



Daffodil
International
University

Faculty of Engineering

Department of Textile Engineering

REPORT ON

Industrial Attachment

At

Universal Menswear Ltd.

AEPZ, Narayangong

Course Title: Industrial Attachment

Course code: TE431

Submitted By

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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

DECLARATION

I hereby declare that, this report has been done by under the supervision of **Engr.Mohammad Abdul Basset**, Assistant professor, Department of Textile Engineering, Daffodil International University. I also declare that neither this industrial attachment report nor any part of this industrial attachment report has been submitted elsewhere for award of any degree. There is no part of this paper directly copy from other.

Submitted by:

Md Arif Billah

ID: 111-23-2372

Department of Textile Engineering

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Yours sincerely

.....

LETTER OF APPROVAL

April 5, 2018

To

The Head

Department of Textile Engineering

Daffodil International University

102,Shukrabad,Mirpur Road, Dhaka 1207

Subject: Approval of project report of B.Sc.in Textile Engineering program.

Dear Sir

I am writing to let you know that this Industrial Attachment report in “**Universal Menswear Ltd**” has been prepared by the student bearing Md.Arif Billah, ID 111-23-2372, is completed for final evaluation. The whole report is prepared based on the proper investigation and information in Universal Menswear LTD. The student was directly involved in their industrial attachment report activities.

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

Yours Sincerely



.....

Engr.Mohammad Abdul Baset

Assistant professor

Department of Textile Engineering

Daffodil International University

ACKNOWLEDGEMENT

At first I express my heartiest thanks and gratefulness to almighty ALLAH for his divine blessing made me possible to complete this industrial attachment report successfully.

I completed this total industrial attachment report in Universal Menswear LTD. AEPZ, Narayangong, Bangladesh. This is fully export oriented woven top & bottom garments.

I fill grateful to **Engr. Mohammad Abdul Baset**, assistant professor, Department of Textile Engineering, Daffodil International University, for providing immediate and necessary help that I required to conduct this report. I would like to thanks all of the administrative personal, quality controllers, sewing operators who involved completing this industrial attachment report more enriched. They all were too much helpful to me to complete this work.

I would like to express my hurtful thanks to **Prof.Dr.Md.Mahbubul Haque**, Head, Department of Textile Engineering, Faculty of Engineering and daffodil international University for his kind help to finish my this report.

I also expressed my gratitude to **Nilanka perera**, GM production, **Nilshanta**, Sr production manager and **Rakibul**, Manager, IE in Universal Menswear limited, for their kind help to every stage of this industrial attachment report. I also would like to thank my entire course mate in Daffodil International University, who took part in this discuss while completing the course work. Finally, I must acknowledge with due respect the constant support and patients of my parents.

DEDICATION

At first, I want to dedicate this industrial report to Almighty ALLAH for giving us to the opportunity to prove myself. Without his help nothing would be possible. Then I want to dedicate this report to my parents. To complete my study they played very important role. It's a great pleasure for me. Without their help it is quit impossible for me to complete this attachment. So I am very grateful to them. My parents were very helpful to ready this attachment. Moreover, I also want to dedicate this report to my honorable teacher & academic supervisor, Assistant professor, Eng. Mohammad Abdul Baset, Department of Textile, Daffodil International University, give me a very good support & guideline to make ready this attachment.

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CHAPTER 1

EXECUTIVE SUMMARY

1.1 Executive summary

The internationally recognized buyers or clients are looking for those countries for producing their apparel products where different types of mills have established as a one stop source for the global apparel market expectation satisfy by developing and providing meet cuts products and services on time, which offer value in terms of quality, price, safety and environmental impact. In Bangladesh there are different types of textile industry those are producing high quality textile and apparel product. Universal Menswear Ltd is one of them. It's a fully export oriented industry. All machines are from different countries like China, German, Uk, Japan. All top managements are from Srilanka, India, Romania and Misor. This company is well decorated and producing high quality product to meet the customer satisfaction.

In this report, I have tried my label best to give more information about this factory. I also observed that Universal Menswear Ltd produce good garments and fulfill internationally buyer requirements.

CHAPTER 2

INFORMATION ABOUT FACTORY

2.1 Introduction

The word UML stands for Universal Menswear Limited. It is engaged in processing read made garments products and exports these products in different countries over world. The UML is basically woven textile manufacturing complex built in 2011 in Adamzi EPZ. This factory produces Jacket and Pant. It is largest suit manufacturing industry in south East Asia by providing high quality product to meet the customer satisfaction. All machines and machines equipment are derived from china,japan,jarman or India. It's a 100% compliance factory. The rules and regulations of this factory are strict. I am really proud working in Universal Menswear Limited.

2.2 Company Profile

Name of the Company: UNIVERSAL MENSWEAR LTD.

Status: Private Company Ltd.

Year of establishment: 2012

Business Type: 100% Export Oriented RMG Factory

Factory Address: AEPZ, Narayangonj, 234-238 & 252-253.

Production Capacity: Jacket section/day : 7000 PCS/DAY

Trouser section/day : 13000 PCS/DAY

Total Manpower: 4800

Main production: Formal pant & Jacket

Total Line: Jacket section: 08

Trouser section: 10

Fax Number: 880-2-8021512



Fig1: Front view of UML

2.3 All buyers & logo

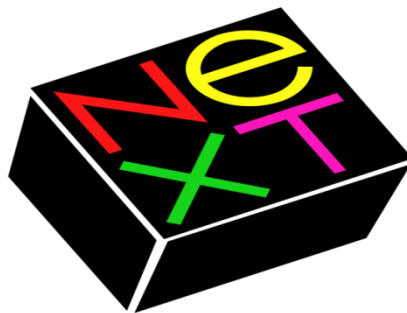
❖ H&M



❖ M&S



❖ Next



❖ Cubes

Cubus

❖ **Prominent**



❖ **J&J**



❖ **Best seller**



❖ **Express**



2.4 Vision

Our vision is to be the largest suit manufacturer in south East Asia by providing high quality product to meet the customer satisfaction.

2.5 Environmental commitment

This company is committed to preserve a healthy and pollution free environment. It has a very efficient collection and disposal system.

2.6 Sources of information

In order to make the report more meaningful, two sources of data have been collected.

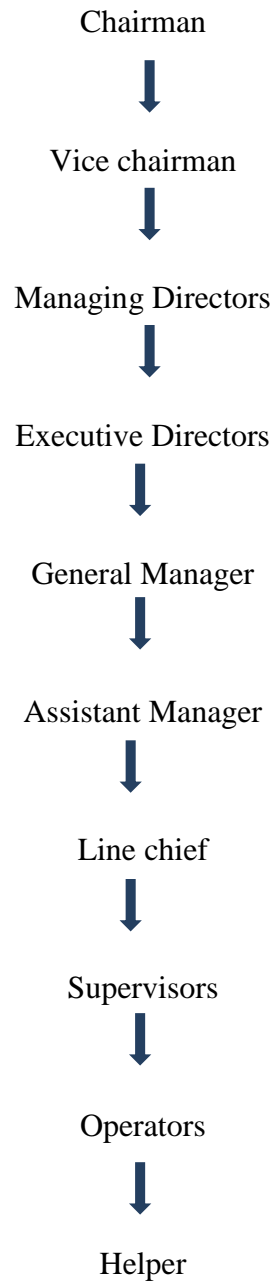
2.6.1 Primary data sources

- ❖ Face to face conversation with the respective officers and staff of the factory.
- ❖ Practical work experience from different department of the organization.

2.6.2 Secondary data sources

- ❖ Previous documents of the organization.
- ❖ Various books, articles and manuals etc.
- ❖ Different web sites.

2.7 Organ gram



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CHAPTER 3

DETAILS ABOUT THE ATTACHMENT

3.1 HR, Compliance & Admin Department

3.1.1 Recruitment Policy

Recruitment is done as per following systems.

- ❖ Serving notice/poster/advertisement in important locations.
- ❖ Personal contacts by own employees.
- ❖ Head hunting for manager/executive.

3.1.2 Selection

During the selection of the workers following factors are considered:

- ❖ Good physical appearance/fitness
- ❖ Age 18 years minimum must be supported by certificate from educational institution or local govt. authorities and confirmed by medical officer.
- ❖ Educational qualification as per job profile.
- ❖ Skill (practical for operators).
- ❖ Wages/salary negotiation.
- ❖ Joining date.

3.1.3 Joining

Selected workers/trainees submit the followings information to HR department on joining

- ❖ Prescribed application form duly filled.
- ❖ Two passport size photographs.
- ❖ Educational certificate.
- ❖ Birth certificate
- ❖ Voter Id
- ❖ Experience certificate (if any).
- ❖ Nominee 1 copy photograph.

3.1.4 Service Confirmation

- ❖ On completion of 6 months satisfactory job performance, company confirms the employees' service permanently.
- ❖ Trainees who fail to show satisfactory performance within this time his/her apprenticeship period are generally extended for another one month. If he/she cannot cope-up within this given period then his/her service is terminated.

3.1.5 Daily Working Hours and Over Times

- ❖ Ten hours a day from 7.30 am to 6.00 pm with 30 minutes lunch break.
- ❖ Maximum two hours overtime per day (maximum 12 hours per week) with one-hour Tiffin break in the afternoon/evening.
- ❖ Friday is weekly holiday.

3.1.6 Medical

Medical facilities are as follows

- ❖ Each worker provided medical allowance @ Tk.150/= per month.
- ❖ First Aid facilities with trained first aider are available for each employee.
- ❖ Accident register for injured person is being maintained.

3.1.7 First Aid Box

Each floor has been provided with sufficient first aid box with following items:

<ul style="list-style-type: none">• Pain relief tablets (Paracetamol).• Nix.• Or-Saline.• Antiseptic cleaner (Savlon).• Roller bandages• Surgical gloves	<ul style="list-style-type: none">• Surgical gauze.• Cotton.• Surgical scissors.• Tourniquet.• Adhesive tape (plasters).• Antibacterial ointment sterile (Savlon)
---	--



Fig2: First Aid Box

3.1.8 Fire safety:

- ❖ Fire extinguisher, hose reel, Fire alarm is available in this factory.
- ❖ There are six exist door for critical situation.
- ❖ Every month fire drill happened two times.



Fig3: Fire extinguisher

3.2 Merchandising Department

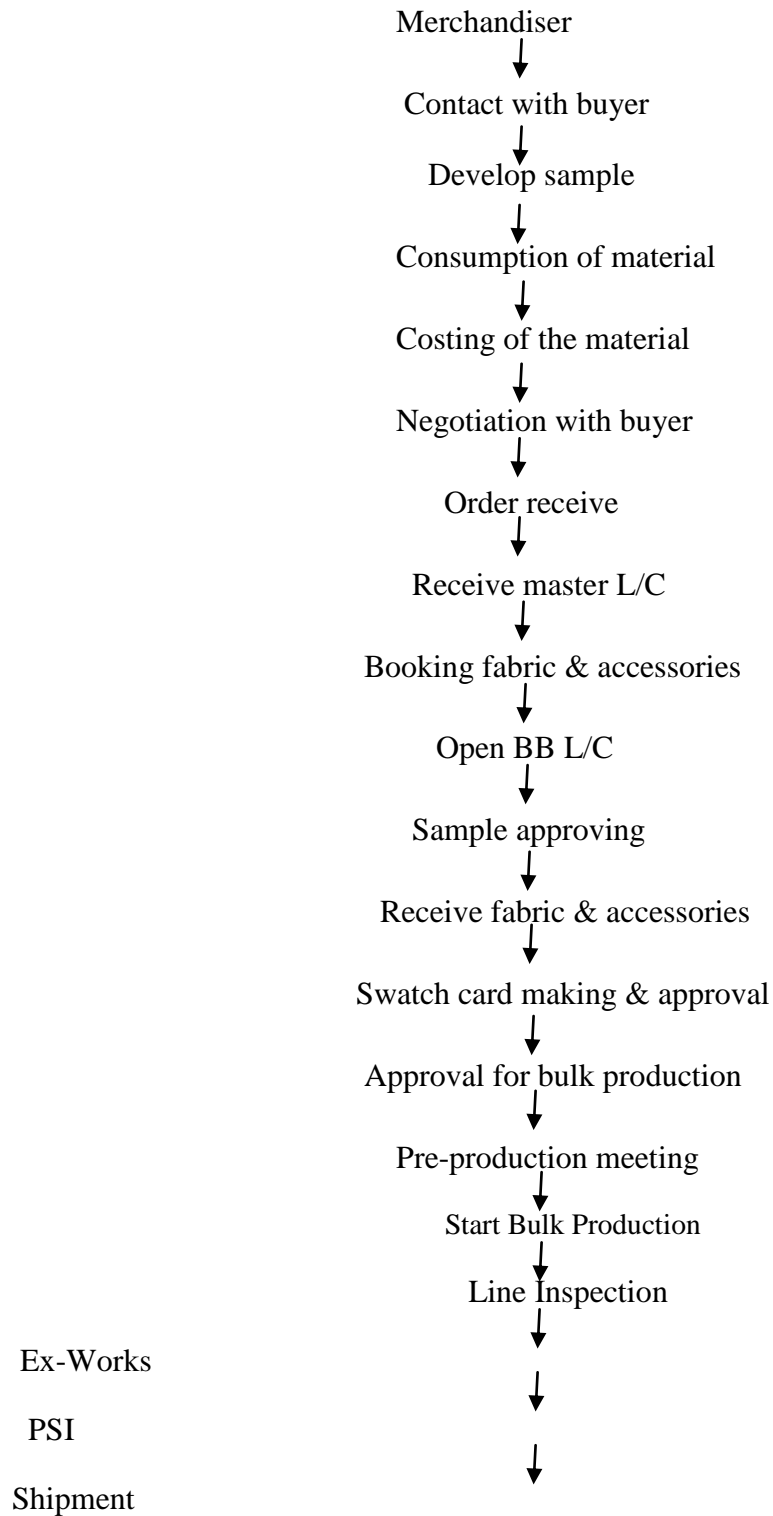
3.2.1 Definition of Merchandiser

Man, who is involved in garments trade, is a Merchandiser. The functions of a merchandiser are known as Merchandising. The term merchandising has been derived from the word merchandise, which means goods that is bought and sold.

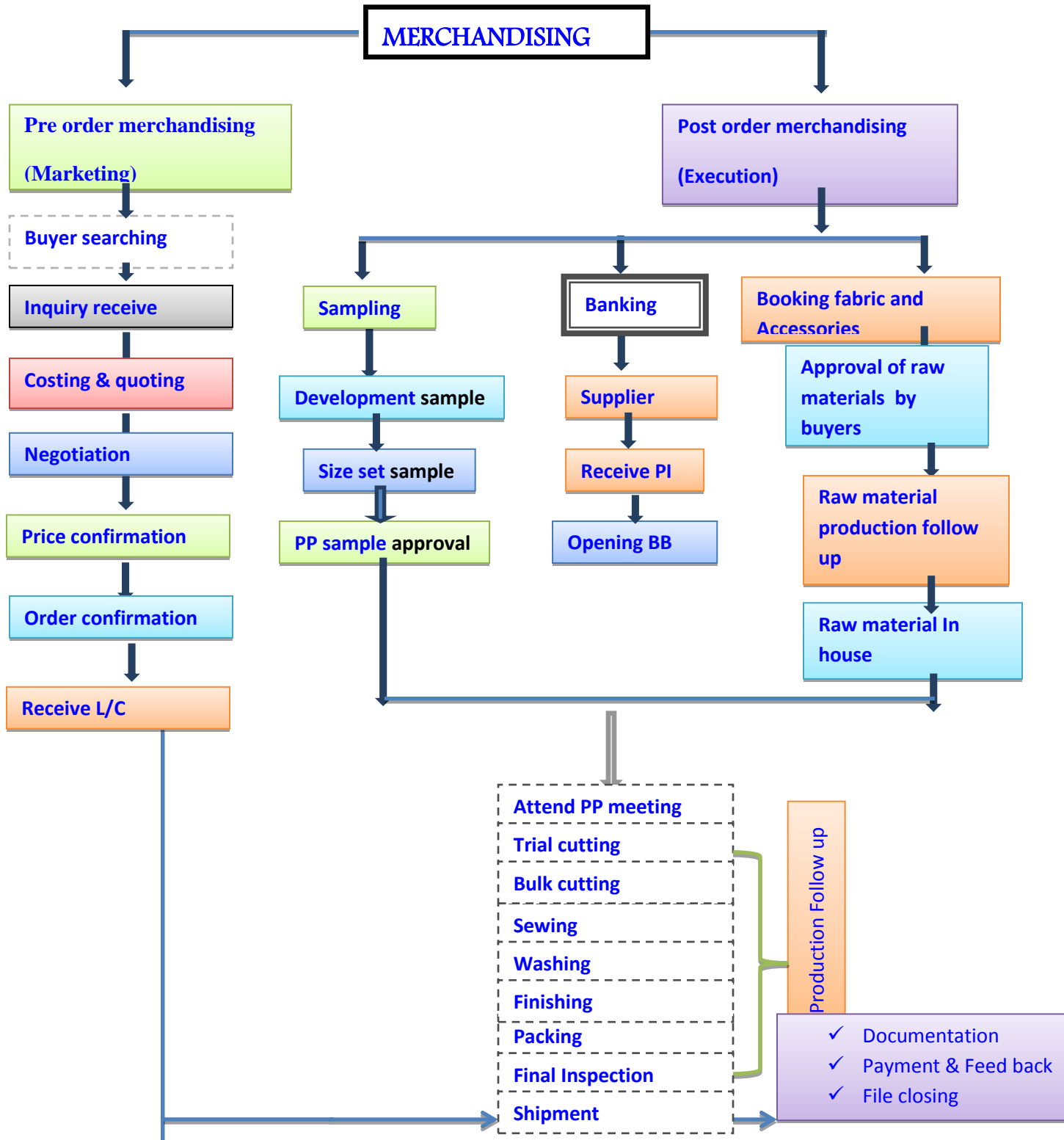
3.2.2 Sample need to prepare by Merchandiser

- Development sample
- Quotation sample
- Size set sample
- Counter sample
- Pre-production sample
- Production sample

3.2.3 PROCESS FLOW CHART OF MERCHANDISING



3.2.4 Function of Merchandising



3.3 Sample Department

3.3.1 Definition of sample:

Sample is the reference garments corresponds to the artwork (styling) done by designer and/or developer, Particular purchase order, Any revision to the style work and conform to any specific requirement, etc.

3.3.2 Sequence of sampling

First pattern (Fit Sample/Development Sample)

↓

Second pattern (Proto Sample)

↓

Counter sample

↓

Salesman Sample

↓

Photo sample

↓

Size set sample

↓

Approval Sample (Size set, mock-up)

↓

Pre-production sample

↓

Production sample

↓

Shipping sample

3.4 CAD SECTION

3.4.1 Aim of CAD section

The main aim of CAD section is to make pattern & marker. At first CAD section receive inquiry sheet or measurement sheet from merchandiser. Then according to the measurement list they produce pattern & marker.

3.4.2 Pattern Making

Pattern is the one of important element of a design. In a garment industries there are two type of pattern uses based on their capability. Mostly big companies are use CAD (Computer aided design) as well as little companies' uses manual pattern. In BGL & BDL use CAD also manual pattern in some cases. Basically Lectra Software uses here. There are 5-6 high skilled people working here.

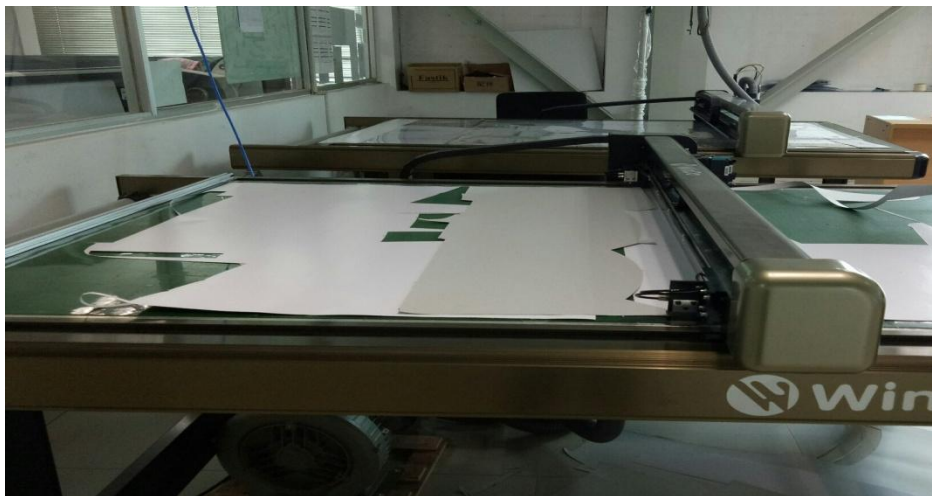


Fig4: Digital pattern making machine

3.4.3 Types of patterns

1. Working pattern: The pattern which is used to make sample garment that is called working or master pattern.
2. Production pattern: The pattern which is used for bulk production that is called production pattern.

3.4.4 Pattern grading

After developing pattern decreases or increases master pattern stepwise, it is called pattern grading. Like this-

3.4.5 Marker making

Marker is a thin paper which contains all necessary pattern pieces for all sizes for a particular style of garments. It gives special instructions for cutting. It can be done both manually & Computerized method. In UML they use computerized method.

In *UML* marker guideline is drawn in paper by AUTOCAD.



Fig5: Marker making machine

3.5 Store department

3.5.1 Definition of Store

Before starting bulk production, all of the materials and accessories are kept in the store. Store department needs to work carefully and sincerely.

3.5.2 Function of store

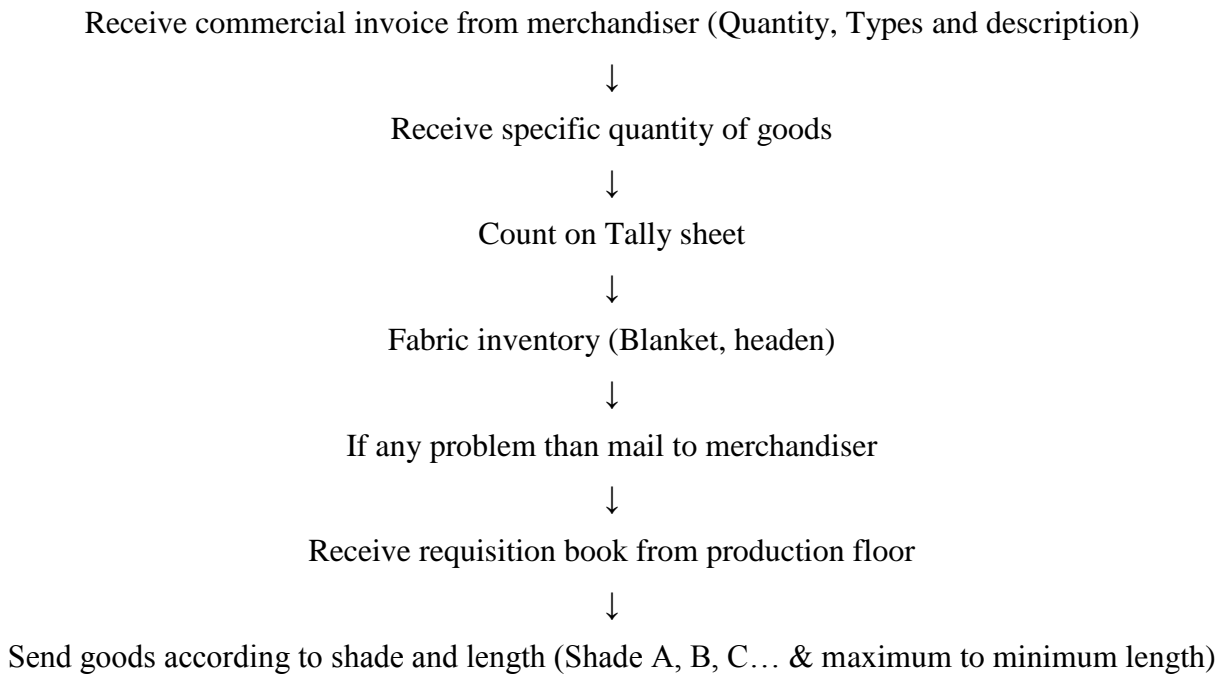
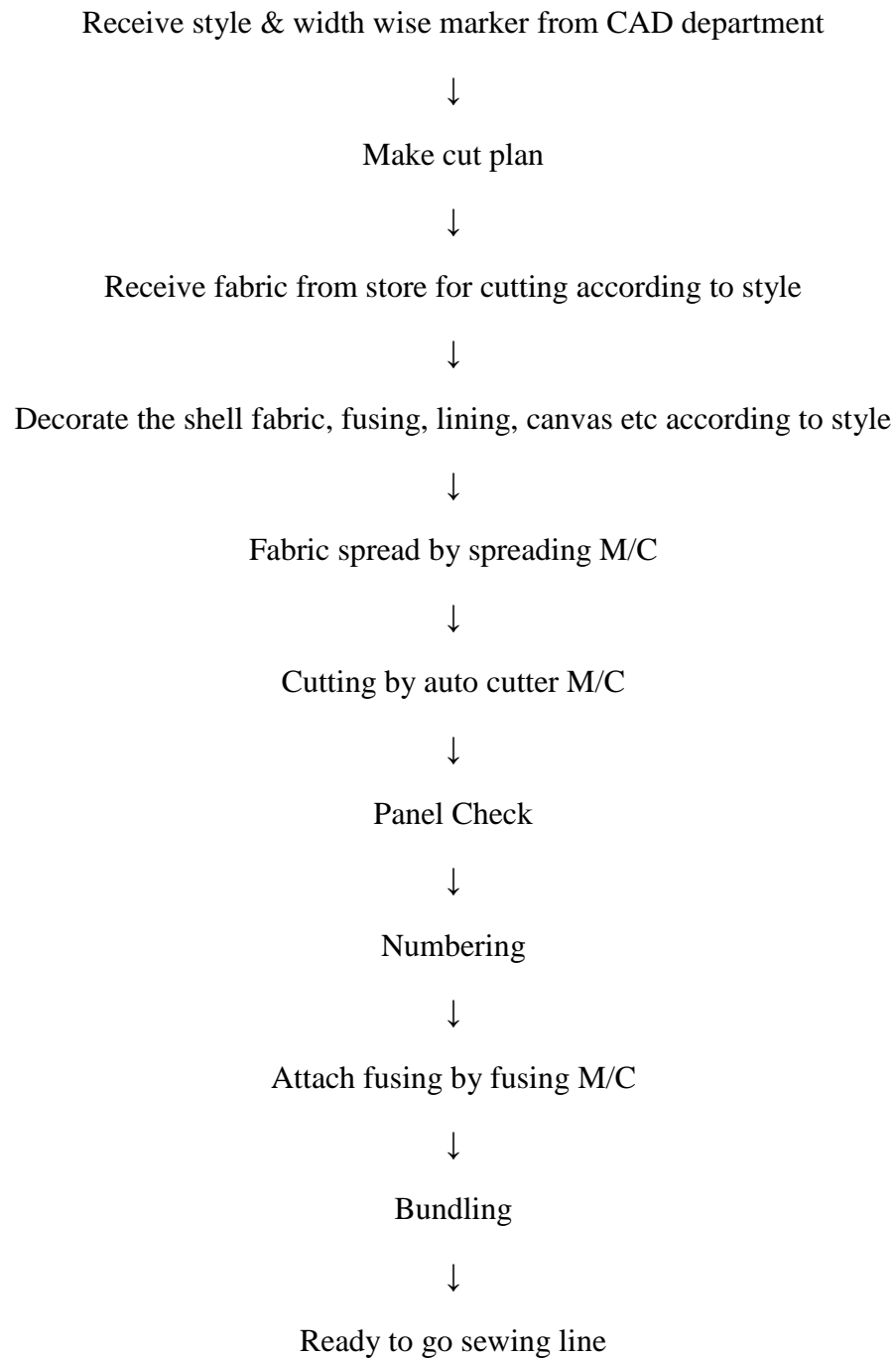


Fig 6: Keeping fabric in store

3.6 Cutting department

3.6.1 Flow process of cutting process



3.6.1 Flow process of cutting department

3.6.1.1 Pre-production meeting

- ❖ Before starting the production we have arrange an internal meeting.
- ❖ Discussed about style with a Sample, Loading plan & Buyer requirements.
- ❖ Records are maintained.



Fig 7: Cutting manager called pre-production meeting

3.6.1.2 Fabric Received from stores

- ❖ Send Requisition from cutting to stores.
- ❖ Received fabric from stores, on the basis of lay sheet & consumptions.
- ❖ Records are maintained.



Fig 8: Fabric receiving from store

3.6.1.3 Fabric Relaxation

- ❖ Fabric Relaxation depending on fabric content. Relaxation time is depended according to elastic or spandex (%) percentage.
- ❖ If it is 2% elastic then need to relax 24 hrs. If it is more than 2% need to do 48 hrs relaxations. (Records are maintained)



Fig 9: Fabric kept in trolley

3.6.1.4 Marker/ Pattern Received (CAD / Pattern making)

- ❖ Cut plan wise marker making.
- ❖ Marker making time must be follow fabric inspection report.
- ❖ After receiving the marker before lying cutting authorized QC must be check with hard pattern, size, ratio, etc.



Fig 10: Marker making

3.6.1.5 Fabric Spreading/Laying

- ❖ Must be follow laying method/Instruction.
- ❖ Marker & Fabric length/width must be follow.
- ❖ Fabric Color/Shade, Face side, way follow as trims card & counter sample.
- ❖ Cutting number, no. of plies, grain line & over lapping must be follow.
- ❖ Reports are maintained.



Fig 11: Fabric spreading

3.6.1.6 Cutting the Lay by CAM (Auto Cutter)

- ❖ Must be follow accuracy of cutting.
- ❖ Correct lay cut by correct marker.
- ❖ cutting time must be follow notched cutting
- ❖ Cutting blade is sharp.
- ❖ Lay height must be adjusted with Auto Cutter Machine.



Fig 12: Fabric cut by auto cutter machine

3.6.1.7 Numbering

- ❖ Cutting number size, serial, shade groups, ratio must be maintained.
- ❖ Before numbering suitable stickers are selected based on the fabric & lining.
- ❖ Country wise sticker must be maintained.
- ❖ Records are maintained.



Fig 13: Numbering area

3.6.1.8 Panel Checking

- ❖ Panel checked by authorized QC.
- ❖ Panel checked for find out any types of material damage & cutting damages.
- ❖ Checked Top, Middle, & Bottom panel in each bundles.
- ❖ Records are maintained.



Fig 14: Panel checking area

3.6.1.9 Panel Replacement

- ❖ Panels are replacing on same cutting & same shade fabric.
- ❖ Laying after end roll fabric keep separate cutting wise & shade wise.
- ❖ Records are maintained.



Fig 15: Panel replacement area

3.6.1.10 Fusing

- ❖ Must be maintained time, temperature, & pressure (Depended on fabric type & buyer Requirements).
- ❖ All fusing machine three times check per day.
- ❖ Bond strength also checks three times per day.
- ❖ Records are maintained.



Fig 16: Fusing area

3.6.1.11 Bundling & Input Issue to sewing

- ❖ Bundling is done cutting wise, country wise, size wise, ratio wise, & group wise.
- ❖ Input time must be follow country, size, ratio & quality.
- ❖ Records are maintained.



Fig 17: Input taking trolley

3.6.2 Capacity of cutting department

Per day jacket production: 8,000

Per day trouser production: 12,000

3.6.3 Number of Machine

Name of M/C	Number of M/C
Lectra cutting M/C	03
Lectra spreading M/C	05
Fusing M/C	06
Band Knife Cutting M/C	05

3.7 Production (Trouser)

In universal menswear limited, Blazers and Trouser is the exported product. So, trouser floor is the important section in this factor

3.7.1 Trouser floor details

- Total line: **10**
- Senior Production Manager:**1**
- Production manager:**1**
- Assistant production manager:**3**
- Line chief: **10**
- Supervisor: **40**
- Operator: **950**
- Quality check point: **3** (Input, Middle and output)

3.8 Production (Jacket)

3.8.1 Jacket floor details

- Total line: **10**
- Senior Production Manager:**1**
- Production manager:**3**
- Assistant production manager:**5**
- Line chief: **10**
- Supervisor: **50**
- Operator: **1350**
- Quality check point: **5**

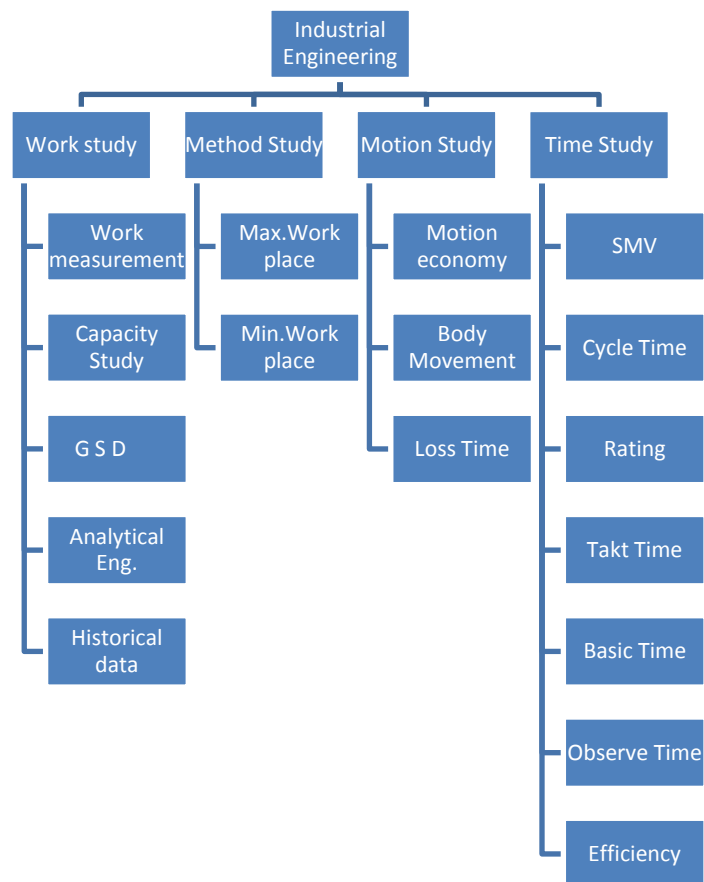
3.9 IE Department

3.9.1 What is industrial engineering?

Industrial engineers (IE) are responsible for designing integrated systems of people, machines, material, energy, and information. Industrial engineers figure out how to do things better. They engineer processes and systems that improve quality and productivity. They work to eliminate waste of time, money, materials, energy, and resources. This is why more and more companies are hiring industrial engineers and then promoting them into management positions.

Industrial engineering (IE) = production↑ cost↓ proper use of all elements↑ efficiency↑profit↑

3.9.2 Types of Industrial Engineering



3.9.3 Activities of Industrial Engineering

- Selection of processes and assembling methods.
- Selection and design of tools and equipment.
- Design of facilities including plant location, layout of building, machine and equipment.
- Design and improvement of planning and control system for production, inventory, quality and plant maintenance and distribution systems.
- Development of time standards, costing and performance standards.
- Installation of wage incentive schemes.
- Design and installation of value engineering and analysis system.
- Operation research including mathematical and statistical analysis.
- Performance evaluation.
- Supplier selection and evaluation.

3.9.4 Work Measurement related formula

♣ Standard Minutes Value (SMV) = Observe Time*Rating +15% (Allowance)

♣ Daily Target = $\frac{Manpower * 10(DailyworkingHours) * 60}{SMV} * WantedEfficiency\%$

♣ Efficiency (%) = $\frac{Output}{Input} * 100$ [Output = SMV*Pro. Quantity]

[Input = Worker*Working Hours*60]

♣ Individual Worker Target/Hr = $\frac{60}{SMV} * WantedEfficiency\%$

3.10RQS Department

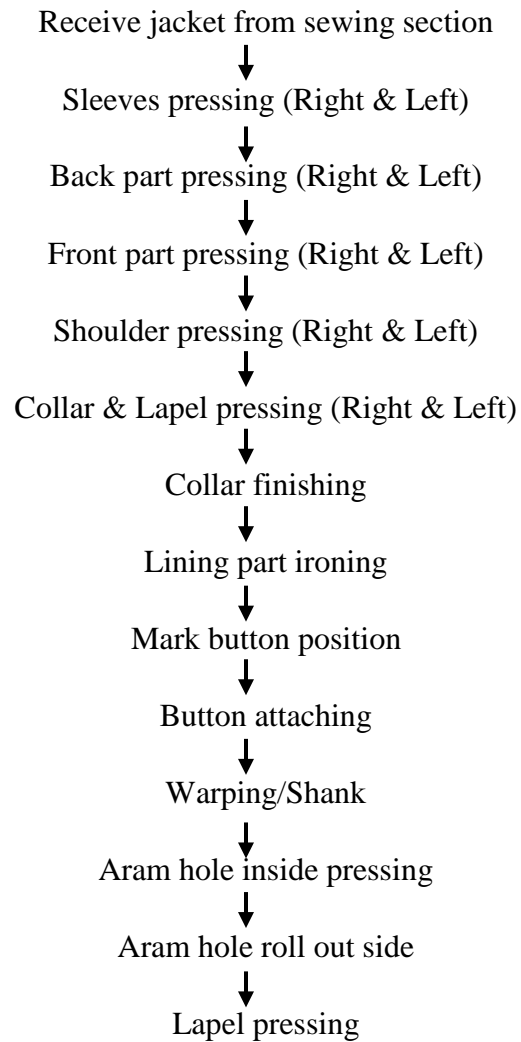
3.10.1 Function of RQS Department

RQS stands for Required Quality System. The function of this department is given below:

01. Order sheet
02. Original standard cutting (as lab department)
03. Collar continuity control report
04. Fabric supplier fabric inspection report
05. Garments supplier fabric inspection report
06. Shade band chart
07. Shrinkage chart
08. Trim card
09. Elastic wash proof
10. Pre-production report of buying office
11. Pre-production report of factory
12. Trail/in line inspection report
13. Pre final/Final inspection report
14. Accessories inspection
15. Nickel test report (trouser)
16. Ferrous test report
17. Needle detector report
18. Embroidery or printing duplicate copy
19. Rejection control

3.11 Pressing & Finishing

3.11.1 Pressing& finishing flow chart of Jacket

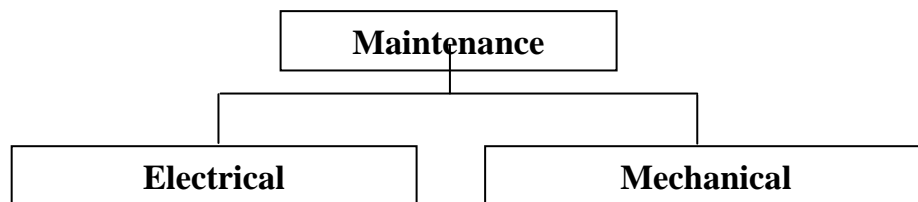


3.12 Maintenance department

3.12.1 OBJECTIVES OF MAINTENANCE

- To keep the factory plants, equipment's, machine, tools etc. in an optimum working condition
- To ensure specified accuracy to product & time schedule of delivery to customer
- To keep the down time of machines to the minimum thus to have control over the production program
- To keep the production cycle within the stipulated range
- To modify the machine tools to meet the need for production

3.12.2 TYPES OF MAINTENANCE



Electrical Section: The boiler, pressing machine, generator & all electrical line are under electrical section.

- ❖ In UML there are two fire tube boilers. Both boilers are separately 2 ton capacity. That means total capacity of this two boiler is 4 ton.
- ❖ In UML there are two generators. One is diesel generator and another is gas generator.

Mechanical Section:All sewing machines

CHAPTER 4

IMPACT OF INTERNSHIP

4.1 HR, Compliance & Admin Department

- ❖ Learned the Recruitment Policy
- ❖ Learned how an employee join in the factory
- ❖ Observed the rules and regulations of HR.
- ❖ Cleared about medical and fire safety facility.

4.2 Merchandising Department

- ❖ Learned about different types of sample
- ❖ How to purchase fabric and other accessories
- ❖ How to deal with buyer
- ❖ Observed coast negotiation
- ❖ Cleared about trim card, thread consumption and fabric consumption
- ❖ Learned how to work with team.

4.3 Sample Department

- ❖ 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 sample required to produce a garments

4.4 CAD Department

- ❖ Observed how to make a pattern
- ❖ Learned about increase marker efficiency
- ❖ Learned how they are receiving style wise sample and make pattern

4.5 Store Department

- ❖ Learned how fabric and all accessories in housed.
- ❖ Observed how to keep style wise all fabric role together
- ❖ Cleared about how they distribute their fabric and accessories in different department

4.6 Cutting Department

- ❖ Learned about different types of cutting machine
- ❖ Learned the process of fabric spreading
- ❖ Observed the process of fabric cutting according to the marker
- ❖ Understood different process of fabric lay
- ❖ Learned how numbering and bundling is done.

4.7 Sewing section

- ❖ Learned about different type of machine used in sewing floor
- ❖ Cleared the conception about production sewing
- ❖ Observed and realized the importance of final inspection at the end of every sewing line
- ❖ Learned different process of pant
- ❖ Learned how to motivate operator to do a good job

4.8 IE & Planning Department

- ❖ Learned details about SMV and how to calculate it.
- ❖ Learned how to take capacity.
- ❖ Observed about production study
- ❖ Observed how to feed line
- ❖ Learned how to make layout

4.9 RQS Department

- ❖ It is the systematic measurement, comparison with a standard, monitoring of process
- ❖ This can be contrasted with quality control, which is focused on process outputs.
- ❖ Process control.
- ❖ Process development
- ❖ Product testing

4.10 Pressing & Finishing

- ❖ Observed various types of finishing process after sewing
- ❖ Observed different types of machine used in finishing section
- ❖ Learned about different type of iron machines
- ❖ Learned about various type of accessories used to attach to the garments
- ❖ Observed the application of different chemicals for the removal of various type of stain
- ❖ Cleared the conception about different packing type and packaging ratio
- ❖ Understood the basic difference gross weight and net weight

CHAPTER 5

CONCLUSION

5.1 Conclusion

I can't but say, Industrial Attachment plays an important role in student life. As it's a large sector, I tried my level best to learn something within this short period. To complete a garments, from starting to shipment, I have learned step by step caused it will help me to find a handsome job and make my bright carrier. I tried to implement my theoretical knowledge in practice life. This attachment helped me to learn many these within short period. What I learned within this period it's not enough as the area of textile field is unlimited but it will help me to achieve my goal.