to finishing section through end line Q.C. Inspector



Show hourly production on production board



Prepare every day input and production statement



Maintain discipline and working environs

3.3.3 Machineries:

- Over lock
- Single needle
- Flat lock
- Button stitch
- Button holing
- Piping cutter
- Bartek
- Kansai
- Snap button



Fig: Plain machine



Fig: Over lock machine

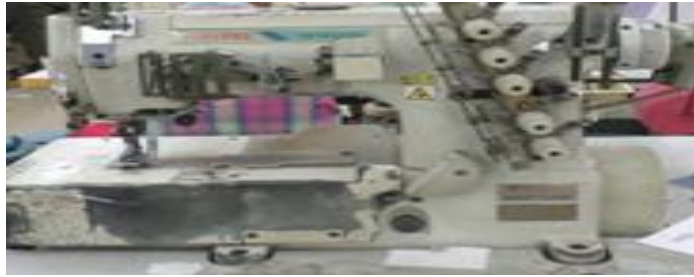


Fig: Bartek machine

3.3.4 Major operations carried out by the section:

- Collect counter sample
- Take cut panel measurement
- Front / back matching
- Start sewing
- Use mockup for critical operation
- Process wise thread trimming & cutting sticker remove
- Process quality check
- End table quality check

3.3.5 Product evaluations carried out by the process:

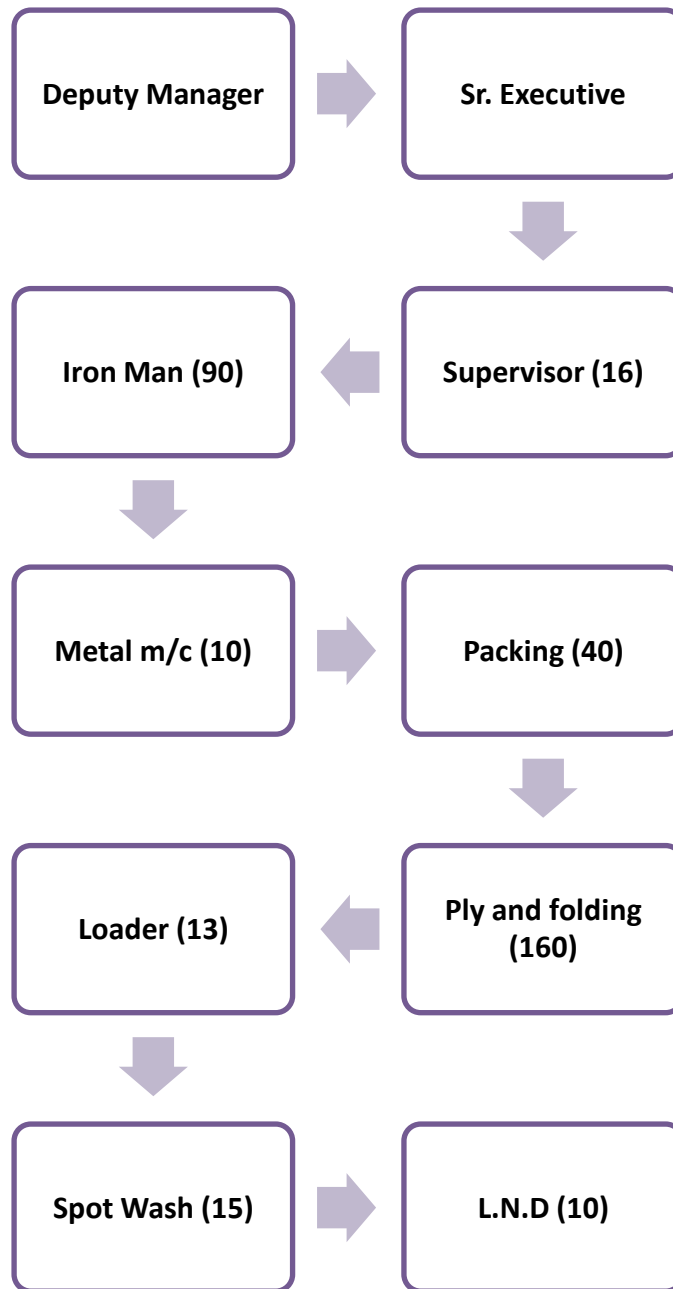
- Calculate the production capacity
- To establish proper layout of the sewing floor
- To provide accurate guideline for the floor supervisor ,floor quality ,line chief and other person of the floor
- To solve any problem of the floor, it may production problem, worker problem etc.
- To provide production report and other information in the floor of the higher authority
- To look after the floor
- To maintain the line chief line quality ,line supervisor and other persons of the floor
- To solve any problem of any line in the sewing floor
- To maintain line input and output materials
- To find out per line production capacity of the sewing floor

3.4 Finishing

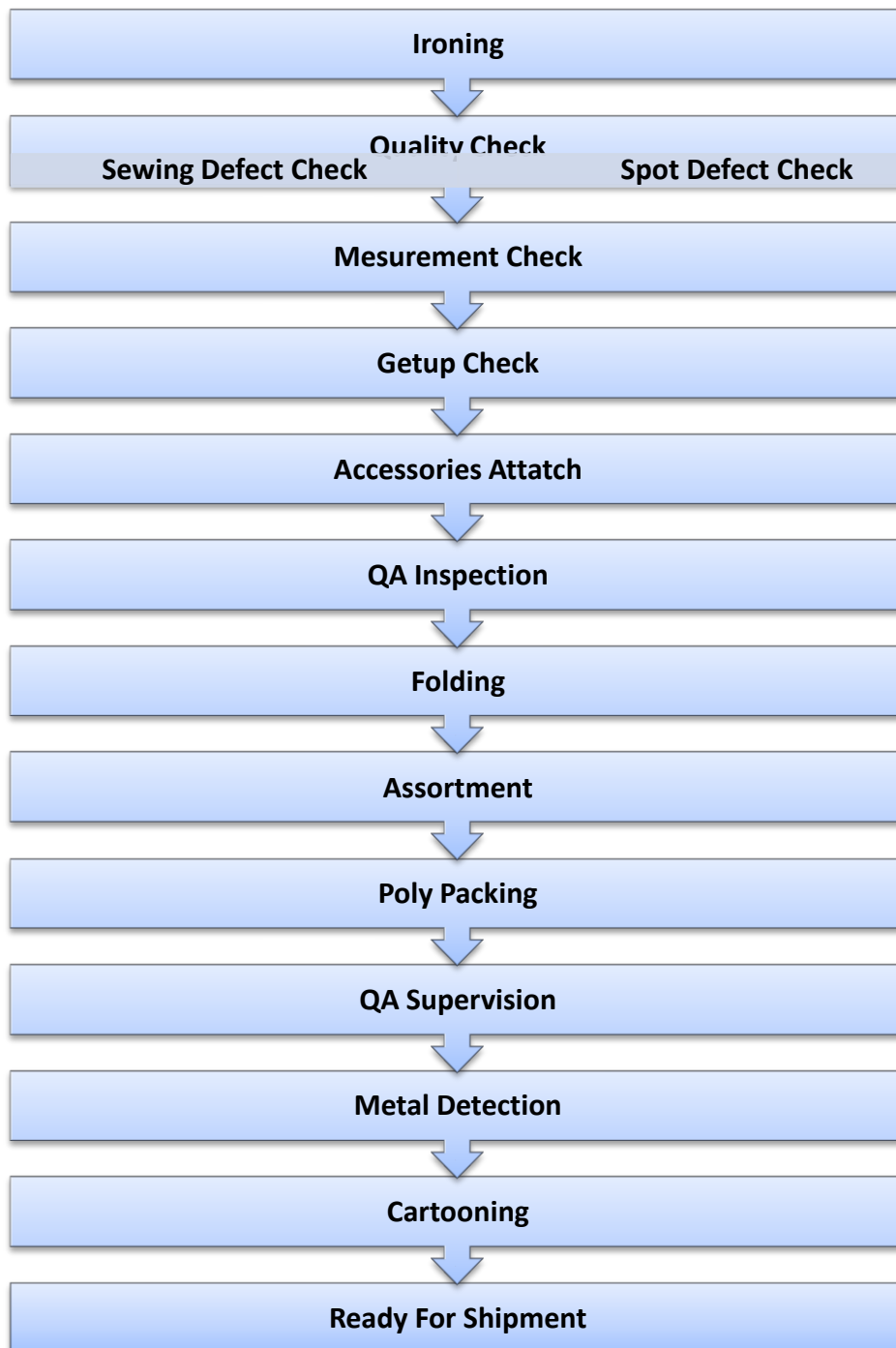


Fig: Finishing section

3.4.1 Organogram:



3.4.2 Process Flow Chart:



3.4.3 Machineries:

- Heat iron
- Steam iron
- Metal detector
- Neck press
- Thread sucker

3.4.4 Major operations:

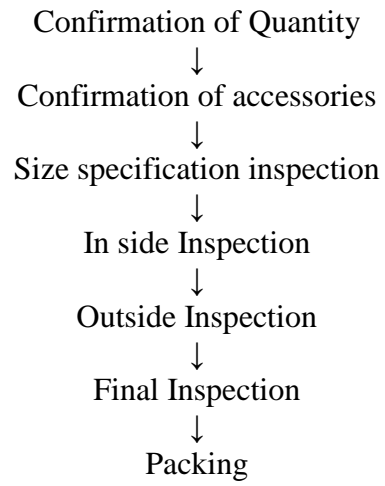
- Thread Suction (Thread Sucker M/c)
- Ironing
- Quality Check
- Metal detection
- Accessories Attach (Hang Tag, Price Tag, Hanger, Sticker, Security Alarm etc.)
- QA Inspection
- Folding/Rolling
- QA Supervision
- Cartooning/Packaging

3.4.5 Product evaluation process:

- Getup check
- Measurement check
- Final garments inspection
- Ratio wise packing inspection

3.4.6 Garment Inspection:

Flow Chart of Garment Inspection



3.5 Store Section

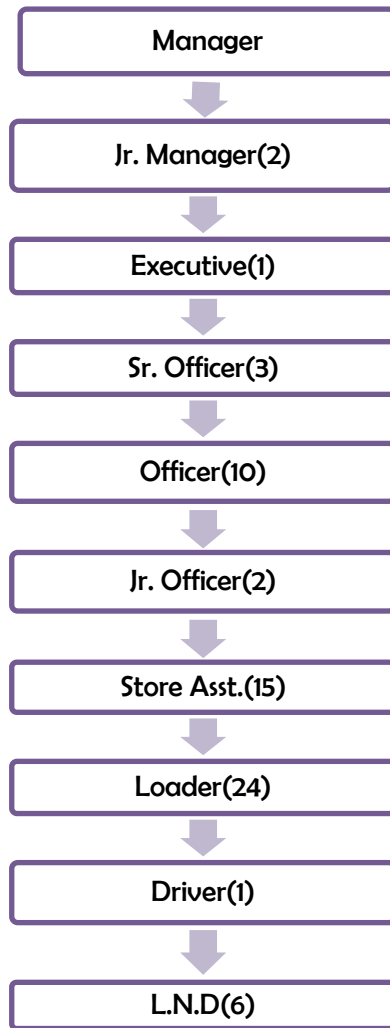


Fig: Store section

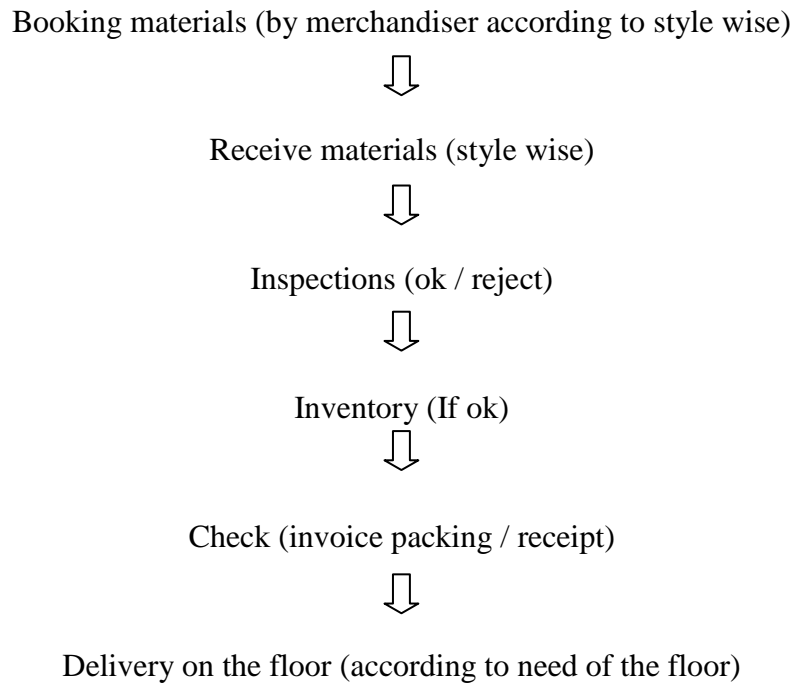


Fig: Store section

3.5.1 Organogram:



3.5.2 Process Flow chart:



3.5.3 Major Operations:

- a) Fabric Received
- b) Fabric inspection
- c) Fabric inventory
- d) Shrinkage test of fabric
- e) Shade grouping of fabric
- f) Color continuity card
- g) Fabric assessment with light
- h) Swatch card maintain

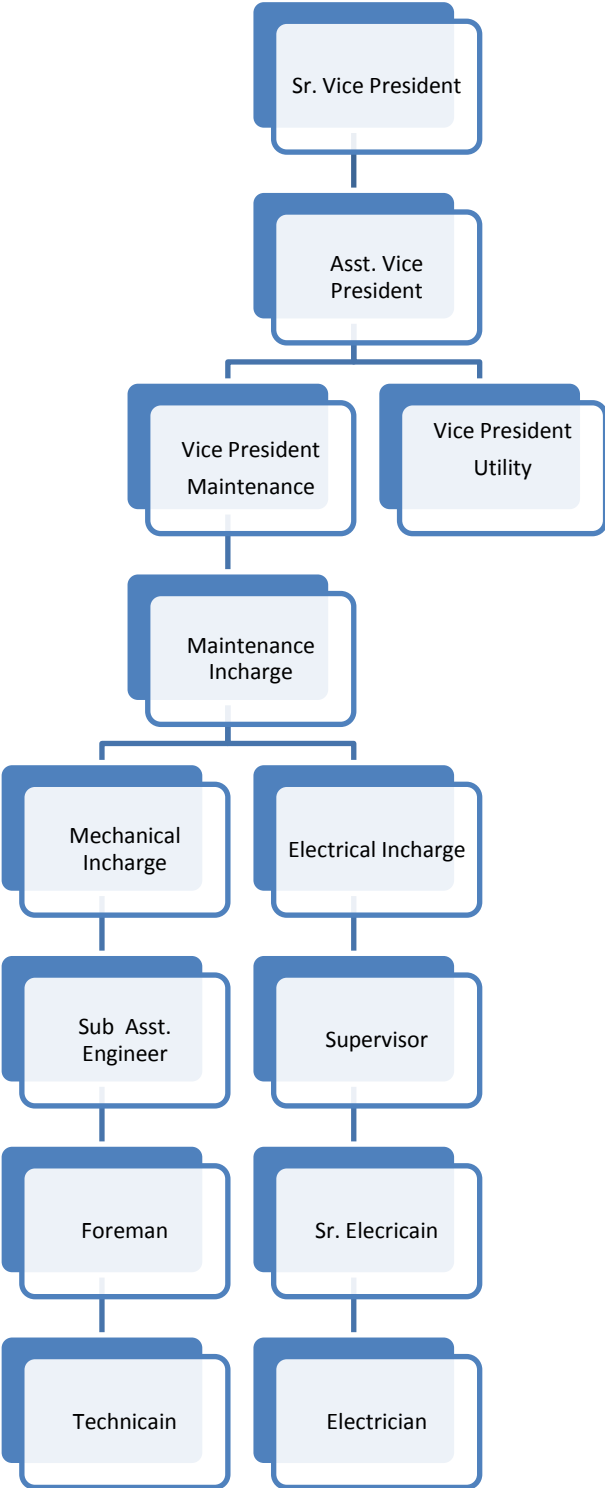
3.5.4 Production Evaluation:

- Store the fabric before production
- Knock the suppliers for delivery accessories at time
- Store the fabric after quality and quantity checking
- Maintaining inventory report
- Supply the materials through the sub-store(sewing floor) with the document (chalan)
- Giving input report to R&D

3.6 Maintenance



3.6.1 Organogram:



3.6.2 Machineries:

1. Combination tools / spanner
2. Socket ratchet set
3. Slide range
4. Monkey pliers
5. Pipe thread cutting tools
6. Bearing puller
7. Pipe range
8. Pipe cutting tools
9. Hole punch
10. Divider
11. Easy opener
12. External thread die
13. Heavy scissor
14. Oil can
15. Drill machine and drill bit.
16. Grease gun
17. Grinding m/c
18. Welding m/c
19. Spirit leveler
20. File
21. Hammer
22. Circlip tools
23. Hacksaw blade
24. Handsaw (wood)

3.6.3 Major Operations:

- Metal cutting.
- Scaling & right angling.
- Perfect leveling.
- Welding & cutting.
- Grinding & cutting of mild steel.
- Greasing of moving parts of m/c.
- Drilling.
- Oiling of moving parts.
- Tightening & loosening of nuts & bolts.
- Tightening of nuts & bolts
- Tightening & loosening of nuts & bolts.
- Tightening & loosening of nuts & bolts.
- Cut the thread in pipe.
- Cutting of gasket & steel sheet.
- External thread cutting.
- Open the broken head bolt.
- Circle marking on metal & wood.
- Punching the hole.
- Assist the opening of bearing from shaft.
- Tightening & loosening of pipe joint.
- Pipe cutting.

3.6.4 Product Evaluation Process:

- By keeping the factory plants, equipment's, machine tools in an optimum working condition.
- By ensuring specified accuracy to product and time schedule of delivery to customer.
- By keeping the downtime of machines to the minimum thus to have control over the production program.
- By keeping the production cycle within the stipulated range.
- By modifying the machine tools to meet the need for production
- By improving productivity of existing machines and to avoid sinking of additional capital.
- By reducing the maintenance cost as far as possible thereby leading to reduction in factory overhead
- By prolonging the useful life of the factory plant and machinery by retaining their acceptable level of accuracy of performance.

04 IMPECT OF INTERNSHIP

4.1 Impact of Sample Section

- Understood why sample section is called a mini-industry.
- Observed how skilled workers work in sample section.
- Learned the process of preparing a pattern for an individual size & design.
- Cleared the conception about different types of sample required to produce a garment.
- Learned about the digitizing board in CAD room.
- Learned the process of determining breakdown ratio for a particular order.
- Understood how to make marker from a pattern by software (Investronica) in CAD room.
- Observed the process of printing a marker on a paper with plotter machine in CAD room.

4.2 Impact of Cutting Section

- Learned about different type of cutting machines (i.e. Straight knife cutting machine, Round knife cutting machine, Band knife cutting machine etc.).
- Learned the process of fabric spreading.
- Observed the process of fabric cutting according to the marker.
- Understood different process of fabric lay.
- Realized the use and importance of metal gloves for fabric cutting process through different cutting machines.
- Observed the panel check process for different type of fabric of different style and design.
- Understood how numbering and bundling is done.

4.3 Impact of Sewing Section

- Learned about different parts of a shirt (i.e. Upper front, Lower front, and back part, Facing, Collar and Sleeve etc.).
- Observed different sewing or joining process of different body parts of a shirt.
- Learned about different type of machines used in a sewing floor (i.e. Single or double needle lock stitch machine , Multi needle chain stitch machine, Over lock machine, Feed of the arm machine etc.).
- Observed the ironing and fusing process for different body parts (i.e. Collar, Placket, Facing Interlining etc.).
- Learned about Standard Minute Value (SMV) of different sewing process.
- Learned the process of determining operator's efficiency in an individual process for a shirt.
- Cleared the conception about production of a sewing floor (line by line and total floor).
- Observed and realized the importance of final inspection at the end of every sewing line.
- Got experienced in making production study of an operator for an individual process for a definite time interval.
- Also got experienced in making capacity graph of a sewing line of a definite style and design.
- Attended Pre-production meeting before the bulk production of an order.
- Realized the importance of Dept. of IE in raising the efficiency of production in a sewing floor.

4.4 Impact of Finishing Section

- Observed various type of finishing process after sewing and washing.
- Observed different type of machines used in finishing section (i.e. Neck press machine, Metal detector machine etc.).
- Learned about different type of iron machines.
- Learned about various type of accessories used to attach to the garment (i.e. Security alarm, Hang tag, Price tag, Barcode label etc.).
- Observed the application of different chemicals for the removal of various type of stain.
- Observed and learned different type of folding process (i.e. Standard fold, Semi-standard fold, Hanger fold, Twill fold, half fold, Full fold etc.).
- Cleared the conception about different packing type (i.e. Master pack, Blister pack, Coffin pack etc.) and packing ratio.
- Understood the basic difference between gross weight and net weight.
- Finally realized why finishing section is unavoidable in garments industry for making the garment attractive and decorative for selling purpose.

4.5 Impact of Store Section

- Understood the necessity & process of inventory.
- Learned how an order is confirmed via merchandiser.
- Realized the role of PI (Pro-forma Invoice).
- Had cleared the conception about fabric inspection method.
- Learned how to examine AQL in a fabric lot.
- Learned the procedure of determining shade variation in fabric through light cabinet.
- Understood the system of preparing color continuity card.
- Learned the procedure of receiving materials & dispatching goods outside of the factory.

4.6 Impact of Maintenance Section:

- Learned about the accuracy to product and time schedule of delivery to customer.
- Understood how to modify the machine tools to meet the need for production
- Learned about the production cycle
- Understood how to improve productivity of existing machines
- Understood the way to reduce the maintenance cost as far as possible

05. CONCLUSION

The industrial training gives us the first opportunity to work in mills. It was a practical experience beyond the normal academic learning. This training gave us actual picture about man, machine, money, material, method and market and interdependence. We have earned the direct practical knowledge about the raw materials, actual running condition of the machine, works of technologist, administration. Industrial training is an essential part for textile education because it minimizes the gap between theoretical and practical knowledge and also increase our thinking level about textile technology.

We have completed our industrial attachment from Robintex Group during two-month long industrial training at Robintex Group. We got the impression that this factory is one of the modern export oriented composite knit garments industry in our Bangladesh. This factory does not compromise in case of quality. Due to this, it has earned a “very good reputation” in foreign market for its quality product over many other export oriented textile mills. It has very well educated and technically experienced manpower to get rid of any defect in production process. It has also organizational hierarchy.