



Faculty of Engineering

Department of Textile Engineering

**Course Title: Study on Cutting, Sewing and Finishing Section at
a Garments industry**

Course code: TE-4214 Project (Thesis)

Submitted By

Md.Sanour bin Islam ID: 152-23-4419

Md.Rakib Ahsan ID: 152-23-4420

Supervised By

Engr.Mohammad Abdul Baset

Assistant Professor

Department of Textile Engineering

Daffodil International University

This Report Presented in partial Fulfillment of the Requirements for the

Degree of Bachelor of Science in Textile Engineering

Advance in Apparel Manufacturing technology

April, 2018



LETTER OF APPROVAL

Date: 15-04-2018

To,

The Head

Department of Textile engineering

Daffodil International University

102, Shukrabad, Mirpur Road, Dhaka 1207

Sub: Approval of Project Report of B.Sc.in Textile Program

Dear Sir

We are just writing to let you know that this project report title Study on Cutting, Sewing and Finishing Section at a Garments industry has been prepared by the student Md.Sanour bin Islam ID:152-23-4419 and MD.Rakib Ahsan ID:152-23-4420 is completed for final evaluation. The whole report is prepared based on the proper investigation and interruption through critical analysis empirical data with required belongings. The student were directly involved in there project activities and the report become vital to spark of much variable information for the readers.

Therefore pray and hope that you would kind enough to accept project report and consider it for final evaluation.

Yours sincerely

Engr.Mohammad Abdul Baset

Assistant Professor,

Department of Textile Engineering

Daffodil International University

DECLARATION

We hereby declare that, this project has been done by us under the supervision of Engr.Mohammad Abdul Baset, Assistant Professor, Department of Textile Engineering, and Daffodil International University. We also declare that project nor has any part of this project been submitted elsewhere for award of any degree.

Submitted by

Name of Students	ID	Signature
Md.Sanour bin Islam	152-23-4419
Md.Rakib Ahsan	152-23-4420



ACKNOWLEDGEMENT

At first we express our heartiest thanks and appreciation to god-like Allah for his kind gift makes us conceivable to finishing of this proposal effectively.

We fell appreciative and wish we significant we obligation to Engr. Mohammad Abdul Baset, Assistant Professor, Department of TE, Daffodil International University, Dhaka. Profound Knowledge and unmistakable fascination of our manager in the field of pieces of clothing creation us to do this postulation .His unending tolerance, insightful direction, persistent consolation, consistent and fiery supervision, productive feedback, important guidance, numerous perusing sub-par draft and rectifying them at all stage need to made conceivable finish this proposal. We might want offer to our heartiest thanks to Engr. Mohammad Abdul Baset, Assistant Professor dept. of TE, for his kind completes my postulation and furthermore other employees and staff of TE division of Daffodil International University.

We might want express because of all staff of "NUR GROUP &RAIYAN KNIT COMPOSITE LTD" Who have given us time and bolster moral amid theory program for giving important data about postulation.

Dedication

Above all, we want to thank almighty Allah. By the grace of Allah, we are successfully done our thesis paper. We want to dedicate our work to our honorable teacher. We want to thank **Engr. Mohammad Abdul Baset**. Whose most contribution behind our success. Specially my father whose hard fatigue helps to reach this situation.

Frankly we want to say, all of our cousin or relatives everyone owing to get the devotion.



ABSTRACT

We completed our thesis project Study on Inspection in various sections in a garments industry. This paper clearly explains the hourly feed inspection reports. Daily garments reject (%) report. In-line garments inspection report, pre final garments inspection reports, Final garments inspection reports. This project based on the different types of sewing defects and their remedies. In the textile industry, Inspection is basically done, before the shipment. This Project is done by Nur group & Raiyan knit Composite Ltd. The Factory Monthly production capacity 900,000 Pecs/month, The Factory per year production capacity 10,800000 Pecs. production number of line 32, number of Sewing M/C 1120, number of manpower 3000. Floor production Production floor area 426,855 square feet. In our study, we us focus on important of sewing defect, how to the control sewing defects in a garment factory, how to the work pre-final and final and final inspection and we us trying to identify that problems, reasons and their remedies. In my project, we have investigation of Cutting Defect 17 we have investigated 45 sewing defect reports from sewing input to output of finishing sections. For the analysis of the reports, we find different type of defects that found in sewing and finishing section. Such as: Skip stitch Broken stitch, oil marks, , open seam, label slanted, dirty mark, oil mark, slanted seam, uncut thread, twisting placket slanted, embroidery hole, , raw age, stripe miss-match, part shading, print problem, foreign yarn, needle mark, connecting thread, pleat, puckering, uneven joint stitch, needle damage etc. Maximum numbers of faults are Skip stitch 30%, Broken stitch 8%, Needle cut 9%, Uncut thread 25%.and others 30% defect.

Table of content

	Letter of Approval	II
	Declaration	III
	Acknowledgement	IV
	Dedication	V
	Abstract	VI
01	Chapter- 1 : Introduction	1
1.0	Introduction	2
1.1	Objective	2
1.2	Methodology	2
02	Chapter-2 :Literature Survey	3
2.1	What is Garments inspection	4
2.2	Steps of the Garments Inspection	4
2.3	Garments inspection Flow chart	5
2.4	Types of Inspection system	5-6
2.5	Various points of Inspection system	6-8
2.6	Inspection Fabric	9
2.7	Inspection of fabric	9
2.8	Types Of Fabric Inspection	9
2.9	Inspection 4- point System	10
2.1.0	Ten Point System	11



2.1.1	Different Types Knit Fabric Defects system	12-13
2.1.2	Fabric related defect	13
2.1.3	Trims and Accessories Inspection	14
2.1.4	Sewing thread Inspection	14
2.1.5	Zipper Inspections	14
2.1.6	List of Trims and Accessories	15-16
2.1.7	Inspection in cutting Section	16
2.1.8	Flow chart cutting room	16-17
2.1.9	Cutting Section Defects	17-18
2.2.0	Acceptable Quality Level of cutting Section	18-19
2.2.1	AQL	19-20
2.2.2	Chart of AQL	20-21
2.2.3	Sewing defect Inspection flowchart	21
2.2.7	The quality control in sewing is in line inspections and “Traffic Light Systems: traffic light system	22
2.2.8	Types of sewing defect	22
2.2.9	Traffic Light System	22-23
2.3.0	Inspection of Finishing Sections	24
2.3.0	Flow chart of garments finishing sections	24
2.3.1	Finishing quality check list	24-25
3.3.2	Inspection of fabric	25-26
3.3.3	Fabric Inspection Report	
2.3.4	Sewing defect Inspection flowchart	
	CHEPTER -3 EXPRIMENTAL DETAILS	27

3.0	Inspection in Cutting section	28
3.1	Marker inspection report	28-30
3.2	Cutting Inspection report quality table	31-33
3.3	Daily cut panel inspection report	34-36
	Inspection in sewing section	36
3.4	Sewing inspection report	37-39
3.5	Sewing in-line inspection report	40-42
3..6	Pre-final inspection report	43-44
3.7	Final garments inspection report	45-47
4.0	Chapter -4 Disruption of Result	48
4.1	After 1 hour cutting pattern inspection analysis	49-50
4.2	After 1hour inspection	50
4.3	After 10 hour cutting pattern inspection report analysis	51
4.4	Cut panel inspection report analysis	52
3.5	Cut Panel inspection report inspection Analysis from data3.1, 3.2 and3.3	52
4.6	Pre Final Quality Audit Report analysis	54
4.7	Final inspection report analysis	56
5.0	Chepter-5 Conclusion	57
5.1	Conclusion	58
	References	57



Number	Table Name	Page No.
Table No:3.1	Marker inspection Report	28-30
Table No:3.2	Cutting inspection report quality table	32-33
Table No:3.3	Cut panel inspection report	35-36
Table No:3.4	Sewing inspection report	38-39
Table No:3.5	Sewing in-line inspection report	41-42
Table No:3.6	Pre final inspection report	43-44
Table No:3.7	Garments Final inspection report	46-47
	Figure Name	
Fig.3.1	Marker inspection Report	28
Fig. 3.2	Cutting inspection report quality table	31
Fig. 3.3	Cut panel inspection report	34
Fig. 3.4	Sewing inspection report	37
Fig. 3.5	Sewing in-line inspection report	40
Fig. 3.6	Pre final inspection report	43
Fig.3.7	Garments Final inspection report	45

Chapter – one

Introduction



1.0 Introduction:

Garments sector of the greatest foreign currency way of our country. It has been improved Garment ventures of the current past years. In the field Industrialization piece of clothing industry is a promising advance. It has given chance of work of millions is jobless, particularly uneducated multitudinous ladies of the nation. It is making huge commitment the field of our fare salary. The Garment businesses at display in Bangladesh: After the development of Bangladesh change radical has gone to our piece of clothing area. Article of clothing enterprises began working from the 10's of the late century. At exhibit there are around 4500 article of clothing businesses in the nation and 70 percent of them are in Dhaka. The rest are in Chittagong and Khulna. These Industries have utilized fifty absences of individuals and 80 percent of them are uneducated country ladies. Around 70 percent of our fare acquiring originates from this division.

1.1 Objective:

- To know about the Garments Factory.
- To know about the garments Wastage.
- To know about the working procedure as well increase the productivity.

1.2 Methodology:

- Textile Industry.
- Internet.
- Book.
- Teacher Lecture sheet.
- Garments Factory

Chapter – Two

Literature Review



2.0 Literature review

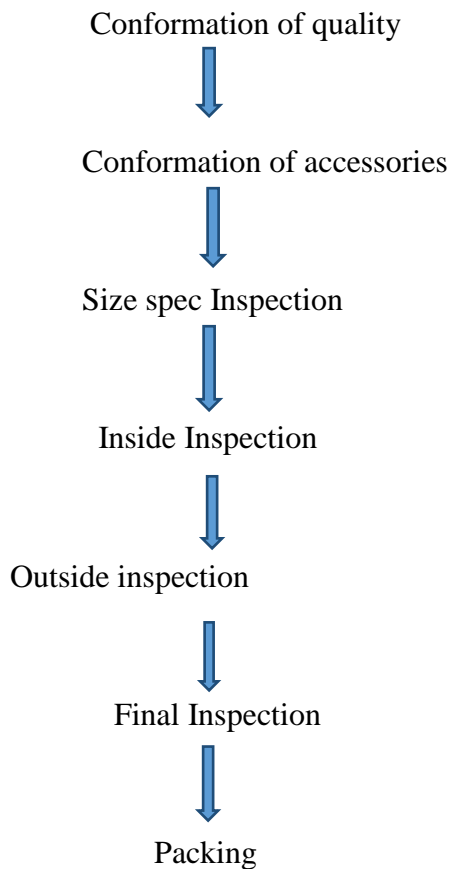
2.1 What is Garments inspection?

Inspection in reference to the Garments industry can be defined as the visual examination or review of raw materials (like fabric, zipper, sewing threads, buttons, trims & accessories etc.), partially of finished components of the garments and completely finished garments in relation to some standards. The main objective of the inspection is the detection of defects as early as possible in the manufacturing process so that time and money are not wasted later on either correcting the defect or writing off the defective garment.

2.2 Steps of the Garments Inspection

1. Inspection of raw materials.
2. Inspection In process.
3. Final Inspection.

2.3 Garments inspection Flow chart:



2.4 Types of Inspection system:

There are many types of inspection following by the inspectors as requirement of consumer.

- a. **Pre-Production check system.**
- b. **Initial production checks system.**
- c. **During production check system.**
- d. **Final Random Inspection system.**

2.5 Various points of Inspection system:

➤ **During Pre-Production Inspection System:**

The following parameters & defects are checked prior to cutting.

- 1) Oils sports
- 2) Fabric Shade matching system.
- 3) Fabric Constructions system.
- 4) GSM (Grams per Square Meter)
- 5) EPI& PPI is required.
- 6) Diameter test.
- 7) Dyeing Levelness.
- 8) Ecological parameters if required system.
- 9) Softness.
- 10) Shrinkage test.
- 11) Body, Sleeve, Collars & Cuffs matching.
- 12) Fabric Holes.
- 13) Vertical & Horizontal Stripe.
- 14) Skewing.
- 15) Yarn thick& thin places.
- 16) Dirt's & Stains.

➤ **During Production Inspection system:**

- 1) Verify Cutting patterns.
- 2) Measurements cut components.
- 3) Cutting shape.
- 4) Fabric defect.
- 5) Body, Collars & Cuffs matching other specific parameters as required by the customers.
- 6) Stitching defects.
- 7) Sewing thread matching.
- 8) Dirt's& Stains.
- 9) Measurements.
- 10) Labels.
- 11) Zipper.
- 12) Trims & Accessories.

➤ **Final Inspections system:**

A. Packing & Assortment:

- 1) Wrong Model
- 2) Wrong Quantities

B. Fabric Defects:

- 3) Wrong Shades.
- 4) Uneven dyeing.
- 5) Fabric Holes.
- 6) Yarns Thick & Thin places.
- 7) Fabric Dirt & Stains.
- 8) Oil stains.
- 9) Sinker line.
- 10) Sinker marks.
- 11) Poor softness.
- 12) Higher Shrinkage

B. Workmanship Defects:

1. Seam open.
2. Puckering.
3. Needle holes and marks.
4. Unbalanced sleeve edges.
5. Unbalanced plackets.
6. Insecure shoulder stitch.
7. Incorrect side shape.
8. Bottom hem bowing.
9. Uneven neck shape.
10. Cross label.
11. Broken & Missing stitch.
12. Insecure button.
13. Untrimmed threads & fabrics.
14. Poor Ironings.
15. Double stitches.

D. General Defects:

1. Shade variation garment parts.



2. Shade variations between garments.

3. Defective printing.

4. Defective embroidery

5. Defective button.

6. Defective trims accessories.

7. Defective fabric.

8. Sewing thread shade variation.

E. Measurement Deviations:

1. Garments length.

2. Shoulder seam.

3. Garments width.

2. Body width.

3. Shoulder length.

4. Arm hole.

5. Arm Opening.

6. Sleeve lengths.

7. Sleeve opening length.

8. Placket length.

9. Placket width.

10. Neck width.

11. Neck opening.

12. Bottom length.

Many of the important parameters of Pre-productions, during productions & Final inspection parameters. This is to ensure that wrong or major defective garments are not packed.

2.6 Fabric Inspection:

2.7 Inspection of fabric:

Fabric is the primary of pieces of clothing crude material. So it is fundamental to guarantee before texture quality it achieves store of pieces of clothing industry, blemished texture generally may brings about disturbance of the creation and conveyance to articles of clothing on times. Delivered the pieces of clothing with flawed textures are may prompt epic expenses to the organization & may cause creation of a stock part. It is great practice to the review textures in an introduce of the textures maker. This is empower speedy substitution to the faulty texture. Still re-review of the textures at the conveyance purpose of the store of the articles of clothing industry is earnestly.

2.8 Types of fabric inspection System:

Fabric inspection after the results should be analyzed to the assess acceptability of a fabric. There are different three grading or inspection system.

- 1) 4-Point Systems.
- 2) Dallas systems.
- 3) 10- Point systems.

2.9 Inspection 4-Point System:

This is 4-Point System, is also called the AAM (American Apparel Manufacturer) point Grading system for the determining fabric quality, widely used by the producers of apparel fabric and is endorsed by AAMA as well the American Society of Quality Control (ASQC)



Fig: 2 Inspection 4-Points System:

This is 4-Points System assigns 1, 2, 3 & 4 penalty points according to the size and significance of defects. More than no of 4 penalty points can be assigned for the single defects. Defects can be lengths or width directions, the system remaining the same. Only major defects are considered. No penalty of points are assigned to minor defect.

In this system, one should inspect at least 10 per cent of the total rolls in the shipment and make sure to select at least one roll of each color way.

Fabric defects are assigned points based on the following

Defect Length	No of points
0 to 3 inches	1points
3.1-6 inches	2points
6.1-9 inches	3points
9 inches over	4 points
Holes &Openings (1 inch or less)	2 points
Holes &Openings (over 1 inch)	4 points

Total defects points per 100 square yards of fabric are calculated by the acceptance criteria is the generally not more than 30 penalty points. Fabric rolls containing more than 30 points are considered seconds.

Formula calculates the penalty a point per 100 Square yards is given by them:

Total Point Scored of the Roll*3600

Fabric width in Inches*Inspected Total Yards

2.1.0 Ten Point System:

The 10 points System was developed in the 1950's. This system was assigns penalty points to each defects, depending on length of the defects.

10 points are assigned as per the following such as:

Defect for the Warp	No of Points
10.1-36 Inches	10Points
5.1-10 Inches	5Points
1.1-5 Inches	3Points

Up to 1 Inch	1Point
Defect for the Fillings	No of Points
Up to 1 width	1 Points
1.1-5 Inches	3Points
5 half to the width of fabric	5 Points
Full width	10Points

Under the Ten- (10) Point System, the piece is graded to first if the total penalty points do not exceed.

Total yards of the piece. The piece is graded a "second if the total penalty points exceed by the total yards of the pieces.

2.1.1 Different Types Knit Fabric Defects system:

1. Broken picks.
2. Thin place.
3. Burl mark.
4. Coarse EPI&PPI
5. Needle mark.
6. Colors fly yarns.
7. Double end-Double pick.
8. End out.

9. Hole.
10. Jerk in.
11. Loom Bar.
12. Reed mark.
13. Reed streak.
14. Shade bar.
15. Slabs.
16. Soiled fillings.
17. Thick place.

2.1.2 Fabric related defect:

Fabric defect mainly depends on the two defect.

Machine related defect.

Material related defect.

Material related factors

Fiber contamination

1. Yarn counts.
2. Yarn Twist variation.
3. Weight variation.
4. Foreign fibers mixed.
5. Short fiber contents.
6. Unfavorable fibers characteristics.

2.1.3 Trims and Accessories Inspection:

2.1.4 Sewing threads Inspection:

Following the features of sewing thread considered-

- 1) Tickets number.
- 2) Thread count.
- 3) Thread Ply.
- 4) Number of twist.
- 5) Thread balance.
- 6) Thread Tenacity.
- 7) Thread Elongation.
- 8) Sewing ability.
- 9) Imperfection.
- 10) Thread finish.
- 11) Thread color.
- 12) Package density
- 13) Winding.
- 14) Thread Package.
- 15) Thread finishing.

2.1.5 Zipper Inspections:

Following the Factors of considered in Zipper.

- 1) Zipper Proper dimension.
- 2) The top ten extensions.
- 3) Slider.
- 4) Teeth size.

- 5) -Zipper tape and color should be uniform.
- 6) Slider has to lock properly.

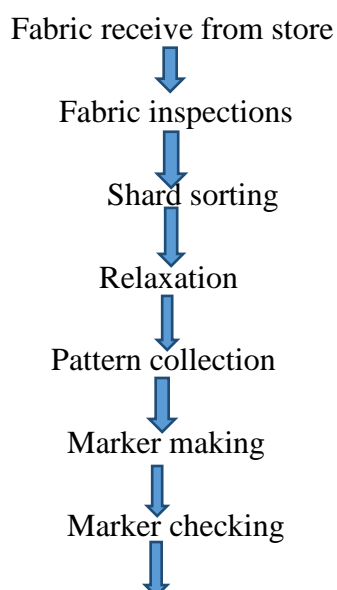
2.1.6 List of Trims and Accessories

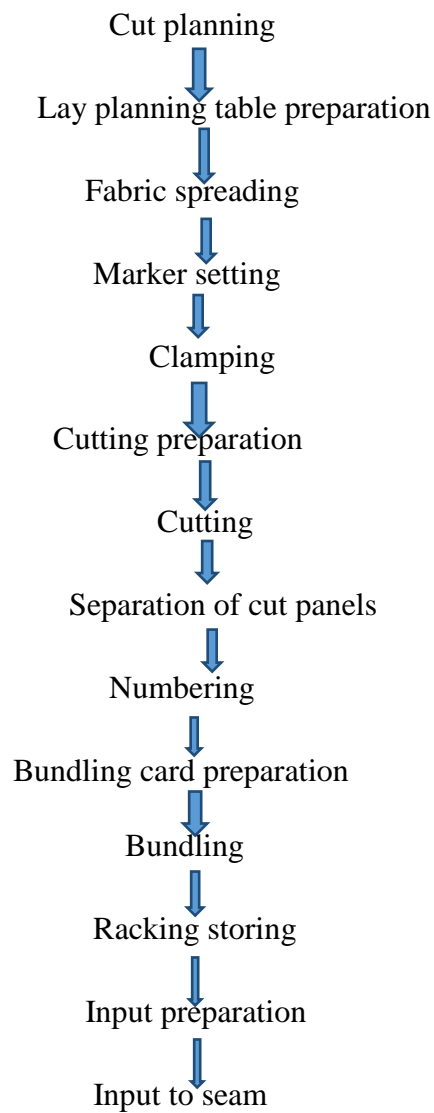
- 1) Sewing Thread.
- 2) Poly pack.
- 3) Carton.
- 4) Label.
- 5) Master carton.
- 6) Button.
- 7) Zipper.
- 8) Interlining.
- 9) Elastic.
- 10) Thread.
- 11) Twill Tape.
- 12) Stopper.
- 13) Draw Cord.
- 14) Piping Cord.
- 15) Logo Print.
- 16) Eyelet.
- 17) Grommet.
- 18) Collar Stay.
- 19) Buckle.
- 20) Rivet.
- 21) Poly bag.
- 22) Elastic bags.
- 23) Mini Poly bags.
- 24) Master Carton.

- 25) Inner Cartons.
- 26) Size Clips.
- 27) Tag Pins.
- 28) Brass Pins.
- 29) Collar Stands.
- 30) Safety Pins.
- 31) Gum Tape.
- 32) Arrow Stickers.
- 33) Barcode.
- 34) Indicator.
- 35) Tissue Papers.
- 36) Back Boards.
- 37) Neck Board.

2.1.7 Inspection in Cutting Section:

2.1.8 Process flow chart of cutting room: Process flow chart is very important for the every garments sector. Flow chart of cutting room means fabrics cutting process by process. Here I give some major important process flow chart of cutting room these are directly used in garments sector are given below:





2.1.9 Cutting Section Defects:

There are some defects occur in cutting section.

1. Stripes matching and checks.
2. Cutting parts mixing.
3. Wrong numbering of the cutting parts.
4. Cutting parts do not surface.
5. Edge the parts a little bit is missing.
6. Fabric grain line missing.

7. Cutting table do not surface or smooth.

The cutting sections quality is insure in two stage.

(1) Spreading of quality controls: Following the point are check during spreading.

- i. Cutting Table marking.
- ii. Ends.
- iii. Fabric Tension.
- iv. Leanings.
- v. Narrow Goods.
- vi. Fabric Count.
- vii. Fabric Ply height.
- viii. Remnants.
- ix. Fabric flaw.
- x. IX. Market placing.

(2) After cutting quality controls. After cutting block bundle are checks by the following points.

- I. Fabric Miss cut.
- II. Fabric Ragged cutting.
- III. Pattern checking.
- IV. Matching Ply.
- V. Notches.
- VI. Stripe Matching.

2.2.0 Acceptable Quality Level of cutting Section

Lot Size	2	3.5	4.5	5.5
	Inspect accept	Inspect accept	Inspect accept	Inspect accept
Less Than 150	9 0	6 0	14 1	9 1

151-280	9	0	22	1	14	1	11	2
281-500	33	1	22	1	21	2	20	4
500-1200	33	1	33	2	33	4	33	6
1200-3200	51	2	51	3	51	6	51	8
3200-10000	81	4	81	6	81	8	81	11
10001-35000	130	6	130	8	130	11	130	15
35000-150000	210	8	210	112	210	15	210	22
150000-500000	320	12	320	15	320	22	210	22
500000 Over	510	15	510	22	320	22	210	22

Defect Rate:

Defect Rating= $\frac{\text{Total no of defect}}{\text{No of bundle check}}$

2.2.1 AQL (Acceptance Quality Level):

Also referred to as Acceptable Quality Level. The sum greatest of a defectives in certain illustration evaluate that make for a given bundle verifiably commendable, Customer will be undeniably need to zero slip off thing stock and benefits and will finally set up to the sufficient of significant worth levels. Markets Competition regardless, will be 'educate' the customer and set up the customer regards. There are only a solitary immaculate sufficient quality levels - zero distortion - All others are exchange off in perspective of upon business acceptable, budgetary and security levels.

An estimation quantifiable of the most extraordinary number of stock imperfect considered attractive in an illustration measure particular. In case the Acceptable Quality Level (AQL) is a not pursued a particular inspecting of a stock, will producers review the diverse parameter in a creation strategy to the choose zones causing the blemish. AQL is the import ants estimation to company'sseeking's a Six Sigma level of a quality control.

2.2.1 Chart OF AQL (Acceptable Quality Level):

2.2.2 Table: single sampling plans for normal (level II) inspection.

Table 2 single sampling plans for normal Inspection Acceptable Quality Level									
Letter	Size of sample	1.0		2.5		4.0		6.5	
		AC	RE	AC	RE	AC	RE	AC	RE
A	2	0	1	0	1	0	1	0	1
B	3	0	1	0	1	0	1	0	1
C	5	0	1	0	1	0	1	1	2
D	8	0	1	0	1	1	2	1	2
E	13	0	1	1	2	1	2	2	3
F	20	0	1	1	2	2	3	3	4
G	32	0	1	2	3	3	4	5	6
H	50	1	2	3	4	5	6	7	8
I	80	1	2	5	6	7	8	10	11
J	125	2	3	7	8	10	11	14	15
K	200	3	4	10	11	14	15	21	22

L	315	5	6	14	15	21	22	21	22
M	500	7	8	21	22	21	22	21	22
N	800	10	11	21	22	21	22	21	22
O	1200	14	15	21	22	21	22	21	21
AC ACCEPTANCE NUMBER					RE REJECTION NUMBER				

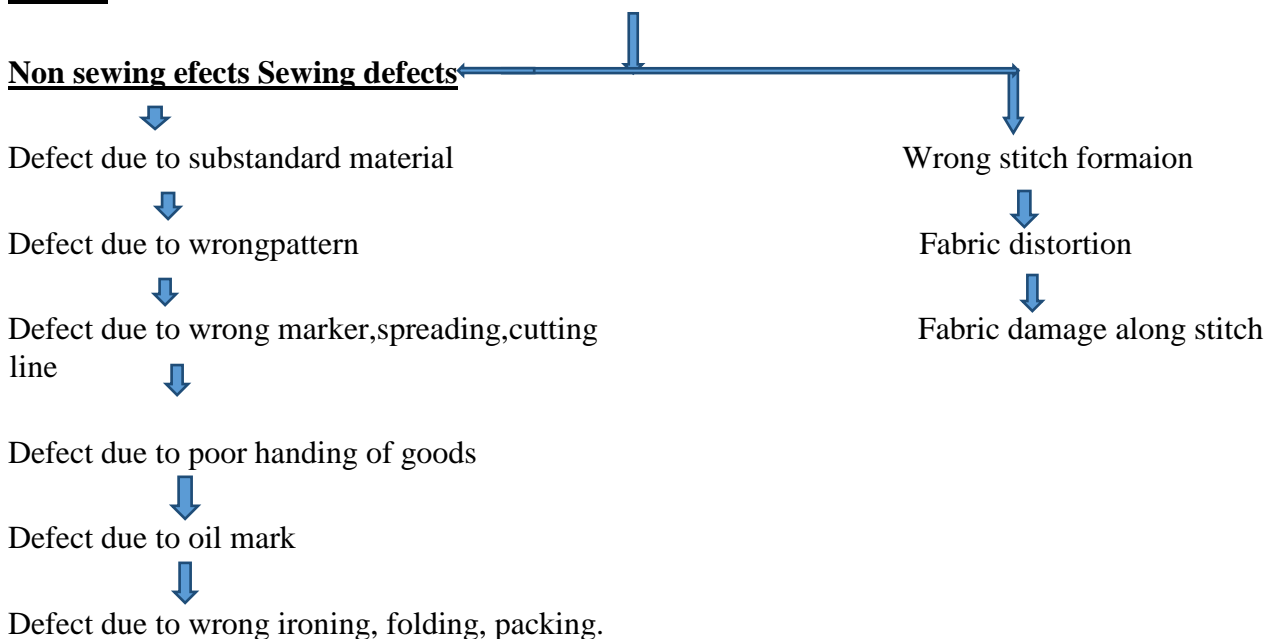
How to read the table:

Your code letters is "O", so you will have to the draw 1300pcs randomly from the total lot size.

Besides, assume you have set your (AQL) at 2.7% for major defects and 5.0% for minor defects. Therefore, here are the limits: the products are accepted if no more than 25 major defect and no more than 25 minor defect found.

2.2.3 Sewing defect Inspection flow chart:

Defects





2.2.7 The quality control in sewing is In line inspections and

“Traffic Light Systems:

In line investigation implies, there is a review table in sewing line and an administrator. That person check the all aspects of the sewing line. In the event that he recover any imperfection at that point send to the sewing administrator.

Sorts of imperfection which isn't worthy in-line investigation

- 1) Join fasten isn't satisfactory
- 2) Broken fasten isn't satisfactory
- 3) Oil and soil spot isn't satisfactory

2.2.8 Types of sewing defect:

- 1) Open seam.
- 2) Wrong stitching.
- 3) Shade matching.
- 4) Missing stitches.
- 5) Improper seam.
- 6) Creasing of garment.
- 7) Improper thread tensions.
- 8) Needle whole defects.

2.2.9 Traffic lighting system:




Movement line quality framework is fundamentally utilized as a part of sewing line in article of clothing industry. You can utilize distinctive shading banner to control your sewing line quality.

Like Green is for alright.

Yellow is for bring up the imperfection.

Red is for stop the

Work or change the administrator from that specific activity.

Traffic Light System ABC Exports															
Operation Name: _____ Operator: _____ Line: _____ Floor: _____ Month: _____															
Instructions: Each operation to be inspected bilaterally. Standard Sample Size: 5 Pieces															
Mark Green  if no defect found. Mark Red  if found 2 defects. Mark Yellow  if found 1 defect.															
Date															
I															
II															
III															
IV															
Signature															

There are some defects due to another some problem such as.

*Needle:

1. Needle picking, texture harm (burr on needle), needle cuts, limit needle, needle complete, needle point.
2. Needle distance across, off base needle measure, needle choice

*Machine:

1. Skipped fasten (chain line), broken line, bobbin string run out
2. Unbalanced fasten, line length variety

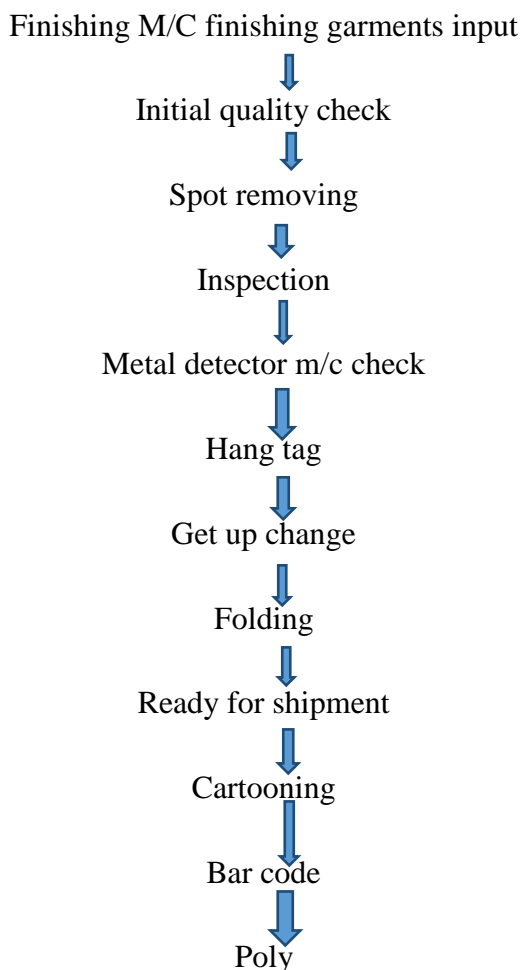
*Operator:

1. Crude edge, handle misalignment, sewing off of piece of clothing

*Thread:

1. Thread harm, broken fastens, dishonorable spool winding
2. Thread hairiness, neps.slubs.

2.3.0 Flow chart of garments finishing sections:



2.3.1 Finishing quality check list:

- 1) Buyer requirement wise sewing check

Buyer requirement wise ironing check

- 2) As per purchaser prerequisite insightful sewing check
- 3) According to purchaser necessity astute pressing check
- 4) Buyer affirmed test wide style check.
- 5) Front part, back part, string can differentiate shading.
- 6) Print or weaving quality and position check
- 7) All procedure SPI check.
- 8) Oil spot or earth spot check.
- 9) Main name, mind mark, and so forth check.
- 10) Any textures blame and reject the pieces of clothing.

- 11) All process estimation check.
- 12) Hang tag and value sticker check.
- 13) Assortment each container pieces amount check.
- 14) Buyer necessity shrewd container estimate, poly size and pieces of clothing size check.

2.3.2 Fabric Trims and Accessories Inspection:

2.3.3 Inspection of fabric:

The nature of a last article of clothing relies upon the nature of a texture when it is gotten as a roll. Indeed, even the most extraordinary assembling techniques can't adjust for imperfect materials. Regularly, we assess 10% of the4 moves we get. Texture Inspection is an essential perspective took after preceding article of clothing assembling to keep away from rejects because of texture quality and looking with surprising misfortune in assembling. Texture investigation is improved the situation blame/deformity rate, texture development, texture weight, shrinkage, end to end or edge to edge shading, shading, hand feel,

Length/width, print flaw and appearance. Surface examination certifications to confine the expulsion of cut sheets or rejected bits of dress in view of surface deficiencies. Cutting surveyed and confirmed surface ensures finished piece of attire quality and additionally abatements, rejects, and improves efficiency and advantageous movements.

Surface is the essential rough material for dress industry and it takes 60-70% of total vestment manufacturing cost. Once any surface committal got by generation line material office, they have to send those to cutting QC inside 48 hours to influence shade to parcel, lab test and physical survey et cetera. To ensure that solitary quality surface is using as a piece of vestments, creation line should make some guarded move and grow up surface examination division's quality with qualified work constrain. Exactly when quality gathering gets any surface dispatch for examination from store then they will start underneath three one of a kind advances in the meantime to restrict finished bits of apparel expulsion, increase creation limit, increase generation lines liberality and quality gathering certainty et cetera.

1. Make shade swatch card to recognize if there are any extraordinary shade inside a transfer.
2. Select a few rolls arbitrarily if there is any running shading inside the roll.
3. Send each shade to research center to get shade variety report.

2.3.4 Different types of fabric (Knit) faults are considered in “of NUR GROUP&RAIYAN KNIT COMPOSITE LTD”

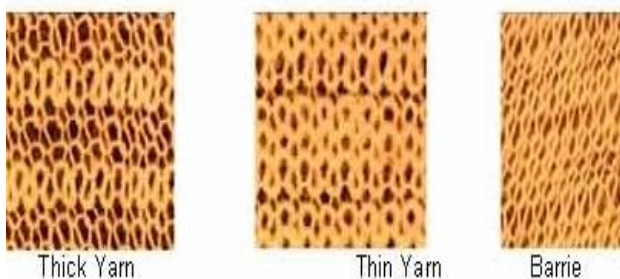
- 1) 100% cotton Single jersey.
 - a. Knots
 - b. Holes.
 - c. Slobs.
 - d. End out.
- 2) 100% cotton piece Rib fabric.

- a. Knot.
- b. Holes.
- c. Miss yarns.
- d. End out.



- 3) 100% cotton piece Interlok fabric

- a. Slobs yarns.
- b. Miss yarns.
- c. Thick yarns.
- d. Holes.



- e. Fly

Fig 5: Different faults of fabrics:

CHEPTER- THREE

EXPRIMENTAL DETAILS

3.0 Inspection in cutting Section:

Garment production starts with cutting process. This process fabrics is being cut into component. In the mass production multiple layer of fabric are lauds on the table and large number of a garments being cut at the time. The laid fabrics stack is called as lay, the cutting process include numbers of sub-process and flow of the process is a followings. Each process is a briefly explained to the following

3.1 Experimental Data-Marker Inspection Reports:

Marker Inspection report of Nur group & Raiyan knit composite ltd.

Buyer name: G.P

Style No: J.K

P.O/No: 1002



SEWING UNIT: _____
 STORE: Nur group
 SEASON: _____

Date	Buyer	Style No.	P.O. No.	Cut No.	Marker width	Marker Length	Marker Type #	Pattern Name*	Marker Name*	RATIO	No of Parts in marker	TG Parts in marker	Grain line	Neck Cut Mark
04/04/18	G.P	J.K	1002	34	156	420	39	group	P1	38/2, 42/1, 44/2	05	17	85	✓
04/04/18	G.P	J.K	1002	35	161	380	27	group	P1	38/1, 42/1, 44/2	04	17	68	✓

* Marker Type: 1 One way Marker 2 Two way Marker 3 Group Marker 4 Blank Marker
 * Marker Name: Has given a Name to each Marker based on shrinkage width and collar (refer cut plan and top sheet)
 * Pattern name: Pattern has been made based on average shrinkage and named as "P-1, P-2"

Style No	Cut No.	GMT Size	Front	Back	Sleeve	Pocket	Belt	Art	Color	Fabric	Lot	Size
J.K	34	38	✓	✓	✓	✓	✓	Art: 428	color: Royal	Fab: Rib	Lot: 625	40
		42	✓	✓	✓	✓	✓	style: jacket				
		44	✓	✓	✓	✓	✓					
J.K	35	38	✓	✓	✓	✓	✓	Art: 428	color: Royal	Fab: Rib	Lot: 625	
		42	✓	✓	✓	✓	✓	style: jacket				
		44	✓	✓	✓	✓	✓					

Date: 04/04/18
 By: [Signature]
 Checked by: [Signature]
 CUTTING O.C. [Signature]
 CUTTING O.A. INCHARGE [Signature]
 G.A. INCHARGE [Signature]

Fig 1: Marker Inspection Report:

Nur Group & Raiyan knit composite ltd

Marker Inspection Report

Buyer name: G.P, Style No: JK, P.O No: 1002

Date	Buyer	Style no	P.O NO	Cut no	Marker length	Marker with	Pattern name	RATIO			Total	No of parts Gant	Total Parts marker	Grain line
4-4-18	G.P	J.K	1002	34	156	479.39	P1	38/2	42/1	44/2	05	17	85	✓
Date	Buyer	Style no	P.O NO	Cut no	Marker length	Marker with	Pattern name	RATIO			Total	No of parts Gant	Total Parts marker	Grain line
4-4-18	G.P	J.K	1002	35	161	380.27	P1	38/1	42/1	44/2	04	17	68	✓

- Marker type: 1.One way marker 2.Two way Marker 3.Group marker 4.Block Marker
- Marker Name: Given a name to each Marker based on shrinkage with and ratio.
- Pattern name: Pattern has been made based on average shrinkage and named as p1:P2.....

Style no	Cut no	GM T size	Front		Back		Sleeve		Pocket		Belt								
J.K	34	38	Ok	ok	o k	o k	ok	o k	ok	o k	o k	o k	Art	428	Color	Royal	Fabri c	R i b	
		42	ok	ok	o k	o k	ok	o k	ok	o k	o k	o k							
		44	ok	ok	o k	o k	ok	o k	ok	o k	o k	o k	Sty le	Jac ket					
J.K	35	38	ok	ok	o k	o k	ok	o k	ok	o k	o k	o k	Art	428	Color royal	royal	Fabri c	R i b	
		42	ok	ok	o k	o k	ok	o k	ok	o k	o k	o k							
		44	ok	ok	o k	o k	ok	o k	ok	o k	o k	o k							

Table No: 3.1 Marker inspection report

3.2 Experimental Data-Cutting Inspection Report Quality table:


Cutting Inspection report of Nur group & Raiyan knit composite ltd.

Buyer: G.P

Style: T-Shirt Parts

Order No: 4004005,4001023,4011002,4013010

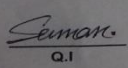
150

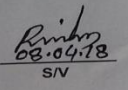


NUR GROUP
HOURLY QUALITY INSPECTION REPORT
CUTTING QUALITY TABLE

Buyer: <u>Gep</u>		Date: <u>07.04.2018</u>	
Style: <u>T-shirt, part</u>		Name of Inspector: <u>Suman Mondal</u>	
O/N: <u>4004005, 4001023, 4011002, 4013010</u>			

Defect Name	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
	8-9	9-10	10-11	11-12	12-01	2-3	3-4	4-5	5-6	6-7	
Fabric Defects (Knitting)	Slub		02	03		01					
	Knot	06		05	04		03	02	07	04	02
	Patta										
	Yarn missing	04		02	03	05	02	03		01	02
	Lycra missing										
	Crese mark										
	Needle mark										
	Contamination										
	Loop	02	03	05	03	02		02		02	05
Fabric Defects (Dying)	Hole	03	06	07	09	04	07	03	09	07	08
	Shading										
	Oil Spot		01						01		
	Dirty Spot	07	02		01			03		03	01
	Color Spot	05									
	Dia mark										
	Gsm Cut	03	06	03	03	07	05	03	07	05	07
	Swatch Cut	06	08	07	05	03	09	05	03	06	03
	Softner Spot										
	Silicon Spot										
Print & Emb.	Print Missing										
	Emb. Missing										
	Emb. Hole										
Fabric Defects (Cutting)	Sticker Mistake										
	Bundle Mistake										
	Bowing										
Total	41	28	37	34	27	26	28	28	31	29	309


 Suman
Q.I


 Rishi
08.04.18
S.V

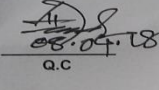

 A.Q.M

Fig 2: Cutting Inspection Report Quality table:



Nur group&Raiyan knit composite ltd

Cutting Inspection Report Quality table

Buyer: G.P, Style: T-Shirt Parts, Order No: 4004005, 4001023, 4011002

Buyer	G.P		Date	07-4-18
Style	T-Shirts Parts		Name of Inspector	Sumon mondol
O/N	4004005,4001023,4011002			

Name Defect	1 st 8-9	2 nd 9-10	3 rd 10-11	4 rd 11-12	5 th 12-01	6 th 2-3	7 th 3-4	8 th 4-5	9 th 5-6	10 th 6-7	Total
Slub		2	3		1		2		3	1	12
Knot	6		5	4		3	2	7	4	2	33
Patta											
Yarn missing	4		2	3	5	2	3		1	2	22
Crease mark											
Needle mark											
Hole	8	6	7	9	4	7	3	9	7	8	68
shading											

Oil sport		1						1			2
Dirty sport	7	2		1	3		3	1			17
Color sport	5										5
GSM cut	3	6	8	9	7	5	8	7	5	7	65
Swatch cut	6	8	7	5	8	9	5	4	6	3	61
Prin missing											
Sticker mising											
Bundle Mistake											
loop	2	3	5	3	2	2		2	2	5	24
Total	41	28	37	34	27	26	28	28	31	29	309

Table No: 3.2 Cutting Inspection Report Quality table

Description:

Garment production starts with cutting process. This process fabrics is being cut into component. In the mass production multiple layer of fabric are lauds on the table and large number of a garments being cut at the time. The laid fabrics stack is called as lay, the cutting process include numbers of sub-process and flow of the process is a followings. Each process is a briefly explained to the following

3.3 Experimental Data-Daily Cut Panel Inspection Report:

Daily Cut panel Inspection report of Nur group&Raiyan knit composite ltd.

Buyer: G.P

Order No: 410400

Color: White

Buyer Name	Order No.	Art No.	Color Name	Batch No.	Cut No.	Bundle No.	Part	Size	Sinker No.	Repeal Qty.	Reject										
											Dirty Spot	Oil Spot	Reject	Sub	Crew Mark	Misang Yarn	Lysis Cut	Print Spot	Sw Mark	Yarn Counts	Shading
G.P	410400	401	White	7253	1	2	F	M	28	1	-	-	1	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	B	M	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	S	M	21	1	-	-	1	-	-	-	-	-	-	-	-
"	"	"	"	"	"	10	F	L	12	1	-	-	-	-	-	-	-	1	-	-	-
"	"	"	"	"	"	"	B	L	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	S	L	5	1	-	1	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	23	F	S	95	1	-	-	1	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	B	S	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	SR	S	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	S-L	S	90	1	-	-	-	-	-	-	-	-	-	1	-
"	"	"	"	"	"	13	F	L	102	1	1	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	B	L	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	S	L	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	5	F	M	118	1	-	-	1	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	B	M	---	-	-	-	-	-	-	-	-	-	-	-	-
"	"	"	"	"	"	"	S	M	109	1	-	-	-	-	-	1	-	-	-	-	-

Fig 3: Cut panel Inspection report:

Nur group&Raiyan knit composite ltd

Daily Cut Panel Inspection Report

Buyer: G.P, Order No: 4004005, Color: White

Buyer Name	Order No	ART No	Color	part	size	Sticker no	Reject quantity	Dirty sport	Oil Sport	Reject	Sub	Missing Yarn	Diamark	Yarn contra	Shading
G.P	4004005	7253	white	F	M	28	1	-	-	1	-	-	-	-	-
GP	-	-	-	B	M	-	-	-	-	-	-	-	-	-	-
GP	-	-	-	S	M	21	1	-	-	-	-	-	-	-	-
GP	-	-	-	F	L	12	1	-	-	-	-	-	-	-	-
GP	-	-	-	B	L	-	-	-	-	-	-	-	-	-	-
GP	-	-	--	S	S	5	1	-	5	-	-	-	-	-	-
GP	-	-	-	F	S	95	1	-	-	1	-	-	-	-	-
GP	-	-	-	B	S	-	-	-	-	-	-	-	-	-	-
GP	-	-	-	S R	L	-	-	-	-	-	-	-	-	-	-
GP	-	-	-	S L	L	90	1	-	-	-	-	-	1	-	-
GP	-	--	-	S L	L	102	1	1	-	-	-	-	-	-	-

				S											
GP	-	-	-	F	M	118	1	-	-	1		1	-	-	-
GP	-	-	-	B	M	-	-	-	-	-	-	-	-	-	-
GP	-	-	-	S	M	109	1	-	-	-	-	-		-	-
GP	-	-	-	F	L	-	-	-	-	-	-	-	-	-	-
GP	-	-	-	B	L	-	-	-	-	-	-	-	-	-	-

Table No: 3.3 Cut panel Inspection report

Sewing Section Inspection:

In-process quality control in sewing segment investigation.

Sewing is the most important in the garments industry. Amid the sewing "In process quality control is finished by the line QC's through 7pcs examination framework. For basic task 100% process examination are completed. The accompanying parameters are additionally checked in sewing area process: Machine checking. Fabric Tension, SPI checking, Needle checking, Inspection sewing thread, Pattern shade checked, sewing inspection table.

3.4 Experimental Data-Sewing Inspection Report:

Sewing Inspection Quality Table Report of Nur group&Raiyan knit composite ltd.

Buyer: G.P

Order No: 0005-728959

Color: JAUNE

Line NO: 20

Fig no: 04 Sewing Inspection Report:



Raiyan Kint Composite LTD.
 Word # 05, Holding # A-1 & A-21/A, Hortokitola, Chandra, Kallakair, Gazipur, Bangladesh.

Hourly DHU report (At Sewing QC Table)

Order no: **0005-728959** Style: **Boy long sleeve T SHIRT** Date: **02-04-18**
 Floor no: **4TH** Line no: **20** Table Quality Name: **SELINA - FARUKA** Color: **JAUNE**

Defects Name:	Hours										
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	
Broken stitch											6
Button Defect											3
Button hole											
fabric fault											4
Needle hole											
Improper tuck											
Improper shape											
Joint stitch		-									2
Label fault											
Measur/Size mistack											
Needle marke											
Open seam											4
Print fault											
Embroidary											
Puckering											
Pleat											4
Rawedge											2
Slanted											
Skip Stitch											12
Shading											
Twisting											
Up-down											
Un-even											10
Uncut thread											
Collar											
Pocket											
Oil spot											12
Dirty spot											
Missing Part											4
Sewing Reject											3
label out of Position											5
Others											
Total check gmts	127	168	177	167	228	157	169	196	215	219	2258
Total pass gmts	120	160	170	160	220	150	160	190	210	200	2215
Total defectives gmts	7	8	7	7	8	7	9	6	5	9	26
Total deects qty	2	3	2	2	3	3	3	6	3	3	26
DHU%	5.52%	4.76%	4.52%	4.19%	3.50%	4.45%	4.76%	4.30%	4.20%	3.27%	3.30%
Defects rectified qty	14	5	8	7	7	6	5	9	4	2	21
Defects balance qty	2	3	2	2	3	3	3	3	4	4	21
Rectify defects check & pass	14	5	8	7	7	6	5	9	4	2	21
Reject qty											2
Supervisor signature	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	

Top 3 defects	Root cause	Cap	Respon person	Implt date

Quality s/v QC Production AQM GM

Fig no: 04 Sewing Inspection Report:

Nur group & Raiyan Kint Composite LTD.

Hourly DHU (Defects hundred per hour unit) Report (At Sewing QC Table)

Buyer: G.P, Order No: 0005-728959, Color: JAUNE,
 Line NO: 20

$$DHU\% = \frac{\text{Total Defects qty} \times 100}{\text{Total Check qty}}$$

Order no: 0005-728959	Style: Boy long SLV: T Shirt	Color: JAUNE
Floor no: 4th	Line no: 20	Table quality Name: Selina-Farida

Defects Name	Hours										
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Broken Stitch		II		I		I		I	I		6
Button Defect			I		I				I		3
Fabric fault										III	4
Joint stitch		II	I			II			II		7
Open seam							II		I	I	4
Pleat	I				II					I	4
Raw edge		II	II	I			II			II	9
Skip stitch	II	II	L	I		I	I	II		II	12
Un-even	II		II	II	II	I	I				10
Oil Spot	II		II		II	II		II	II		12
Missing Part							II		I	I	7
Sewing Reject										III	3
Label out of position				II	I			I	I		5
Total Check gmts	127	168	199	167	228	157	168	146	219	214	2298
Total pass gmts	120	160	190	160	220	150	160	140	210	200	2215
Total defective gmts	7	8	9	7	8	7	8	6	9	7	76
Total defects qty	7	8	9	7	8	7	8	6	9	7	76
DHU%	5.51%	4.76%	4.52%	4.19%	3.50%	4.45%	4.72%	4.10%	4.10%	3.27%	3.30%
Defect rectified qty	14	5	8	7	7	6	5	8	4	7	71

Defect balance qty	7	8	9	7	8	7	8	6	9	7	66
Rectify defects check & pass	14	5	8	7	7	6	5	8	4		72
Reject qty										7	7

Table No: 3.4 Sewing Inspection Report

Description:

We found & flowing problem As Below

ART#999 TOP Turquoise 1.Fabric color some deferent from our original Swatch sealing Sample 2. Print looking shiny less 3.BTM Hem stitching wit h as per paper 4mm but balk have 5mm /6mm and neck rib height more 4. SLV BTM hem puckering due to heaming time do not match point 5.neck tape wavy 6. Dirty sport 7.Neck rib loose 8. Crease mark of front 9. Poor shape BTM

NB-PONT TOTALLY NOT ACCEPT

We will never accept these quality please rectify all above mention defect.

3.5 Experimental Data-Sewing In- Line Inspection Report:

Sewing Inspection Quality Table Report of Nur group&Raiyan knit composite ltd.

Buyer: G.P

Order No: 30003050

Inspected By:Afzal

In-Line Inspection Report

DESCRIPTION	KIDS NIGHT WEAR	DATE	11.02.2018.
ORDER#	3003050	AGENT	RAIYAN KNIT COMPOSITE LTD.
ORDER QTY	1331985TS/235658Pcs.	FACTORY	RAIYAN KNIT COMPOSITE LTD.
DELV DATE	15.03.2018.	ATTN	MR.ZIHAN/MR.HARUN/MR.RAZZAK
SHIPMENT MODE		INSPECTED BY	ALFAZ
NO# OF PCS CHECKED:		REPORT #	

Fabric Material :		FAB INSP	GSM RORD	GSM FOUND	SHADE	HANDFEEL	REMARKS
ART#	COLOR	QTY	CUT QTY	OUTPUT QTY	WASH SENT	WASH RCVD	PACKED QTY
996 TO	MINT	35861	17500	5830			
996 BTM	MINT/WHITE	35861	8598	2955			
997 TO	WHITE+PINK RINGED(AOP)	30738	5280	-			
998 TOP	BLUE	35861	5280	1299			
998 BTM	GREY MEL	35861	15210	5031			
999 TOP	TURQUOISE	30738	4250	480			
999 BTM	NAVY	30738	13250	4537			
		235658	64088P.	19682P.			

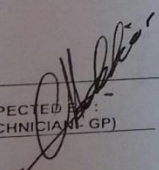
DEFECT DESCRIPTION

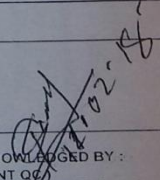
WE FOUND & FOLLOWING PROBLEM AS BELOW.

ART# 999 TOP (TURQUOISE): ① FABRIC'S COLOR SOME DEFERENCE FROM OUR ORIGINAL SWATCH + SEALING SAMPLE. ② PRINT LOOKING SHINY LESS. ③ BTM HEM STITCHING WIDTH AS PER PAPER 5MM BUT BULK HAVE 6MM/7MM. AND NECK RIB'S HEIGHT MORE ④ SLV+BTM HEM PUCKERING DUE TO HEMMING TIME DO NOT MATCH POINT. ⑤ NECK TAPE WAVY. ⑥ DIRTY SPOT. ⑦ NECK RIB'S LOOSE. ⑧ CREASE MARK AT FRONT. ⑨ POOR SHAPE BTM & SLV OPENING.

(NB) PRINT TOTALLY NOT ACCEPT

WE WILL NEVER ACCEPT THESE QUALITY
 PLS RECTIFY ALL ABOVE MENTIONED DEFECT.

INSPECTED BY: (TECHNICIAN - GP) 

ACKNOWLEDGED BY: (AGENT QTY) 

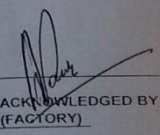
ACKNOWLEDGED BY: (FACTORY) 

Fig No: 5 Sewing In- Line Inspection Report:

Nur group & Raiyan knit composite ltd

Sewing In- Line Inspection Report

Buyer: G.P, Order No: 3003050, Order quantity: 1331985TS/235658pcs



Description	Kids night wears	Date	11-2-18	
Order	3003050	Factory	Raiyan knit composite ltd	
Order quantity	1331985Ts/235658pcs	Inspected By	Alfaz	
ART	COLOR	QTY	CUT QTY	OUTPUT QTY
996 TO	MINT	35861	1760	5830
996BTM	MINT	35861	8598	2755
997 TO	WHITE/PINK	30738	-	-
998 TOP	BLUE	35861	5280	1299
998 BTM	GREY MEL	35861	15210	5031
999 TOP	TURQUOISE	30738	4250	480
999BTM	NAVY	30738	13250	4537
		235658	64088PCS	19682PCS

Table No: 3.5 Sewing In- Line Inspection Report

DEFFECT DISCRPTION
<p>We found & flowing problem As Below</p> <p>ART#999 TOP Turquoise 1.Fabric color some deferent from our original Swatch sealing Sample 2. Print looking SHINY less 3.BTM Hem stitching wit h as per paper 5mm but balk have 6mm /7mm and neck rib height more 4. SLV BTM hem puckering due to heaming time do not match point 5.neck tape wavy 6.</p>

Dirty sport 7. Neck rib loose 8. Crease mark of front 9. Poor shape BTM

NB-PONT TOTALLY NOT ACCEPT

We will never accept these quality please rectify all above mention defect

3.6 Experimental Data-Pre- Final Inspection Report:

Final Report of Nur group&Raiyan knit composite ltd.

Buyer: G.P

Order No: 30003050

Inspected By: Afzal

Inspection repo. Inspektionsbericht	Photo Board Lot - A	Final Inspection End - Inspektion	Photo Board Lot - B	Inspection date: 01.02.2018. Inspektionsdatum:
order no. Auftrags-Nr.:	3001051	del. date Verschiffungstermin:		rust: Button: rivets: zipper: Rost: Knöpfe: Nieten: RSV:
supplier Lieferant:	RAYAN KNIT	assort.: Sortimentsgröße:	15 SET / CTN	nickel: button: rivets: zipper: Nickel: Knöpfe: Nieten: RSV:
container no.: Container Nr.:	2ND	tot. ctn.: Total Kartonzahl:	7420 CTN	total qty of Order: 111300 PACKS Ordermenge:
No. Of ctn.: Karton-Anzahl:	3710 CTN	Total ctn qty of shipment: ges. Verschiffungsmenge:	3710 CTN	qty. of shipment: 55650 PACKS Verschiffungsmenge:
Ctn. Shpd. No: 3711-7420		bal. tot. ctn. restl. Kartonanzahl:	3710 CTN	bal. total qty.: 55650 PACKS Restmenge:
Ctn. no. Chkd for Qty: 61 CTN		next container dt.: Nächster Container am:		Ctn. sent to Germany:

EAN-No. 28327979 is correct: YES same barcode-no. on photoinlay & hangtag: YES EAN Code colour: BROWN
readability of barcode on photoinlay (1 assortment): (4A) on hangtag: (4A)

Size / Größe: 47/46, 48/50, 52/54 colour / Farbe: 4 ART'S / 8 COLOR Marken-RV / YKK-Zippers: N/A.
Sets: sind verbunden / are connected: Measurement / Maße MEASURE WITHIN TOLERANCE.

Prüfung nach Doppel-Stichprobenplan (ft. ISO-Norm) / double random sampling plan
Quality-check: 61 CTN Quantity pcs. check: 500 SETS Found Insects NO.
Qualitätskontrolle: Prüfmenge / Stk.: Inspection result: Inspektionsergebnis: 19/18
P.P. Bag Wt + Quality Checked: 50 MM

AQL = 2,5 Major (1st) 2.1 / 2.1
4,0 Minor
(2nd check if necessary / ggf. 2. Prüfung notwendig)

AQL = 2,5 Major (2nd)
4,0 Minor

assortment check OK Quantity ctn. check: 742 CTN Article No.: N/A.
Sortimentskontrolle Prüfmenge / Karton: Zipper Auto Lock: Yes / No
Checked Pieces:

No.:	Major defects found:	pcs.:	No.:	Minor defects found:	pcs.:
Nr.:	Hauptfehler:	Stück:	Nr.:	Nebenfehler:	Stück
	HI-KING BTM	03		FOREIGN YARN	04
	HI-KING SLV / IRREGULER SLV	02		POOR SHAPE SLV	03
	FABRICS KNOT	01		PUCKERING BTM / SLV HEM	04
	BROKEN	04		POOR SHAPE BTM	01
	OFF SHAPE BOTTOM	01		DIRTY SPOT	03
	OFF SHAPE NECK	02		OIL STAIN	03
	SKIP STITCH	02			
	DIRTY SPOT	01			
	OIL STAIN	01			
	FABRICS HOLE	02			
		(19)			(18)

Total / Gesamt: Total / Gesamt: 18

Remarks / Bemerkungen: WE FOUND CTN MEAS: - 59X40X15 CM
AND CTN WEIGHT: - 7.366 KG.

goods accepted:
goods rejected:

THIS REPORT DOES NOT RELEASE FACTORY / SUPPLIER / AGENT FROM ANY CLAIMS ARISING AFTER GOODS HAVE ARRIVED AT FINAL DESTINATION AND HAVE BEEN ACCEPTED BY ULTIMATE BUYER.

Supplier / Lieferant:
Agent's Representative:
for G. GÜLDENPFENNIG GmbH
Technician: 1. ALFAZ.
2.
3.

Fig No: 3.6 Pre-finals Inspection Report:

Pre-final inspection Report:

Inspection Report	Photo Board	Final Inspection	Photo Board	Inspection date:
Inspections be	Lot-A	End-Inspection	Lot- B	01-02-2018

rich				
Order no: Auftrags-Nr	3001051	Del. Date: Verschiffungstermin		Rust: Button rivets: Zipper: Rost: Knopfe: RSV
Supplier Lieferant	Raiyan Knit	Assort: Sortimentsgrobe	15 SET/CTN	nickel: Button rivets: Zipper: Nickel: Knopfe: RSV
Container no: Container Nr:	2nd	Tot. ctn: Total Kartonzahl	7420 CTN	Total qty of order: 111300 packs
No. of ctn: Karton-Anzahi	3710 CTN	Total ctn qty of shipment: ges. Verschiffungs menge	3710 CTN	Qty. of shipment: 55650 packs
Ctn. Shipd. No.	3711-7420	Bal. tot. ctn. Restl. Kartonanzahl	3710 CTN	Bal total qty: 55650 packs
Ctn. No. Chkd for Qty:	61 CTN	Next container dt: Nachster Container am:		Ctn. Sent to Germany

EAN-No. 23327979 is correct: yes same barcode-no. on photo inlay & hangtag: yes EAN Code Colour: 3 Rowan
Readability of barcode on photo inlay: 4A on hangtag: 4A
Size/Grobe: 44/46, 48/50, 52/54 Colour: 4 Art's/8 Color Marken-RV/YKK-Zippers: N/A
Sets: sind verbunden /are connected: Measurement/ Mable Measure Within Tolerance

Table No:3.6 Pre-finals Inspection Report

Descriptions:

This report does not riles factory /supplier/ agent from any claims arising after good have arrived at final destination and have been accepted by ultimate buyer.

3.7 Experimental Data-Final Garments Inspection Report:

Final Inspection Report of Nur group&Raiyan knit composite ltd.

Buyer: A.E.O

Order No: 223844

Inspected By: Sayed

GARMENTS INSPECTION REPORT

S.S.A

TYPE OF INSPECTION		PTL	IN LINE
BUYER	AEO	DATE	10.9.14
STYLE	8616	INSPECTED BY	Sayed
ORDER NO	223844	PLAN SHIP DATE	
ITEM	LADIES TROUSER		
ORDER QUANTITY	10,000 pcs		
WEAVING	THREAD	WORKMANSHIP	SEE COMMENTS
FABRIC	LABLE	FOLDING	
COLOR	DARK	POLY	
BUTTON HOLE	PRINT	CARTON	

LOT SIZE	ACCEPTABLE QUALITY LEVELS			
	INSPECT	ACCEPT	INSPECT	ACCEPT
LESS THAN 151	8	0	5	0
151-200 ✓	8	0	20	1
201-500	32	1	20	1
501-1200	32	1	32	1
1201-3200	50	2	50	1
3201-12000	80	3	80	1
12001-35000	125	5	125	1
35001-150000	200	7	200	1
150001-500000	315	10	315	1

(Audit Report)

PRODUCTION STATUS		PRINT	EMBROIDERY ✓	PRINT
CUTTING	SEWING	WASHING	POLY	CARTON
DEFECT DESCRIPTION		MAJOR	MINOR	
/				

LOT QTY	280	SAMPLE QTY	08	AQL	1.5	DEFECT QTY	02
COMMENTS				RESULT	PASS	Sayed	

Q.A. MANAGER: *Obe* *Q.A.M* TECH MGR GM

Fig no: 07 Garments Final Inspection Report:
Nur Group & Raiyan knit composite ltd

Final Garments Inspection Report

Buyer: A.E.O, Order No: 223844, Inspected By: Sayed

Types of description	PTL	IN LINE	
Buyer	AEO	DATE	10.09-17
Style	8616	INSPECTED	SAYED
Order no	223844		
Item	LADIES TROUSER		
Color	DARK	EMBROIDERY	

LOT SIZE	AQL (Acceptable Quality Level)			
	1.5		2.5	
	INSPECT	ACCEPT	NSPECTA	ACCEPT
LESSTHEN 15	8	0	5	0
151-280	8	0	20	1
281-500	32	1	20	12
501-1200	32	1	32	3
1201-3200	50	2	80	3
3201-10000	80	3	80	5
10001-25000	125	8	125	7
35001-15000	200	7	200	10
150001-500000	8315	10	315	14

				PRION
				CARTON
				MAJOR=MINOR
TOTAL QUANTITY	280	AQL=1.5		CHECK QUANTITY=OO
				ALLOW QUANTITY=OO
				RESULT=PASS

Table No: 3.7 Garments Final Inspection Report

Description:

This is a standout amongst the most essential stages if there should arise an occurrence of Inspection in wrapping up. Since, in the wake of passing completing table it goes for cartooning or shipment. All trims and frill and besides, overabundance strings are checked here precisely. In material assembling, completing alludes to the procedures that change over the knit fabric into a usable material and all the more particularly to any procedure performed in the wake of coloring the yarn or texture to enhance the look, execution, or "hand" (feel) of the completed material or dress.



Chapter-04

Discussion of Results

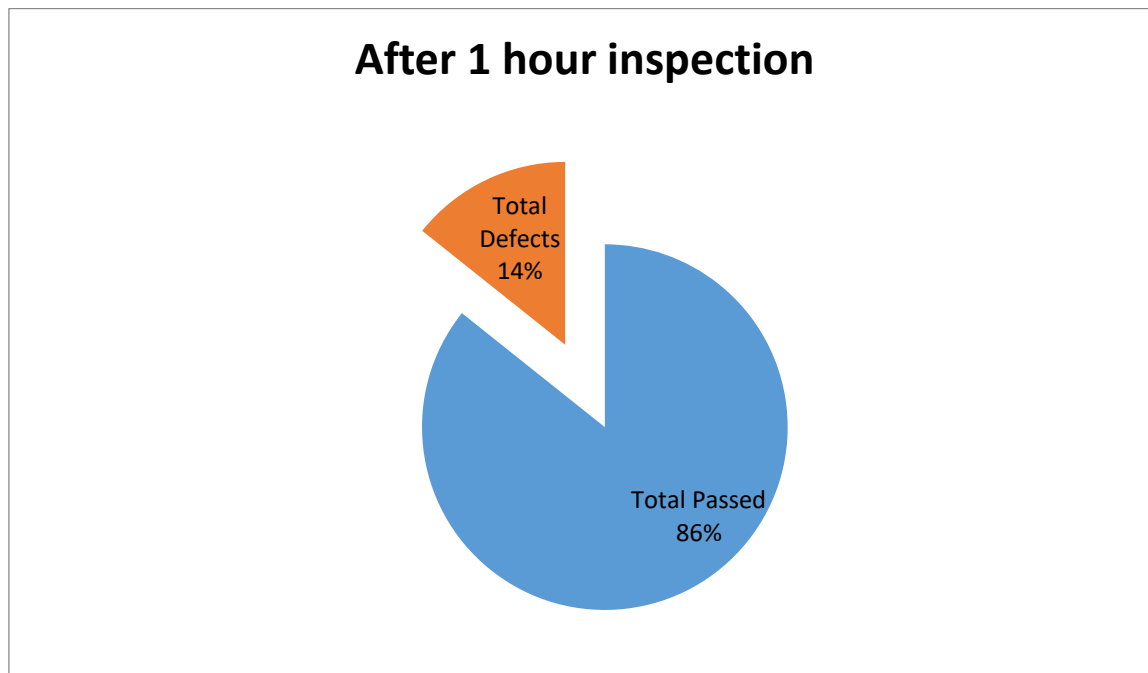
4.1 Discussion of Results in Cutting Section

After 1- hour cutting Pattern inspection Analysis from data3.1, 3.2 and3.3:

Hours	Total piecescheck	QC pass	Defect piece	Rectified piece	reject
1st	70	29	41	41	2
2nd	90	62	28	28	1
3rd	95	58	37	37	3
4th	92	58	34	34	2
5th	88	61	27	27	1
6th	89	63	26	26	2
7 th	92	64	28	28	3
8 th	95	67	28	28	2
9th	90	59	31	31	2
10th	92	61	29	29	2

Total	893	528	309	309	18
--------------	------------	------------	------------	------------	-----------

4.2 Analysis Report from Data:

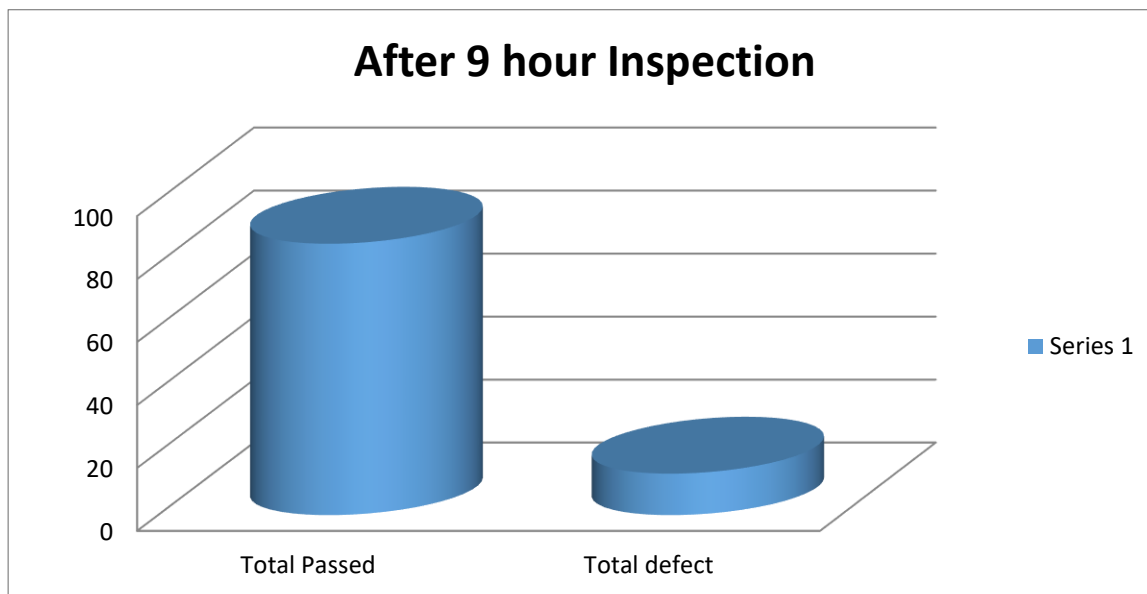


Graph No: 01 After 1 hour inspection

Descriptions:

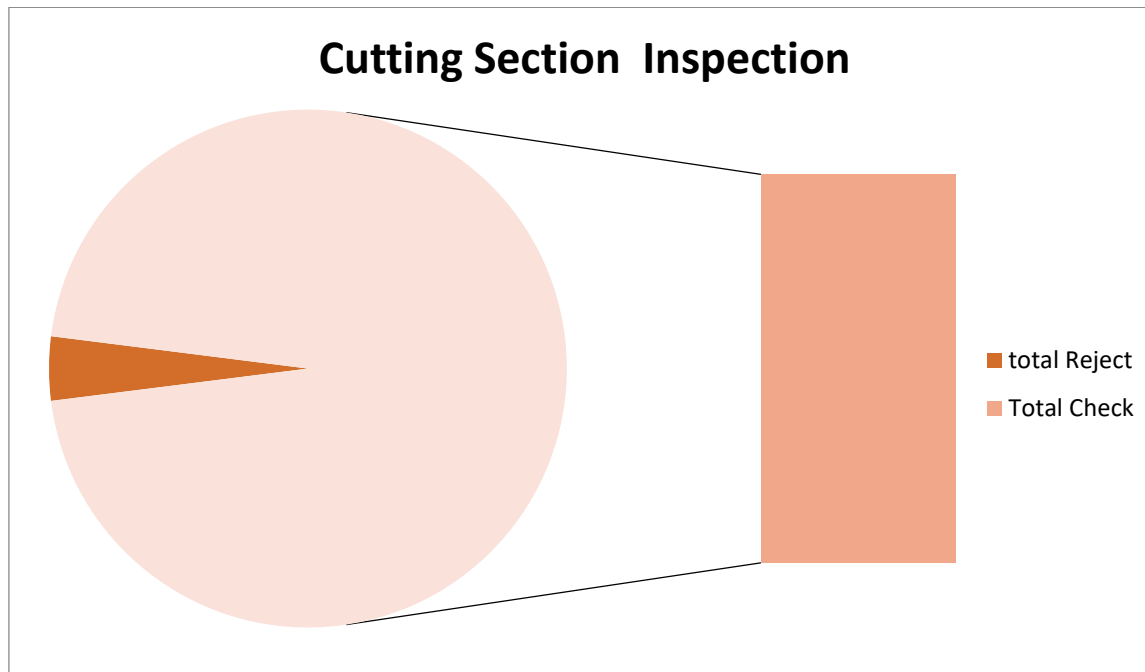
After 1 hour cutting pattern inspection inspector inspect total 70 pieces Garments pattern 29 of them quality passed. reject 2 of them. Total checked pieces in percentage are 86% and total defects percentage 14%.

4.3 After 9- hour cutting Pattern inspection Analysis:



Graph No: 02After 9- hour cutting Pattern inspection Analysis

After 9 hour cutting Pattern Inspection inspector inspect total 883 pieces of Garments Pattern 528 pieces of them quality Passed defect done 18 of them. Total checked Piece in percentage 86.2% and total defects 13.8%.



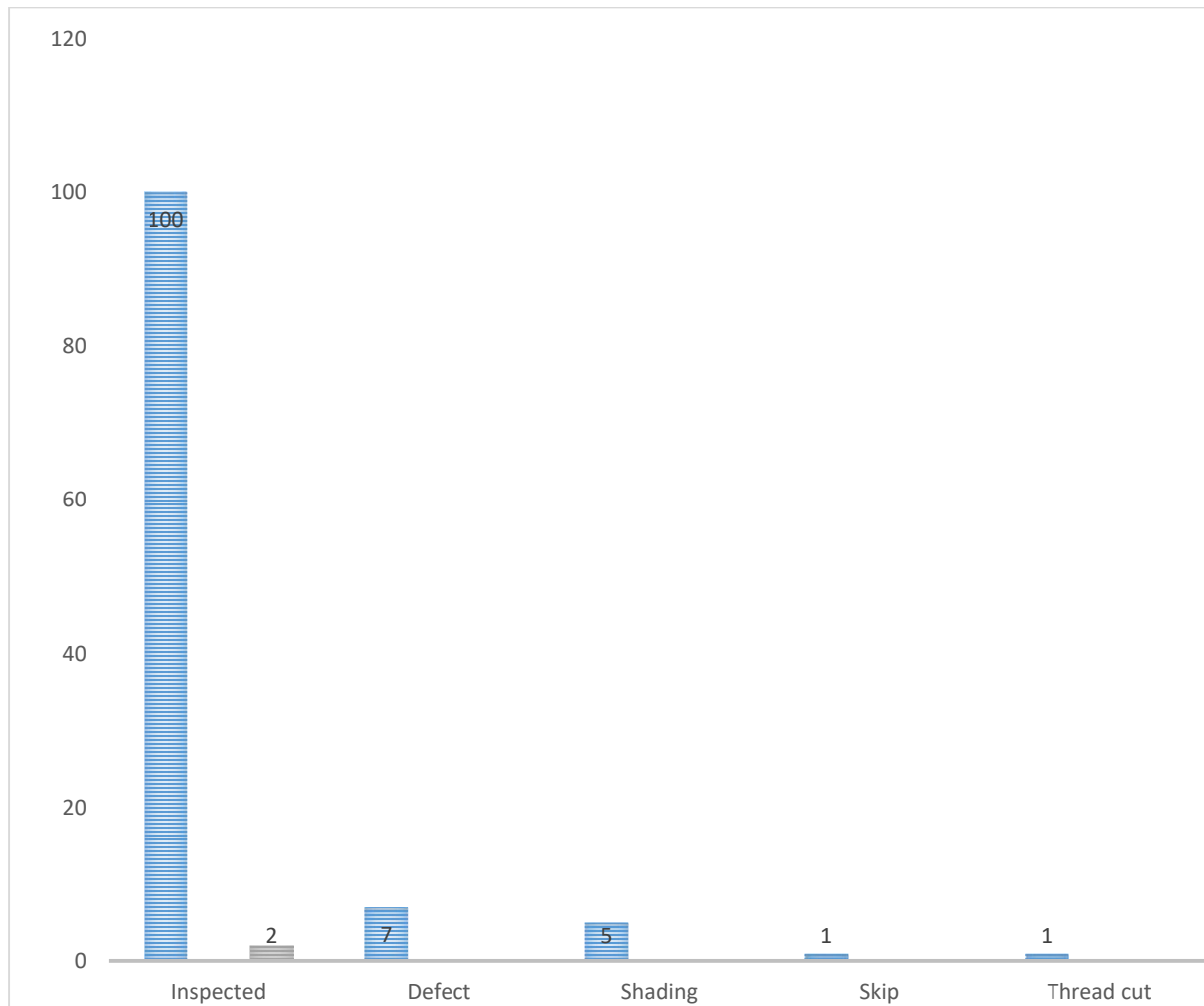
Graph No: 03 After 9- hour cutting Pattern inspection Analysis from data3.1, 3.2 and3.3:

4.4 Cut panel inspection Report Analysis:

Cut Panels Inspection Report from Nur group & Raiyan knit composite ltd. Is shown in Figure 3. This is a scan copy of their original cut panel's report. In this report factory done work for cut panel's bundle at bundle serial number. Total Inspection 401 Pattern pices. Total Reject 16 Pieces. Total Check Percentage Are 96.10% and reject Percentage 3.90%. of Patterns After placing the serial number in every component of cut panel, inspection process is started from this stage. Though rolls are accepted in initial inspection still there are some defects on the roll. So quality team does sort out those defective components during cut panel inspection. QC replace the defect component from the balance fabrics, which QC kept from each roll, depends on numbering. It is mentionable that QC does record how many layers have completed from each roll to identify the fabric for replacement. The report we are following call "cut panel inspection report". Here this report shows eleven columns and twenty four rows. Here find out three defects at three bundles and recovery this defect. And finally shown defect% in this report.

4.5 Sewing Inspection Report Analysis from data3.4 and3.5:

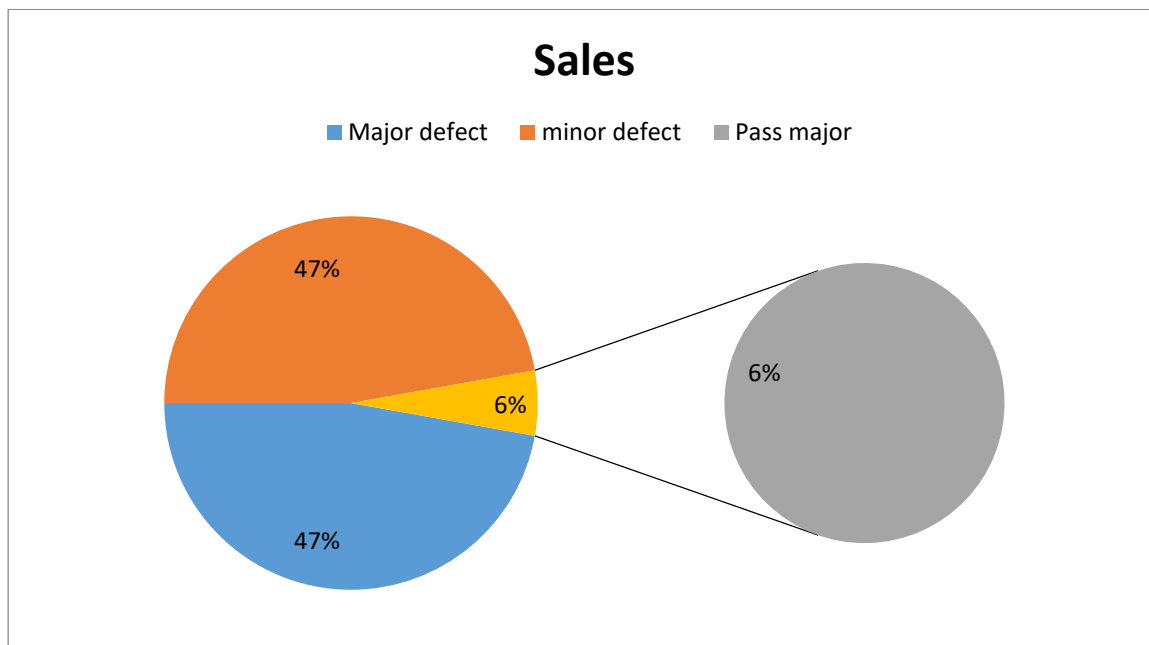
Sewing Inspection Report from Nur group & Raiyan knit composite ltd is shown in Figure 4 This is a scan copy of their original Inspection report .In this report shown & checking parameters given inspected Garments 2. Here inspected Qty 100 and defect Qty 7. Here part shading defect 5, skip 1 and thread cut 1. In this report given details for what types of wash is used.



Graph No: 04 sewing Inspection Report Analysis

4.6 Pre Final Quality Audit Report Analysis From data 3.6:

Pre-final /final quality audit report from Nur group & Raiyan knit composite Ltd. Is shown in Figure 6. This is a scan copy of their original Pre-final /final quality audit report. According to shown check point to be noted correct and incorrect of Finishing section. Here defects description in two steps 1. Minor, 2. Major. And showed defects criteria in two steps 1. New, 2. Repealed. Defects description- 1. Crease to strong. 2. Crease mark. This to defects are minor defects and defect criteria new. This lot is ok now need production running. Here inspection results Major Defect 21% and Minor Defects 21% it is pass major 2.5 and minor 4. When products first lot wash complete then QC section check the products such as shade, measurements & dry process. If all process match buyers requirements then products go to the finishing section. But if process not matches then products goes to again washing section. Again all process continues in this product and then rechecks shade, measurements and dry process. If now match all process this products goes to finishing section.

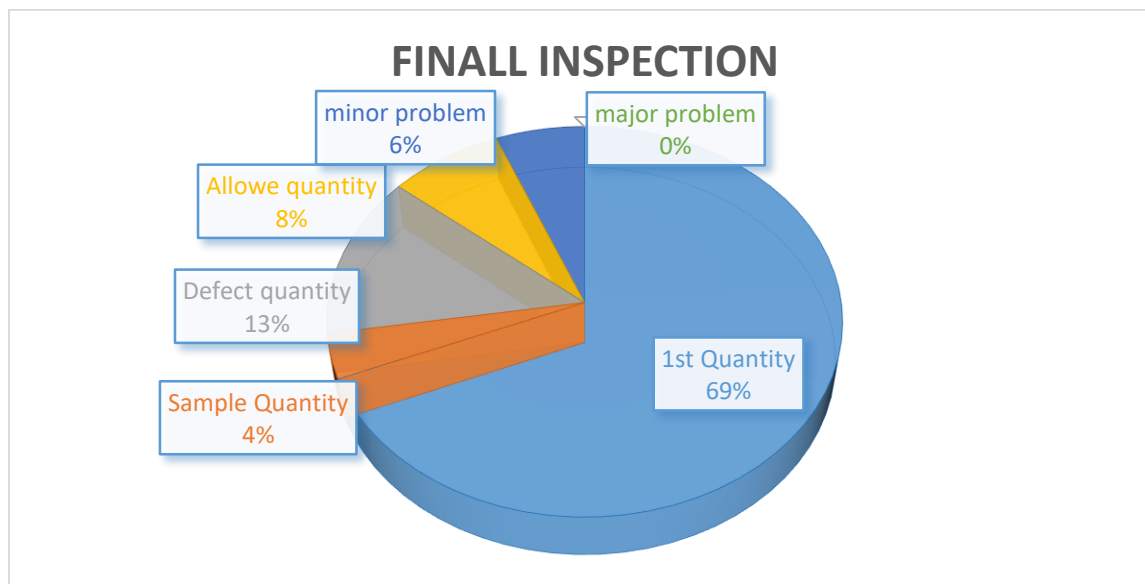


Graph 5 Pre Final Quality Audit Report Analyses

4.7 Final Inspection Report Analyses From data 3.7:

Garments inspection reports from Nur group & Raiyan knit composite Ltd. Is shown in Figure 7. This is a scan copy of their original garments inspection reports. In Figure 1 shown lot Qty 280, sample Qty 8, AQL 15, defect Qty 55, allowed Qty 32, and result is pass. When total order complete to buyer's requirements then buyer send 3rd party to check final products/garments inspection. If AQL 5, then it is minor problem it is easily solve so it is acceptable. But if AQL above 5, then it is major problem. If AQL acceptable in buyers requirement then garments ready to shipment. But if AQL is not acceptable buyer's requirement then garments not ready to shipment.

Again do AQL then recheck AQL if acceptable AQL then goes to shipment.



Graph No: 06 Final Inspection Report Analyses

This document is provisory Draft Report and as such is for informational purpose only .Bureau verities issues this document at clients request to provide a preliminary summery of the same day that the inspection is completed. You are advise that this document has not been reviewed and approved by supervisor under our quality assurance system and may contain errors. We disclaim any liability decision concerning the acceptance .payment authorization, or shipment of the inspected goods are made.



Chapter- 5 (Five)

Conclusion



5.0 Conclusion:

We completed our project by collected by the inspection information from Nur group&Raiyan knit composite It.This project help us to know about to the inspection procedure not only that but also we also able to know about various type of cutting sewing, and finishing faults and also their rectified method quality item can accomplish the market request, so at first to satisfy the review procedure of the texture. From this report subtle elements thought regarding the assessments in texture, trims and extras area here texture is the fundamental material in the creation so if texture is great at that point made great quality articles of clothing. So guarantee all property of texture and adornments. In Cutting area, at first made example in alter shrinkage at that point made marker from design. At the point when marker lay on the table in takes after the standard estimation of item. In this area processing plant takes after five distinctive reviews. In inspection segment, here purchaser gave standard item so all item take after this standard prerequisites. In this segment industrial facility takes after five diverse investigations provide details regarding this request. In completing segment, here all items keep up the standard necessities of items. Along these lines, here industrial facility keeps up articles of clothing investigation report and last QA execution report. In Quality Section, showcase esteem and request amount rely upon nature of articles of clothing. So here industrial facility takes after various parts assessment of the items and guarantee all nature of the items.



06. References

1. <http://www.businessdictionary.com/definition/quality.html>
2. <http://www.saching.com/Article/Factors-Affecting-Quality-in-MaterialManagement/5682>
3. http://en.wikipedia.org/wiki/Quality_control
4. http://en.wikipedia.org/wiki/Quality_assurance
5. http://www.ehow.com/list_7867675_types-quality-control.html
6. <http://www.fabricinspection.com/>
7. http://www.fibre2fashion.com/industry-article/41/4017/texture_faults1.asp
8. http://www.fibre2fashion.com/industry-article/9/837/absconds_in-garments2.asp
9. http://www.onlineclothingstudy.com/2012/01/activity_light-framework_for-quality.html
10. Md. Saiful Azam, Md. Abu Saleh-Garment Manufacturing Technology.
11. <http://www.apastyle.org/learn/quick-guide-on-references.aspx#Websites>