

-INTERNSHIP REPORT

**SUBMITTED IN PARTIAL FULFILMENT OF THE REQUIREMENTS FOR
THE AWARD OF
BACHELOR OF SCIENCE – FASHION DESIGN**

by

SELVA JOTHI BLESSY. R (41105015)



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

SATHYABAMA

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

Accredited with “A++” by NAAC

JEPPIAAR NAGAR, RAJIV GANDHI SALAI, CHENNAI – 600119

JULY 2023

SCHOOL OF BUILDING AND ENVIRONMENT

DEPARTMENT OF FASHION DESIGN

INTERNSHIP REPORT (S105AINT)

2023 – 2024

Name of the student: SELVA JOTHI BLESSY. R

Reg no : 41105015

Semester : V

Batch : 2021- 2024



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SCHOOL OF BUILDING AND ENVIRONMENT

DEPARTMENT OF FASHION DESIGN

INTERNSHIP REPORT (S105AINT)

2023 – 2024

VIVA –VOICE EXAMINATION

This is to certify that the Internship (S105AINT) is the work of Selva j. R - 41105015, during semester V, is a student of Fashion Design department had undergone training in SCM GARMENTS has been monitored by the continuous assessment during May 2023 to June 2023.

Submitted for Viva Voice examination held on: 06/09/2023

Mentor

Class Coordinator

Internal Examiner

External Examiner

Head of the Department
Head of the Department
Fashion Design
Sathyabama Institute of Science and Technology
Chennai-600 119.



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DECLARATION

I SELVA JOTHI BLESSY. R here by declare that the Internship (SI05AINT) for 21 days from 11th May2023 to 3rd June 2023 done by me under the guidance of Mr. K.S. RAVISIDHAAT, is my original work and is prepared based upon the data and information collected during my internship period is submitted in partial fulfillment of the requirements for the completion of practical training session.

Date: 06/09/2023.

Place: CHENNAI

R. Selva Jothi Blessy.

SIGNATURE OF THE CANDIDATE

ACKNOWLEDGEMENT

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

I convey my thanks to **Dr. DEVYANI GANGOPADHYAY** Dean, School of Building and Environment for providing me necessary support and details at the right time during my internship period.

I express my deep sense of gratitude to **Mrs. KRITHIKA** Head of the Department, Department of Fashion Design, School of Building and Environment, for providing me the assistance and knowledge at the right time during the progressive reviews.

I admire, the great opportunity that has provided to us and all the elements that made a contribution toward my understanding throughout this period I would like to extend my sincere gratitude to **Mr. SENTHIL KUMAR** for giving me this wonderful opportunity of an industry internship program

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

Last but not the least, I would also like to thank all my **FAMILY MEMBERS, FRIENDS AND RELATIVES** who shared their support to me during the Internship period.

BONAFIDE CERTIFICATE FROM COLLEGE



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Ref: SHD/2023/04/24/57

24 April, 2023

BONAFIDE CERTIFICATE

This is to certify that **Ms. SELVA JOTHI BLESSY R**, Register Number **41105015** is a Bonafide student of our Institution pursuing 2nd year **BACHELOR OF SCIENCE** in **FASHION DESIGN** during the academic year **2022-2023**. She will be completing the course in the year **2024**.

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 Nagar, Rajiv Gandhi Salai

Chennai - 600 119.

MAIL REQUEST FROM DEPARTMENT TO COMPANY

Internship of our students
regarding Add label



GAYATHRI N 24 Apr

to sekar, FASHION, bcc: me ▾



Dear Sir,

I am N. Gayathri, working as Assistant Professor in the Fashion Design department of Sathyabama Institute of Science and Technology. Students pursuing B.Sc. Fashion Design degree from our department needs to complete their internship for 21 days in their Second year as a part of their curriculum. We request you to kindly permit our students for their internship in your esteemed organization for 21 days from 11th May to 3rd June 2023. Kindly confirm your acceptance by mail.

please find attached students name list with their register number.

Parkavi. D - 41105012

Sathyasri.S - 41105014

Selva jothi blessy .R - 41105015

Best Regards

N. Gayathri

Assistant Professor

Department of Fashion Design

Sathyabama Institute of Science & Technology

Chennai - 600119

MAIL ACCEPTANCE FROM COMPANY



GAYATHRI N 27 Apr

Dear Sir/Madam, I am N. Gayathri, working as Assistant Professor in the Fashion Design



GAYATHRI N 28 Apr

to me, drparkavipargu@gmail.com ✓



Best Regards

N.Gayathri
Assistant professor
Department of Fashion Design
Sathyabama Institute of Science and Technology
Chennai - 600119

----- Forwarded message -----

From: SCM Garments <sekar@scmgroups.com>
Date: 27 Apr 2023, 10:06 am
Subject Re: internship of our students regarding
To: GAYATHRI N <gayathri.design@sathyabama.ac.in>
Cc: FASHION HOD <fashionhod@sathyabama.ac.in>

Dear Gayathri,

Thank you for approaching us, and it was nice to hear from you about the internship programme. We support young people in learning new facets of the styles and trends that are now popular. will undoubtedly encourage your students to pursue their goals and new learning opportunities.

Thanks & Regards
Sekar
SCM Garments

PERFORMANCE CERTIFICATE

DEPARTMENT OF FASHION DESIGNING

PROFESSIONAL TRAINING REPORT 2023

(continuous progress report of the fashion design trainee for the period of 21 days in the Industry to be submitted to HOD by the trainee in charge the organization)

1. **Name of the industry:** SCM GARMENTS
2. **Address and contact Number:** Anaipudur, Avinashi, Tamil nadu- 641654.
3. **Name of the student:** Selva Jothi blessy .R
4. **Duration:** 11.05.2023 - 03.05.2023
5. **Total no of days:** 21 days
6. **Evaluation of performance criteria shall be on**
* Note: kindly grade the student as per her overall performance in the office during the assessment days, which will be converted to the allotted 40 marks by the department.

Description of works	Excellent	Good	Fair	NA
Understanding of the departments	✓			
Participation in the industry	✓			
Handling the given work	✓			
punctuality	✓			
Coordination with other workers	✓			
Attitude	✓			
Overall performance	100% GOOD			

Compliments & suggestions:



Signature of the head of the office:

CERTIFICATE



TO WHOMSOEVER IT MAY CONCERN

This is to certify that Ms. SELVA JOTHI BLESSY R, Roll. No 41105015,
Studying Hnd-Bachelor of Science in Fashion Design in SATHYABAMA
institute of Science and Technology, Chennai had undergone Industrial
Training from 11.05.2023 to 03.06.2023 in our concern.

During that period her conduct was good.

Place: Tirupur

Date: 03.06.2023

 SCM Garments Pvt Limited


Authorised Signatory



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@scmgrouops.com Website : www.scmgarments.com

INTERNSHIP DETAILS

1. INDUSTRY / ORGANIZATION: EHA SILKS

Mentor Name : Mr. Senthil Kumar

Designation of the mentor: EXECUTIVE (TESCO)

Contact Number : 9944044443

Address : Anaipudur, Avinashi, Tamil Nadu- 641654

2. INSTITUTION: SATHYABAMA INSTITUTE OF SCIENCE AND TECHNOLOGY

Mentor Name : Mr. k. s. RaviSidhaarth

Designation of the mentor: Assistant Professor

Student Name : Selva jothi blessy. R

Department : Fashion Design

Address : Jeppiaar Nagar, Rajiv Gandhi Salai,
Chennai- 600119 Tamil Nadu, INDIA.

DAILY REPORT

DATE	REPORT
15/5/2023	Visiting a Company's Outlet
16/5/2023	Visiting various departments
17/5/2023	Visiting Showroom
18/5/2023	Storeroom process
19/5/2023	Types of machineries
20/5/2023	Bundle system
21/5/2023	Production process
22/5/2023	IE (Industrial Engineering)
23/5/2023	Sewing Department
24/5/2023	Quality check department
25/5/2023	Checking and AQL Department
26/5/2023	AQL Department
27/5/2023	Ironing, Folding and tagging
28/5/2023	Presentation Department
29/5/2023	Finishing Department
30/5/2023	Washing Department Testing Department
31/5/2023	Testing Department
01/6/2023	Field work
02/6/2023	Field work
03/6/2023	Field work
04/6/2023	Field work

INDEX

S.NO	CONTENT	PG.NO
1	INTRODUCTION	15
2	SEQUENCE OPERATION	20
3	PLAN LOCATION AND LAYOUT	21
4	IE (INDUSTRIAL ENGINEER)	22
5	SAMPLING DEPARTMENT	23
6	PATTERN MAKING	25
7	FABRIC STORE DEPARTMENT	27
8	CUTTING	28
9	SEWING	33
10	FUSING	36
11	GARMENT INSPECTION	37
12	QUALITY DEPARTMENT	39
13	QUALITY CONTROLL(QU)	41
14	GARMENT WASHING	43
15	FABRIC SHRINKAGE	44
16	TIME STUDY FORMAT	45
17	METAL DETECTION- SOP	47
18	HEAT TRANSFER- SOP	48
19	BUTTON ATTACHMENT- SOP	49
20	LABLE MANAGEMENT- SOP	50
21	POPPER, RIVERT AND PRESS STUD ATTACHMENT	52
22	PRESSING- SOP	53
23	FINISHIND DEPORTMENT	54
24	PACKING	60
25	MERCHANDISER	62
26	EXPORT	63
27	CONCLUTION	64
28	BIBLIOGRAPHY	65

ABSTRACT

The report is on garment manufacturing process in SCM garments, Avinashi. This report is made on practical knowledge on how garment is made, what are the procedure followed etc. This report is made by observing, discussing with related people, taking information from files analysis standard of SCM garments. In this report I discussed about different departments in garment industry, how department are interrelated and what is the work flow etc. I hope this report gives a complete information on garment manufacturing.

1.INTRODUCTION

Training implies a process of upgrading an individual's knowledge, skills and competencies. When an employee joins the organization, he/she is given job-related training to ensure satisfactory performance of the tasks and duties assigned, so that the employee can contribute more to the organization.

On the other hand, development has a long-term view. It is all about preparing the employee for the current as well as future jobs, by providing them with learning opportunities to increase their capacities, to undertake more challenging complex tasks

1.1 COMPANY PROFILE

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

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've 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 foot-prints in the history of garment industry

1.2 MANAGEMENT TEAM

Being the extreme innovators and believers in game-changing businesses of the future, our Management team is known for challenging conventional wisdom and spotting opportunities quickly. A leadership team personifying excellence and execution, they are never short of creating disruptive next practices and generating exponential value – for the company, for the nation and for the people.

1.3 FOUNDER

SCM Garments sets sight on even more ambitious goal, remain inspired and guided by the story and philosophy of the founder Shri. A. Kulandaivel Mudaliar. It has adopted of converting adversity into opportunity and making impossible into possible by challenging conventional wisdom.

1.4 MILESTONE

1989- SCM garments was established with its foray into the textile domain.

1993- SCM set up its turnkey knitting unit.

2003- SCM established its own textile spinners.

2005- SCM established its own textile spinners.

2016- SCM established its own textile spinners.

2017- SCM factory international production into Ethiopia.

GROUP

SCM SPINNING MILLS

SCM KNITTING MILLS

SCM PROCESSING

SCM GARMENTS

SISTERS CONCERN

SCM Textile Spinners,

The Chennai Silks,

SCM Energy Divisions,

The KTM Jeweler Private Limited,

Aathava Garments India Private Limited,

1.5 Sister concern



Figure 1- Textile Spinners logo



The Chennai Silks

Figure 2- The Chennai Silks logo



Sree Kumaran
THANGAMALIGAI

Figure 3- Sree Kumaran Thangamaligai logo



Figure 4- Shri chendhil murugan logo

1.6 PRODUCTS OFFERED

SCM Garments offers variety of products like
Kids wear,
Women's wear,
T- Shirts,
Winter wears,
Summer wears.

1.7 MAJOR CLIENTS

Tesco, UK
Hema, Netherland
Lindex, Sweden
Kiabi, France



Figure 5 -In Field – presentation work



Figure 6- Showroom – Group discussion

2.Sequence of operation



Figure 7-Garment manufacturing process

3.PLAN LOCATION AND LAYOUT

Sri Cendhur Murugan GARMETS PRIVATE LIMITED is a huge organization located at Tiruppur, South Africa and Ethiopia. It is one of the largest Textile Kingdom in Tamil Nadu Head office is located at VALAYANKADU TIRUPUR. It consists of 55 units around Tiruppur District. SCM Garments Unit -9 is located at Anaipudur, Avinashi. Department location in

Unit 9:

3.1Floor layout

Ground floor- Separate building for storage of raw materials, fabric separation area

1. Separate block for fabric inspection area final output storage area.
2. Separate block for pressing and ironing.

First floor - first floor consist of stitching department, sampling area, trimming and checking area, accessories store.

Second floor - Second floor consist of stitching department, sampling area, trimming and checking area, accessories store.

Third floor - Third floor consist of stitching department, sampling area, trimming and checking area, accessories store.

3.2 PRODUCT OR LINE LAYOUT

All the process equipment and machines are organized in line with the sequence of operations of the product, the layout is named product kind of layout.

During this kind of layout, only 1 product of 1type of product is made in an operational space. This product should be standardized and made in large quantities so as to justify the layout. The material is provided at one finish of the line and goes from one operation to subsequent quite rapidly with a minimum add method, storage and material handling.

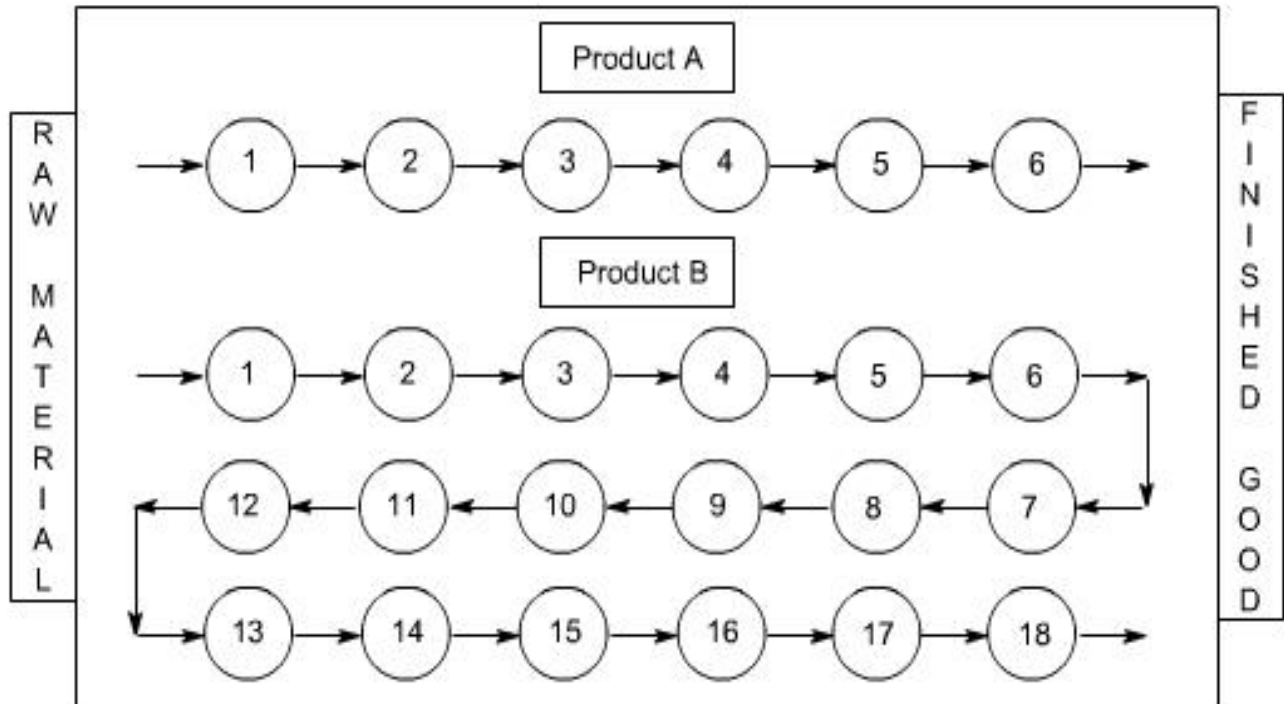


Figure 8-Line layout

4.IE (Industrial engineer)

4.1 IMPORTANCE OF IE

- IE place a vital role in garment industry, because of exporting garment to other countries and the constant growth of foreign exchange is increased.
- Developing and implementation process improvements and technological upgrades, reviewing production schedules, processes, specifications and information.
- Designing production processes that maximized efficiency and reduce waste

4.2 RESPONSIBILITY OF IE

- Design control system to minimize costs and production issues
- Develop design and production standards in cooperation with management and user personnel.
- Design the layout of facilities and determine personnel requirements.
- Train staff for new processes and provide instructions and manuals.

4.3 Industrial Engineering Process Flow

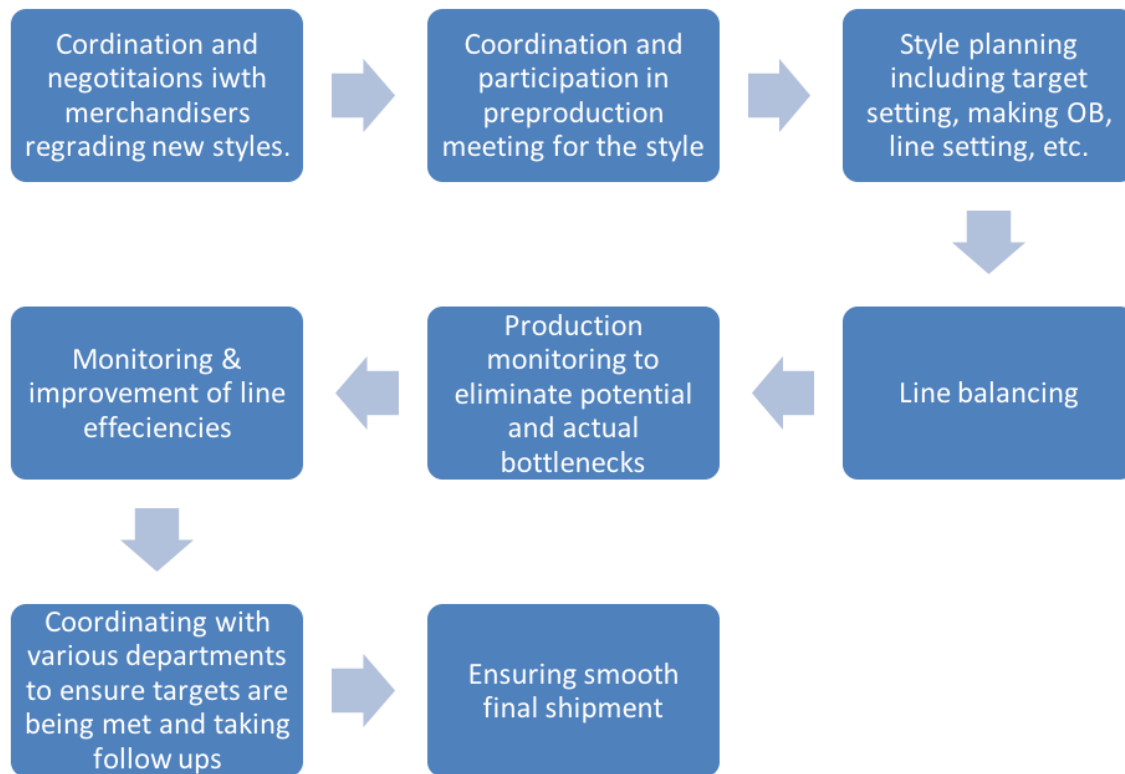


Figure 9-This is the flow chart flowed by IE

5.SAMPLING DEPARTMENT

In any garment industry the first stage for garment production is sampling. From sampling, we get information related to cost, timing, labor and production of garment production. The buyer can also be satisfied by sampling. Sampling is also giving us market knowledge along with another knowledge of garment production. After checking the quality of the sample, the buyer either allows to manufacturer or cancels the deal that the buyer had made to the manufacturer to produce. In other words, the sample in garment production is as important as the foundation in building a house.

Garment approval or order approval is given by the buyer only after sampling That is, it would not be unfair to say that garment production is possible only through samples. In fact, the first phase of garment production is sampling. The process of making the garment starts only after the sample is approved.

To produce any garment, a mail is sent by buyer to the merchandiser or manufacturer, also known as a tack-file, spec sheet or order sheet. This order sheet contains all the information related to garment. Such as product style number, code, measurement of all parts of the garment and stitches types, garment reference number, color specification types of fabric and its quality, embroidery or

types of print and other accessories used in making the garments Such as thread and button, zipper, stud etc. occur.

Now the merchandiser or manufacturer study the order sheet sent by the buyer and prepare the garment samples according to buyer. Sampling for the buyer is completed by the manufacturer in various stages and the buyer is satisfied with these samples so that order can be obtained from him. Now we will discuss here about various samples to be prepared for the buyer in the garment industry. The typical samples namely described as

5.1 PROMOTION OR SALESMAN SAMPLE

Promotional samples are also called salesmen samples. The manufacturer uses genuine textiles and accessories to make this sample. It is a high-quality sample. The retailer or buyer has to pay to get it

5.2 PROT SAMPLE

The first sample that is prepared after the order sheet is received from the buyer is called the proto sample. In this sample, this sample is prepared using accessories, similar to the order sheet and fabric. And after that this sample is sent to the buyer. After getting approval of this sample by buyer, the process of making fit sample starts.

5.3 FIT SAMPLE

Fit sample is made again after the proto sample approved. All the details of the order sheet sent by buyer to make the fit sample are taken into consideration and this sample is prepared by actual design, fabric and accessories. The garment construction and garment measurement is also taken care of in the fit sample. The fit sample is prepared and worn by the model within a given time, it's fitting etc. is checked and sent to the buyer. After the fit sample is approved by the buyer, preparation is made to make the size set sample

5.4 SIZE SET SAMPLE

Small, medium, large size, etc. samples are made under the size set sample. Size set samples are also prepared according to order sheet sent by buyer. When the size set samples are also approved by the buyer then the manufacturers proceed in the process of bulk fabric cutting

5.5 PRE- PRODUCT SAMPLE

Samples are the samples, which are made in the production department once all the above sampling approvals are received. They are made with the actual fabrics, trimmings, and accessories that will be used in the future placed order. After a full and final approval is received from the buyer, the actual production can proceed.

5.6 TOP SAMPLE

Top samples that are picked up in between, once the manufacturing process has begun. All buyers do not demand for top of production samples, but some do, to make sure that the garments being manufactured are as per the decided specifications.

5.7 SHIPMENT SAMPLE

Shipment samples are sent to the buyer when the completed garments are packed and are ready to be shipped. These samples are sent in cases when the garments are directly delivered at stores or warehouses of the buyers, to view the final product and its packaging.

5.8 RESPONSIBILITIES OF SAMPLING DEPARTMENT IN APPEREL INDUSTRY

Sample department of apparel manufacturing industry has to maintain the below responsibilities:

- Getting clarifications about style details from the merchandiser,
- Checking patterns work-ability,
- Preparation of different samples and getting the buyer's approval,
- Informing quality-related problems, encountered during preparing samples to QC,
- Minimizing operations and consumption

6. PATTERN MAKING

6.1 WORKING PATTERN

The working pattern is a detailed blueprint of a garment made without allowances, primarily used for sample making. It involves tracing basic pattern blocks on paper and labeling each piece with its part name and corresponding garment size. Through fittings and adjustments, the pattern is refined to achieve the desired fit and design. It is then transferred onto fabric to create a test fit sample. Further modifications may be made based on feedback from the test fitting to ensure optimal fit and comfort. After multiple iterations, the final pattern is approved and serves as the template for manufacturing the garment in various sizes. This meticulous process ensures the garment matches the original design vision and provides a well-fitting.

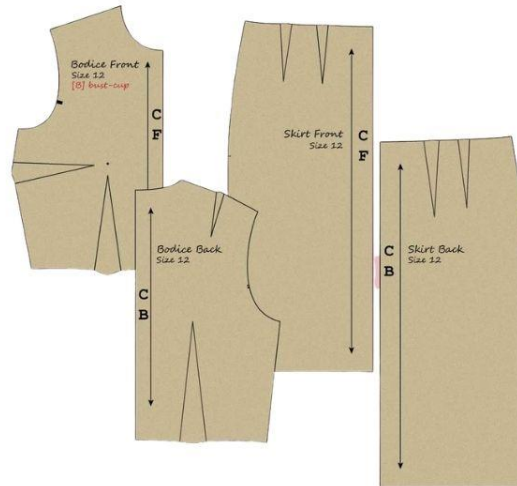


Figure 10- This is working pattern

6.2 PRODUCT PATTERN

A production pattern is a blueprint detailing exact dimensions for a product style. It includes allowances to account for minor variations during manufacturing, ensuring consistent and high-quality end products.

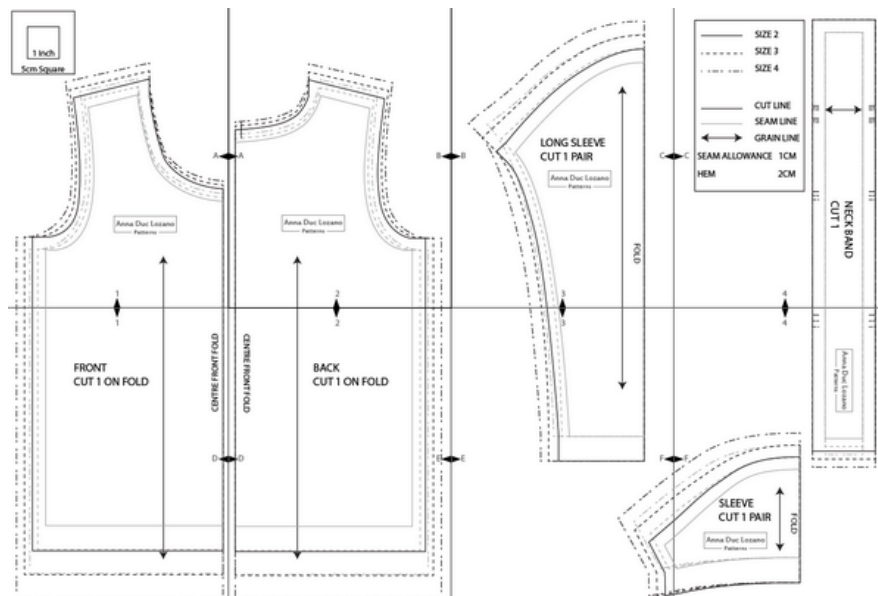


Figure 11- This is product pattern

7. FABRIC STORE DEPARTMENT

For a bulk production industry, it is essential to maintain a well-organized and well-equipped inventory system. The main responsibility of fabric store department is to store all the raw materials specially fabric necessary to produce garments. This department is sub divided into three sections. Inventory can be described as stock maintained between any two processes for uninterrupted operation. It can also be defined as assets that are intended for sale, or are in the process of being produced for sale, or are to be used in producing goods. Inventory is primarily maintained due to two reasons—to optimize the sourcing cost (where requirement can be predicted) and to minimize the risk of stock out (where requirement cannot be predicted).

The higher the inventory, the higher the capital blockage, and/or the higher the space requirement; on the other hand, lower inventory may lead to disruption in production or unsatisfied customers. Therefore, managing inventory is very important for a garment factory. The main goal of all the garment production systems is to decrease the total production time which leads to reduction in inventory cost.



figure 12- Fabric store

This department's main responsibility is to store all the raw materials needed to make the garments.

Main Responsibility of Fabric Store Department



8. CUTTING

In the view of modern garments business, it's seen that quality is the first requirement of all the buyers around the world.

In garments manufacturing, Cutting is an important process to make a quality product. Quality full fabric cutting reduces the wastage of fabric and makes the business profitable. To achieve quality full fabric cutting, a few methods have to maintain which are discussed in the following.

8.1 METHODS OF FABRIC CUTTING

In the garments industry, there are two available cutting methods, are-

- Manual Method,
- Computerized Method

8.2 MANUAL FABRIC CUTTING MACHINE

Here cutting process is done by using a knife, scissors, drill, etc. The knife is placed in the head of the cutting machine. The manual method is the most used cutting method in the garments industry.

The manual cutting method can be done by using the following equipment:

8.3 ROUND KNIFE

This machine is called round knife cutting machine because its cutter is round but slightly octagonal in shape. It is also called rotary knife cutting machine. This machine is small in size, flexible and used for small production. It is also a popular cutting machine. Round blade cutting machines are used to cut large and medium-size components of simple shape from low-fabric spreads or to cut single articles from one or two material plies. The machine is moved along the cut contours, while the fabric spread remains in a fixed position. Round-knife machines are the most effective for cutting slippery materials as the rotary movement of the knife ensures the continuous compression of the fabric plies. Round-knife cutters are lighter (between 3 and 11 kg) than straight knife cutting machine and are therefore easier to move.



Figure 13- Round knife

8.4 BAND KNIFE

Band knife machine is a special cutting device used in sewing and furniture industries, which allows to evenly and accurately cut fabric, upholstery foam or other soft materials used in clothing and furniture industry. The band knife cutting machine significantly reduces material cutting time compared to vertical and circular knives, and also minimizes the number of uneven cuts the choice of band type depends on the material to be cut and the thickness of the stack and the machine itself, there are different models of band knife machine available, which differ in the arm gap size (the distance between the band and the body), the type of tabletop, the ability to adjust the speed of the cutting band, the availability of dust removing vacuum system, and by the type of the control panel. The band knife machines are used for cutting materials such as: cotton, upholstery foam, wool, silk, linen, synthetic fabrics, leather, cardboard, insulation, air filters.



Figure 14- Band knife

8.5 STRIGHT KNIFE

Straight knife cutting machine is used to cut components of differing size. This is the most frequently used equipment for cutting garments in bulk. It is moved along the cut contours, while the fabric spread remains in a fixed position. The machines are manurable and capable of curvilinear cutting. Straight-knife cutting machine is the world's most popular and most versatile. Available in all standard electrical configurations, with the largest variety of sizes and blade speeds in the industry. It is the most useful cutting instrument in garment cutting. In apparel industry, more than 99% cases this knife is used.



Figur e 15- Stright knife

8.6 SCISSOR

These fabric scissors have been used for years by tailors and are known to cut fabrics with ease and precision. They are considerably large and heavy but amazingly built to simplify the task of tailors and other craftsmen. They are the best instruments to cut different types of cloth materials, leather, and other materials used to design clothes.

With time and traditional usage, the tailors' scissors are extremely reliable and popular. They have a unique design with razor-sharp blades, and they are also very long-lasting. Modern technology has also renovated it to fit other purposes. You can check the living premium tailor scissor for cutting cloth and fabrics with accuracy.



Figure 16- Scissor

8.7 DIE- CUTTING

Die cutter is a special type of cutting instrument. It is generally used for leather technology. It is not suitable to cut large parts. Sometimes, it is used for. Garment cutting Basically, die-cutting machines are used to convert web or sheet materials into shapes. Therefore, they are used for processing woven fabrics, non-woven textiles as well as rubber sheets.



Figure 17- Die-cutting

8.9 DRILL

Drill and notched are other types of cutting instruments in the apparel industry. It is specially used to mark and cut at corner points where necessary. The following are the uses of drill and notched cutting machines in apparel manufacturing. They are-

1. Button and Button hole making.
2. Pocket placing for shirts, coats, trouser etc.
3. Notched is used to identify folding line, seam line etc.

So, straight knife, band knife, round knife, die cutter, drill, and notched are mechanical instruments for fabric cutting. Every cutting instrument is essential for completing the full cutting operation.



Figure 18- Drill

8.10 COMPUTERIZED FABRIC CUTTING METHOD

In the modern clothing manufacturing industry, the computerized cutting method becomes so much popular day by day due to its higher production and less time-consuming efficiency. Here all programs are loaded into the computer and the computer performs all the activities which are loaded.

The computerized Cutting method can be done by using the following equipment:

- Water jet cutting
- Laser beam cutting
- Plasma torch cutting



Figure 19- Computerized cutting machine

9.SEWING

9.1 SEWING LAYOUT LINE

The sewing line layout can be defined as the way sewing workstations are placed in the sewing floor to form a line (or batch) that works on single style. The purpose of choosing one line layout

over other is to achieve best production with existing resources. The line layout in a factory is not changed frequently.

After receive the garments components from cutting section, all the garments' parts are joined and sewn as sequentially. Obviously, all the components are sewn respects on buyer requirement. Sewing section is the most important department of a garment manufacturing industry. Sewing machines of different types are arranged as a vertical line to assemble the garments. Sequence of types of sewing machine arrangement depends on sequence of assembling operations

$$\text{Efficiency} = \frac{\text{Earn minute}}{\text{Avaibility minute}} * 100$$

$$\text{Earn minute} = \text{line output} * \text{SAM (Standard Allowed Minute)}$$

$$\text{Available Minute} = \text{man power} * \text{working hours}$$

$$\text{Target} = \text{man power} * \frac{\text{Working hours}}{\text{SAM}}$$



Figure 20- Sewing line

SEWING SECTION

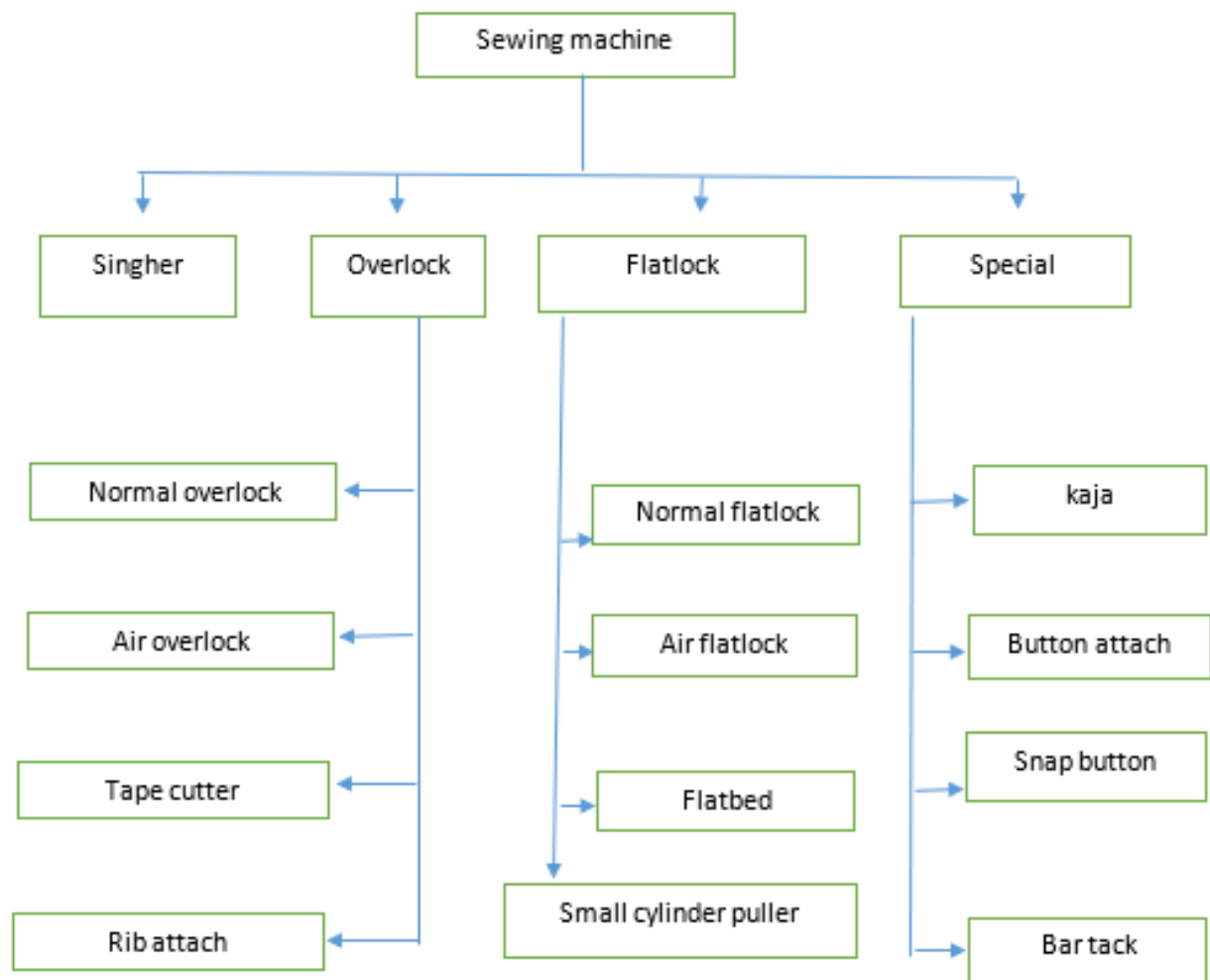


Figure 21- sewing layout

9.2 TYPES OF SEWING MACHINE

- Embroidery Machine
- Lockstitch Sewing Machine
- Flat lock
- Over lock
- Buttonholing Machine
- Button Attachment Machine
- Bar-Tacking Sewing Machine
- Double-Needle Sewing Machine

9.3 SEWING-SOP

- All necessary Equipment's/Machineries with good will be available in the production floor
 - Red seal sample along with comments should be available on production site prior to line feeding
 - Cut work will feed to the production lines along with bundle card (Style, Size, Color, lay no details) & 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
 - Work in progress (WIP) must be clearly labelled with internal use and product details and protected from contamination where necessary
 - 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 (inside & outside)
- Any out of specification findings must be recorded by the in-line & end-line examiner. Both corrective and preventative actions must be agreed and implemented
 - 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

10. FUSING

Fusing is a base fabric having a deposition of thermoplastic adhesive resin which can be bonded to another fabric by the application of heat and pressure.

Regardless of which fusible and machine are used, fusing is controlled by four processing components – temperature, time, pressure and cooling and these have to be accurately combined in order to achieve the optimum results

10.1 FUSING -SOP

- Interlining must be sourced from Tesco Nominated interlining suppliers
- Fusing machine must be well maintained & in good condition
- Fusing machine will be set according to data sheet

(Temperature/Pressure/Time) provided by nominated interlining supplier

- Fusing 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
- Fusing bond strength tests must be carried out on regular intervals
- Durability wash test will be carried out on each batch and fused stock is held on a 'positive release system' until wash test results are confirmed
- Fusing 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 color change must be assessed for every fabric batch/dye lot



Figure 22 Fusing machine

11. GAREMENT INSPECTION

11.1 CLOCK WISE INSPECTION

Checkers and auditors inspect garments at the end of a line, in finishing and in various audit stages. All do garment inspection but not the right procedure. An effective inspection procedure would help you to increase the quality of the inspection job as well as productivity on this task. n this article, a standard method of garment checking has been explained step by step. A Polo shirt has

been taken for example. Inspection of a garment is done in a clockwise direction as shown in the following figure.



Figure 23- clock wise

- First, check appearance by holding the garment at shoulder points. Examine the front and back of the garment.
- Lay the garment flat on the audit table. Check for garment details.
- Open and check center front opening.
- Inspect inside and outside of the collar and Neck. Inspect inside shoulder seams
- Fold garment forward at the shoulder and check back neck.
- Check the tension of the neck seam. Stretch out to full extent.
- Inspect left shoulder seam. Inspect left armhole seam.
- Fold left sleeve across the front of the garment. Inspect left back armhole. Check for shading.

- Inspect left sleeve cuff outside and inside. Check the tension of the left cuff seam. Stretch out to full extent.
- Inspect the left underarm. Inspect the left side seam.
- Check the tension of the left underarm seam. Check the tension of left side seam.
- Inspect bottom outside and inside, front and back.
- Check the tension of the bottom hem. Stretch out the bottom to a full extent.
- Inspect right side seam. Inspect right underarm.
- Check the tension of the right-side seam. Check the tension of right underarm seam
- Inspect right sleeve cuff outside and inside. Check the tension of right sleeve cuff. Stretch out to full extent.
- Fold right sleeve across the front of the garment. Inspect right back armhole. Check for shading.
- Inspect right armhole seam. Inspect right shoulder seam.
- Turn garment over. Lay garment flat on the audit table. Examine style details and examine uncheck seam on the back.
- Turn garment inside out. Lay garment flat on the audit table. Inspect for obvious defects. Examine unchecked seams on the inside.
- The above steps can be used for other garment products by covering product specific quality requirements. The origin of this article is the Adidas quality manual.

12. QUALITY DEPARTMENT

Quality is of prime importance in any aspect of business. Customers demand and expect value for money. As producers of apparel there must be a constant endeavor to produce work of good quality.

In the garment industry, garment quality control is practiced right from the initial stage of sourcing raw materials to the stage of a final finished garment.

12.1 The cost of quality

- More waste means less profit
- Poor quality will damage your chances of winning new business
- Consistent defects can ruin relationships with your customers or stop a brand launch in its tracks.

The following examples can be classed as defects within garments and textiles:

- Different within the same garment
- Fabric defects
- Exposed notches
- Loose or Hanging threads
- Pulled or Loosed yarns
- Holes
- Defective stitches
- Stains



Figure 24- Quality checking

12.2 ACCEPTABLE QUALITY LEVEL(AQL)

AQL is one of the most frequently used terms when it comes to quality in the apparel export industry. As most of the acceptance decisions of the apparel shipments for the export market are made on the basis of AQL based sampling plans. AQL means Acceptable Quality Level. In any business process, before accepting the finished goods from the manufacturer buyer do inspection of goods. It is so much important in export garment sector. Because foreign buyers are so much concern about product quality. They give AQL on the product to the manufacturer. Buyers do inspection of goods as randomly process. If AQL pass that means goods are in acceptable quality level he gives certificate to ship the goods. The AQL level varies process to process, product to product and even buyer to buyer. In the following table a sampling plan is given for final shipment inspection. Acceptance Quality Level (AQL) refers to the maximum number of defective items that could be considered accepted during the random sampling of and inspection. The defects that are found during inspection are classified into 3 categories:

1. Critical: Must be 100%accurate. There is no range.
2. Major: Normally 2.5%
3. Minor: Normally 4%

13. QUALITY CONTROLL (QC)

13.1 QC IN GAREMENTS MANUFACTURING

Quality control in garment manufacturing is an important part in the production process, where the garments are assessed for quality and defects are identified. Quality control (QC) is called often as production inspection.

Quality control in garment manufacturing should take place at different stages in the production process, where the raw materials are inspected before production begins, semi-finished goods and finished goods are also assessed. During quality QC, a number of things can go wrong and could have ripple effect in the entire production line. If the quality of the raw materials is poor, the finished products will very likely be of poor quality; similarly, if the sewing of garment components is incorrect, the final products will be highly defective.

Apart from detecting defects and improving efficiency, the quality control stage is also crucial to maintaining brand integrity. Correcting manufacturing problems at early stages lines can prevent

future issues, as well as saving money by reworking or retooling parts that are faulty. If defects are found at the later stages, one could also identify the root causes and improve in next production batches.

13.2 QUALITY CONTROL STANDARD

Here are some of the main considerations for garment manufacturers and exporters:

- To check raw materials and confirm for use in cutting, sewing processes.
- Check cutting quality, patterns, cut parts.
- Check the sewing process, do 100% inspection of stitched pieces and move quality garment for finishing.
- Checks garments after washing and finishing stage up to packing of goods.
- All the above checks are necessary to avoid failure of final inspection, rejection of shipments and control over manufacturing cost.
- It is to be noted that the importance of controlling garment quality may vary for the other part of the supply chain.



Figure 25- points of QC

14. GAREMENT WASHING

Garment washing is normally done after garment stitching. According to the fashion trend and the customers' demand, buyers ask for garment washing for specific product ranges. For the washing, apparel buyers mention exactly what types of washing they need for the order.

For example, I worked with the buyer Tom Tailor and made t-shirts and polo shirts. They asked for garment washing like – Vintage wash, Cloud wash, enzyme wash, softener wash or Acid wash. Each wash has different types of appearance on the fabric surfaces. Wash types mainly depend on product types. For denim product, a heavy enzyme wash is required where for the knitted T-shirt, light softener wash may be okay.

14.1 IMPORTANCE OF GARMENT WASHINH

The primary objectives of garment washing

- To remove starch that applied during fabric manufacturing.
- To soften the garment hand, feel and improve bulkiness
- To remove dirt, spots, oil stains that accumulate to the garment at the garment manufacturing processes.
- To remove chemicals used during the printing process and embroidery process

As mentioned above, sometimes you wash garments to meet customer requirement.

- Washed clothes can be worn directly after purchasing
- To give a faded look or any other color-tinted look to the garment.
- To stabilize garment shrinkage and dimensional instability
- To improve bulkiness and soft hand feel

To have an idea about washes, common garment washing types are explained below.

14.2 .1 STONE WASH

To get faded look on the garment surface white stone is used with enzymes during washing. During washing fabric come in contact with stones and by rubbing color fades. Stonewash generally used for denim product washing.

14.2.2 ACIDE WASH

For acid wash, the base color of the garment taken out by spraying acid on the specified areas.

14.2.3 HEAVY ENZYME WASH

Vintage means old look. To get the old or used appearance garments are washed inside the washing machine with enzymes. Fleece sweatshirts are washed with the heavy enzyme.

14.2.4 CLOUD WASH

Cloud wash gives the appearance of white patches on the garment surface that looks like a cloud in the sky.

15. FABRIC SHRINKAGE

The textile fabric has a common feature that it shrinks in wet processing. Shrinkage means the length of the fabric gets shorten after wash. So, prior to cutting fabric for bulk production, you must check its shrinkage percentage in washing. The shrinkage percentage needed to add to the production pattern. Otherwise, you would not get garment of correct fit and measurement could not match the specification sheet.

This post will discuss how to calculate fabric shrinkage percentage by your own at home or in a factory.

15.1 FABRIC SHRINKAGE CALCULATION

Before washing – After washing (100- 95 = 5)

$$= \frac{5}{\text{Before washing}} * 100 \left(\frac{5}{100} * 100 = 5 \right)$$

Fabric shrinkage = 5%

16. TIME STUDY FORMAT

This format is used to calculate the work time of the employees a calculation of SAM and target of HR.

This includes

- Operation name,
- Cycle time- 5 readings
- Average cycle time
- Standard minute value
- With allowance
- SAM

- HR target
- Day target 100%.

16.1 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.

16.2 STANDARD ALLOWED MINUTE(SAM)

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.

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.

16.3 SAM CALUCTION

Per operation time (using stopwatch) = 5 time

$$\text{Average cycle time} = \frac{5 \text{ times}}{5}$$

SMV (Standard Minute Value) = average cycle time
60

Allowance = (company has allotted a certain % for the workers) that is 15%.

$\text{SAM} = \text{SMV} * \text{ALLOWANCE}$

$$\text{HR Target} = \frac{60}{\text{SAM}}$$

Day target= HR target * 100.

E.g.: For efficiency

Line output = 1000

SAM = 5.2

Man power = 15

Working hours = 600

$$\text{Therefore efficiency} = \frac{5200}{9000} * 100$$

$$\text{Efficiency} = 57\%$$

For SAM

Cycle time = 10, 12, 13, 14, 15

$$\text{Avg cycle time} = = \frac{10+12+13+14+15}{5}$$

Avg.cycle time = 12.8

$$\text{SMV} = = \frac{12.8}{60}$$

$$\text{SMV} = 0.21$$

$$\text{Allowance} = 15\% = 1.15$$

$$\text{SAM} = \text{SMV} * \text{ALLOWANCE}$$

$$= 0.21 * 1.15$$

$$\text{SAM} = 0.241$$

For target

$$\text{HR Target} = = \frac{60}{0.241}$$

Target = 248 hours

Day target = 100 * target

Day target 100 % = 24,800.

17. METAL DETECTION-SOP

- Metal detector machine/equipment must detect Ferrous component & machine must be with conveyor belt and an audible alarm which must be purchased from approved machine brands
- The metal detector must be located in a dedicated and clearly identifiable area. The exit/feed off side of the metal detector must be a 'Metal Free' area
- 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
- Metal detector operators must be trained against the manufacturer's instructions in the correct usage of the metal detection machine
- 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
- All detected goods must be held in a "Metal Free" area and only released after a further positive 9-point system check has been conducted
- All Tesco products must pass through metal detection process & recorded. The product must have all labels, swing tickets and packaging attached
- When the alarm sounds all garments on the conveyor belt must be placed in a rejection bin for inspection before being passed through the metal detector again. Only garments that pass this second test are acceptable
- Products rejected again must be searched to find the contaminants that have triggered the alarm
- Once the contaminant is identified and removed, all garments must pass successfully through the metal detector again before being accepted
- Any contaminant detected must be kept with documentation confirming source of contaminant and action taken to prevent future contamination
- If metal detector machine is failed to detect a test piece, all products that have been checked since the previous positive test must be quarantined and retested through a unit that has been verified to be working correctly
- The metal detector must be serviced at regular intervals (minimum annually) by the manufacturer or an engineer from an approved suppliers list. Details of the services must be recorded and retained



Figure 26- Metal detection machine

18. HEAT TRANSFER - SOP

- Heat Transfer machine must be well maintained & in good condition
- 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
- Fabric shrinkage and color change must be assessed for every fabric batch/dye lot

- 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.



Figure 27-Heattransfer machine

19. BUTTON ATTACHMENT-SOP

- Lockstitch button attach machines must be used with thread wipers. Hand sewing or chain stitch is not to be used
- A physical standard of the positioning must be available at all machines
- Pull test must be performed after button attach operation according to requirement (childrenswear- 90N, Adultwear-70N)
 - For Shirts - 2 holes button sew machine with a 2mm shank & min 14 sts & 4 holes button sew machine with a 2mm shank & min 24 sts. A shank is not acceptable for kids & baby products.
 - A thread tension system must be in place to ensure correct tension achieved after bobbin change
 - 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
- All button machines must be serviced on a regular basis with records to demonstrate



Figure 28- Button attachment machine

20. LABEL MANAGEMENT- SOP

- All types of labels must be sourced from nominated suppliers
- Packaging supplied to the production line must be controlled and checked to ensure it is correct and for the right product
- The material and labels must be stored in a controlled area until issued to the production. Records of packaging supplied to the packing line must be maintained
- Label 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 operators must be issued with a copy of "product number" for the style in production

- Packers must be issued with Bar-code number to check on a size/color basis
- Replacement labels issued due to loss, damage or incorrect issuing must be issued on a controlled basis and records kept
- All spare labels must be returned to secure storage and at the end, all remaining labels must be returned to central store once contract is completed
- Barcodes on all packaging must be checked against Tesco issued information before the packaging is used
- On line printed bar codes must be checked and recorded at regular intervals
- Stocks that rejected/leftover identity all F&F labelling/branding shall be totally removed by the Supplier prior to disposal of the stocks and 6 months after shipment
- It is the suppliers responsible to ensure that any fiber composition brand names meet the legal requirements for the country that it is intended to be sold e.g., Spandex is not accepted in Europe
- Velour, velvet, fake fur etc. - where the fiber composition is different, the face must be quoted separately from the back, e.g., face 100% cotton, back 100% nylon (NOT 50% cotton 50% nylon)



Figure 29- Label checking

21. POPPER, RIVET AND PRESS STUD ATTACHMENT-SOP

- All metal buttons/poppers/eyelet/rivet must be sourced from nominated supplier
- Popper, rivet and press stud attachment machines must be pneumatic
- Pinch gauge settings are established at the beginning of the contract
 - with records available
 - Technical data sheets must be established, approved by Tesco at preproduction and production stage and available at every machine
- Pull test must be performed for all types of poppers/ rivet/ press stud according to the requirement (childrenswear- 90N, Adultwear-70N)
- Machines are segregated from the production floor to reduce the risk of metal contamination
- All poppers/ rivet/ press stud machines are positioned on a 'gridded floor' to allow for the capture of any spilt parts
- Popper, rivet and press stud attachment type and manufacturer of the attachment used matches the machine
- All button, Popper, rivet and press stud machines must be serviced on a regular basis with records to demonstrate



Figure 30- Button pull test machine

22. PRESSING -SOP

- All necessary Equipment's/Machineries with good will be available in the Pressing & Packing section
- Where pressing is required, at a minimum, 'hand steam irons' that produce dry steam and vacuum tables with a strong vacuum must be used
- Stock must be stored after pressing so that it doesn't crease and retain moisture (example-hanging rail/stored in min qty)
- All Tesco products must be packed in a dedicated area which is clean, Tidy and good Lighting
- An approved packing standard must be available at packing area
- All labels & hang tags must be stored securely and independently by style/Size/color
- 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
- The site must not use pins to pack Tesco product in packing area
- If the nature of the stain or base material requires a cleaning chemical to be used, the cleaning area must be well ventilated and the chemical(s) must be kept in a designated store with restricted access
- Procedures must be in place to ensure that the correct numbers of items are present in the pack when a number has been declared
- All finished goods must go through a systematic AQL process prior to the shipment. This must be carried out against the required Tesco AQL level as defined in the Tesco clothing Manual



Figure 31- pressing

23. FINISHING DEPARTMENT

Finishing is the last step of the garment production and all mistakes made during the process accrue and become a huge problem at this stage.

In the production department garments are stitched by sewing machines. Stitched garments are finished in the finishing department. Finishing activities are performed prior packing garments into poly bags. The major activities of a finishing department include thread trimming, checking garments and ironing.

23.1.1 THEREAD CUTTING

In the stitching department, thread trails and thread chains are not trimmed neatly. Uncut threads and thread tails in garments are trimmed in the finishing department by helpers. Uncut and loose threads on garments are considered defects.



Figure 32- Thread cutting

23.1.2 GARMENT CHECKING

All garments are checked at the finishing stage for visuals and measurement. Finishing checkers check the complete garment inside and out. Checking is done for garment detailing, such as care labelling, and trims.



Figure 33- Garment checking

23.1.3 REMOVING STAIN

Stains and spots are found on garments. Spots are removed using a hand spot gun or by using a stain removing machine prior to pressing. Dust and stains can be removed by machine washing. So, many times finishing department wash garments inside department



Figure 34- Removing stain

23.1.4 BUTTONS ATTACHING

Products those have trimming like button, snap button, eyelets are attached in finishing section . In the finishing section of a manufacturing process, various products may undergo trimming and attachment of components like buttons, snap buttons, and eyelets to achieve their final form and appearance. Here are some products where these finishing touches are commonly applied



Figure 35- Button attachment

23.1.5 IRONING

Garments are ironed using a steam iron. This is done to remove creases in the garment. For knitted garments measurements are set by steam press. Vacuum pressing tables are used for garment pressing.



Figure 36- Ironing

23.1.6 FOLDING AND TAGGING

Pressed garments are folded in a specified dimension. Tags, such as price tags and hang tags are attached to the garment by means of a Kimble gun or threads.



Figure 37- Folding and tagging

23.1.7 PACKING THE GARMENTS

Finally, properly folded garments are packed into poly bags as per customer requirements. Individual poly bags are then packed into bigger cartons.



Figure 38- Packing the garments

23.1.8 PREPARING OF PACKING LIST

The packing in-charge prepares a packing list for the shipment. After packing is completed for an order, the finishing department informs the concerned merchant.

ORDNUR APPARELS LTD

FINAL PACKING LIST

INVOICE NO	
BUYER	
P.O NO	
STYLE NO	
DESCRIPTION	

DATE :	1-Feb-19	
ORDER QTY :	5000	PCS
SHIP QTY :	5066	PCS
EXCESS / SHORT :	66	PCS

CASE NO	COLOR	SIZE									PCS PER CTN	TOTAL CTN	TOTAL QTY	GRAND TOTAL
		29	30	32	33	34	36	38	40	42				
	BLACK	40									40	2	80	103
		23									23	1	23	
			40								40	4	160	173
			13								13	1	13	
				40							40	8	320	347
				27							27	1	27	
					40						40	8	320	358
					38						38	1	38	
						40					40	21	840	861
						21					21	1	21	
							34				34	31	1054	1092
							38				38	1	38	
								34			34	26	884	899
								15			15	1	15	
									34		34	17	578	589
									11		11	1	11	
										34	34	18	612	644
										32	32	1	32	
											144	5066	5066	

SUMMARY

SIZE	COLOR	29	30	32	33	34	36	38	40	42			TTL
ORDER QTY	BLACK	103	180	350	351	845	1077	878	578	638			5000
CUT QTY		105	184	357	358	862	1099	896	590	651	0		5100
READY QTY		103	173	347	358	861	1092	899	589	644	0		5066
EXCESS/SHORT		0	-7	-3	7	16	15	21	11	6	0		66
PERCENTAGE		0.00%	-3.89%	-0.86%	1.99%	1.89%	1.39%	2.39%	1.90%	0.94%			1.32%
GR.WEIGHT-LBS		26.68	27.12	28.44	29.37	29.32	26.68	27.34	28.00	28.66	0.00		
NT.WEIGHT-LBS		24.91	25.35	26.68	27.60	27.56	24.91	25.57	26.24	26.90	-1.76		
GR.WEIGHT-KGS		12.10	12.30	12.90	13.32	13.30	12.10	12.40	12.70	13.00			
NT.WEIGHT-KGS		11.30	11.50	12.10	12.52	12.50	11.30	11.60	11.90	12.20	-0.80		

CTN MEASUREMENT :

7.54 CBM

QUALITY.AGM

FACTORY INCHARGE

Figure 38- r packing list

23.1.9 INTERNAL SHIPMENT AUDIT

Quality department perform internal shipment audit in the finishing department. This audit is done prior to final inspection.

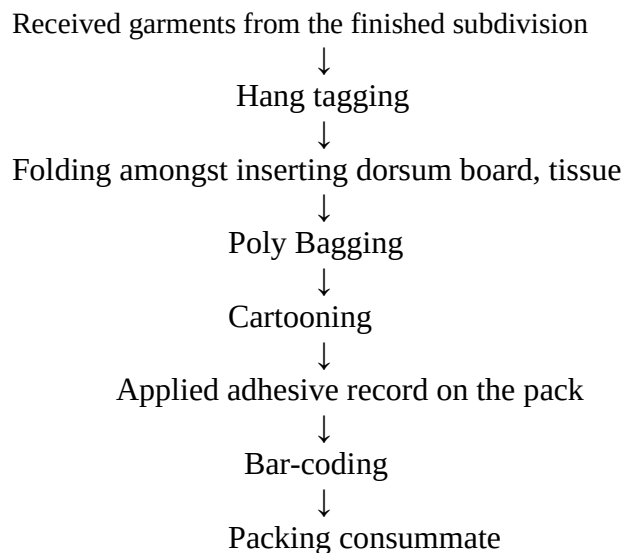
24. PACKAGING

Packaging is an important part of the product, which has to receive a lot of attention to the people. There are different types of packing methods which is done according to the buyer's instruction.

Packaging also refers to the process of design, evaluation, and production of packages. Packaging can be described as a coordinated system of preparing goods for transport, warehousing, logistics, sale, and end.

Packaging means wrapping, compressing, filling or creating of goods for the purpose of protection of goods and their convenient handling. Packaging means a case, container, wrapper or other receptacle for packaging goods

24. FLOWCHART OF PACKAGING



24.2 BASED ON GARMENT PACKAGING

Different types of packaging are there for different types of garments. Following are the most used packing types

- Stand up pack: Shirt (90° angle)
- Flat pack: Sport wear/Shirt/Trouser
- Hanger pack: Blazer, Coats, Pants

- Semi stand-up pack: Shirt
- Half fold pack: Pant

PACKAGING MATERIAL

- Plastic clip
- Paper board
- Wooden Boxes and Crates
- Butterfly
- Plastic collar
- Tag pin
- Ball head pin
- Poly bag
- Inner box
- Tissue paper
- Carton box
- Scotch tape



Figure 39- Packing

25. Merchandising

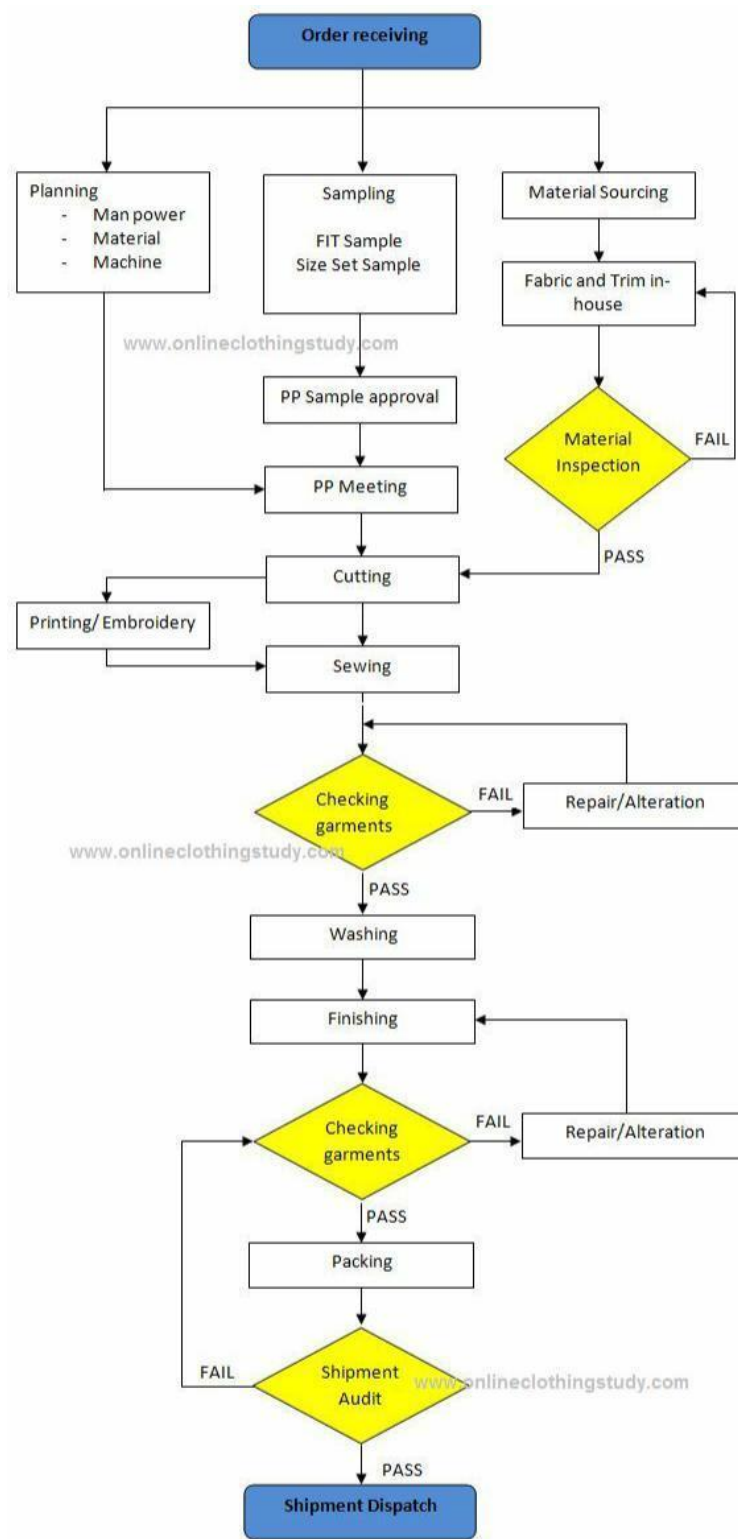


Figure 40- Flow chart

25.1 ROLE OF MERCHANDISER

In an apparel industry, merchandiser plays an important role. He/she acts as a marketer to get the orders from the buyers. All the information about the orders will be processed by the merchandiser and disseminated to other departments in the form of Order Confirmation (OC) which is internal. Like stores – for fabric store along with the order details the fabric consumption per garment is given so as to issue the exact quantity (in meters) of fabric to avoid wastage.

To the accessories department the order details along with the samples of accessories and the number of units required per garments are mentioned so as to avoid the confusion as they will be handling different orders.

Apart from the above merchandiser has to do the following:

- Correspondence with the buyer (regular updates on the order status)
- Getting approvals from the buyer
- Co-ordination, negotiation and follow up with the suppliers
- Co-ordination with all the departments involved

26. EXPORT

The role of an export merchandiser is to execution of the export order right from order placement to shipment of the goods. The responsibility of an export merchandiser is to coordinate all other department activities together to complete the order within a given time. Main exporters of SCM GARMENTS are **kiabi** and **Tesco**. In the apparel export industry, the top merchandiser duties are,

1. Communication
2. Planning
3. Keep on track
4. Decision making
5. Sourcing
6. Negotiation
7. Costing
8. Coordination
9. Regular meetings
10. Maintaining the reports.

27. CONCLUSION

I'm glad that I had such a good experience during internship in the production unit of garments. Learning about various aspects of garment production and managing manpower is valuable knowledge that can benefit you in future career.

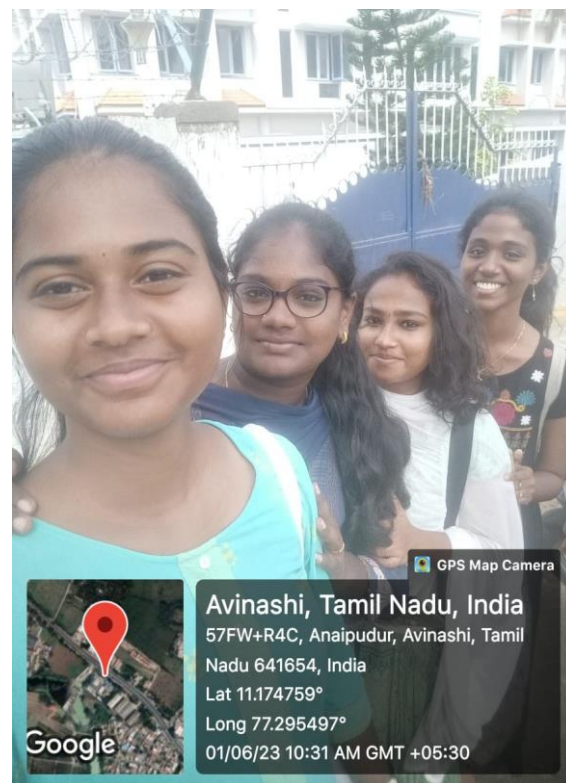
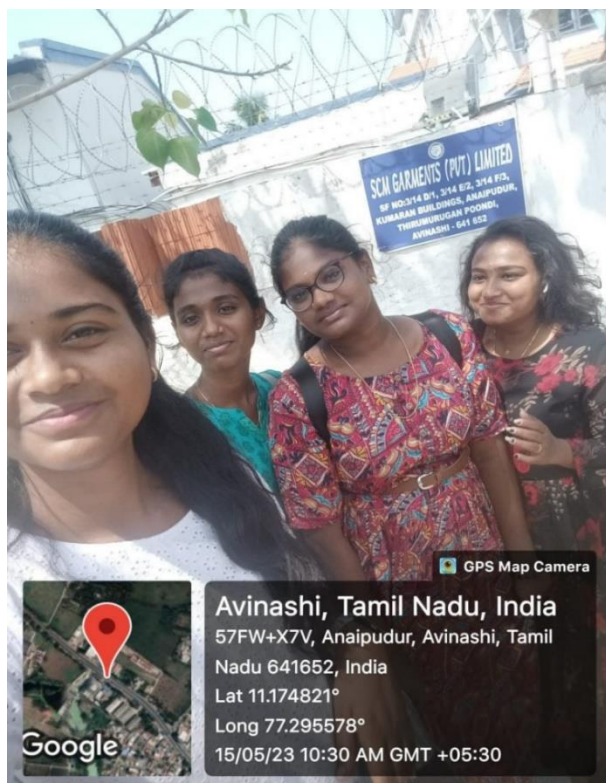
Having a supportive and helpful staff can make a significant difference in the quality of the learning experience. It's great to know that I had a team that was willing to share their expertise and guide throughout internship.

Additionally, working with well-maintained equipment is essential in any production setting, as it ensures efficiency and quality in the output. By having access to good condition equipment, were likely able to work more effectively and gain practical skills in the process.

As you move forward in your career, be sure to apply the knowledge and skills acquired during this internship. The experience you gained will undoubtedly be valuable in pursuing a successful career in the garment industry or related fields. Always remember to continue learning and seeking opportunities for growth and development.

SCM GARMENTS





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