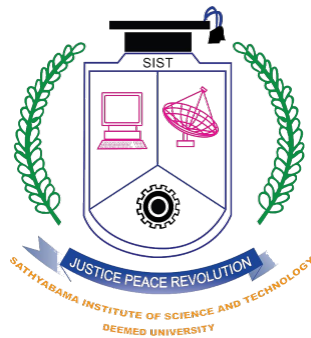


INTERNSHIP REPORT

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

by

NANDHINI.G(41105008)



**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 : NANDHINI.G

Reg No : 41105008

Semester : V

Batch : 2021-2024



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)

2023 – 2024

VIVA –VOCE EXAMINATION

This is to certify that the Internship (S105AINT) is the work of **NANDHINI.G - 41105008**, during semester V, is a student of **Fashion Design** department had undergone training in **WHITE HOUSE INDIA PRIVATE LIMITED** has been monitored by the continuous assessment during 11/05/2023 to 03/06/2023.

Submitted for Viva Voce examination held on: **06/09/2023**

Mentor

Class Coordinator

Internal Examiner

External Examiner

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



SATHYABAMA

INSTITUTE OF SCIENCE AND TECHNOLOGY

(DEEMED TO BE UNIVERSITY)

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DECLARATION

I **NANDHINLG** here by declare that the Internship (S105AINT) for 21 days from 11/05/2023 to 03/06/2023 done by me under the guidance of **Ms.R.PRIYA DHARSHINI**, 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

Nandhini - G

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 **Ms. S. 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 HR **Ms.AHILA** for giving me this wonderful opportunity of an industry internship program.

I would like to express my sincere and deep sense of gratitude to **Ms.R.PRIYA DHARSHINI** for her 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 COLLAGE



SATHYABAMA

INSTITUTE OF SCIENCE AND TECHNOLOGY

(DEEMED TO BE UNIVERSITY)

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www.sathyabama.ac.in

Ref: SHD/2023/04/24/51

24 April, 2023

BONAFIDE CERTIFICATE

This is to certify that **Ms. NANDHINI G**, Register Number **41105008** 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



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, nandhinigajendran693



Best Regards

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

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

From: Whitehouse India <ahila@whitehouseindia.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>

Hello Gayathri,

Good to hear from you on internship program and thank you for approaching us.

We encourage new generation and support them to learn new aspects of current market fashion and trends.

Will surely support your student to pursue new learning opportunities and their dreams.

Thanks & Regards
Ahila
Whitehouse India

PERFORMANCE APPRAISAL

DEPARTMENT OF FASHION DESIGNING

PROFESSIONAL TRAINING REPORT 2023

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

1. **Name of the industry :** White House India Pvt Ltd
2. **Address and contact Number:**No:6, GST road village,Nandhivaram, Nandhivaram,Guduvanchery,Tamil Nadu -603202
3. **Name of the student:** Nandhini.G
4. **Duration:** 11.05.2023 - 03.06.2023
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 Job. done.			

Gr. Nandhini, Really Co-ordinating the work and also support the design team.(white house)
Compliments & suggestions:
Gr. Nandhini having a potential to work in the Industry. And also efficient in learning the technique and also Co-ordinating the works with the team.

Signature of the head of the office:

Capable of Managing the team and able to get a good job & career growth in fashion & Apparel Industry.
All the best for her future!!!
S. Sanyal

CERTIFICATE



08/06/2023

TO WHOMSOEVER IT MAY CONCERN

This is to certify that **MS.G.NANDHINI (41105008)** Studying B.sc Fashion Design in Sathyabama Institute of Science and Technology, have successfully completed her “ **Internship Training** ” at our organization during the period from 11-05-2023 to 03-06-2023.

During the period her conduct and character was found satisfactory.

For white house

For WHITE HOUSE


Authorised Signatory

(AGM-HR)

WHITE HOUSE
6 GST ROAD,
GUDUVANCHERY,
CHENNAI - 603202
TIN : 3210052045

Two Star Export House Certified by the Govt. of India • Approved by the Govt of India for Projects contributing to Sustainable Development in India

Tel : +91 44 25619000
info@whitehouseindia.com
www.whindia.in



INTERNSHIP DETAILS

1.INDUSTRY / ORGANIZATION:WHITE HOUSE

Mentor Name : MS. SARANYA

Designation of the mentor: Sr. Designer (Design Dept . Incharge)

Company name :White house India exports private limited

Company address :White house India exports private limited,No : 6, GST Road, village, Guduvanchery,Tamil Nadu 603202

2. INSTITUTION: SATHYABAMA INSTITUTE OF SCIENCE AND TECHNOLOGY

Mentor Name : Ms. PRIYADHARSHINI.R

Designation of the mentor: Assistant Professor

Student Name : Nandhini.G

Department : Fashion Design

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

DAILY REPORT

DATE	REPORT
11/5/2023	Visiting a Company's Showrooms
12/5/2023	Sample Department
15/5/2023	Cutting Department
16/5/2023	Printing unit
17/5/2023	Design Department
19/5/2023	Packing Department
20/5/2023	Costing Department
22/5/2023	Design Department
23/5/2023	Surplus Department
24/5/2023	Tech pack
25/5/2023	Stitching unit
26/5/2023	Yarn store
27/5/2023	Manual cutting
28/5/2023	Quality checking
29/5/2023	Dyeing Unit
30/5/2023	Embroidery unit
31/5/2023	cad Unit
01/6/2023	Merchandising department
02/6/2023	fabric / trims
03/6/2023	Design Department / store room
04/6/2023	Production department

TABLE OF CONTENTS

INDEX	PAGE
INTRODUCTION.....	14
COMPANY PROFILE.....	15
ABOUT COMPANY.....	16
HR DEPARTMENT.....	22
FINANCE (PURCHASE,SOURCING).....	22
MERCHANDISING DEPARTMENT.....	23
DESIGNING DEPARTMENT.....	25
CAD& PATTERN.....	30
SAMPLING DEPARTMENT.....	30
PRINTING UNIT.....	35
EMBROIDERY UNIT.....	47
DYE & WASH.....	50
PRODUCTION.....	53
YARN STORE.....	54
FABRIC.....	56
SPREADING.....	56
CUTTING.....	57
SEWING.....	61
QUALITY CHECKING.....	64
PACKING DEPARTMENT.....	66
MY WORK.....	68
CONCLUSION.....	69
BIBLIOGRAPHY.....	70

1.INTRODUCTION

- White House is a manufacturer and exporter of cotton and blended knit garments,since 1985 to the European,UK,US and Australian markets. Currently they supply to world-wide reputed brands,who have their outlets in over 36 countries.They have a vertically integrated set up and all the operation Required for making knit Garments are in - house.They produce wide range of products for men,Women,& children Garments, based on customer specification.
- Though critical and deep study, this report examines the type of production system that is used in Fashion apparel industry. It shows the analysis and comparison of production with respect to cost, Quality and productive. In this efficiency is the most important thing. The sewing system is depending Upon the efficiency and style.
- This is study based on complete operations of casual wear, street wear, sports wear, Active wear, Like T shirt, Henley , polo, sweat shirt, sweat hood, legging.It also focus on the positive and negative Aspects of production system. This company give more important to the customers need and to satisfy Their needs without any negative feedback.

2.COMPANY PROFILE



INDUSTRY NAME : **WHITE HOUSE INDIA EXPORTS PRIVATE LIMITED**

INDUSTRY ADDRESS: **White house India exports private limited, No : 6, GST Road, village, Guduvanchery, Tamil Nadu 603202**

PHONE: +914427469000

WEBSITE : <http://ww.whitehouseindia.com>

ROC : CHENNAI

COMPANY CATEGORY : COMPANY LIMITED BY SHARES

REGISTRATION NUMBER : 67393

COMPANY SUB CATEGORY : NON - GOVERNMENT BODY

DATE OF INCORPORATION: 17 April 2008

AGE OF COMPANY : 15 years, 1 month, 15 days

3.ABOUT COMPANY



WHITE HOUSE INDIA EXPORTS PRIVATE LIMITED is a private incorporated on 17 April 2008. It is classified as Non-govt company and is registered at Register of companies, Chennai.

White House Knits Private Limited (WHKPL) is 32 years 7 months old private limited Indian Non-Government company incorporated on 05 Oct 1990. Its registered office is in Chennai, Tamil Nadu, India.

The corporate was formerly known as White House India Exports Private Limited. The company is engaged in manufacturing of textile.

The company's status is Active , and it has filed its Annual Returns and Financial statements up to 31 Mar 2022 (2021-2022).it's a company limited by shares with an authorized capital of Rs 0.97 cr as per MCA.

3.1 CLIENTS AND CUSTOMERS

- GANT
- Polo Ralph Lauren
- Decathlon
- Wrangler lee
- RB sellers
- Children's world wide fashion(CWF)
- Asmora

3.2 BRANDS:

- Little Marc Jacobs
- GANT
- Dickies
- Ben Sherman
- Billabong
- Ben Sherman
- Agile
- Oxbow

- Campus
- DKNY
- Decathlon
- Boss
- Huge boss
- Lee
- Timberland
- TBS

3.3 CERTIFICATIONS AND ACCREDITATIONS



3.4 OUR VISION

Adapt to new Innovations, Processes, Systems, Technologies and Sustainable practices to exceed Customer Expectations with focus on Ethical Approach, Employee Engagement and Responsibility towards our Environment and Society

3.5 GARMENTS

White House is a manufacturer and exporter of Cotton and Blended Knit garments, since 1985 to the European, UK, US and Australian markets. Currently we supply to world-wide reputed brands, who have their outlets in over 36 countries.

They have a vertically integrated set up and all the operation required for making Knit Garments are in-house.

They produce wide range of products for Men, Women, & Children Garments, based on Customer specification

Some of the product types they produce for our Customers are:

- T-shirts
- Polo
- Sweat Shirts
- Sweat hood
- Sweat Zip
- Cardigans
- Pants
- Shorts
- Boxer Shorts
- Tank Top
- Leggings
- Yoga Pants

3.6 SUSTAINABLE PRODUCTS

Since 2014, they have laid a lot of emphasis on sustainable fabrics, trims and packing materials for our garment production.

They source following yarns with stringent quality specification to knit various type of fabrics.

- Organic Cotton
- Organic Cotton / Recycle Cotton Blends
- Organic Cotton / Recycle Polyester Blends
- Organic Cotton / Hemp Blends
- Organic Cotton / Bamboo Blends
- Organic Cotton / Tencel Blends

They have taken steps on Sustainability through various measures including

- Waste Minimization
- In-process Control
- Adoption of Clean Technologies

They focus on the processes that identify and eliminate waste in various operations involved through continuous improvement

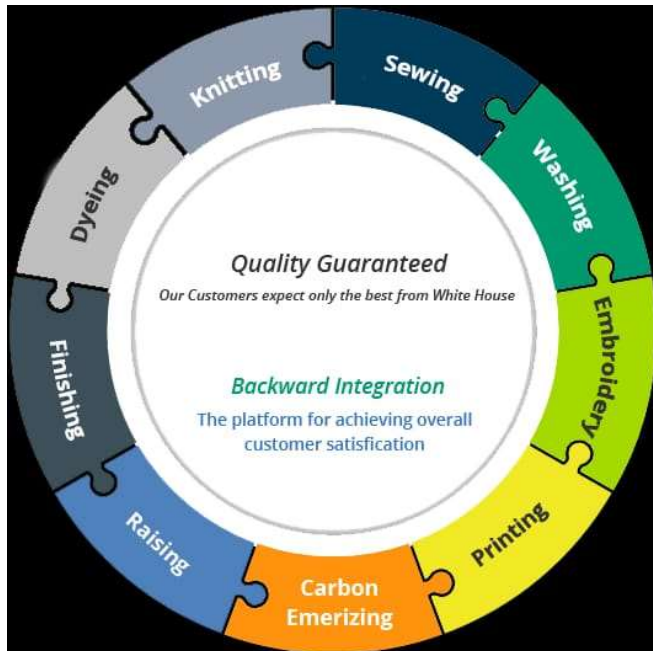
3.7 HIGG INDEX

- The Higg Index is a set of tools developed by SAC (Sustainable Apparel Coalition) that enables us to improve there sustainability strategy through accurate measuring and scoring Company's sustainability performance.
- With Higg Index we prioritize, what to measure and choose the best practice, implement it an compare with industry standards.

- There Higg Index 2.0 FEM (Facility Environmental Module) score has been verified by third party Agency for our Dyeing and Garment Factories

3.8 QUALITY GUARANTEED

All our sewing, printing and embroidery units are certified with SA-8000, GOTS and REACH compliant.



3.9 QUALITY MANAGEMENT

- White House endeavors to exceed Customer's expectation on Quality Standards.
- White House has exclusive Internal Quality Audit Team (IQAT), of QAs' headed by a Quality Manager independent to the Factory Quality Team and reports to the Top Management.
- Their goal is to ensure that excellence is inherent in every step of the Garment Manufacturing from Fabric to Garment finishing stage.
- All Fabric and Finished Garment inspections are verified and authorized by the IQAT. This Team is nominated by some of our Customers to conduct final garment inspection on behalf of them.

3.10 CORPORATE SOCIAL RESPONSIBILITY

- They have installed RO plant to village nearby for supply of drinking water
- They support the local Government Hospital by providing equipment.
- They take responsibility to do annual painting of the local school.

3.11 ENVIRONMENTAL RESPONSIBILITY

- White House is committed to greener environment and made a huge investment in treating the textile processing effluent. The effluent is handled in 3 stages:
- Treating the dye house effluent by biological method to reduce the Biological Oxygen Demand (BOD) and Chemical Oxygen Demand (COD).
- Treated water from the above process is passed through Reverse Osmosis (RO) plant to recycle 85% back to the dye house.
- Reject water from RO plant is mixed with dye water effluent and evaporated in multiple stage Evaporator. The water vapour from the evaporators, after condensation, is also reused in the process.
- The effluent water is completely recycled to achieve ZERO DISCHARGE status.
- The treated water from effluent treatment plant is also used for cultivating land producing Mangoes, Guavae and Coconuts. Main part of the land is under paddy cultivation. We are glad to have been able to convert a barren land into a green belt.
- The State Government of Andhra Pradesh has recognized our contribution to award "Cleaner Production Technologies" certificate.

3.12 PRODUCTS CATEGORIES:

- Women's wear
- Kids wear
- Men's wear



3.12 DEPARTMENTS :

1.Management:

- HR (Human Resource)
- Finance
- Merchandising
- Designing
- Sample
- Cad
- Print
- Embroidery

2.Production department

- Quality
- Panel checkers
- Merchandise
- Shipment
- Purchase
- Planning
- CAD(Computer Aided Designing)

3.13 FACTORY LAYOUT

FLOORS	DEPARTMENTS
GROUND	• Human Resource • Manager • Yarn store • Packing department • Stores • Surplus • Logistic • Canteen • Cutting • Power supply
1 F	• Production • (IE) Industrial Engineering
2 F	• Sampling department • Merchandising department • Finance • Purchase • Designing

3.14 COBJECTIVE

Objective of the study is to learn about the functioning of export house and working of various departments particularly production, merchandising and sampling, earning knowledge about different departments of the company, their function and information flow during work.

3.15 DATA COLLECTION METHOD

I collected this by following method-

- Personal interview from various departments.
- Close observation during work.
- Internal data from various departments.
- And secondary data was collected from the websites of White house India.

4.HR (HUMAN RESOURCE)

Human Resources is in charge of arranging interviews ,coordinating hiring efforts,and on boarding new employs.

4.1 MAIN WORK:

- Recruitment
- Administration
- Compensation and Benefits
- Employee Relations
- Training and development
- Performance management
- Motivating employees
- Workplace communication
- Workplace safety

4.2 WELFARE OFFICER:

Maintain good workers and employer relationship within the organization. Compliant management of workers as early as possible to provide ideas to the management of the factory while there is any internal labor management police is formulated.

5.FINANCE DEPARTMENT

A finance department is the unit of a business responsible for obtaining and handling any monies on behalf of the organization.The department controls the income and expenditure in addition to ensuring effective business running with minimum disruptions.

5.1ROLE OF FINANCE:

- Investment Decision
- Financial Decision
- Dividend Decision

- Liquidity Decision

5.2 SOURCING:

- The process of determining how and from where manufactured goods or components will be procured.
- The main motivational force to do sourcing of garments/ fabrics is to give the highest level of satisfaction, at low production cost.
- Fabric sourcing
- Trims
- Accessories
- Thread

5.3 PURCHASING:

Procurement involves the process of planning, selecting suppliers, establishing payment terms, strategic vetting, and selection, the negotiation of contracts services and actual purchasing of goods.

5.4 ROLE OF PURCHASING:

- Selecting suppliers
- Negotiating
- Administering long term contracts
- Monitoring supplier performance
- Placing orders to suppliers
- Developing a responsive supplier base
- Maintaining good supplier relations

5.5 FUNCTIONS OF PURCHASING :

- Lower costs
- Reduce risk and ensure the security of supply
- Manage relationships
- Improve quality
- Pursue innovation
- Leverage technology

6.MERCHANDISING DEPARTMENT

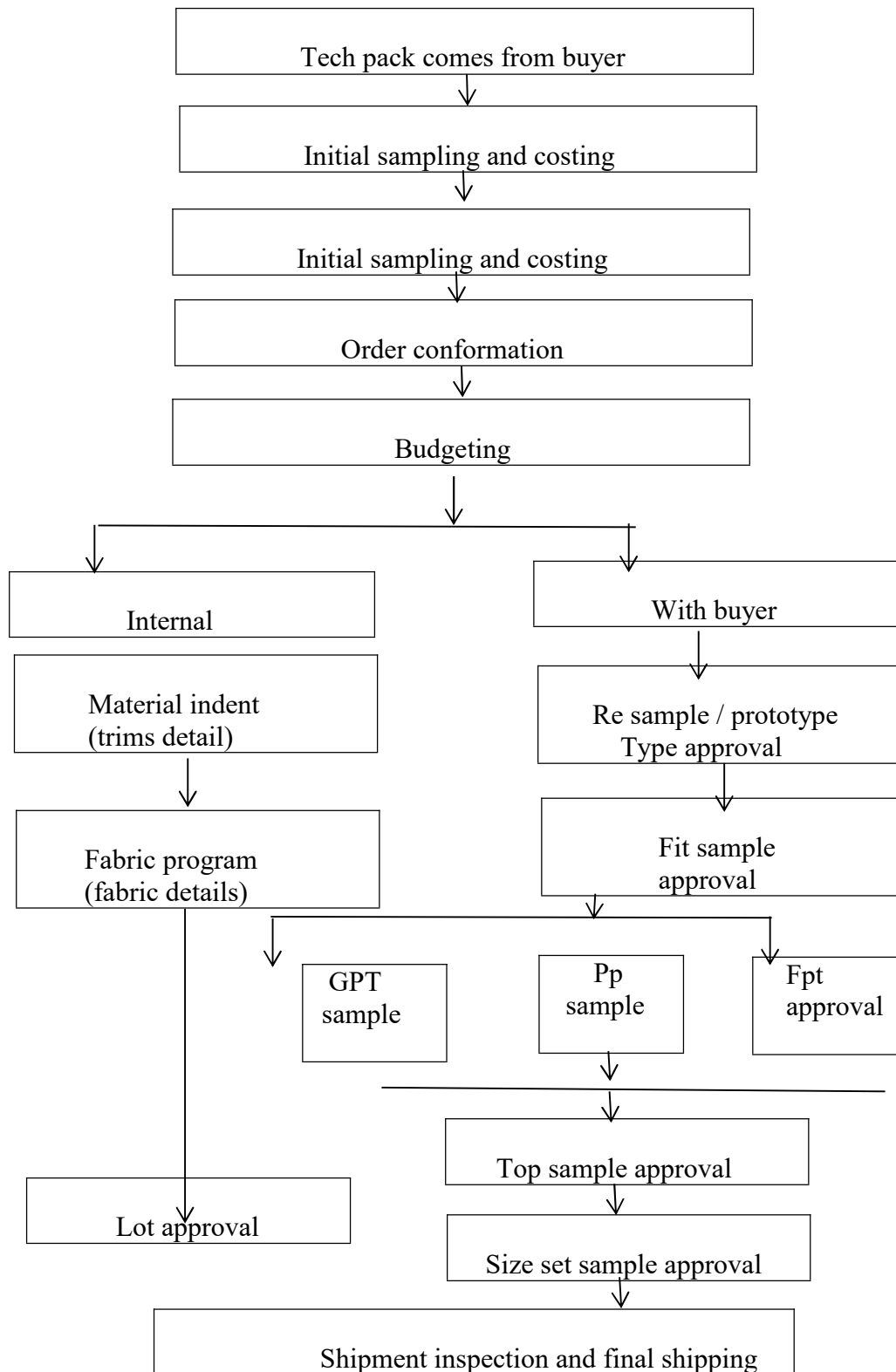
Merchandising is a specialized management functions within the fashion industry. It is the business that moves the world fashion from designers showroom to retail sales floor and in to the hands of consumers. It is the internal planning that takes place within a retail organization in order ensures adequate amount of merchandise are on hand to be sold at prices that the consumers are willing to pay to profitable operation.

6.1 Following are the responsibilities of merchandisers which give importance to them:

- Internal & external communication,
- Sampling,
- Lab dips,

- Accessories& trims,
- Preparing internal order sheets,
- Preparing purchase orders,
- Advising and assisting production,
- Advising quality department about quality level,
- Mediating production and quality departments,
- Helping documentation department,
- Taking responsibility for inspections and Following shipment.

6.2 PROCESS FLOW OF MERCHANDISING DEPARTMENT



6.3 IMPORTANT TERMS IN COSTING

- Yarn cost
- Process cost
- Process loss
- CMT (Cutting, Making & Trimming)
- Negotiation (getting the best out of a deal)
- Commission percentage (%) for Middle man
- Shortage
- Buyer specification (It is buyers' responsibility to specify the quality required)
- Quantity
- Currency
- Mode of Shipment (sea, air)
- FOB (Free on Board)
- CIF (Cost, Insurance and Freight)
- OH (Over head)
- Quota (Not applicable nowadays)
- Profit (level of %)
- One of the Major responsible jobs handled by Merchandise department is Quality Control

7.DESIGNING DEPARTMENT

7.1COMPONENTS OF A BUSSINESS ORIENTED COLLECTION:

Types of collection:

There are two types of collection

- Creative collection
- Commercial collection

7.2 CREATIVE COLLECTION:

- The creative collections are intended to highlight the theme worked on, to explore a concept, ideas, and other inspirations from the designer at the time of conception of the work. Because of this nature, no one necessarily "wears" the clothes displayed on the catwalks.
- The objective is that, from these pieces, others are created that capture the spirit of the collection, but that meet the requirements of market wear-ability, trends, and the preference of the collection's target audience.

7.3 COMMERCIAL COLLECTION:

Commercials, on the other hand, are those that are already created with the aim of being sold. That is, they do not focus on the conceptual stage, which is the deepening of the chosen theme. They only make use of studies of fashion trends to launch sets of clothes and accessories that work on a certain theme and reach the consumer quickly.

7.4 SOME IMPORTANT TERMS IN COMMERCIAL COLLECTION:

- Research design
- Porto- type
- Production
- Quality fit
- Quantity
- Supply chain management
- Inspirational
- Unique selling price
- Fashion season

7.5 FASHION SEASONS:

- Spring summer (January - march, April)
- Fall winter (July - Sep)
- Resort /cruise (holiday)
- Spruce spring (before spring summer)
- Pre -Fall (may/ June)
- Resort (December)
- Summer(Jun/July)
- Winter sale (December/July)

7.6 SUPPLY CHAIN MANAGEMENT:

- Concept
- Design
- Planning
- Prototype
- Production
- Logistic
- Distribution
- Retail

7.7 FORECASTING:

Forecasting is the activity of predicting the future happenings or problems. A designer has to predict the future uncertainties in the current order or industry so that alternative actions or corrective measures can be taken in advance this also includes giving suggestion or ideas about new technologies or new products or latest industry trends.

Some forecasting sites:

- WGSN
- Promo style
- Fashion snoop
- F trends

7.8 DECISION MAKING ON COLORS:

- Designers selecting colour for presentable.
- Sometimes it “ feels good” because they know it’s right because of their experiences with color and its effect on people.

- Honestly, sometimes the color choices many designers make look like they opened up the Pan-tone color books swatches panel, scrolled down, and randomly clicked on something.

7.9 TRADE SKETCH :

In the garment industry , a computer - aided design sketch (CAD sketch), also known as a flat sketch or technical flat, is a technical drawing of a garment that is laid flat to show design details such as seams and stitching.

7.10 TECH PACK:

Tech pack stands for Technical package it also known as specification sheet. It is a blueprint created by a technical designer which is used to make a final garment . It contains all the detailed information

- Size
- Measurements
- Stitch type
- Trims
- Labels
- Stitch length
- Technical sketch
- Seam type
- Grading chart
- Construction detail
- Accessories and trims details

7.11 GOALS OF TECH PACK:

Every tech pack can be considered as an ideal one if it meets the following goals:

- Helps in making sample and quote the price
- Explain the design to manufacturer to turn design into a product
- Should help in minimizing samples, decrease cost and bring product to market faster I.e. decreases production time
- Help to make the entire product perfectly with almost no or few errors.

7.12 PRODUCT DEVELOPMENT

In the context of garment export business normally product development is handled by design department. Design team are responsible for whole production development process. In export houses sampling department is considered as product development department.

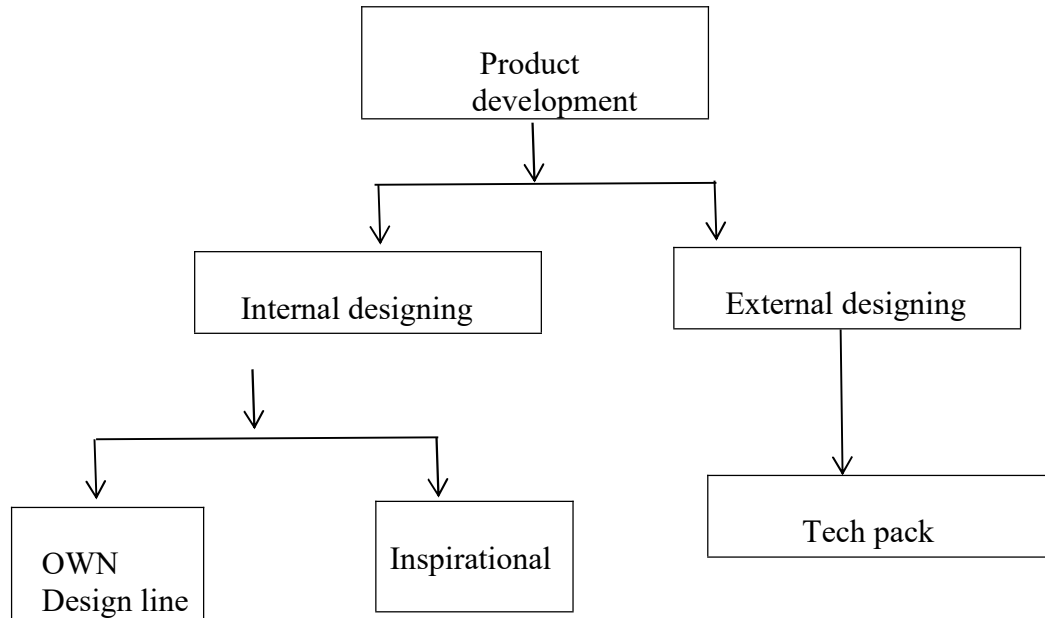
Product development in the garment industry refers to the process of creating and bringing a new clothing product to market. It involves various stages, from conceptualization and design to production and distribution. The goal of product development is to design and produce garment that meet market Demand, consumer preferences, and industry trends while also considering factors like cost, quality, and sustainability.

Stages involved in garment industry:

- Market research
- Conceptualization

- Pattern making
- Sample review and testing
- Costing and sourcing
- Production
- Quality control
- Marketing and sales

7.13 CLASSIFICATION



7.14 RANGE PLANNING:

A Line Plan (Range Plan) is a roadmap used for laying out the option counts of a new collection by attributes such as end-use, price band, color group, print type, etc., to ensure alignment between Design, Merchandising, and Sourcing teams.

Range plans usually include:

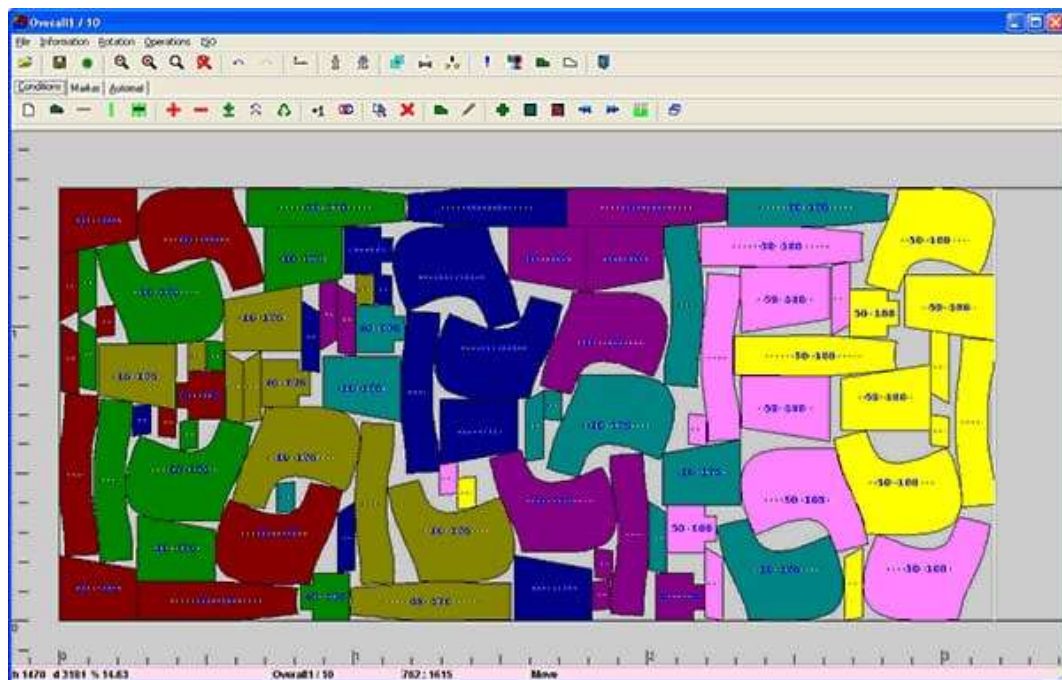
- Total number of garments
- Illustration of flat drawing of every garment
- Proportion of different garments types(top/bottom)
- Specific garment styles
- Different fabrics and colour way for each garment
- Cost price per garment
- Selling price per garment
- Order quantities per style
- Sizes
- Manufacturer details

8.CAD & PATTERN DEPARTMENT

Computer Aided Design (CAD) becomes an essential tool for pattern making and related jobs in garment industry. In apparel industry CAD Software is used for pattern making, Grading of pattern, marker making and digitizing manual patterns. CAD system involves any type of design activities which use of to develop analyses or modify any engineering or garment design.



(Figure 1)



(Figure 2)

8.1 FEATURES OF A CAD SOFTWARE

The application of CAD is vastly incorporated in various types of industries ranging from manufacturing, aerospace etc. to designing of garments, textiles, machines, layouts, architectural structures. The application of CAD software is thus based on certain features of it which can be classified as:

1. Solid Modeling:

With CAD solid components of desired shapes can be made virtually by joining, cutting, trimming different solid volumes. The final solid model comes out to be an exact replica of the actual shape, but it can also be seen and rotated like the real product. It even allows us to get inside any 3D model to inspect it from the inside. With this, any model can be constructed using parameters like measurements, physics etc. and can be edited at any point of time by undoing or modifying it keeping the original as it is.

2.Surface Modeling:

With CAD, solid components can be given texture, details by trimming, stitching and joining different surfaces to create the final shape of the model.

3. Assembly:

With CAD, assembling of the models created in solid or surface modeling can be done to get an overview of how the product will look in the final assembling allowing us to make changes accordingly. It is also used to see actual fittings and the working of the assembled model.

4. Drafting details:

3D drawing can also be created from a 2D drawing of the components or assemblies only by providing the parameters and dimensions.

5. Reverse Engineering:

Real components of any design can be converted into 3D CAD model with instruments like laser scanner, white light scanner, CMM (coordinate measuring machine) etc. The CMM machines are used to measure or decode the shape of any real model. The virtual model created can be used for any modification purpose, shared, and documented. Later it is updated to the final model.

9.SAMPLE DEPARTMENT

Sample is the prototype or model of the garment, upon what the buyer can decide on how and whether to confirm the order or not.

Garment sampling process is one of the principle process in garment manufacturing and it plays an important role in attracting buyers and confirming export order.

Process

Sourcing Fabric and Accessories for making the Garment

↓
Cutting (For Sample Only)

↓
Embellishment

↓
Sewing

↓
Iron

↓
Quality Control

↓
Pre check Form

↓
Buyer QC

↓
Forwarding from the Merchandiser

↓
Sending Sample to the Buyer

9.1 SAMPLE MAKING :

Sampling is a process of making a product Proto - type prior to starting of bulk production. The same process is applied to garment sampling. In mass garment manufacturing, where apparel brands source garments in bulk quantity, sample making is an essential step before placing the bulk order.

9.2 ORDER FABRIC DETAILS:

Order Rf :GAMO13YWZO

Style/mode: 200701

Quantity: 25

Out sheet	Size	Size ratio	No of pieces
95 melange	S,M,L,XL	0,0,0	5.8.84

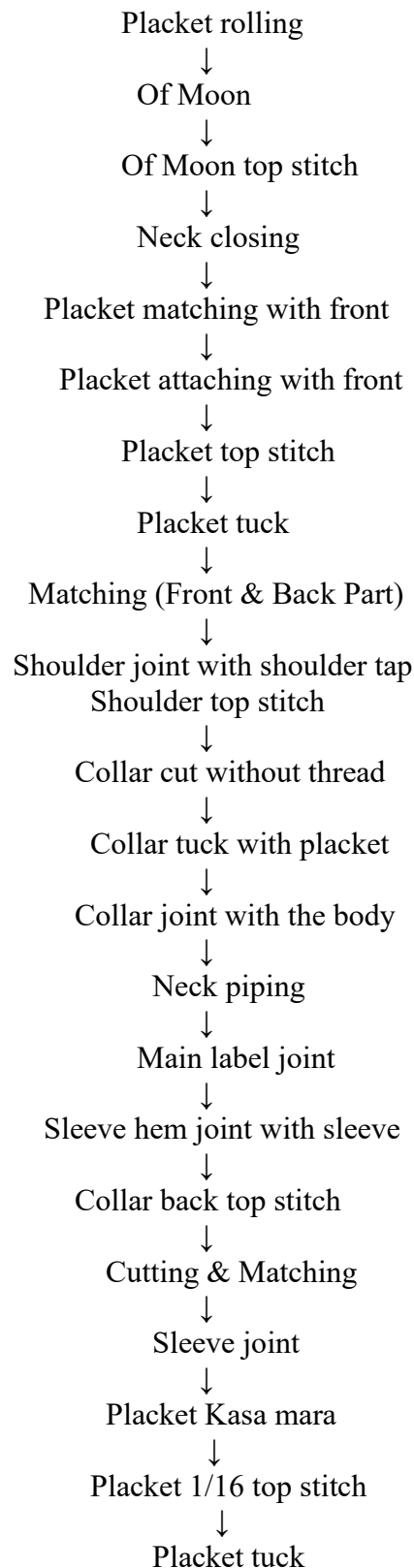
Component	colour	Quality
body	red	Fleece
Body,bottom	1	Rib
Hood inside	1	Single jersey

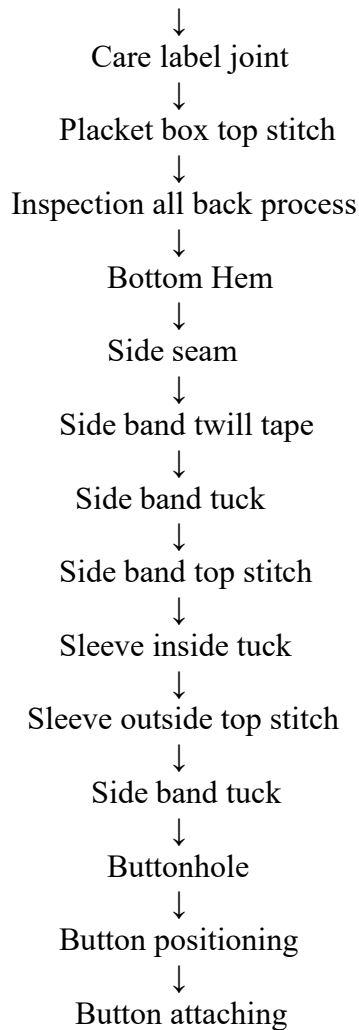
GSM	Lay width	Costed con\sm
300	160	0.600
370	150	0.140
150	185	0.050

Cutting sample:

- Manual cutting
- Machine cutting

9.3 OPERATION BREAKDOWN OF POLO SHIRT :





9.4 PROCESS

Polo shirt making

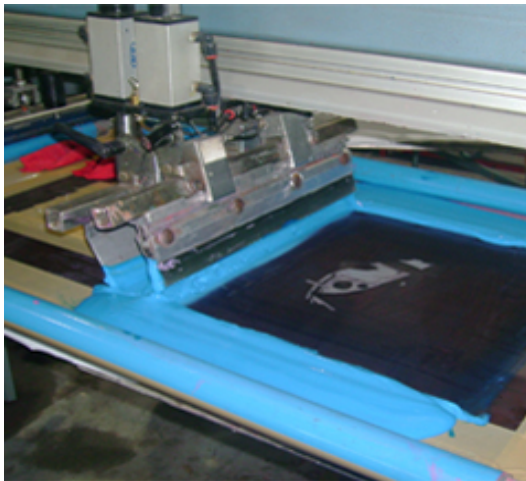
- Placket rolling is done by using the plain machine
- Moon is done by using the plain machine.
- Moon top stitch is done by using a flat lock machine.
- Neck closing is done by using the plain machine.
- Placket matching with the front is done on the table.
- Placket attaching with the front is done by using the plain machine.
- Placket top stitch is done by using the plain machine.
- Placket tuck is done by using the plain machine.
- Matching (Front & Back Part) is done on the table.
- The shoulder joint with the shoulder tap is done by using an over lock machine.

- The shoulder top stitch is done by using a flat lock machine.
- Collar cut without thread is done by using an over lock machine.
- Collar tuck with placket is done by using a plain machine.
- A collar joint with the body is done by using an over lock machine.
- Neck piping is done by using a flat lock machine.
- The main label joint is done by using the plain machine.
- Sleeve hem joint with sleeve is one by using over lock machine.
- Collar back top stitch is done by using a flat lock machine.
- Cutting & Matching is done on the table.
- The sleeve joint is done by using an over lock machine.
- Placket Kasa mara is done by using the plain machine.
- Placket 1/16 top stitch is done by using the plain machine.
- Placket tuck is done by using the plain machine.
- Care label joint is done by using the plain machine.
- Placket box top stitch is done by using the plain machine.
- Inspection all back process is done on the table.
- Bottom Hem is done by using a flat lock machine.
- The side seam is done by using an over lock machine.
- Side band twill tape is done by using the plain machine.
- Side band tuck is done by using the plain machine.
- Side band top stitch is done by using the plain machine.
- Sleeve inside tuck is done by using a plain machine.
- Sleeve outside top stitch is done by using the plain machine.
- Side band tuck is done by using the plain machine.
- The buttonhole is done by using a buttonhole machine.
- Button positioning is done on the table.
- Button attaching is done by using a button attaching machine.

10.PRINTING UNIT

Printing is a process for producing of reproducing text,image,or designs onto paper or other materials using a mechanical or digital device called a printer.

White house printing division has an annual printing capacity of 6 million impression.The unit is equipped with 6/9/12/14/16 color automatic printing machines and flock printing system.They are fully equipped with a re-printing setup wherein all screens required for all kinds of prints are internally prepared,screen coated,auto set,exposed and developed for production.We have technical expertise for computerized color separation and film making.



(Figure 3)



(Figure 4)



(Figure 5)



(Figure 6)



(Figure 7)



(Figure 8)

10.1 DIFFERENT TYPES OF PRINTING TECHNIQUES:

- High density print
- Non PVC print
- Glitter print
- Foil print
- puff print
- Emboss print
- Mould print
- Digital print
- Pigment print
- Silicone print
- Flock print
- Discharge print
- CMYK print

HIGH DENSITY PRINT:

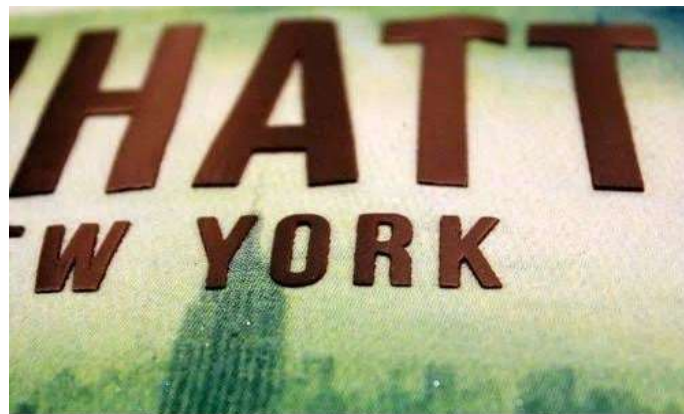
- This is one of the recent development in printing which gives thick prints on the surface of garments.
- Achieved by either giving more number of coats or by using thickener indirect films used for making the screens.
- The process in which they use a thick layer of emulsion to create a higher print.
- This is greatest method is usually used for special effects on designs.



(Figure 9)

NON PVC :

- Relatively new breed of ink and printing with the benefits of plastic but without the main toxic components - soft feeling print.
- Suitable for kids wear.
- 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. Re transfer printers print onto the reverse of clear film that is thermally bonded to the card.



(Figure 10)

PIGMENT PRINT :

- These penetrate the fabric more than the plasticize inks and create a much softer feel.
- Also useful for larger area prints where texture is important.
- Pigment printing is the process of transferring pigment dye stuffs to the fabric by direct printing and abrasion printing method, which is generally applied to polyester knitted and woven fabrics, but can also be applied to natural fibers.



(Figure 11)

GLITTER PRINT :

- Metallic flakes are suspended in the ink base to create this sparkle effect.
- Usually available in gold or silver but can be mixed to make most colors.
- Glitter printing uses a dense specialty finish that adds pop, sparkle and elegance in any color to any printed piece, including gift cards, credit cards, packaging, retail POP displays, book covers, and greeting cards.



(Figure 12)

PUFF PRINT:

- An additive to plastic inks which raises the print off the garment, creating a 3D feel.
- In this method when the paste is printed and dries it looks like normal printing garments but once it is cured the prints get raised from the surface of fabric.



(Figure 13)

DISCHARGE PRINT:

- Used to print lighter colors onto dark background fabrics, they work by removing the dye already present in the garment.
- This gives a much softer texture.



(Figure 14)

FOIL PRINT:

- This printing method is based on the use of metallic foil paper of aluminium or copper one.
- The print fixation method is similar to transfer printing. this print method is popular among youngsters.



(Figure 15)

SILICONE PRINT:

To counter inferior wash and weather durability, poor hand feel of some prints like plastic printing mills tried silicone inks because of their good washing durability, hand feel, elongation properties and environmental friendliness.



(Figure 3:8)

FLOCK PRINT:

- This process involves printing of glue on the fabric first, applying the fiber flock on the gel printed by keeping the fabric on special table.
- It requires a little high time for curing than normal prints . 120 seconds at 160c will be sufficient for curing.



(Figure 16)

DIGITAL PRINT:

- Digital textile printing is described as any ink jet based method of printing colorants onto fabric.
- Digital printing is the process of printing digital-based images directly onto a variety of media substrates. There is no need for a printing plate, unlike with offset printing. Digital files such as PDF s or desktop publishing files can be sent directly to the digital printing press to print on paper, photo paper, canvas, fabric, synthetics, card-stock and other substrates.



(Figure 17)

MOULD PRINT:

- Sublimation mould printing uses mould to allow a constant, steady design to be transferred from paper to fabric.
- With heat and pressure applied, the dye on the transfer paper becomes a gas and is then absorbed into the fabric itself. We specialize on polyester fabric sublimation printing.



(Figure 18)

EMBOSS PRINT:

- Embossing is when you raise a logo or other image to create a 3D graphic. This raised design is achieved by pushing a metal die into paper, card stock (or other chosen material) from underneath.
- Embossed printing involves creating raised images, which results in a 3D effect. Traditionally, the image is pressed onto the paper or cardstock, but Mimaki offers an easier way to alter an image's look and texture and achieve a three-dimensional embossed design.



(Figure 19)

CMYK PRINT:

- CMYK screen printing is a popular T shirt printing technique for achieving a full colour design on white garments.
- CMYK printing is done by layering four colors (cyan, magenta, yellow, and black) on top of each other to re-create a realistic image with only four screens.



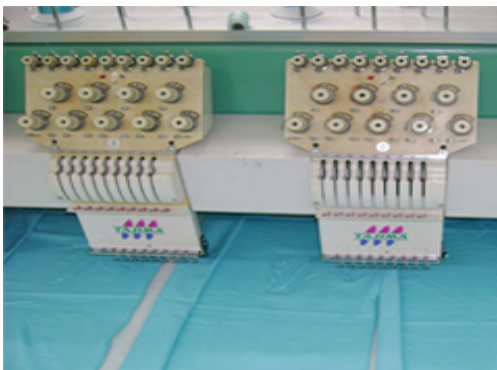
(Figure 20)

11.EMBROIDERY UNIT:

White House Embroidery division has an annual embroidery capacity of 450 million stitches.It has state -of-the-art automated 9 barudan multi-head embroidery machines from japan with 164 heads which can embroider up to 9 colors.Exclusive 4 head Embroidery machine for sampling.2 GM1 laser cutters are connected to 80 embroidery heads for seamless and high quality applique embroidery.They have in house expertise to create complicated designs.



(Figure 21)



(Figure 22)



(Figure 23)



(Figure 24)



(Figure 25)



(Figure 26)



(Figure 27)



(Figure 28)



(Figure 29)



(Figure 30)



(Figure 31)



(Figure 32)



(Figure 33)



(Figure 34)

11.1 THE WIDE RANGE OF POSSIBILITIES INCLUDE REGULAR STITCHES LIKE

- Satin stitch
- Tatami stitch
- Motif stitches
- Program stitches
- Photo embroidery
- 3D embroidery
- Applique work

11.2 TYPES OF EMBROIDERY:

- Carded applique
- Satin applique
- Che-nail chain embroidery
- Metallic thread embroidery
- Lurex thread
- Split satin
- Silicone brush
- Applique + patch
- Dark in glow
- Emboss
- Taffeta
- Bead+ sequence
- Digital print with lace work

CARDED APPLIQUE:

- Cards decorated with cut paper arranged to mimic the look of cloth applique.
- Cut cloth and embroidery often used as embellishment on clothing and quilts.



(Figure 35)

SATIN APPLIQUE:

- This stitch got its name because it resembles a piece of satin.
- Sewing decorative stitching or surface embellishments on many types of projects.

CHENAIL EMBROIDERY:

Chenille embroidery, colloquially known as “chenille” is a kind of specialized loop or chain embroidery ,which is made with yarn, not typical embroidery threads - polyester or viscose.



(Figure 36)

METALIC THREAD EMBROIDERY:

- Metal thread embroidery is a form of decorative needlework that uses one or more different types of metal thread.
- This type of work is much more expensive than using ‘ normal’ threads, such as linen, silk or wool, and as a result is associated with status and wealth, whether it is secular or religious in nature.



(Figure 37)

LUREX THREAD EMBROIDERY:

- Lurex thread is very similar to passing thread but with a synthetic thread wrapped around a fibre core instead of metal thread.

- The great thing about the Lurex thread is that it does not tarnish but has the appearance of a real metal thread.

SILICONE BRUSH:

- Silicone brush embroidery is a decorative technique that involves piping lines of royal icing in sections, and then using a damp brush to pull a portion of the icing away from the piped line.
- The result is a textured brush effect that resembles that of embroidered stitching.



(Figure 38)

APPLIQUE + PATCH :

- Applique patches are a brilliant way to disguise a hole in a garment, or even to turn into badge.
- Appliqué is ornamental needlework in which pieces or patches of fabric in different shapes and patterns are sewn or stuck onto a larger piece to form a picture or pattern. It is commonly used as decoration, especially on garments. The technique is accomplished either by hand stitching or machine.



(Figure 39)

DARKIN GLOW:

Glow in the dark thread will glow for about 15 minutes after being exposed to light, and longer if in backlight. To reactivate, expose them to light again.

EMBOSS:

Embossed fill is a decorative fill stitch used to fill wide and large areas with patterned stitching while keeping the appearance of a solid field.



(Figure 40)

BEAD AND SEQUENCE:

BEAD EMBROIDERY:

Bead embroidery is a type of bead work that uses a needle and thread to stitch beads to a surface of fabric, suede, or leather.

SEQUENCE EMBROIDERY:

The embroidery objects in a design form a stitching sequence. Initially, objects are stitched in the order in which they were created. You can change the position of a selected object by cutting and pasting it elsewhere in the sequence, or by using the re-sequence docker.



(Figure 41)

12. DYE & WASHING

12.1 GARMENT DYEING & WASHING

Monthly Washing Capacity of 50000 units, & Garment Dyeing Capacity of 25000 units.

12.2 WASH TYPES

- Enzyme wash
- Softener silicon finish
- Stone wash
- Distress wash
- Optic wash
- Oxy Bleach
- Crinkle wash
- Dyeing quality

Dyeing quality

- Pigment dyeing
- Reactive dyeing

12.3 DYEING:

White House is one of the first modern dye houses in South India. The unit has a monthly dyeing capacity of 450 tons. They are equipped with world class machineries for different process routing. They have installed Dyeing machine capacities ranging from 50 kg to 2000 kg.

- Continuous washing machine
- 8 & 10 chamber stenters
- Compacting Machines
- Raising Machines
- Carbon Brushing Machine
- Auto inspection & Packing m/c
- Automatic dye/chemical dispensing system
- Accredited Physical & Chemical Laboratories
- Bulk Dye & Chemical dispensing machine
- Spectro Photometer

They have implemented RFID tag technology to improve the supply chain management and for information accuracy.

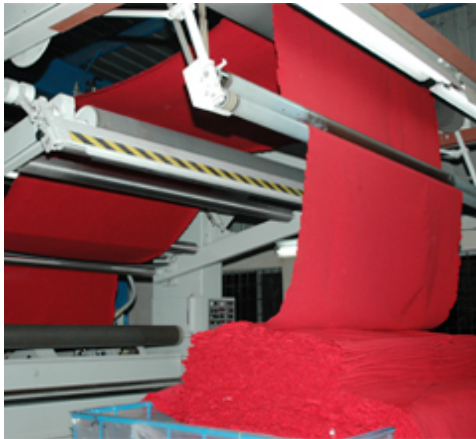
Effluent treatment plant with zero discharge concept for waste water treatment, using reverse osmosis and multiple effect evaporator resulting in safe environment.



(Figure 42)



(Figure 43)



(Figure 44)



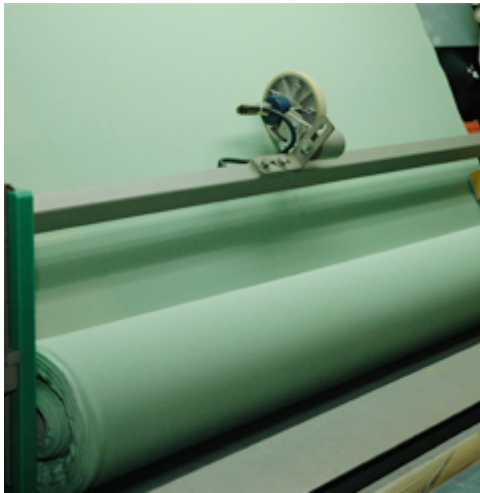
(Figure 45)



(Figure 46)



(Figure 47)



(Figure 48)



(Figure 49)



(Figure 50)



(Figure 51)



(Figure 52)



(Figure 53)



(Figure 54)



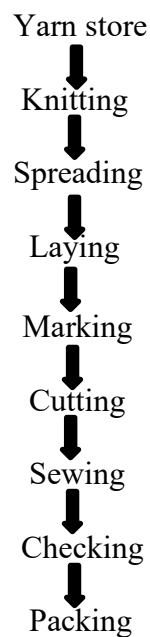
(Figure 55)



(Figure 56)

13.PRODUCTION AND PLANNING

Production department is the main task in the whole organization. process which involves in production:

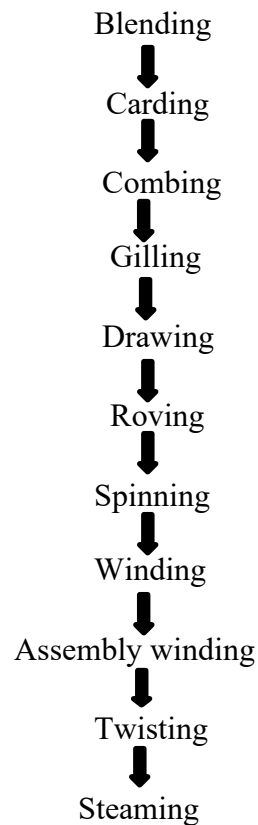


13.1 YARN STORE:

Yarn:

A textile yarn is a continuous strand of staple or filament fibers arranged in a form suitable for weaving, knitting, or other form of fabric assembly. Also, a yarn is a textile product of substantial length and relatively small cross-section consisting of fibers with twist and/or filaments without twist.

YARN PROCESS FLOW



Mentioned things on yarn carton box :

- Count - 10/1
- Yarn - 100% BCL
- Lot no - 1k9134C001
- Excise no - 2300045279
- Net / cross wt - 50.40/52.80

Lot card:

- Order ref
- Mill
- In v/no/dt
- G.R.N no/dt

13.2 KNITTING UNIT

White house knitting unit has monthly of capacity of 300 tons of fabric , equipped with 45 circular knitting machines.

The range of fabric include

- Single jersey
- Single jersey with lay in yarn
- Pique
- French terry
- Interlock
- Campus Rib
- Pullover Rib
- Single jersey/ pique feeder stripes
- Interlock pique
- Waffle

13.3 FABRIC:

They manufacture and supply Cotton and Blended Knit Fabrics, since 1990. They have also been nominated by reputed brands, for supply of fabrics to their sourcing factories. They produce wide range of fabrics from as delicate as 90 gsm to 450 gsm. They source following gray, melange & dyed yarns with stringent quality specification to knit various

13.4 TYPES OF FABRICS:

- Organic Cotton
- Recycled Cotton
- Recycled Polyester
- Cotton Slub
- Cotton Slub Organic
- Cotton Flex
- Cotton Viscose
- Cotton Polyester
- Cotton Modal
- Cotton Wool
- Bamboo Cotton
- Cotton Elastane
- Cotton Sorona
- Spun Polyester
- Polyester Filament
- Poly acrylic
- Cotton Nylon
- Cotton Hemp
- Cotton Tencel
- Cotton Viscose
- Merino Wool Recycled Polyester

They have a strong R&D Department wherein they develop new fabrics for our esteemed Customers. Some of the gray, melange and yarn dyed fabric types They produce for our in-house consumption and Customers are

- Single Jersey
- Single Jersey Plated
- Single Jersey Popcorn
- Single Jersey Quattro
- Single Jersey mini jacquard
- Pique
- Honeycomb Pique
- Fleece
- Rib
- Interlock
- Flat back Rib
- 8 lock Double knit structures

13.5 SPREADING:

Spreading is the process of unwinding large rolls of fabric into long, wide tables in preparation for cutting each piece of a garment.

Types of spreading:

- Auto machine spreading.
- Manual spreading.

Manual spreading:

- It is the process of laying the fabric by manual spreading may be used for all kind of fabrics and small meters fabrics.
- fabric is completely laid by Hand. With the help of mechanical assistance as roller cutter. With the help of manually operated spread truck. This is most extensively used for smaller production.



(Figure 57)

13.6 AUTO MACHINE SPREADING:

- Automatic spreading is nothing but spreading is done by a spreading machine and lay the fabric.
- Automatic fabric spreading means the smooth laying out of various types of fabric according to specific length. Fabric Spreading Machine is one type of machine by which the smooth laying out of various types of fabric according to specific length automatically instead of pulled by workers.



(Figure 58)

13.7 SPREADING LAY:

Before wash - Fabric
Width - 165
Length - 246

After wash - Fabric
Width - 157
Length - 227

13.8 CUTTING DEPARTMENT :

Cutting:

- The cutting is the process of reproduction of shape of pattern pieces in the fabric during the production of garment.
- The objective of cutting is to separate fabric parts as replicas of the pattern pieces in the marker plan.
- In achieving this objective, certain requirements are precision of cut, clean edges, support of the lay and consistent cutting.



(Figure 59)

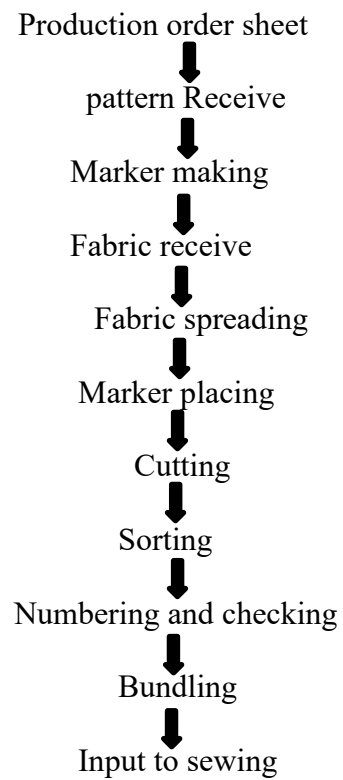


(Figure 60)



(Figure 61)

FLOW CHART OF CUTTING:

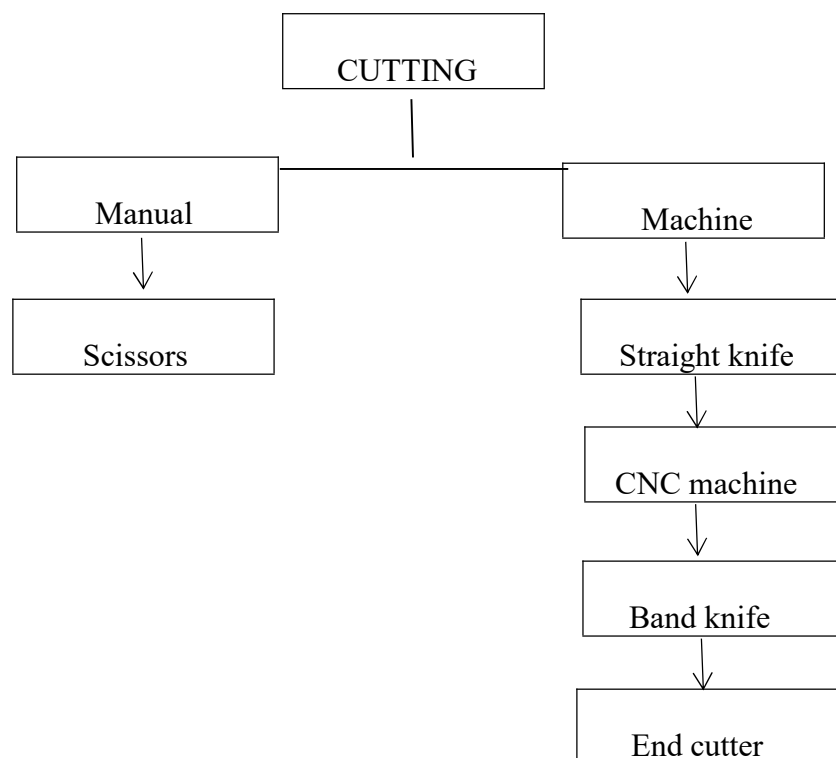


Factors affect the cutting process for fabrics are as follows: -

- Nature of fabric (grainline shade, twill etc.)
- The thickness of fabric.
- Design characteristics of a finished garment.
- Machines and tables used.

TYPES OF CUTTING

- Manual
- Machine



13.9 MANUAL CUTTING :

Hand shears :

- Hand shears are normally used only when cutting single or double plies.
- The obvious disadvantage of the method lies in the time it consumes and the consequent high labour cost per garment, but it is appropriate for made-to-measure garments.

Straight knife :

- Vertical blade
- Precipitates up and down
- Corners and curves can be cut accurately
- Most versatile and commonly used
- Blades length - 6 to 14 inches
- Spread depth depends on blade length and adjustable height of the blade guard
- All of the pieces cut from a lay are identical.

Cnc machine (computerized cutting machine)

CNC fabric cutting machines make garment cutting more flexible.

Band knife:

The band knife machines are used for cutting materials such as:

- Cotton
- Wool
- Silk
- Linen
- Synthetic fabrics
- Leather
- Card board

13.10 STICKERING :

- Stickering machine name - Blade
(including number depends upon the size)
- The method used to stick a numbering sticker on the garment cut panels is known as stickering.
- The stickers attached to the panels help other departments to identify the order number, style number, size, fabric lot number of the garment from the serial number printed on the sticker.

Size stickering :

Used to analyzing size .

Tags:

XXL - Orange tag
XL - Green tag
M - Pink tag
L - Blue
S - yellow
XXXL - violet

Details on the stickering :

Article No - 25933
Size - XL
Group - 2
PCs - 18
Panel - 603 to 620
Order ref - w23 - Gan- 008.3
Batch no - XXXX
Cut week - 20/2023
Lay slip - YYYYYY
Panel name - All parts
Color - 95 melange

13.11 BUNDLING

Bundling also depends on styling and tech pack of the garments. Such as back yoke of shirt is always bundled along with back, for easy handling in sewing line and nearby cut parts. Collar two parts and collar stand two parts is always bundled together because of nearby parts and similar sewing specifications.

13.12 SEWING

After cutting process the fabric will tie with bulk and separated cutting parts are given to the sewing team. Sewing team get the pattern parts and the accessories they started to stitch the pieces of fabric into the garment. There are 20-40 operations in the line for one polo Garment. The operations will differ by the style of the garment. After finishing the garment and the End control team will check the garments defects or any damage of the product.



(Figure 62)



(Figure 63)



(Figure 64)



(Figure 65)



(Figure 66)

Types of machines

- Single needle machine.
- Double needle machine.
- Over lock machine.
- Flat lock machine
- Specialized machines.

Once the garment is finished the garment will check by the many teams like END CONTROL team AQL team and then AQL Executives.

Checking points

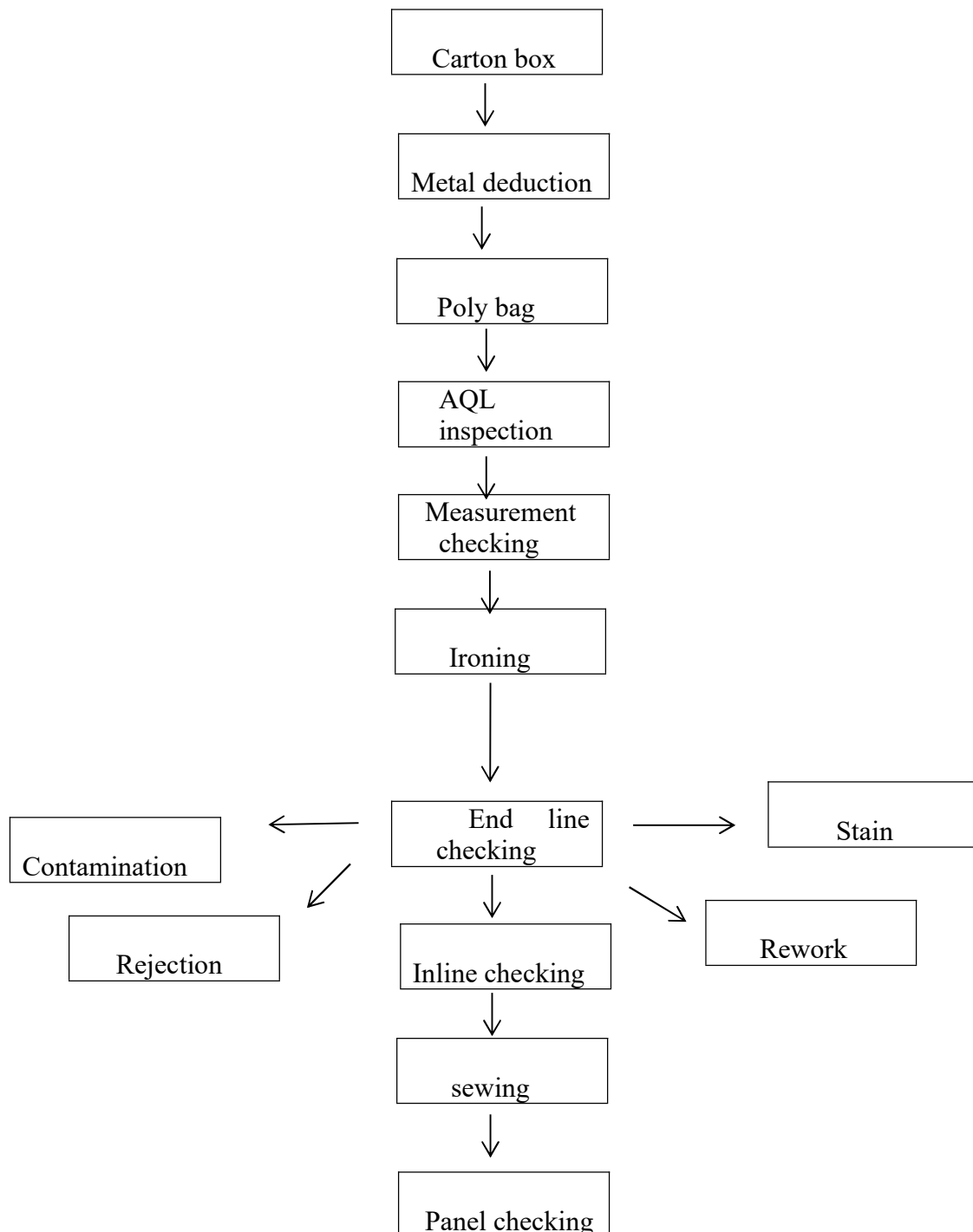
- Front part
- Back part
- Side seam
- Bottom
- Trims and Accessories

- Measurements
- Remove the extra thread

13.13 INDUSTRIAL ENGINEERING:

They use Industrial Engineering to study and reduce the work flow and the method flow. There sewing factory is completely driven by a highly efficient Planning & Production software FASTREACT to have a great control over WIP, Production Process and Delivery. Automatic conveyer system ETON for 80 work stations helps to reduce handling and downtime thereby improving efficiencies. They have a dedicated sample unit with 80 work stations for making Proto, Size set and Salesmen sample

WORK FLOW CHART



13.14 QUALITY CHECKING

Quality Control Department plays an important role in producing quality garment right first time.

Quality checking step by step:

- Measure garment dimensions.
- Check function of closures, buttons, zippers and other accessories.
- Verify proper packaging and labeling of garments.
- Test fabric for conformance to quality standards.
- Report on quality defects and severity.

13.15 MEASURE GARMENT DIMENSIONS:

The most important function of any piece of clothing is that it fits the end consumer as intended. Every garment importer can attest that customers will often return a garment if it doesn't fit as expected. Ill-fitting garments don't just create extra costs for you in the form of unsalable products. They can also create long-term problems as once-loyal consumers disavow your brand and turn to a competitor with better quality control.

13.16 CHECK FUNCTION OF CLOSURES, BUTTONS, ZIPPERS AND OTHER ACCESSORIES

Most garments aren't simply a few pieces of fabric stitched together. Rather, they also include functional and stylistic accessories like buttons, snaps, zippers, ribbons and elastic bands. A broken closure on a garment usually renders the clothing item unwearable and, therefore, unsaleable. Most consumers find poor quality closures to be a nuisance and frustration to repair. Poor quality or attachment of these accessories can lead to negative customer reviews and can even cause bodily harm to consumers.

Common tests include:

Pull test: Pull at the accessory with a pull gauge for 10 seconds to confirm it stays securely attached to the garment

Fatigue test: Use the accessory as intended for 50 cycles (e.g. button and unbutton 50 times) in quick succession and confirm it's still functional and the garment is undamaged after testing.

Stretch test: Stretch elastic bands and straps for proper elasticity and check for any breakage in elastic fibers or stitching. QC professionals generally conduct pull tests and fatigue tests on two pieces of each style of garment. It's normally unnecessary to carry out these tests on every piece in the sample during inspection because the processes used in attaching accessories to garments tend to be consistent throughout a shipment. But the quality of elastic materials used in production of some garments can vary between pieces. So inspectors usually perform a stretch test on the full sample size when relevant.

13.17 VERIFY PROPER PACKAGING AND LABELING OF GARMENTS:

Verifying proper packaging and labeling of garments is an essential part of most final inspections.

Proper packaging ensures your garments arrive at their final destination in the same condition they left your supplier's facility. Aside from inspecting packaging, your QC team should also check the labeling of garments to ensure compliance to legal requirements.

Conformance to legal requirements for garment labeling

- Fiber content of clothing compliant with the Textile Fiber Products Identification Act.
- Country of origin: where the item was manufactured or where the most significant manufacturing process occurred
- Manufacturer identity: either the company name or the Registered Identification Number (RN) of the manufacturer, importer or another firm marketing, distributing or otherwise handling the product
- Care instructions compliant with the Care Labeling Rule

Packaging inspection for garments

Most garments are sealed in poly-bags by factory staff before being packaged in retailer and shipping cartons for transit. Incorrectly packaging and sealing your garments can lead to dust and moisture permeating and soiling your products. And failing to comply with legal requirements for suffocation warnings on poly bags could lead to fines.

Inspecting packaging for potential quality issues in transit and distribution includes verifying:

- Poly bag sealing method
- Poly bag size
- Appropriate labeling, bar-codes and price tags
- Retail artwork and printing
- Carton assortment

13.18 TEST FABRIC FOR CONFORMANCE TO QUALITY STANDARDS

Fabric GSM check

Grams per square meter(GSM) is a measurement of fabric density applied to garments and raw textiles. Almost anyone can perform a GSM check with little training and equipment needed. During inspection, QC staff use a GSM cutter to cut a circular piece of fabric from a sample and then weigh it using an electric balance. They then compare the measured GSM to the customer's specifications.

Stitches per inch (SPI) check

A check for stitches per inch (SPI) involves the QC inspector simply counting the number of stitches in one inch of a selected area of the garment. An SPI check is easy to conduct, as it only requires a tape measure and adequate lighting. Checking SPI on two pieces of each style in a shipment is normally adequate.

While a SPI check is relatively nontechnical and easy to perform, that doesn't make it any less important than other testing. Stitch density is an important determinant of a garment's quality and durability. Garments with a higher SPI are less likely to fall apart with regular use and tend to last longer than those with a lower SPI.

Material composition check

Some obvious differences in fabric composition can be detected by hand feel alone during a garment inspection. But most garment importers require material composition testing by a qualified lab that's outfitted with proper equipment and controls. Material composition should reflect the breakdown of fiber types listed on the product label. Fabric composition that doesn't match what's printed on the labeling can cause financial and legal trouble that can irreversibly damage your brand.

13.19 REPORT ON QUALITY DEFECTS AND SEVERITY:

Visual inspection for quality defects is a critical step to any professional QC inspection for garments (related: How Experienced Importers Limit Quality Defects in 3 Stages [book]). Like those found in other types of products, different quality defects found in garments often differ in severity. Some defects may be easily overlooked by customers, while others are likely to result in product returns.

Some common defects garment importers might face include:

- An untrimmed thread.
- Shading variance between different pieces of the same style or different parts of the same piece.
- A loose needle left in the garment.

Most garment importers would agree that a loose needle left in a garment is a more severe issue than an untrimmed thread because of the hazard it poses to the consumer. But the severity of other defects might vary based on your intended market and sale price. Setting defect classifications before quality control inspection for garments will help ensure that QC staff consider all defects in accordance to your specific quality standards.

14.PACKING DEPARTMENT

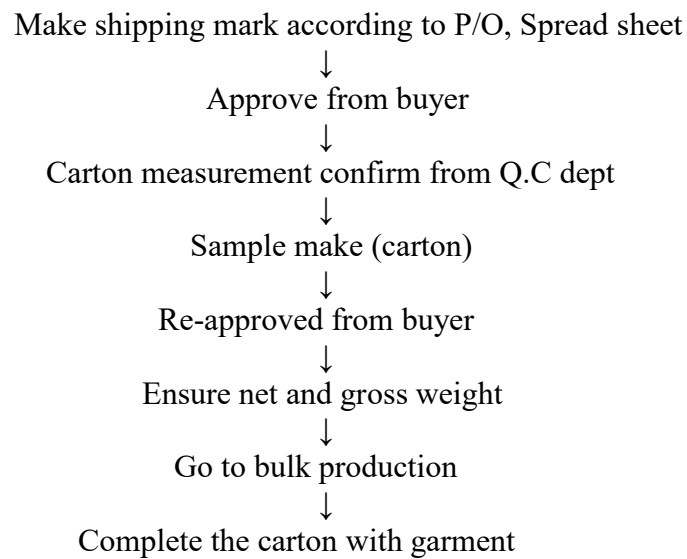
14.1 PACKING SECTION:

Packing is part of garment finishing. It is done by the requirement of the buyer. Various types of packing accessories are available in the storeroom such as poly-bag, packing board, tissue paper, hanger, scotch tape, gum tape, carton, etc.

14.2 INFORMATION OF CARTON BOX:

- BOX TOT - 4/4
- Season
- Article no
- Box type
- Size
- Colour
- Po number
- Shipment reference

Flow Chart of Packing



Cartons are made according to buyer instruction and lengthwise it contains the buyer name, width-wise it contains the measurement, net & gross weight. Carton contains the information that is printed by screen print style. In the apparel manufacturing process, fabric is the main raw material. It is impossible to make apparel only with fabric. To make complete apparel different types of secondary materials are used. These secondary materials are known as trimmings and accessories. Accessories are not directly attached to the body of apparel by sewing, only used for finishing and packing purpose. Basically, accessories are used for decorative purposes and trimmings are used as functional purposes.

14.3 INFORMATION OF ORDER COMPLETION REPORT:

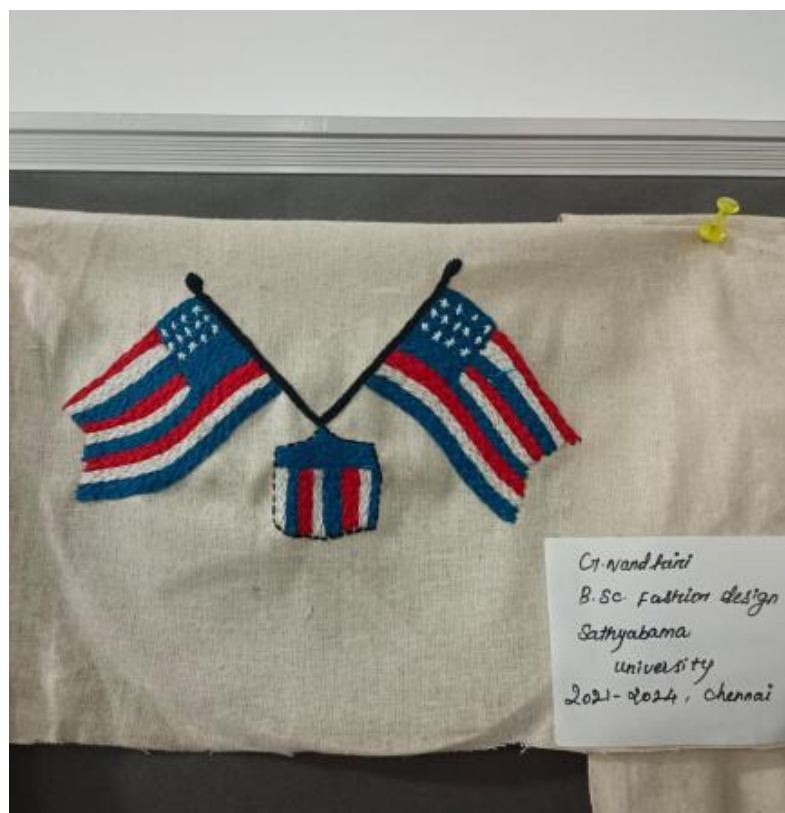
- Order city
- Possible to cut qty
- Cut qty
- Line issued qty
- End line passed qty
- Packed qty
- panel rejection
- Garment rejection
- Wash test
- Sample
- Good garment
- Cut to ship
- Order to ship

Defects :

- **Wrong sticker**– A finished garment has two or three stickers. The sticker used in the garments is incorrect.

- **Incorrect placement**– The specification sheet has details on where to use which sticker and any deviation finds is a packaging defect.
- **Incorrect Folding**– Folding is defined by the buyer in their specification whether it should be tri - fold or quad-fold.
- **Incorrect quantity in Carton** – A carton has a specific quantity that how many have to be in each carton.
- **Crease mark for folding**– All ironed garments should not have wrinkles or creases.
- **Packing orientation mistake**– The packing orientation to keep a carton also mentions in the garment specification.
- **Case label Missing**– Every case has one label with the PO number, style, size, quantity, gross weight, net weight, and some other information. If there is no case label, the carton cannot be identified.
- **Wrong case label**– Right label is to be attached and all information should be correct there.
- **Carton damaged**– Carton damage for mishandling and transportation.
- **Missing tag**– All tags and stickers should be in a carton.

15 .MY WORK:



(Figure 67)

CONCLUSION

This internship taught about the manufacturing processes used in the fashion industry, which is at the cutting edge of design, innovation, and large-scale production. This program helped to gain knowledge about the casual wear industry's raw material sourcing, production, quality control, and final product. It offered knowledge on premium clothing of the finest quality in the global market for casual wears. The internship program has shed light on the establishment of internal control procedures and organizational abilities that are pertinent to the apparel industry. Additionally, learnt on the workplace ethics and helped in individuality development. Overall, this internship program gave a lot of knowledge about the structure of the fashion industry, how it operates in accordance with moral principles, and how it contributes to the world

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