



Faculty of Engineering
Department of Textile Engineering

Topic: Different Types of Sewing Faults and Their Remedies

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A thesis submitted in partial fulfillment of the requirements for the degree of Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology

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Letter of Approval

Date:09-10-2021

To

The Head

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102, Shukrabad, Mirpur Road, Dhaka 1207

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

Dear Sir,

Assala-mu-alaikum sir! I am simply writing to tell you that this task report titled as "Study on Different Types of Sewing Faults and Their Remedies" has been set up by the under study bearing ID 191-23- 5523 and 191-23-5505 and 191-23-5522 is finished for definite assessment. The entire report is readied in light of the best possible examination at Alliance Knit Composite Ltd. Furthermore, intrusion through basic examination of observational information with required possessions. The under study were straight forwardly associated with their undertaking exercises.

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

Yours Sincerely



Mohammad Abdul Baset

Assistant Professor

Department of Textile Engineering

Daffodil International University

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Alhamdulillah! At first, we express our heartiest thanks and gratefulness to almighty Allah for his divine blessing which makes possible to complete this project successfully.

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‘**Md. Moklesure Rahman of IE Section in KAC Fashion Wear Ltd.**’ were very vital in the completion of this project, their guidance and encouragement played a key role in the planning and completion of this project.

Finally, we express our sincere gratitude to our parents and friends for their continuous support, ideas and love during our studies.

ABSTRACT

This project is ‘Study on sewing problem and their remedies’ of “KAC Fashion Wear Ltd.” Garment manufacturing is quite different from any other conventional manufacturing. It is not a continuous production method. Each style is a different product that requires a different type of fabric, color, buttons, thread, etc. Sewing process is one of the most important stages in labor intensive ready-made clothing enterprises. Quality faults occurring during this process adversely affect the product quality and product efficiency, and also increase the production cost. The aim of this study is to investigate whether the knit production process is under control in a knit production enterprise and to detect the processes with the highest rates of sewing faults in sewing department and finally to make suggestions for improving the quality control. Also, the processes with highest amounts of sewing faults and the effects of these processes on fault rates were investigated.

Finally after 7 Days end line inspection inspector inspect Total 3,330 pitches of garments, 2,633 pitches quality passed, 21 pitches rejects, and 565 defects and alter 650 pitches. Here, Pass gmts percentage 52%, Defects percentage 10.5%, Reject percentage 0.64%, Alter percentage 11.25% and After 7 Days end line inspection inspector inspect total 448 defects found. Here, 7 Days end line inspection Reports most defects are-Uncut Thread 33, Broken Stc 46, Raw edge 71, Up down 67, Skip Stc 47, Pleat 52, Join stc 28, Open seam 65. Finally, we have found different types of sewing faults by Sewing machine and operator. We are also mentioning remedies for specific reasons which all are included in this project report. We also included some end line inspection report of **“KAC Fashion Wear Limited.**

DECLARATION

we hereby declare that, this report has been done under the supervisor of Mohammad Abdul Baset, Assistant Professor, Department of Textile, Daffodil International University. I also declare that neither this internship report nor any part of this internship report has been submitted elsewhere for award of any degree.

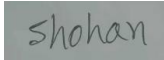
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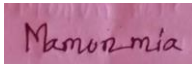
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Chapter-1

Introduction

1.0 Introduction

This section of sewing is the most important part of apparels factory. Maximum faults are arise here which hamper the total quality of the apparels. We just see the some common types of sewing faults of readymade apparel factory which are explained in this article with their causes and remedies.

1.1 Objectives of the Study

- To identify the causes of sewing fault and solve this.
- To implement technical solutions toward thread defects
- To know about proper quality management system.
- To create new method of quality control.
 - To know how to analyze a garment effectively and efficiently.
- To show how technical know-how can increase production efficiency.
- To minimize sewing fault from garments.
- To improve quality of garments.

1.2 Importance of the Study

In this unit we can save our coast. This article clarifies the reasons for sewing shortcomings in instant pieces of clothing. Sewing shortcomings are an issue generally looked by piece of clothing producers. Regardless of it being an exceptionally basic issue, it is extremely hard to dispose of it totally. A few parts of the sewing flaw arrangement, its causes, and assurance and cures are talked about in this article. The creator noticed that it is extremely hard to dispense with flaws totally. The inquiries whether the level of a blame is adequate or not depends to a great extent on the sort of article of clothing, area of the crease, appearance. Quality flaws happening amid this procedure unfavorably influence the item quality and item proficiency, and furthermore increment the generation cost. The point of the examination is to research how to control quality in piece of clothing generation and make proposals for enhancing the quality control. By this examination, we showed that the examination of every quality control process would make a noteworthy commitment to create a quality piece of clothing and get ready more compelling in the change designs.

1.3 Background of the Study

The biggest and the most essential segment in an article of clothing industry is its sewing segment. In this segment, every last sewing machine and occupations of machine administrators ought to be assessed on a normal reason for recognizing, revising and controlling of flaws and keeping up nature of items. To guarantee the nature of the item, quality control faculty need to control quality in an alternate area in piece of clothing industry, which are specifically or in a roundabout way required with creation. Quality is the distinction between items. It is the integrity or disagreeableness in an item. This definition remains constant till this date. The Garment additionally assumes an essential part in the general public. For create great article of clothing we have to keep up quality and quality relies upon sewing course of action of piece of clothing.

Chapter- 2

Literature Survey

2.1 What is Sewing Faults

In textile and Apparel industry sewing is one of the major processes in apparel production. It plays an important role in maintaining the quality of clothes. Hence it is important that all defects have to be avoided during sewing any apparel. In this paper, faults or defects that can take place during sewing along with different remedies to solve these defects are discussed.

2.1 Sewing:

The basic process of sewing involves fastening of fabrics, leather, furs or similar other flexible materials with the help of needle and threads. Sewing is mainly used to manufacture clothing and home furnishings. In fact, sewing is one of the important processes in apparel making. Most of such industrial sewing is done by industrial sewing machines. The cut pieces of a garment are generally tacked, or temporarily stitched at the initial stage. The complex parts of the machine then pierces thread through the layers of the cloth and interlocks the thread.

2.2 Sewing faults causes & their remedie:

Sewing faults can be classified as three groups given below

- Problems of stitch formation.
- Problem of pucker.
- Damage of fabric on seam line.

2.2.2 There are mainly three types of sewing defects:

- Problem of stitch formation.
- Due to fabric distortion.
- Due to fabric damage along seam line.

Due to various reasons, the stitches may be in different shapes and appearances instead of being in the shapes and appearances that should have been. About the various types of sewing faults, problem reasons and the means of solution are discussed below:-

- Uncut thread.
- Skip Stitch.
- Slipped Stitch.
- Staggered Stitch.
- Unbalanced Stitch.
- Variable Stitch Density.
- Puckering.
- Uneven.
- Slanted.
- Broken stitch.
- Dirt marks.
- Open seam.

2.3 Types of Faults:

There are two main types of faults:-

1. Non-Sewing faults.
2. Sewing faults.

Faults may occur in garments any garments industry on mass scale. The source of defects are given below:-

2.4 Non-sewing faults:

1. Defect due to wrong pattern. •
Defect due to wrong cutting.
2. Defect due to poor handling of goods.
3. Defect due to oil marks. • Defects due to wrong ironing, folding, and packing.

2.2 Sewing Machine:

A sewing machine is a mechanical or electromechanical device equipped with a needle (or needles) threaded at the point-end, which puncture the fabric periodically as it moves under the needle. Each stitch is created as the thread loops onto itself (chain stitch) or locks around a second strand of thread (lock stitch), sewing the fabrics together.

Sewing machines are used in both the home and industry, but are designed differently for each setting. Those for the home tend to be more versatile in terms of the number and kinds of stitches they can perform, but they operate more slowly than industrial machines, and have a shorter life span. Industrial machines are heavier, have a much longer life span, are capable of thousands of stitches per inch, and may be designed for very specialized tasks.



Figure 2.2.1 Sewing Machine

2.3 History of Sewing Machine:

Sewing as long as 20,000 years ago, during the last Ice Age. It was over 1500 years later in 1790, that the first workable sewing machine was invented and patented by the British inventor Thomas Saint. Earlier, in 1755, Karl Weisenthal, a German inventor, devised the first sewing machine needle, but did not produce a complete machine. Saint's machine, which was designed to sew leather and canvas, mainly on boots, used only a single thread and formed a chain stitch. Instead of a needle, an awl was employed to pierce a hole through the material being sewed. Another mechanism placed the thread over the hole, and then a needlelike rod with a forked point carried the thread through to the underside of the work, where a hook caught the thread and moved it forward for the next stitch. When the cycle was repeated, a second loop was formed on the underside of the cloth with the first loop, thus forming a chain and locking the stitch. Saint's machine, however, never progressed beyond the patent model stage. And it overlooked the Weisenthal needle design.

machine for an English corset-maker. He returned penniless to find that sewing machines were being sold by many manufacturers, all infringing on some part of his 1846 patent. In 1856, after favorable litigation, Howe entered into the world's first patent pool. In 1851, Isaac M. Singer (1811-75) patented the first rigid-arm sewing machine. Before this, all machines employed an overhanging arm that held the needle directly and vibrated with it. Singer's machine also included a table to support the cloth horizontally, instead of a feed bar; a vertical presser foot to hold the cloth down against the upward stroke of the needle, and an arm to hold the presser foot and the vertical needle-holding bar in position over the table. A real breakthrough was his invention of a foot treadle instead of a hand crank. Parts of Singer's new machine were based on Howe's work. In fact, Singer was sued by Howe for infringement of the latter's patent rights, but a compromise was reached where Singer paid a royalty.

2.4 Types of Sewing Machine:

In accordance with operating system there are two types of sewing machines are available in the apparel industry. They are given below:

- A. Manually operated sewing m/c
- B. Electrically operated sewing m/c
 - Lock stitch m/c (2-needle with spilt needle bar sewing)
 - Lock stitch m/c (single needle sewing m/c)
 - Lock stitch m/c (single needle with automatic thread trimmer)
 - Over edging machine
 - Over lock m/c (1-needle, 3-thread)
 - Over lock/Over edge sewing m/c (twin needle, 4-thread m/c)
 - Automatic multi-needle shirring machine
 - Top & bottom cover stitch flat lock machine (cylinder bed and flatbed)
 - Bar tack sewing m/c (with automatic thread trimmer)
 - Button attaching machine
 - Button hole sewing m/c (for knit fabric)
 - Chain stitch sewing machine
 - Collar and cuff turning and blocking machine
 - Double chain stitch m/c
 - Double chain stitch sewing m/c (4- needle elastic inserting m/c)
 - Double chain stitch sewing machine (4- needle short)
 - Interlock m/c (twin needle, 5-thread over lock m/c)
 - Label/elastic inserting machine
 - Lock stitch m/c (1-needle with vertical trimmer wiper & reverse feed)



2.4.1 Over lock sewing machine



Figure 2.4.2 Flat Lock sewing machine

1. Skip stitch:

Causes-

- If the sewing thread is unable to form a loop.
- Irregular thread tension on the upper or lower loop.
- Due to needle deflection.
- If needle thread loop is too small.

Remedies-

- The needle should be changed.
- Needle size and thread should be adjusted.
- The thread should be changed.
- The tension of the thread should be adjusted.



Figure 2.4.3 Skip Stitch

2. Seam Puckering:

Seam puckering is common problem on woven or knits fabric. Seam puckering mention to the gathering of a seam during or after laundering, causing not proper seam appearance.

Cause:

- Spreading of sewing thread.
- Construction of fabric.
- Uneven patterns.
- Shrinking sewing threads.

Remedies:

- Proper feed mechanism should be used with equal ply stretch.
- Fabric shrinkage exactly must be almost similar.
- Fabric and sewing thread shrinkage presentence should be equal.

Using less tension to the thread.



Figure 2.4.4. Seam Puckering

3.Broken stitch:

When stitches are broken during sewing is called broken stitch.

Cause-

- It appears due to improper trimming or machine usage.

Remedies-

- Make sure the proper stitch balance is being used.
- Use needle with appropriate needle point.

Tension and threading should not be fiddled with much



Figure 2.4.5 Broken Stitch

4. Slipped Stitch:

Stitches in the seam line are present in a regular wise. If the interloping or interlacing between top and bottom thread of stitch is not take place or missed is known as slipped stitch.

Causes-

- Due to needle deflection.
- If needle thread loop is too small.
- Irregular thread tension on upper or lower loop.

Remedies-

- Needle to be changed.
- Needle size and thread size must be adjusted.



Figure 2.4.6 Slipped stitch

5. Uncut thread:

This sewing fault is one of the major problems in apparel sewing. Extra thread on seam line.

Causes-

- It appears due to improper trimming or finishing.

Remedies-

- Garments finishing should be checked properly
- Thread trimmer should be used.
- Operator training.



Figure 2.4.7 Uncut thread

6. Oil Spot:

Causes:

During sewing process if oil and wax are deposit from the machine to the fabric surface then oil spot is occurred. It's creating a unfear spot image on the fabric surface.

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



Figure 2.4.8 Oil spot

7.Open seam:

Portion of the garment that has not been covered by sewing thread.

Causes-

- Improper handling of the parts of garments.
- Improper setting and timing between needle and looper or hook. Remedies-
- Clear markings for stitch line.
- Tension should be quantifiable



Figure 2.4.9 Open seam

8.Needle Mark:

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

Causes:

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

Remedies:

- To cure any types of sewing faults.
- To ironing at good temperature and uniform.



Figure 2.5.0 Needle Mark

9 Uneven Stitch:

If any seam line is not uniform and two line of stitch are not to be regular or actual measurement are missing in the garments seam that called Uneven Stitch.

Causes:

- Because of the lack of experience or concentration of worker.
- Sometime for the machine problem.

Remedies:

- Seam is open and sewing again exactly.
- If machine measurement problem then solve it.



Figure 2.5.1 uneven stitch

10.Variable stitch density:

- More tension to the thread.
- Fraying of thread in the needle.
- Becoming more heated of thread.
- Becoming more heated of hook.
- Use of low quality threads.

- Improper unwinding of thread from package during sewing.
- Twisting of needle thread in the bottom of thread package.
- Twisting of thread in the thread guide. Snarling of thread before tension disk.
- The position of thread guide must be 2.5 times higher than the position of thread package.

- The edges must be smooth, and needle must be changed as needed.
- Finer threads must be used or to be used heavy needle.
- High quality needle must be used.
- Lubricant must be available.
- Thread to be change.
- Foam pad must be used to the bottom of thread package.
- Proper threading of sewing thread during sewing.

11.Unbalanced Stitch.

This type of defect is found in lock stitch machine. If the interlacement of threads are not take place in the middle (i.e. if the interlacement is taken place in the upper or lower position from the middle) of two layers of fabric then it is known as unbalance stitch.

Causes-

- Use of right thread path.
- Setting of proper tension to the sewing thread.
- Proper care to the twisting of the thread during sewing.
- Used wrong thread path.
- Wrong tension of sewing thread.
- Wrong adjustment of needle thread path. Remedies



Figure 2.5.2 Unbalanced Stitch

Chapter: 03

Experimental Details

3.0 About Experimental Data:

A factory should set different modern quality procedures and quality management technique for the betterment of RMG sector.

I have collected some data in KAC Fashion Wear Ltd. Then I calculated defects percentage from different types of defects found in sewing section. Broken stitch, uneven stitch, seam puckering, open seam, needle holes etc. are the most common defects found in sewing section.

Data Analysis:

For data analysis must have an idea about DHU. DHU means “Defect per Hundred Units”.

It means number of defects found per 100 garments.

$$DHU = (\text{Total defects found} / \text{Total inspection of garments}) * 100$$

3.1 End Line Inspection Report- 1

Sewing Line 01 in KAC: A copy of End of The End Line Inspection report is attached that we have collected from the KAC

2 KAC ☐ KAC FASHION WEAR LTD. ☐ KAC COMPOSITE KNIT IND. LTD.

In Process Inspection Report

Client: **MONAF** **BS COLOUR** **5001** **20-1-2022** **SEWING** **BLACK** **NECK RIB JOINT**

Line	Operation	Machine	Tool	Material	Time	Yield	Defect	Remarks
1	1.1	1.1	1.1	1.1	1.1	1.1	1.1	1.1
2	2.1	2.1	2.1	2.1	2.1	2.1	2.1	2.1
3	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
4	4.1	4.1	4.1	4.1	4.1	4.1	4.1	4.1
5	5.1	5.1	5.1	5.1	5.1	5.1	5.1	5.1
6	6.1	6.1	6.1	6.1	6.1	6.1	6.1	6.1
7	7.1	7.1	7.1	7.1	7.1	7.1	7.1	7.1
8	8.1	8.1	8.1	8.1	8.1	8.1	8.1	8.1
9	9.1	9.1	9.1	9.1	9.1	9.1	9.1	9.1
10	10.1	10.1	10.1	10.1	10.1	10.1	10.1	10.1
11	11.1	11.1	11.1	11.1	11.1	11.1	11.1	11.1
12	12.1	12.1	12.1	12.1	12.1	12.1	12.1	12.1
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53	53.1	53.1	53.1	53.1	53.1	53.1	53.1	53.1
54	54.1	54.1	54.1	54.1	54.1	54.1	54.1	54.1
55	55.1	55.1	55.1	55.1	55.1	55.1	55.1	55.1
56	56.1	56.1	56.1	56.1	56.1	56.1	56.1	56.1
57	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1
58	58.1	58.1	58.1	58.1	58.1	58.1	58.1	58.1
59	59.1	59.1	59.1	59.1	59.1	59.1	59.1	59.1
60	60.1	60.1	60.1	60.1	60.1	60.1	60.1	60.1
61	61.1	61.1	61.1	61.1	61.1	61.1	61.1	61.1
62	62.1	62.1	62.1	62.1	62.1	62.1	62.1	62.1
63	63.1	63.1	63.1	63.1	63.1	63.1	63.1	63.1
64	64.1	64.1	64.1	64.1	64.1	64.1	64.1	64.1
65	65.1	65.1	65.1	65.1	65.1	65.1	65.1	65.1
66	66.1	66.1	66.1	66.1	66.1	66.1	66.1	66.1
67	67.1	67.1	67.1	67.1	67.1	67.1	67.1	67.1
68	68.1	68.1	68.1	68.1	68.1	68.1	68.1	68.1
69	69.1	69.1	69.1	69.1	69.1	69.1	69.1	69.1
70	70.1	70.1	70.1	70.1	70.1	70.1	70.1	70.1
71	71.1	71.1	71.1	71.1	71.1	71.1	71.1	71.1
72	72.1	72.1	72.1	72.1	72.1	72.1	72.1	72.1
73	73.1	73.1	73.1	73.1	73.1	73.1	73.1	73.1
74	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1
75	75.1	75.1	75.1	75.1	75.1	75.1	75.1	75.1
76	76.1	76.1	76.1	76.1	76.1	76.1	76.1	76.1
77	77.1	77.1	77.1	77.1	77.1	77.1	77.1	77.1
78	78.1	78.1	78.1	78.1	78.1	78.1	78.1	78.1
79	79.1	79.1	79.1	79.1	79.1	79.1	79.1	79.1
80	80.1	80.1	80.1	80.1	80.1	80.1	80.1	80.1
81	81.1	81.1	81.1	81.1	81.1	81.1	81.1	81.1
82	82.1	82.1	82.1	82.1	82.1	82.1	82.1	82.1
83	83.1	83.1	83.1	83.1	83.1	83.1	83.1	83.1
84	84.1	84.1	84.1	84.1	84.1	84.1	84.1	84.1
85	85.1	85.1	85.1	85.1	85.1	85.1	85.1	85.1
86	86.1	86.1	86.1	86.1	86.1	86.1	86.1	86.1
87	87.1	87.1	87.1	87.1	87.1	87.1	87.1	87.1
88	88.1	88.1	88.1	88.1	88.1	88.1	88.1	88.1
89	89.1	89.1	89.1	89.1	89.1	89.1	89.1	89.1
90	90.1	90.1	90.1	90.1	90.1	90.1	90.1	90.1
91	91.1	91.1	91.1	91.1	91.1	91.1	91.1	91.1
92	92.1	92.1	92.1	92.1	92.1	92.1	92.1	92.1
93	93.1	93.1	93.1	93.1	93.1	93.1	93.1	93.1
94	94.1	94.1	94.1	94.1	94.1	94.1	94.1	94.1
95	95.1	95.1	95.1	95.1	95.1	95.1	95.1	95.1
96	96.1	96.1	96.1	96.1	96.1	96.1	96.1	96.1
97	97.1	97.1	97.1	97.1	97.1	97.1	97.1	97.1
98	98.1	98.1	98.1	98.1	98.1	98.1	98.1	98.1
99	99.1	99.1	99.1	99.1	99.1	99.1	99.1	99.1
100	100.1	100.1	100.1	100.1	100.1	100.1	100.1	100.1

Inspector: **Monaf** **20-1-2022**

Figure 3.1.1 End Line Inspection Report- 1

KAC Fashion Wear Ltd.

Date: 20-01-2022 Order No: 312532

Color:Black

Buyer: MAX
Style No: 5001

Sewing Line: 01
Inspector: Monaf

Hours	1 st	2 nd	3 rd	4 th	5 th	6 th	7 th	8 th	9 th	10 th	Total
Missing	1				1	3	2	1	1	3	12
Wrong placement		1		1			1		1		4
Broken/ open stich	2	1	7	6		4	3	2	1	2	27
Pleat		1	2		2	1	2		1	2	10
Bad tension											
High low		3	4	6		2		1			16
Puckering	1	1				2					4
Uneven	1			1	1		1			2	6
Needle cut											
Skip			1	1		2					4
Wavy											
Raw edge	2	1	3	2	1	4	3		2	4	24
Uncut loose thread	3	2	7	5	2	7	3	4	6		39
Measurement t deviation											

Size mistake											
Fabric spot											
Reject	-	1	1	-	-	-	1	-	1	-	4

Damage											
Total=	9	14	11	21	7	18	24	7	9	19	139
Total check gmts	80	80	139	104	123	145	160	158	185	532	1706
Total pass gmts	80	70	110	80	90	120	100	130	166	220	1146
Total defectives gmts	15	12	25	20	30	17	10	20	15	40	204
Total Defects qty	15	12	25	20	30	17	10	20	15	40	204
DHU%	11.6 %	8 %	12.5 %	23 %	3.28 %	11.03 %	7.5 %	6.32 %	4.51 %	3.32 %	8.46 %
Defective rectified qty	8	14	29	22	5	17	11	9	8	19	133
Defective balance qty	7	3+2	2+2	2+2	2+1	1+1	1+2	2+2	2+1	2+2	4
Rectify defective check & pass	12	12	27	19	4	18	9	9	8	21	1139

Table 3.1 End Line Inspection Report- 1

DHU= (Total defects found/Total inspection of garments)*100

Here, at line (01) my observation date was 07/12 /21. At this time the buyer was KAC. The item was SHORT PANT. In this line there was 19 worker with 16

In this way, total 1706 pcs of garments checked in our 10hrs observation. Here I totally found 204 pitches of defective garments where 200 pitches are altered and 4 pitches are rejected.

3.2 End Line Inspection Report- 2

Sewing Line 02/3 in KAC: A copy of End of The End Line Inspection report is attached that we have collected from the KAC

KAC FASHION WEAR LTD.
KAC COMPOSITE KNIT IND. LTD.
 In Process Inspection Report

Client: **M/S SHAKIL**
 Line: **02/03**
 Style: **GARGIA**
 Date: **02/03/2022**
 PO: **17772**

Section: **SEWING**
 Item: **WAIST BAND JOINT**

Item	Quantity	Accepted	Rejected	Remarks
1	100	96	04	
2	100	96	04	
3	100	96	04	
4	100	96	04	
5	100	96	04	
6	100	96	04	
7	100	96	04	
8	100	96	04	
9	100	96	04	
10	100	96	04	
11	100	96	04	
12	100	96	04	
13	100	96	04	
14	100	96	04	
15	100	96	04	
16	100	96	04	
17	100	96	04	
18	100	96	04	
19	100	96	04	
20	100	96	04	
21	100	96	04	
22	100	96	04	
23	100	96	04	
24	100	96	04	
25	100	96	04	
26	100	96	04	
27	100	96	04	
28	100	96	04	
29	100	96	04	
30	100	96	04	
31	100	96	04	
32	100	96	04	
33	100	96	04	
34	100	96	04	
35	100	96	04	
36	100	96	04	
37	100	96	04	
38	100	96	04	
39	100	96	04	
40	100	96	04	
41	100	96	04	
42	100	96	04	
43	100	96	04	
44	100	96	04	
45	100	96	04	
46	100	96	04	
47	100	96	04	
48	100	96	04	
49	100	96	04	
50	100	96	04	
51	100	96	04	
52	100	96	04	
53	100	96	04	
54	100	96	04	
55	100	96	04	
56	100	96	04	
57	100	96	04	
58	100	96	04	
59	100	96	04	
60	100	96	04	
61	100	96	04	
62	100	96	04	
63	100	96	04	
64	100	96	04	
65	100	96	04	
66	100	96	04	
67	100	96	04	
68	100	96	04	
69	100	96	04	
70	100	96	04	
71	100	96	04	
72	100	96	04	
73	100	96	04	
74	100	96	04	
75	100	96	04	
76	100	96	04	
77	100	96	04	
78	100	96	04	
79	100	96	04	
80	100	96	04	
81	100	96	04	
82	100	96	04	
83	100	96	04	
84	100	96	04	
85	100	96	04	
86	100	96	04	
87	100	96	04	
88	100	96	04	
89	100	96	04	
90	100	96	04	
91	100	96	04	
92	100	96	04	
93	100	96	04	
94	100	96	04	
95	100	96	04	
96	100	96	04	
97	100	96	04	
98	100	96	04	
99	100	96	04	
100	100	96	04	

Inspector: **Lat**
 Date: **02/03/2022**

Figure 3.2.1 End Line Inspection Report- 2

KAC Fashion Wear Ltd.

Sewing Line: 02/3			Inspector Name:Sakil				Color: Blue				
Buyer:Garcia			Date: 19-01-2022				Style:022735				
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Total check gmts	90	133	162	225	220	122	143	62	65	444	1630
Total pass gmts	100	110	120	200	200	100	100	50	50	270	1300
Total defectives gmts	24	23	29	23	19	22	22	20	22	110	314
Total defects qty	25	23	30	23	20	23	22	20	22	110	218
Rectify defective gmt check & pass	22	22	28	22	18	20	21	20	22	110	305
Rectify Qty	24	23	29	23	19	22	22	20	22	110	314
Reject		1	2		3	3	1	2	2	6	16
Name Of Defects:											
Broken Stc.	4	2	1	2	1	2	4	1	2	10	29
Skip Stc.	3	2	2	1	2	3	2	2	1	11	26
Join Stc.	4	3	1	2	1	4	2	1	2	8	28
Raw edge	4	3	1	1	1	1	3	2	1	11	25
Uneven Stc.	2	1	2	2	1	1	1	1	2	3	18
Puckering											
Up & Down	4	3	4	3	2	2	2	1	1	2	24
Size mistake	3	1	2	1	1	4	1	1	1	2	17
Twisting											
Shading											
Fabric fault	1										1
Poor iron											
Without process											
Bartack problem	-	2	3	2	1	2	-	3	3	10	26
Hook bar											
Uncut thread	2	1	2	1	2	1	2	1	1	9	22
Dirty spot	2	1	2	2	1	2	2	2	3	9	26
Oil stain		2	3	2	2	3	3	2	1	7	25

		-	-		-		-	-	-	-	
Pleat	3	2	4	3	2	3	1	1	3	9	31
Reverse											
Open seam	5		4	4	1	2	3	2	6	7	34
Needle mark											
Down stc.	1	1		2	2	3	1		2	6	18
Tack problem	3	2	1		1	2	1	1	2	6	19
Contamination											
1 st Highest		Def Qty		2 nd Highest		Def Qty		3 rd Highest		Def Qty	
Open seam		28		Skip stitch		27		Broken stitch		30	

Table 3.2 End Line Inspection Report- 2

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

$$= (25/125)*100$$

$$= 23\%$$

The Table 4.2 can see that, at sewing line (02) our observation date was 01-12-2021. The buyer was as colour. Total worker or operator worked at sewing line (03) was 29 with 14 helpers and 2 QC operators. From our observation I found that from 8am-8 pm they check 1630 pcs of garments and there have been total 218 defects.

In this way, total 1630 pcs of garments checked in our 10hrs observation. Here I totally found 314 pitches of defective garments where 202 pitches are altered, 16 and pitches are rejected.

3.3 End Line Inspection Report- 3

Sewing Line 06/7 in KAC: A copy of End of The End Line Inspection report is attached that we have collected from the KAC

KAC FASHION WEAR LTD.
KAC COMPOSITE KNIT IND. LTD.

In Process Inspection Report

CL Name: **MD-MOTION**
Line: **6/7**
Model: **NATEX**

Style: **P0333 52** No: **201216**

Date: **26.01.2022**
Inspector: **S. K. KINGS**
Color: **JADE GREEN**
Size: **PANT**

Item	Inspection	Quantity	Unit	Remark
1	100	100	100	
2	100	100	100	
3	100	100	100	
4	100	100	100	
5	100	100	100	
6	100	100	100	
7	100	100	100	
8	100	100	100	
9	100	100	100	
10	100	100	100	
11	100	100	100	
12	100	100	100	
13	100	100	100	
14	100	100	100	
15	100	100	100	
16	100	100	100	
17	100	100	100	
18	100	100	100	
19	100	100	100	
20	100	100	100	
21	100	100	100	
22	100	100	100	
23	100	100	100	
24	100	100	100	
25	100	100	100	
26	100	100	100	
27	100	100	100	
28	100	100	100	
29	100	100	100	
30	100	100	100	
31	100	100	100	
32	100	100	100	
33	100	100	100	
34	100	100	100	
35	100	100	100	
36	100	100	100	
37	100	100	100	
38	100	100	100	
39	100	100	100	
40	100	100	100	
41	100	100	100	
42	100	100	100	
43	100	100	100	
44	100	100	100	
45	100	100	100	
46	100	100	100	
47	100	100	100	
48	100	100	100	
49	100	100	100	
50	100	100	100	
51	100	100	100	
52	100	100	100	
53	100	100	100	
54	100	100	100	
55	100	100	100	
56	100	100	100	
57	100	100	100	
58	100	100	100	
59	100	100	100	
60	100	100	100	
61	100	100	100	
62	100	100	100	
63	100	100	100	
64	100	100	100	
65	100	100	100	
66	100	100	100	
67	100	100	100	
68	100	100	100	
69	100	100	100	
70	100	100	100	
71	100	100	100	
72	100	100	100	
73	100	100	100	
74	100	100	100	
75	100	100	100	
76	100	100	100	
77	100	100	100	
78	100	100	100	
79	100	100	100	
80	100	100	100	
81	100	100	100	
82	100	100	100	
83	100	100	100	
84	100	100	100	
85	100	100	100	
86	100	100	100	
87	100	100	100	
88	100	100	100	
89	100	100	100	
90	100	100	100	
91	100	100	100	
92	100	100	100	
93	100	100	100	
94	100	100	100	
95	100	100	100	
96	100	100	100	
97	100	100	100	
98	100	100	100	
99	100	100	100	
100	100	100	100	

Inspector: **S. K. KINGS**
Date: **26.01.2022**

Figure 3.3.1 End Line Inspection Report- 3

KAC Fashion Wear Ltd.

DAILY END-LINE INSPECTION REPORT

Date: 20-01-2022 Order No: 201213

Color: jade Green

Buyer: Natex

Sewing Line: 6/7

Hours	1 st	2 nd	3 rd	4 th	5 th	6 th	7 th	8 th	9 th	10 th	Total
Missing	3	1		2	1		1	1	1		10
Wrong placement		1									1
Broken/ open stich		1			2	1		1		3	8
Pleat	1	2	1	1	2	2	1		1	3	14
Bad tension											
High low			1	1			2				4
Puckering	2		1		2	1	1	1	1	1	10
Uneven	2		1	1	1		3		2	1	11
Needle cut											
Skip	1				1				1		3
Wavy											
Raw edge	1		2		1	3	1	1		3	12
Uncut loose thread	2	3	4	2	1	3		2	1	3	21

Flying Spot											
Damage		1									1
Total=	10	8	14	5	8	4	10	3	12	21	95
Total check gmts	114	159	122	201	166	133	115	126	105	388	1659
Total pass gmts	120	15	120	103	160	130	110	120	100	380	1220
Total defectives gmts	8	9	6	3	8	5	4	7	4	16	84
Total Defects qty	9	13	7	6	5	9	4	9	4	22	88
DHU%	11 %	8.5 %	6 %	4.56 %	4.81 %	4.14 %	5.21 %	6.25 %	5.71 %	9.55 %	8.25 %
Defective rectified qty	—	14	11	6	9	8	7	7	6	20	86
Defective balance qty	13	4+2	2+2	2+2	1+2	1+2	1+2	2+2	2+2	2+2	6
Rectify defective check & pass	8	4	9	4	13	3	9	2	4	12	80
Reject	—	2	—	1	—	1	—	—	-	—	4

Table 3.3 End Line Inspection Report- 3

Total no of defective products

$DHU\% = (Total\ no\ of\ checked\ products) \times 100 = 6.36\%$

1st Highest Defect s= Uncut loose treat 21pcs

2nd Highest

Defects= Missing 10pcs 3rd

Highest Defects = Uneven

11pcs

Total Pieces checked =1659

Total Defects =84

. Here, at line (03) my observation date was 03/11/21 At this time the buyer was Garcia The item. In this line there was 22 worker with 12 helper and 2 quality control operator. I observed that line from 8-8pm and they checked 1659pcs of garments and there was total 88 defects.

Like this way, total 1659pcs of garments checked in 12hours observation. Here I totally found 88 pcs of defective garments and there is no rejection.

Here, the list of defects below I found at line (3)

- Missing=10
- Broken stich=8
- Pleat=14
- High low=4
- Uneven=11
- Skip=3
- Raw edge=12
- Uncut loose treat=21

3.4 End Line Inspection Report- 4

Sewing Line 04/5 in KAC: A copy of End of The End Line Inspection report is attached that we have collected from the KAC

KAC FASHION WEAR LTD.
KAC COMPOSITE KNIT IND. LTD.
 In Process Inspection Report

Client: *Hushier* PO: *MW53291* PO: *MW53292*

Date: *20-01-2022*
 Section: *Sewing*
 Color: *Dark Blue*
 Item: *T-shirt*

Quantity: *1000*

Item	Description	Quantity	Unit	Price	Total
1	1000	1000			
2	1000	1000			
3	1000	1000			
4	1000	1000			
5	1000	1000			
6	1000	1000			
7	1000	1000			
8	1000	1000			
9	1000	1000			
10	1000	1000			
11	1000	1000			
12	1000	1000			
13	1000	1000			
14	1000	1000			
15	1000	1000			
16	1000	1000			
17	1000	1000			
18	1000	1000			
19	1000	1000			
20	1000	1000			
21	1000	1000			
22	1000	1000			
23	1000	1000			
24	1000	1000			
25	1000	1000			
26	1000	1000			
27	1000	1000			
28	1000	1000			
29	1000	1000			
30	1000	1000			
31	1000	1000			
32	1000	1000			
33	1000	1000			
34	1000	1000			
35	1000	1000			
36	1000	1000			
37	1000	1000			
38	1000	1000			
39	1000	1000			
40	1000	1000			
41	1000	1000			
42	1000	1000			
43	1000	1000			
44	1000	1000			
45	1000	1000			
46	1000	1000			
47	1000	1000			
48	1000	1000			
49	1000	1000			
50	1000	1000			
51	1000	1000			
52	1000	1000			
53	1000	1000			
54	1000	1000			
55	1000	1000			
56	1000	1000			
57	1000	1000			
58	1000	1000			
59	1000	1000			
60	1000	1000			
61	1000	1000			
62	1000	1000			
63	1000	1000			
64	1000	1000			
65	1000	1000			
66	1000	1000			
67	1000	1000			
68	1000	1000			
69	1000	1000			
70	1000	1000			
71	1000	1000			
72	1000	1000			
73	1000	1000			
74	1000	1000			
75	1000	1000			
76	1000	1000			
77	1000	1000			
78	1000	1000			
79	1000	1000			
80	1000	1000			
81	1000	1000			
82	1000	1000			
83	1000	1000			
84	1000	1000			
85	1000	1000			
86	1000	1000			
87	1000	1000			
88	1000	1000			
89	1000	1000			
90	1000	1000			
91	1000	1000			
92	1000	1000			
93	1000	1000			
94	1000	1000			
95	1000	1000			
96	1000	1000			
97	1000	1000			
98	1000	1000			
99	1000	1000			
100	1000	1000			

Inspector: *[Signature]* Date: *20/01/22*

Figure 3.4.1 End Line Inspection Report- 4

KAC Fashion Wear Ltd.

DAILY END-LINE INSPECTION REPORT

Date: 20-01-2022 Order No: MW53291

Color: Dk BLUE

Buyer:JMS

Sewing Line: 4/5

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Total check gmts	47	60	70	81	100	90	80	82	-	-	610
Total pass gmts	40	50	56	77	70	72	60	65	-	-	490
Total defectives gmts	11	17	14	15	13	18	20	21	-	-	132
Total defects qty	12	17	14	20	17	18	20	15	-	-	133
Rectify defective gmt check & pass	15	17	14	15	19	15	20	18	-	-	133
Rectify Qty	12	17	14	15	17	18	20	15	-	-	128
Reject	2	-	2	1	-	1	2	1	-	-	09
Name Of Defects:											
Broken Stc.	1	3	1	1	3	1	3	3	-	-	16
Skip Stc.	2	3	1	2	3	2	1	-	-	-	14
Join Stc.	-	1	-	-	2	-	1	-	-	-	04
Raw edge											
Uneven Stc.	-	3	2	1	3	3	2	1	-	-	15
Puckering											
Up & Down	2	1	-	3	2	2	1	2	-	-	13
Twisting											
Shading	2	2	-	1	-	-	1	-	-	-	06
Fabric fault											
Poor iron											
Without process											

Uncut thread	1	1	2	3	2	3	3	1	-	-	16
Dirty spot	1	-	1	-	1	-	1	-	-	-	04
Oil stain	-	1	2	-	-	-	2	-	-	-	05
Label displace											
Tal part											

Shape out/off											
Sharing	1	-	1	-	-	2		1	-	-	06
Pleat	3	1	4	3	2	2	-	1	-	-	16
Reverse											

Open seam	2	1	1	2	3	2	3	2	-	-	16
Print problem											
Needle mark											
Down stc.											
Tack problem											
Contamination											
1 st Highest	De f Qty			2 nd Highest			Def Qty			3 rd Highest	

Table 3.4 End Line Inspection Report- 4

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

= (12/57)*100

= 23.5%

This The Table3.4can see that, at sewing line (01) our observation date was 04-11-2021. The buyer was Garcia. Total worker or operator worked at sewing line (01) was 16 with 07 helpers and 2 QC operators. From our observation I found that from 8am-5am they check 610 pcs of garments and there have been total 133 defects.

In this way, Total 610 pcs of garments checked in our 8 hrs observation. Here I totally found 133 pitches of defective garments where 124 pitches are altered and 9 pitches are rejected.

Chapter-4

RESULT AND DISCUSSION

4.1 Analysis of End Line Inspection Report- 1



Figure 4.1: Graphically Show Defects Number Measurement End of Line Inspection Report- 1

- Missing=12
- Wrong placement=4
- Broken stitch=27
- Pleat=10
- Uneven=6
- Raw edge=24
- Uncut loose thread=39

Discussion:

After 10 hours end line inspection inspector inspect total 121 defects found.

1st highest defect is raw ede 24 defects found.

2nd highest defect is worong placement 4 defects found.

3rd highest defect pleate 14 defects

found. 4th highest defect is uneven 6

defects found. Uncut loose thred 39

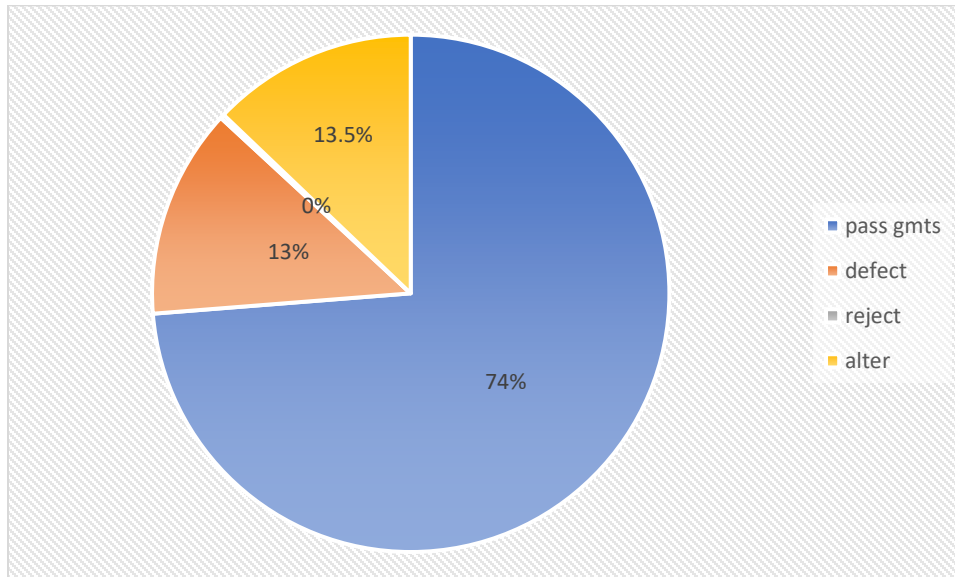


Figure 4.2: Graphically Show Data Analysis of End Line Inspection Report- 1

- **Discussion:**
- After 10 hours end line inspection inspector inspect Total 1706 pitches of garments and 1146 pitches quality passed.
- Here, passed gmts percentage 74%
- Defects percentage 13.5%
- Reject percentage 0%
- Alter percentage 13%

4.3 Different Sewing defects are shown from table no: 3.2

Defects

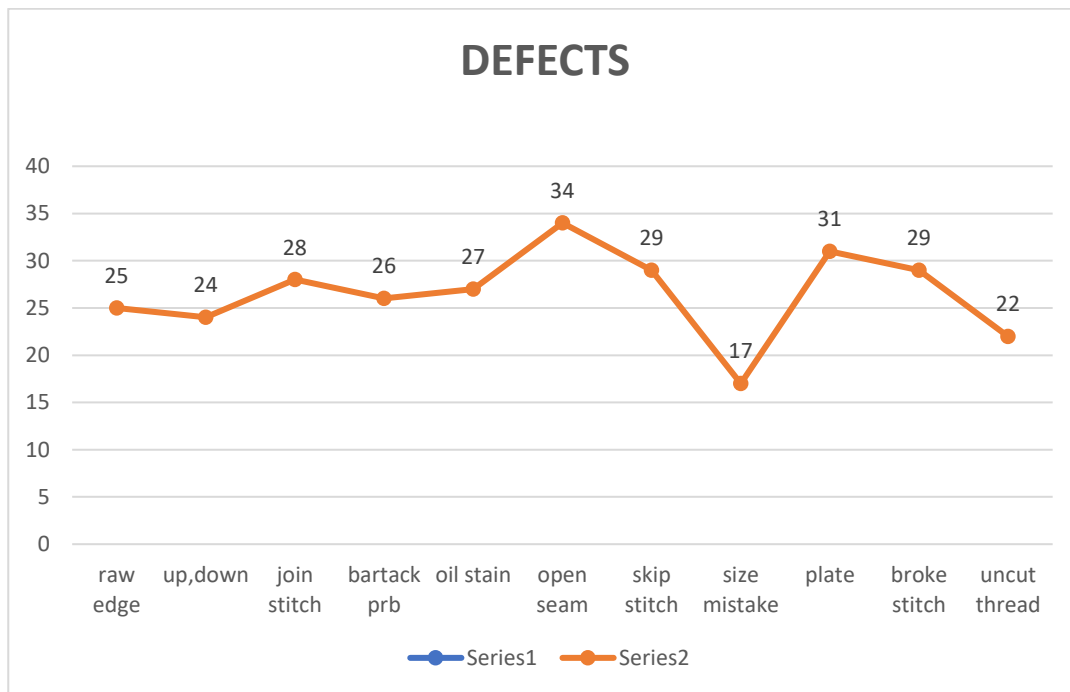


Chart4.3Line Inspection report 3.2

I see the report 3.4 I found uncut loose thread is the main fault. I saw 10 hour's production and found 22 uncut loose thread, anyway all pieces were changed. Uncut loose thread sewing issue happen last hour working time. In this hour there was 4 pieces of fault garments.

For this sewing issue, I have taken notes of data from Q.A.D for real causes and cures of this kind of fault. It appears due to improper trimming or finishing. In sewing process extra thread allowance. Garments finishing should be checked properly.

Figure 4.4 Graphically Show Data Analysis of End Line Inspection Report- 1

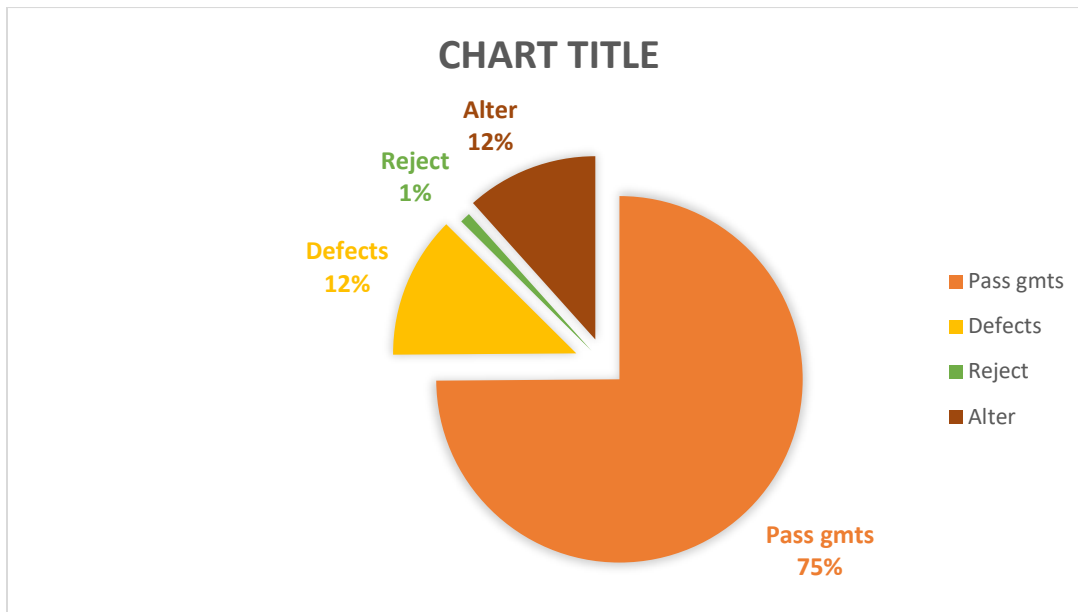


Figure 4.4 Graphically Show Data Analysis of End Line Inspection Report- 2

Discussion:

After 10 hours end line inspection inspector inspect Total 1020 pitches of garments and 1300 pitches quality passed.

Here

Reject percentage = 1%

Alter percentage = 12%

passed gmts percentage = 75%

Defects percentage = 12%

Chart4.5Line Inspection report 3

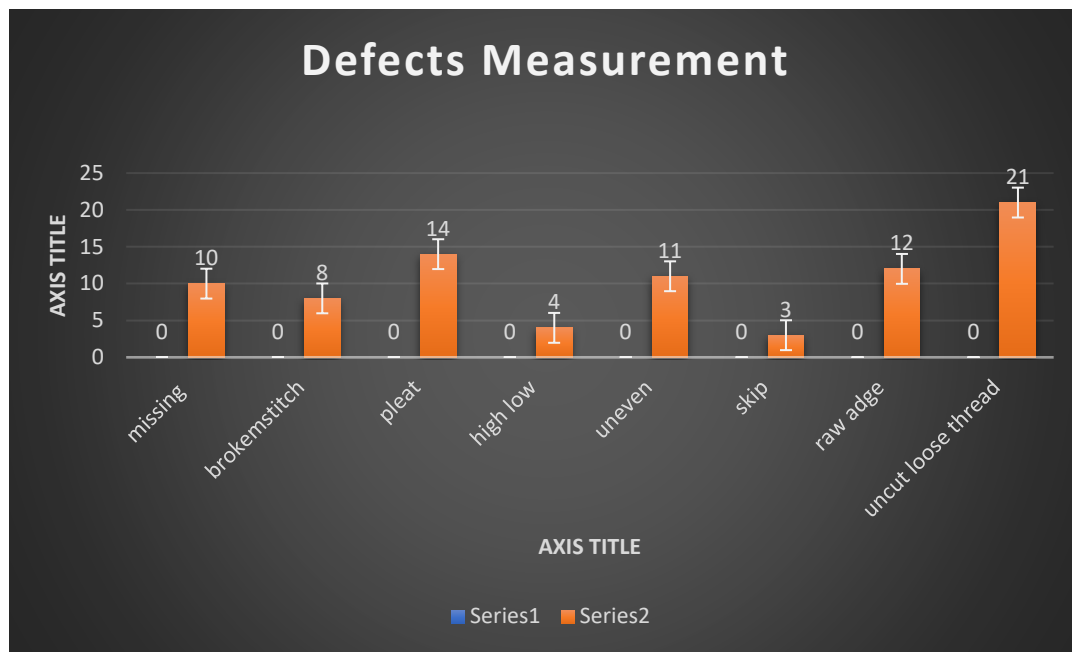


Figure 4.5.: Graphically Show Sewing Defects Number Measurement of End Line Inspection Report- 3

I see the report 3.3. I found uncut loose thread is the main fault. I saw 10 hour's production and found 21 uncut loose thread, anyway all pieces were changed. Uncut loose thread sewing issue happen last hour working time. In this hour there was 10 pieces of fault garments. For this sewing issue, I have taken notes of data from for real causes and cures of this kind of fault. It appears due to improper trimming or finishing. In sewing process extra thread allowance. Garments finishing should be checked properly. Sewing thread use properly.

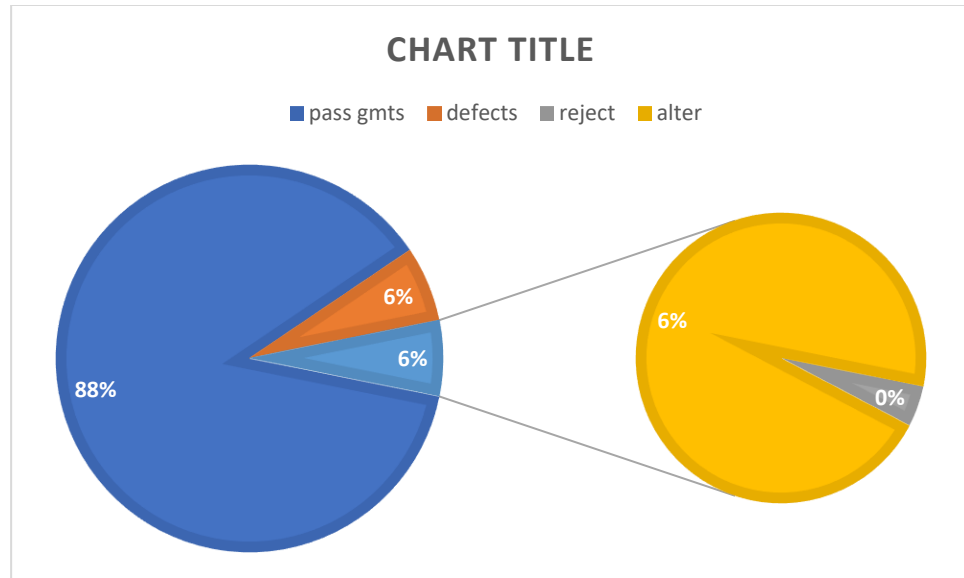


Figure 4.6 Graphically Show Data Analysis of End Line Inspection Report- 3

Discussion:

After 10 hour's inspection inspector inspect total 1659 pitches of garments and 1220 pitches quality pass.

Here,

Pass gmts percentage 88%

Defects percentage 6%

Alter percentage 6%

Reject percentage 0%

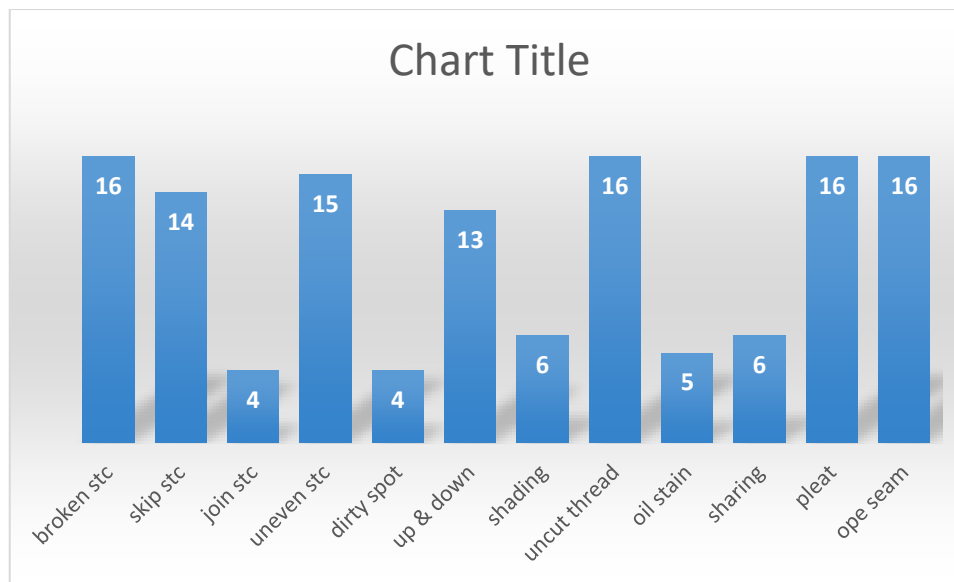


Figure 4.7 Graphically Show Sewing Defects Number Measurement of End Line Inspection Report- 4

broken stc	16
skip stc	14
join stc	4
uneven stc	15
dirty spot	4
up & down	13
shading	6
uncut thread	16
oil stain	5
sharing	6
pleat	16
ope seam	16

Discussion:

After 8 hours end line inspection inspector inspect total 133 defects found.

Here,

1st highest defect is up down 13 defects found.

2nd highest defect is Brocken stitch 16 defects found.

3rd highest defect is shading 06 defects found.

4th highest defect is join stitch 04 defects found.

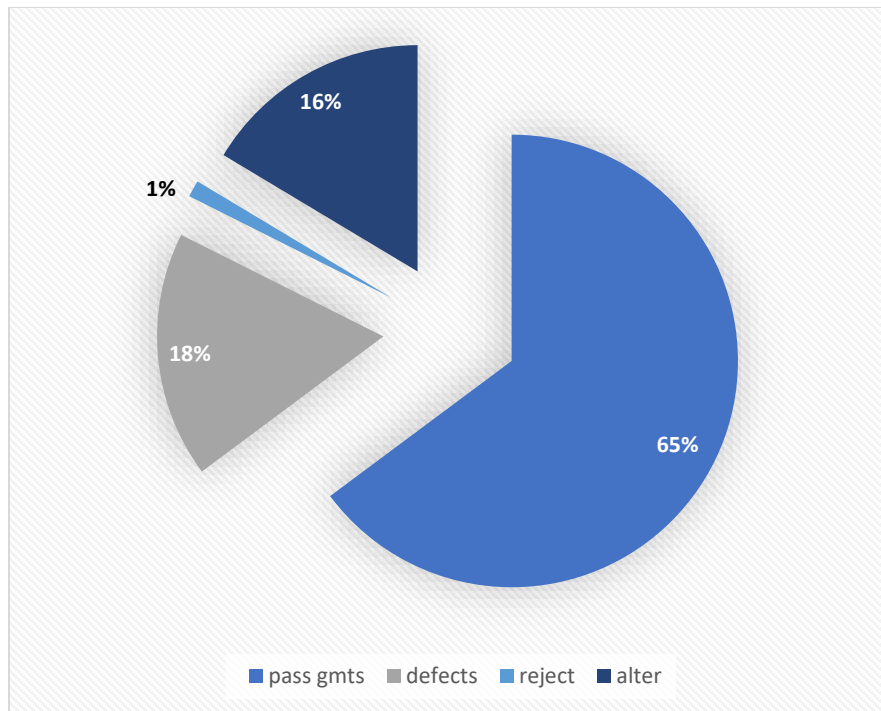


Figure 4.8Graphically Show Data Analysis of End Line Inspection Report- 4

Discussion:

After 8 hour's inspection inspector inspect total 610 pitches of garments and 490 pitches quality pass.

Here,

Pass gmts percentage 65%

Defects percentage 18%

Alter percentage 16%

Reject percentage 1%

Chapter-5

Conclusion

5.1 Conclusion:

Finally, we have completed our thesis at “**KAC Fashion Wear Ltd**” and then after lots of inspection, experiment & discussion. We have gathered a large experience about this project. We have increased our knowledge about how sewing is done for making garments, problems of sewing & how those problems are minimized. This project used a variety of garment samples which were grouped according to the end product categories. This study on sewing process in a ready-made clothing enterprise, the reasons increasing quality faults and the priorities were determined for the improvement studies. This project is about sewing process in a ready-made clothing factory and the improvement of the sewing faults. To enable a good quality system in enterprises, there should be an adequate number of quality staff and the quality consciousness of workers should be increased. Material quality should be controlled by performing input controls, while the production quality should be provided by intermediary controls during production. Quality level should be constantly improved and for this purpose, regular trainings should be prepared in the enterprise.

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