



SATHYABAMA

**INSTITUTE OF SCIENCE AND TECHNOLOGY
(DEEMED TO BE UNIVERSITY)**

Accredited "A" Grade by NAAC | 12B Status by UGC | Approved by AICTE

www.sathyabama.ac.in

**SCHOOL OF BUILDING AND ENVIRONMENT
DEPARTMENT OF FASHION DESIGN**

**INTERNSHIP REPORT (S105AINT)
2022-2023**



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DEPARTMENT OF FASHION DESIGN**

**INTERNSHIP REPORT (S105AINT)
2022 - 2023**

Name of the Student: ARCHANA RICHI.R.

Reg No.: 40105003

Semester: V

Batch: 2020-2023



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SCHOOL OF BUILDING AND ENVIRONMENT

DEPARTMENT OF FASHION DESIGN

INTERNSHIP REPORT (S105AINT)

2022 - 2023

VIVA-VOCE EXAMINATION

This is to certify that the Internship Report (S105AINT) is the work of ARCHANA RICHIR, who had undergone training in SCM GARMENTS Industry and has been monitored by the continuous assessment during May 2022 to June 2022.

Head Of The Department

Head of the Department

Fashion Design

Sathyabama Institute of Science and Technology

Chennai-600 119.

(R. PRIYADARSHINI)

Submitted for Viva-voce Examination held on 21-10-2022

Internal Examiner

External Examiner



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DECLARATION

I ROSHINI hereby declare that this Internship Report (S105AINT) for 28 days from 25th may 2022 to 23rd June 2022 done by me under the guidance of Ms. R. Priyadharshini is submitted in partial fulfillment of the requirements for the completion of the Internship training session.

DATE: 21 - 10 - 2022

PLACE: CHENNAI

SIGNATURE OF CANDIDATE

ACKNOWLEDGEMENT

I am pleased to acknowledge my sincere thanks to Board of Management of **SATHYABAMA INSTITUTE OF SCIENCE & TECHNOLOGY** for their kind encouragement in doing this project and for completing it successfully. I am grateful to them.

I convey my thanks to **Ms. S. Krithika (HEAD OF THE DEPARTMENT), Department of Fashion Design, School of building and Environment** for providing me necessary support and details at the right time during the progressive reviews.

I would like to express my sincere and deep sense of gratitude to **Mr. Ravi Siddharth** for his valuable guidance, suggestions and constant encouragement paved way for the successful completion of my Training.

I would like to thank **Ms. Dharshini Kumar** for providing me an opportunity to engage myself as a trainee in **DHARSHINI'S BRIDE O CAFÉ boutique, Shop No. 29, D.N.S. Plaza, First Floor, No. 4, 5, Nageshwaran Rao Road, Panagal Park, T. Nagar, Chennai, Tamil Nadu 600017.**

I would also like to express my sincere thanks to **Ms. R. Priyadharshini** for her valuable guidance, during the entire Professional Training period.

I wish to express my thanks to all Teaching and Non-teaching staff members of the Department of Fashion Design who were helpful in many ways for the completion of the project.

BONAFIDE CERTIFICATE



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Ref: SHD/2022/05/14/A4

14 May, 2022

TO WHOMSOEVER IT MAY CONCERN

This is to certify that **Ms. ARCHANA RICHI. R**, Register Number **40105003** is a Bonafide student of our Institution pursuing **BACHELOR OF SCIENCE in FASHION DESIGN** during the academic year **2021-2022**. She will be completing the course in the year **2023**.

This certificate is issued for the purpose of Applying **INTERNSHIP**.

DEAN (STUDENT AFFAIRS)

Dr. G. SUNDARI, M.E., Ph.D.

DEAN (STUDENT AFFAIRS)

SATHYABAMA

INSTITUTE OF SCIENCE AND TECHNOLOGY

(DEEMED TO BE UNIVERSITY)

Jeppiaar Nager, Rajiv Gandhi Salai

Chennai - 600 119.

CERTIFICATE



23.06.2022

TO WHOM SO EVER IT MAY CONCERN

This is to certify that **Miss.Archana Richler** Student of **B.Sc-FASHION DESIGN-in SATHYABAMA INSTITUTE OF SCIENCE & TECHNOLOGY,CHENNAI** has done her Training in our Unit following **Production Process** only from **26.05.2022 to 23.06.2022**.

During the internship, she has closely worked as a part of the administration team and, we found that she is very regular, innovative, hardworking and quick learner.

We wish her all Success in future.

Best regards,


GM - HR



SCM Garments Pvt Limited

57, V.O.C NAGAR (SOUTH), VALAYANKADU, TIRUPUR - 641 603, INDIA.
PH: 91 - 421 - 4319888, Fax: 91- 421 - 2248889 , CIN No: U18101TZ2006PTC012698
E-Mail: scmcre@scmggroups.com Website : www.scmgarments.com

ABOUT SCM GARMENTS

Established in 1989, SCM Garments Private Limited is the destination of superlative apparels that are knitted with immaculate quality and strong values. Each of our brands is a natural extension of our philosophy of excellence that is created with zeal and concern to our customers who are spread over globally. As an exports arm of The Chennai Silks (TCS), we exist to create experiences where passion and purpose come together. We leverage on robust research and advanced technologies which makes us

"A Fiber to Fashion company".

We are part of the biggest and most efficacious company - SCM Group of Companies. We believe that quality and efficiency are a quintessential part of our very being and to measure up to our own ideals. Also, instilling a sense of ownership and pride enhances a long-term relationship with our customers. To stay true to our pride in workmanship, we have established a dominant presence in every part of the textile spectrum and our pride lies in being independent and self-sufficient in every stage of garment production. We will continue to persist with confidence and move steadfastly despite any obstacles and thereby leaving remarkable footprints in the history of garment industry.

WHY SCM GARMENTS

Company is spread over 10,000 sq. ft with hi-tech automated machineries that help us handle diverse orders. Vertically integrated infrastructure with world-class machineries holds all the garment manufacturing processes and **helps us produce premium fabrics and prestigious brands.**

Expertise lies in developing products from 'concept to fruition' and beyond. Constant focus on innovation has helped us to emerge as a trendsetter in garment industry and be known worldwide for our unbeatable range of products.

MEN'S WEAR

Choose from a wide collection of men's wear tailored to suit the requisites of the style icons of today.

WOMEN'S WEAR

An impeccable array of clothing for the divas that rule at home and the boardroom.

KID'S WEAR

Vibrant, sporty, and comfortable clothing for children of all ages to have fun while they look good.

WORK DIARY

26/5/22	THURSDAY	Company visit
27/5/22	FRIDAY	SOP companies, types of machines
28/5/22	SATURDAY	Printing department
30/5/22	MONDAY	Teck pack checking department
31/5/22	TUESDAY	IE department checking department
1/6/22	WEDNESDAY	Quality control department
2/6/22	THURSDAY	SOP department
3/6/22	FRIDAY	Acceptance Quality level
4/6/22	SATURDAY	Measurement checking
6/6/22	MONDAY	Button testing
7/6/22	TUESDAY	Teck pack and ordering processing
8/6/22	WEDNESDAY	Teck pack
9/6/22	THURSDAY	Accessories
10/6/22	FRIDAY	Accessories
11/6/22	SATURDAY	Label management machine maintenance
13/6/22	MONDAY	Line production inspection
14/6/22	TUESDAY	Inspection
15/6/22	WEDNESDAY	AQL
16/6/22	THURSDAY	AQL
17/6/22	FRIDAY	Garment safety measures and laws
18/6/22	SATURDAY	Plan layout
20/6/22	MONDAY	Sampling merchandising
21/6/22	TUESDAY	Sampling merchandising
22/6/22	WEDNESDAY	pattern
23/6/22	THURSDAY	Pattern making

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PROCESS

We have hi-tech imported compacting machines from USA & Italy for both open-width and tubular fabrics. Taiwanese raising machines enable brushing on all varieties of fabrics wherein our sue-ding division is supported with machines that are imported from Italy. Our in-house washing units feature recyclable water and multiple wash options like silicon/stone and enzyme, bio-polish, etc.

PRINTING

Our trendy print designs leave impressive impressions that comply with the ever-changing trends and needs of the customer. To offer a complete range of print options, we have installed state-of- the-art placement printing machines which facilitate various types of prints like reactive, discharge, pigment, plastisol, high density, flock, rubber etc.



Fig:1

EMBROIDERY

Enabling intricacy of design, our embroidery division is housed with 24 imported machines from Germany, China & Japan. Equipped with 326 heads, these machines are capable.



Fig:2

ACCESSORIES

We have sophisticated equipment from Switzerland for manufacturing inner elastics for briefs, jog pants, shorts, etc. that ranges from 3mm to 60mm are produced using the machinery.



Fig:3

INFRASTRUCTURE

We continue to contribute our innovative ideas to the hosiery world through our technical expertise. Our company is spread over 10,000 sq.ft with hi-tech automated machineries that help us handle diverse orders. Our vertically integrated infrastructure with world-class machineries holds all the garment manufacturing processes and helps us produce premium fabrics and prestigious brands.



Fig:4

SPINNING

The finest combed cotton yarn is produced from our spinning division. With 28 combing machines, 45 ring frames and 20 Auto Conner machinery, the spinning unit uses of organic cotton to produce high-quality yarn. The state-of-the-art machinery helps in achieving superior quality organic cotton yarn from counts Ne 20's to Ne 60's. We also produce yarn blends from counts Ne 20's to Ne 50's.



Fig :5

KNITTING

The hi-tech machineries from Germany and Italy help us creating Rib, Interlock and Fancy designs. Interlock, Drop Interlock and Auto Stripes are facilitated with highly-automated Spanish machines. Taiwanese machines for Rib and Wheel Jacquard with Lycra, Japanese Collar knitting machines to knit all types of flat knit collars and machines from Singapore for Jersey with three thread conversion.

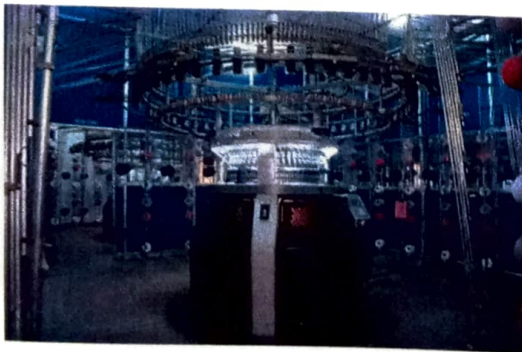


Fig: 6

DYEING

Completely equipped with Reverse Osmosis feed tank, our dyeing plant at Erode recycles discharged water and make it suitable for irrigation, thereby justifying to our environment. friendly operations. It houses advanced machinery from This, Germany as well as HTHp machines for polyester dyeing, winch dyeing, soft flow machines, drying machines and rotary printing.



Fig: 7

PROCESSING

We have hi-tech imported compacting machines from USA & Italy for both open-width and tubular fabrics. Taiwanese raising machines enable brushing on all varieties of fabrics wherein our sue-ding division is supported with machines that are imported from Italy. Our in-house washing units feature recyclable water and multiple wash options like silicon/stone and enzyme, bio-polish, etc.



Fig:8

PRODUCTION UNIT

- Design studio
- Spreading and cutting
- Stitching
- Finishing
- Packing

THE STUDIO

The contemporary design studio wherein the latest trends and techniques are deployed for garment design is equipped with the most up-to-date software that facilitates pattern making, 3D imaging, graphics, draping, etc.



Fig:9

CUTTING & SPREADING

The latest Cutting Systems from the USA, with CAD, CAM, CAS, exclusive Plotting facilities and Band Knife Cutting Machines from Japan, Korea and Germany are the highlights of this division. Our automatic spreading machines enable the spreading of tubular, open-width, and woven fabrics.



Fig: 10

STITCHING

It is a process that requires a high degree of dexterity and astute precision. To ensure this, we have a team of skilled personnel who work towards stitching perfection with 2500 imported sewing machines. There are 40 production lines maintained as per the guidance of Kurt Salmon Associates, the renowned global Management Consultancy, which sets us apart.



Fig: 11

FINISHING & CHECKING

Oil fired boilers provide steam at required temperatures for pressing and drying. For shirts & trousers, a separate pressing facility has been allocated. The garment is then completely checked for defects.

Japanese Needle detector machines have been installed for 100% metal-free products.



Fig :12

PACKING

Packing is done with the utmost meticulousness. In-house stuffing is carried out with great care. Highest standards are complied with from expert packing to safe dispatch and deliver.



Fig :13

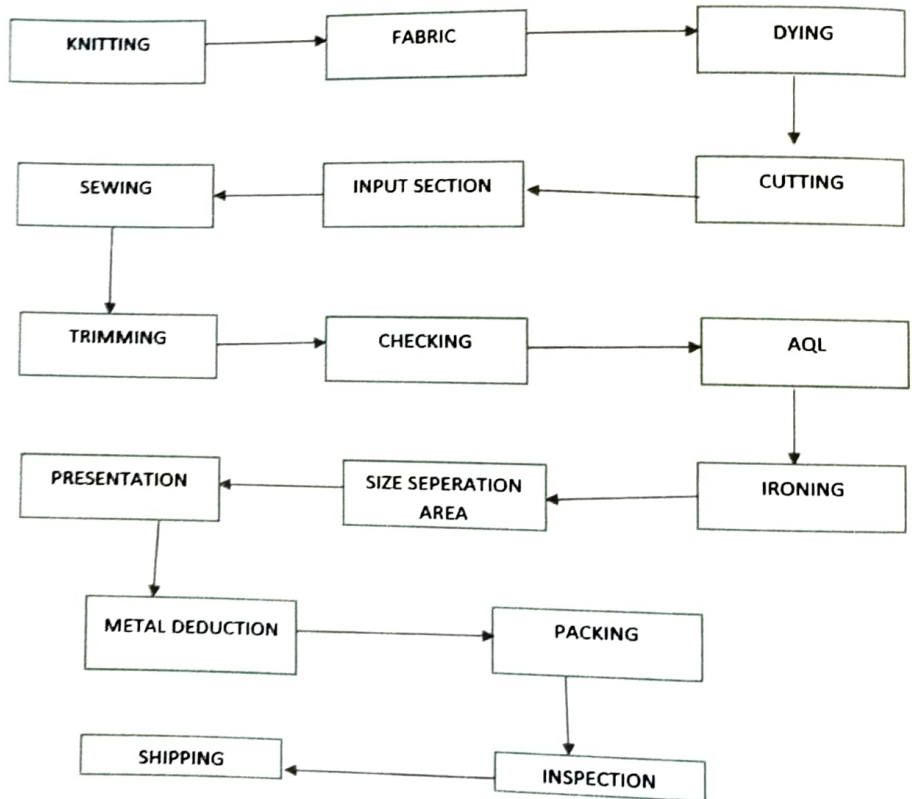
PRODUCTION PROCESS

The production process cares the reworking of variety of inputs into those outputs that are needed by the market. This involves 2 main sets of resources

The Reworking resources

The Works resources

The transforming resources embrace the buildings, machinery, computers, and other people that do the reworking processes. The reworked resources area unit the raw materials and parts that area unit reworked into finish product.



KNITTING

Knitting is a methodology by which yarn is manipulated to form a textile or material, usually utilized in many varieties of garments. Knitting creates multiple loops of yarn, referred to as stitches, in a very line or tube. Knitting has multiple active stitches on the needle at just once. Cloth consists of variety of consecutive rows of intermeshing of loops. As every row progresses, a recently created loop is force through one or additional loops from the previous row, placed on the gaining needle, and the loops from by using a machine.



Fig: 14

FABRIC

The output of the knitting process is the fabric, the basic color of the fabric is the grey and it will be washed for the next process.



Fig: 15

DYEING

Dyeing is the process where the necessary colour will be added to the material, and the quality of the colour will be checked. Compacting will be done when a textile finishing machine that is intended specially for compacting 100% cotton knit like jersey, pique, interlock, plush, rib and sinker etc. Again, the fabric will be washed and tested.

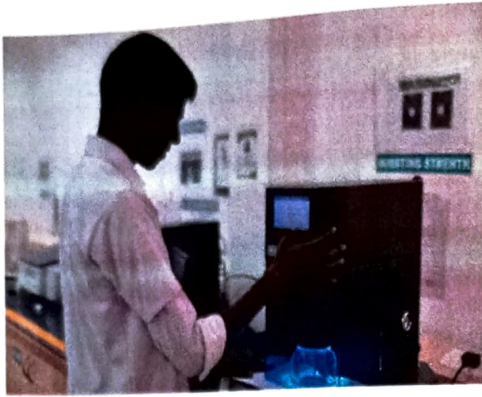


Fig: 16

CUTTING

The material is received in bundle and it will be kept for a few relaxations at temperature. The fabric is unfolded regarding twenty layers. The planning that is needed are marked or printed in a cardboard sheet.

- Straight knife
- Band knife
- scissors



Fig :17

INPUT SECTION

The stickered material will be in bundle and it will be placed in the storage area. the stock for 3 days work will be stored in this input section. From input section the materials will be passed to the production area.

SEWING

Garments are sewn in an assembly line, with the garment becoming more complete as it progresses down the sewing line. Sewing machine operators receive the materials in an bundle of cut fabric and repeated sew the same portion of the garment, passing that completed portion to the next operator.

For example: the first operator may sew the collar to the body of the garment and the next operator may sew a sleeve to the body. Quality assurance is performed at the end of the sewing line to ensure that the garment has been properly assembled and that no manufacturing defect exist. When needed the garment will be reworked at designed sewing Sections. This labor-intensive process progressively transforms pieces of fabric into designer garments each operator work time will be calculated and it will be noted in a time format sheet.



Fig: 18

TRIMMING

The material part except main material that are employed in clothes are referred to as trimming. The materials employed in room apart from material are referred to as trims. On the opposite hand we can say that the materials are directly hooked up with material to create a garment are referred to as trims. Like threads, buttons, lining, interlining, zippers, labels etc.



Fig: 19

CHECKING

A team starts to visualize clothes, whether sewing is correctly done or is there any spots on the garment. If they realize any spot, they take away its mis-treatment chemicals and if there's serious sewing drawback, they come back it to stitching department to rectify a similar.



Fig: 20

AQL

AQL (Acceptable Quality Level). It is the final checking process of the garment before the garment is sent to the Buyer, the checking includes garment quality and thorough inspection, direct inspection of regulations, duties. All procedural and quality requirements are met, the result or result of the final inspection is pass, and the garment is ready to be sent to the Buyer. But if it finds a critical point during the final inspection process, the garment is declared failed.

Lot Batch Size			Inspection Levels							
			General Inspection Levels			Special Inspection Levels				
			I	II	III	S-1	S-2	S-3	S-4	
2	to	8	A	A	B	A	A	A	A	
9	to	15	A	B	C	A	A	A	A	
16	to	25	B	C	D	A	A	B	B	
26	to	50	C	D	E	A	B	B	C	
51	to	90	C	E	F	B	B	C	C	
91	to	150	D	F	G	B	B	C	D	
151	to	280	E	G	H	B	C	D	E	
281	to	500	F	H	I	B	C	D	E	
501	to	1,200	G	I	J	C	C	E	F	
1,201	to	3,200	H	K	L	C	D	E	G	
3,201	to	10,000	I	L	M	C	D	F	G	
10,001	to	35,000	K	M	N	C	D	F	H	
35,001	to	150,000	L	N	P	D	E	G	I	
150,001	to	500,000	M	P	Q	D	E	G	I	
500,001	and over		N	Q	R	D	E	H	K	

Sample Size or Lot Size	Sample Size	Acceptable Quality Level (Single Sampling Plan for Normal Inspection)													
		0.4		0.65		1		1.5		2.5		4		6.5	
		Accept	Reject	Accept	Reject	Accept	Reject	Accept	Reject	Accept	Reject	Accept	Reject	Accept	Reject
A	2														
B	3														
C	5														
D	8														
E	13														
F	20														
G	32														
H	50														
I	80														
J	125														
K	200														
L	315														
M	500														
N	800														
P	1,250														
Q	2,000														

Fig: 21

SIZE SEPERATION AREA

After the final check, the materials will be separated according to their size and arranged, if this is not done the garments will get collapsed with different sizes. The size can be separated by using the tag which is inserted at the inner side of the garment.

IRONING

Pressing or ironing is that the most important finishing method in readymade clothes sector that is completed by subjecting a fabric to heat and pressure with or while not steam to remove unwanted creases and to impart a flat a look to the clothes. Pressing or ironing additionally done to introduce creases within the apparel within the clothes producing industries, pressing is termed as ironing.



Fig: 22

PRESENTATION

The final check of the material with the presence of the tag, seal, and overall material check will be done in this process.

PACKING

Garment packaging is that the method of wrapping, pressing, filling, or making of products for the aim of protection and their acceptable handling. This is often the final method within the production of clothes that prepares the finished merchandise for delivery to the client. It's a very important a part of the garment producing method. Garment packaging is additionally use to get ton of attention from the client.



Fig: 23

CARTOON BOXING

Garments are delivered to the client in cartons. Clothes in poly baggage are kept in a carton box as per instruction of the client. Loading cartons with clothes are known as packaging.

Clothes are loaded in cartons during a selected proportion of size and color. This proportion is termed assortment. It shows what sizes and colors should go with every carton. It's the need of a store of buyer's finish that the package is selected.



Fig: 24

SMV AND SAM

STANDARD MINUTE VALUE

SMV is out lined as the time that is allowed to perform employment satisfactorily. Usually, it's expressed in minute worth. The total elaboration of SMV is normal Minute worth. SMV term is generally utilized in the clothes producing business.

STANDARD ALLOWED MINUTE

Standard allowed minute (SAM) means that what quantity time is needed to create one complete garment as well as allowances. SAM is employed to measure the task or work content of a garment. This term is wide employed by industrial engineers and production people within the garment producing business.

TIME STUDY FORMAT												
Job No.	Description	TIME					REMARKS	DATE	TIME	TIME	TIME	TIME
		1	2	3	4	5						
1	Preparation	10	10	10	10	10	10	10	10	10	10	10
2	Excavation	10	10	10	10	10	10	10	10	10	10	10
3	Backfill	10	10	10	10	10	10	10	10	10	10	10
4	Gravel	10	10	10	10	10	10	10	10	10	10	10
5	Gravel	10	10	10	10	10	10	10	10	10	10	10
6	Gravel	10	10	10	10	10	10	10	10	10	10	10
7	Gravel	10	10	10	10	10	10	10	10	10	10	10
8	Gravel	10	10	10	10	10	10	10	10	10	10	10
9	Gravel	10	10	10	10	10	10	10	10	10	10	10
10	Gravel	10	10	10	10	10	10	10	10	10	10	10
11	Gravel	10	10	10	10	10	10	10	10	10	10	10
12	Gravel	10	10	10	10	10	10	10	10	10	10	10
13	Gravel	10	10	10	10	10	10	10	10	10	10	10
14	Gravel	10	10	10	10	10	10	10	10	10	10	10
15	Gravel	10	10	10	10	10	10	10	10	10	10	10
16	Gravel	10	10	10	10	10	10	10	10	10	10	10
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68	Gravel	10	10	10	10	10	10	10	10	10	10	10
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73	Gravel	10	10	10	10	10	10	10	10	10	10	10
74	Gravel	10	10	10	10	10	10	10	10	10	10	10
75	Gravel	10	10	10	10	10	10	10	10	10	10	10
76	Gravel	10	10	10	10	10	10	10	10	10	10	10
77	Gravel	10	10	10	10	10	10	10	10	10	10	10
78	Gravel	10	10	10	10	10	10	10	10	10	10	10
79	Gravel	10	10	10	10	10	10	10	10	10	10	10
80	Gravel	10	10	10	10	10	10	10	10	10	10	10
81	Gravel	10	10	10	10	10	10	10	10	10	10	10
82	Gravel	10	10	10	10	10	10	10	10	10	10	10
83	Gravel	10	10	10	10	10	10	10	10	10	10	10
84	Gravel	10	10	10	10	10	10	10	10	10	10	10
85	Gravel	10	10	10	10	10	10	10	10	10	10	10
86	Gravel	10	10	10	10	10	10	10	10	10	10	10
87	Gravel	10	10	10	10	10	10	10	10	10	10	10
88	Gravel	10	10	10	10	10	10	10	10	10	10	10
89	Gravel	10	10	10	10	10	10	10	10	10	10	10
90	Gravel	10	10	10	10	10	10	10	10	10	10	10
91	Gravel	10	10	10	10	10	10	10	10	10	10	10
92	Gravel	10	10	10	10	10	10	10	10	10	10	10
93	Gravel	10	10	10	10	10	10	10	10	10	10	10
94	Gravel	10	10	10	10	10	10	10	10	10	10	10
95	Gravel	10	10	10	10	10	10	10	10	10	10	10
96	Gravel	10	10	10	10	10	10	10	10	10	10	10
97	Gravel	10	10	10	10	10	10	10	10	10	10	10
98	Gravel	10	10	10	10	10	10	10	10	10	10	10
99	Gravel	10	10	10	10	10	10	10	10	10	10	10
100	Gravel	10	10	10	10	10	10	10	10	10	10	10

Fig: 25

WORK DONE

TYPES OF MACHINES

I have seen the types of machines Sigher, Overlock, flatlock, Snap button, Croch meter, Pull test machine, Light detecting machine.

SINGER MACHINE

Machine Condition: New Only

Machine Type: Semi-Automatic

Max Sewing Speed: 2000-3000 (stitch/min)

Number Of Needles: Single needle

Usage/Application: Heavy Material

Power: Single Phase



Fig: 26

Overlock Sewing Machine

Overlock machines are available in 3 threads, 4 threads and 5 threads over edge sewing. An overlock machine can form various types of stitches like stitch class 503, stitch class 504 and stitch class 512.

Purpose: This machine is used for serging garment panels (for example: trouser panels serging) and for overedge stitch.

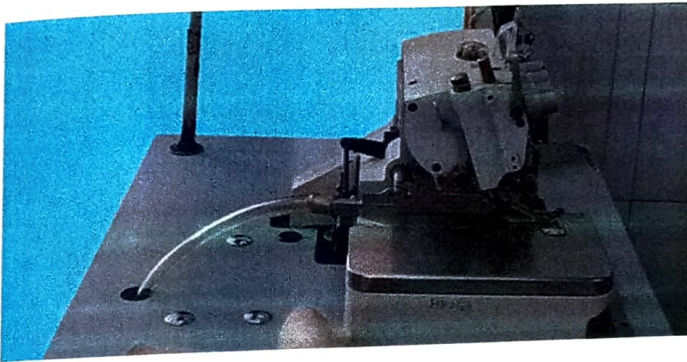


Fig: 27

Flatlock sewing machine

This machine is called a cover-stitch sewing machine. Flatlock sewing machines normally come with 2-3 needles. For the bottom cover stitch machine 2 needle threads pass through the material and inter loop with 1 looper thread with the stitch set on the underside of the seam. Flatlock sewing machine form stitches like Stitch class 406.

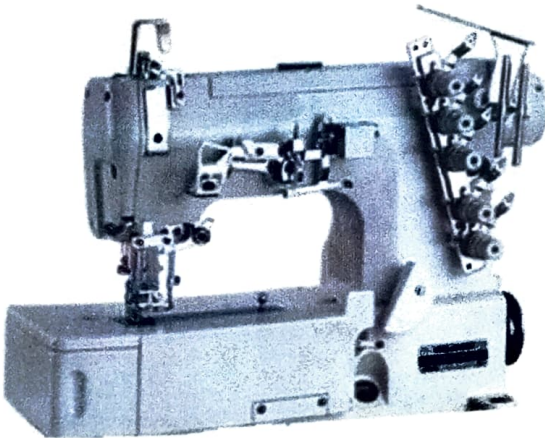


Fig: 28

Button Attaching Machine

A special machine used only for stitching button in a garment. different sizes of button can be attached in same the machine by changing the settings.

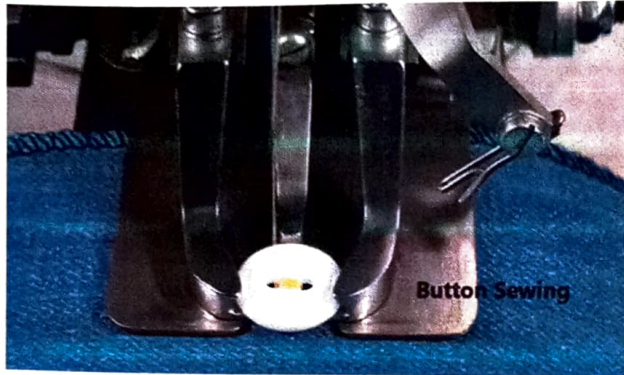


Fig :29

Bar tack machine

Bar tack stitch is made to reinforce the seam and garment component. Like in belt loop joining and at the bottom of side pocket opening bar taking is done.

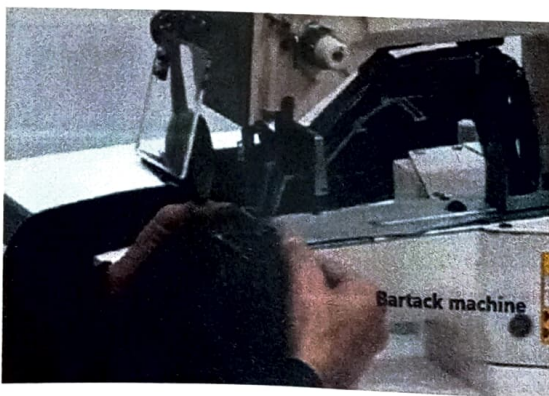


Fig: 30

SAM

STANDARD ALLOW MINUTE

SIZE QUALITY/ TOTAL QUALITY*SAMPLE SIZE

Efficiency = $\frac{\text{earn minute}}{\text{Available minute}} * 100$

Available minute

Earn minute = line output * SAM (Standard Allowed Minute) Available Minute = man power * working hours

Target = man power * working hours

SAM

TYPES OF PRINTING

- Pigment
- Non pvc
- Pvc
- Glitter
- Radiant
- Flock
- Puff
- High density
- Discharge

PIGMENT PRINTING

Pigment printing is one of the essential parts of the textile industry. It refers to the dyeing of clothes and dress materials. There are various types of dyes available in the market which is used for pigment printing.



Fig: 31

NON-PVC PRINTING

Non-PVC print can be appropriately applied to cotton, lycra, and polyester fabrics. It can be unanimously applied to natural as well as synthetic fibres; mixed as well as organic fibers. It is apposite for indoor and outdoor markings and graphics.



Fig: 32

PVC PRINTING

Polyvinyl Chloride (PVC) is a strong plastic material used in professional ID card printing. This material offers a smooth finished surface, meaning that color and branding details show up vividly.



Fig: 33

GLITTER PRINTING

Primitively, glitter printing is a type of a transfer printing process. Glitter print makes use of the glittering granules called the glitter powder that after print are easily visible on the fabric.



Fig: 34

HIGH DENSITY

The High-Density Screen-Printing process. The High-Density Screen-Printing Process of printing a T-shirt is the process in which we use a thick layer of emulsion to create a higher print. This is a great method is usually used for special effects on designs and to make your design pop.



Fig :35

DISCHARGE PRINTING

Discharge printing, also called Extract Printing, method of applying a design to dyed fabric by printing a colour-destroying agent, such as chlorine or hydrosulfite, to bleach out a white or light pattern on the darker colored ground.



Fig: 36

IE DEPARTMENT

CHECKING DEPARTMENT

- Not sewing is correctly done or is there any spots on the garment
- Mis – treatment chemicals
- Serious sewing drawback they come back it to stitching department

QUALITY CONTROL DEPARTMENT

- Pre – production quality control.
- Quality control during production.
- Final inspection.
- Quality control to development a sampling plan.
- Post production quality evaluation.

SOP DEPARTMENT

- Button attachment
- Fabric store
- Sewing
- Needle control
- Metal detection
- Pressing and packing
- Heat transfer
- Cutting room
- Fusing
- Machine management

BUTTON ATTACHMENT SOP

Lockstitch button attach machines must be used with thread wipers. Hand sewing or chain stitch is not to be used

Pull test must be performed after button attach operation according to requirement.

All button machines must be serviced on a regular basis with records to demonstrate.

Button holes must have sufficient stitch cover to prevent fraying & Knives must be sharpened regularly to prevent snagging of fabrics Button made of natural wood, rubber, seashell, real pearl, or other limited natural resource material cannot be used for Tesco products.

FABRIC SOP

All incoming fabrics must be held in a dedicated and clearly identifiable quarantine area until the inspection processes have been completed Fabric store must have the record of inventory against delivery notes Minimum 10% fabric will be inspected followed by 4-point system Color fastness, shrinkage, spirality test must be carried out by in-house testing lab. All fabrics must have a clear identification in storage area. There must be a dedicated, Quarantine area for the holding of any non- conforming fabric.

SEWING SOP

Cut work will feed to the production lines along with bundle card & cut panel inspection report. All labels must be securely stored on the production floor and feed to the line according to production plan (quantity, size, color) and must be recorded. Label attach operator must be issued with a copy of "product number" for the style in production Thread ends must be removed throughout the sewing process prior to final examination TCQC/TESCO Technologist will carry out in-line/1st bulk inspection from initial production and implement the corrective and preventive actions

At End of line, 100% of all production must be examined on white surface table against Approved Sample.

All non-conforming products identified at the end line must be segregated from other product. All faults must be marked and the non-conforming products organized by fault category for corrective action.

NEEDLE SOP

Needles can be only exchangeable with the same type & also new and used needles must be stored securely

Stock replenishment must be on a strict 'New for Old' exchange

If a needle breaks, all parts must be accounted for before a new needle is issued

If all parts of the needle cannot be found then the immediate vicinity

must be checked with a magnet and any product or part product must be fully metal detected

If all parts have still not been located then the issuing of a new needle must be approved by an authorized person

All needle records relating to stock control must be kept for a minimum of 1 year from shipment & all broken needle control records must be kept for a minimum of 6 years from shipment.

METAL DETECTOR

Metal detector machine must be locked. After detecting any metal, machine can be only reset by key switch which is own by the responsible person for the dept. Any contaminant detected must be kept with documentation confirming source of contaminant and action taken to prevent future contamination. Calibration checks should be conducted hourly every day and when the machine is started up and at the end of the working day following 9-point system. The metal detector must be in a dedicated and clearly identifiable area. The exit/feed off side of the metal detector must be a 'Metal Free' area.

PACKING SOP

All labels & hang tags must be stored securely and independently by style/Size/colour

Packers must be issued with Bar-code number to check on a size/color basis. All finished products must be checked against an approved size chart. Stock must be stored after pressing so that it does not crease and retain moisture (example-hanging rail/stored in min qty.

HEAT TRANSFER MACHINE SOP

Heat transfer machine will be set according to data sheet (Temperature/Pressure/Time) provided by nominated heat seal supplier. An Approved standard is available to show the position/ location of the transfer print/embellishment on each design by size. Heat Transfer Machine must be 'check tested' at least twice a day for time by stop watch and glue line temperature with thermo strips (at least 2 thermo papers) & must be recorded. Carbon paper testing for uniform pressing must be carried out twice a day for any new shape/style. Wash Durability test must be carried out on each batch for wash garments. Heat Transfer machine must be calibrated at least the minimum frequency recommended by the machine manufacturer. Calibration certificates and records must be available and up to date. Fabric shrinkage and colour change must be assessed for every fabric batch/dye lot.

CUTTING SOP

Spreading length/no of Lay/ Lay tension/ height must be checked prior to proceed for cutting. Band knife working areas must have secure partitioning. Where checked or striped fabrics are used and require matching by the use of independent 'pins' then the use of these 'pins' must be controlled & recorded. All electrical cables for cutting equipment must be suspended away from the cutting blade. Straight knife operators must stand next to the table. Operators.

INSPECTION

- ☐ Back right arm hole.
- ☐ Right arm hole seam and shoulder seam.
- ☐ Right sleeve.
- ☐ Cuff inside and outside.
- ☐ Right side seam and underarm hole seam.
- ☐ Left shoulder seam and arm hole seam.
- ☐ Back left arm hole.
- ☐ Left sleeve cuff inside and out.
- ☐ Left underarm seam and side seam.



Fig:37

CONCLUSION

SCM Garment private limited, Tirupur. Is one of the Export Company that has units for production and processing. In my conclusion SCM Garments running Tirupur in successfully, but their losing percentage is 3 kindly reduce the loss percentage. In some units are follow the standard production strategy to increase the production. But majority units are having not a strategy. Implement the 6-sigma strategy to avoid the rejection and rework to increase our production status and our goodwill. To change the all units in systematically to avoid the stock in the line, to provide a scanning system to easily identify the pieces in our units, where it is stock. If the company take activity to increase our production and export.

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