

CONCLUSION

A good quality control system is a necessary component in the production of good garments. Quality means money. Therefore a factory must be able to produce an acceptable quality level as agreed before hand between the manufacturer and the buyer. With a random quality checking procedure well organised system based on the following suggestions would produce better quality products, because quality control has been recognised universally as a scientific method of improving quality.

SUGGESTIONS

- 1) Quality of the imported yarn should be checked.
- 2) Trials must be carried out before introducing new yarn batches.
- 3) The number of samples taken for trials should be based on statistical principles.
- 4) Statistical quality control systems must be introduced.
- 5) It is desirable for the quality controller to have a knowledge of statistical quality control methods.
- 6) Various section heads should be given training on the use of modern technological methods and equipment.

- 7) The communication system between the various department should be effective so as to detect and correct the faults as and when they occur on the line.
- 8) The boarding section should be rearranged after a thorough work-study.
- 9) The person in charge of Production should have a sound knowledge on all the matters concerned with the departments under him.
- 10) An investigation should be carried out to estimate the optimum winding tension for maximum production efficiency in the knitting section.
- 11) An investigation should be carried out to estimate shrinkage percentage. It would help calculate raw measurements, and hence reduce waste in cutting.
- 12) Length variation is a typical problem in the case of plane knitted articles (Fig 24,26,27). Statistical machine adjusting method would be a help to reduced fault percentage from exceeding 2% of total production(Fig 28).
- 13) Twist factor should be changed for acrylic yarn which is used for 1x1 rib.



LINKING MISTAKE PERCENTAGE 1985 - 1986

Operator	Month	Oct.	Nov.	Dec.	Jan.	Feb.	Mar.	Ap.	May.	Jun.	Jul.	Aug.
21184		0.5	0.3	0.3	0.4	0.4	1.4	1.5	0.4	1.1	1.2	1.0
21262		1.3	0.9	0.8	0.6	0.8	2.4	4.2	2.2	1.7	2.5	1.5
30126		0.7	1.5	1.8	0.4	1.6	2.3	1.4	1.0	3.0	2.8	2.5
30534		1.4	1.8	1.8	1.4	2.8	4.8	5.7	1.8	3.0	1.6	2.0
30535		1.9	2.4	1.9	0.6	2.6	4.5	3.3	2.1	2.9	2.8	0.9
30709		0.3	0.8	1.1	0.7	0.6	4.3	0.8	1.5	0.7	1.5	0.7
40729		1.4	0.2	-	1.0	0.8	3.3	2.2	0.9	1.7	1.9	1.4
40929		2.5	0.4	0.3	0.6	2.1	2.6	0.7	0.4	0.8	0.3	0.5
50206		2.4	2.0	1.2	2.9	5.2	4.3	2.6	-	-	-	-
50227		3.5	1.9	0.9	0.1	1.5	2.8	2.6	1.6	3.6	1.3	1.3
50334		1.8	0.3	1.3	3.7	-	3.6	-	-	-	-	-
50508		2.2	0.3	-	-	-	-	-	-	-	-	-
50344		6.3	-	-	-	-	-	-	-	-	-	-

(Tab 19)

BOARDING MISTAKE PERCENTAGE 1985 - 1986

Operator	Month	oct.	nov.	Dec.	Jan.	Feb.	Mar.	Apr.	May.	Jun.	Jul.	Aug.
21083		0.4	0.5	1.5	0.6	2.8	1.6	2.4	1.4	1.8	0.8	0.6
21199		0.0	0.4	1.5	1.2	3.5	1.7	3.2	2.8	2.5	1215	2.7
30125		1.6	1.2	3.3	4.5	5.0	1.2	0.4	1.7	-	-	-
30431		2.9	2.9	2.9	3.8	3.9	3.2	1.4	2.1	2.5	2.8	4.1
40231		2.3	2.8	1.4	2.1	4.3	8.0	4.0	1.1	1.7	1.0	5.5
40605		0.6	3.0	1.7	2.6	4.1	6.6	7.8	-	4.6	3.1	2.9
40906		1.3	1.0	0.9	-	5.5	0.7	0.6	0.2	1.7	2.5	0.2
40832		2.8	1.7	1.2	3.3	4.2	4.6	2.0	1.1	1.4	1.2	1.8
40834		3.6	2.5	0.9	2.7	2.7	0.9	1.0	0.8	1.2	5.2	3.6

(Tab 20)

GRADING MISTAKE PERCENTAGE (1985 - 1986)

Operator / Month	Oct.	Nov.	Dec.	Jan.	Feb.	Mar.	Apr.	May.	Jun.	Jul.	Aug.	
20946	0.5	0.8	0.9	0.2	0.6	2.1	1.3	1.5	0.5	1.4	1.4	
21011	1.2	0.9	0.4	0.8	1.5	1.9	1.4	2.1	1.0	1.1	1.2	
21038	0.7	0.2	0.5	0.7	0.6	1.0	1.0	1.3	1.1	0.6	0.5	
21084	0.8	0.6	0.5	0.2	1.0	1.7	2.5	1.3	1.1	0.7	1.7	
30149	1.0	0.4	0.7	1.8	0.9	2.2	2.5	2.1	0.7	1.6	1.6	
31220	1.2	1.4	0.5	0.5	1.1	1.5	2.7	1.3	0.8	1.2	1.0	
40525	0.9	0.8	0.1	0.5	0.7	1.2	1.4	1.0	1.2	0.7	0.6	
40833	1.2	0.6	0.9	0.1	0.8	1.9	2.6	-	1.1	-	1.4	
21196	0.7	0.7	-	-	-	-	-	1.5	0.5	0.1	0.3	

(Tab 22)

CUTTING MISTAKE PERCENTAGE (1985 - 1986)

Operator \ Month	Oct.	Nov.	Dec.	Jan.	Feb.	Mar.	Apr.	May.	Jun.	Jul.	Aug.
21093	2.5	2.3	2.2	2.6	2.9	2.4	3.8	2.8	1.7	1.7	1.6
21094	2.3	2.8	2.0	2.1	2.7	2.0	3.4	2.2	1.5	1.4	1.4
21243	2.1	1.9	1.8	1.7	1.8	1.5	1.4	0.4	1.3	1.2	1.0
30144	2.5	2.3	2.2	2.2	2.1	2.0	2.0	1.5	1.7	1.8	1.6
30148	1.9	2.1	1.7	1.9	1.8	1.5	0.9	1.7	1.2	1.1	0.9
40714	2.2	2.1	2.3	2.0	2.1	1.7	1.6	1.5	1.5	1.6	1.3
40904	2.4	-	2.2	2.7	2.3	1.7	3.0	2.3	1.7	1.4	1.5
50212	-	-	3.8	3.3	3.9	3.9	2.3	2.1	2.5	2.8	1.5
51111	-	-	-	2.2	1.8	1.4	1.8	0.7	1.1	2.1	1.6
60303	-	-	-	-	-	-	3.1	3.2	3.2	4.2	1.4

(Tab 23)

SAWING MISTAKES PERCENTAGE (1985 - 1986)

(Tab 24)

Operator	Month	Oct.	Nov.	Dec.	Jan.	Feb.	Mar.	Apr.	May.	Jun.	JUL.	Aug.
21048		6.1	5.4	5.3	5.5	5.3	4.3	5.0	4.8	4.8	3.5	5.3
21087		3.8	3.4	3.5	3.5	3.1	3.2	3.4	4.8	5.5	3.1	2.9
21110		4.8	4.9	5.4	5.5	5.6	4.0	4.3	5.0	-	-	-
30211		7.7	7.0	7.5	12.5	6.5	6.0	5.5	6.3	5.6	5.8	6.5
30905		8.1	7.2	6.3	6.3	6.3	5.5	5.2	5.7	5.8	6.3	6.0
30911		3.5	2.9	3.9	2.8	2.6	2.7	2.9	2.6	2.6	2.1	2.2
40122		6.5	6.3	6.2	6.7	6.5	5.3	6.0	5.5	5.5	5.6	5.2
40236		7.6	4.7	5.7	5.8	6.3	5.0	6.2	5.4	5.3	5.4	5.6
40309		5.1	6.7	5.6	5.3	4.8	4.3	4.0	4.7	4.0	4.2	4.8
40405		7.7	5.0	7.1	6.0	6.0	5.2	5.0	5.6	5.7	6.5	6.1
40625		5.2	6.9	5.9	4.6	4.2	3.2	3.9	3.9	4.3	4.5	4.3
40632		7.8	5.6	5.6	4.6	4.2	3.8	4.6	5.0	5.1	4.5	5.3
40633		6.2	6.8	5.7	6.7	6.2	5.2	5.6	5.7	5.5	4.9	-
41109		-	-	2.5	9.8	6.0	5.7	5.4	5.5	5.3	5.8	5.7
50329		6.2	6.6	7.5	6.4	5.8	5.1	5.0	4.8	-	5.6	-
50331		-	-	12.9	5.9	5.5	5.6	5.7	5.5	5.8	5.2	5.2
50431		9.2	5.5	6.7	6.0	6.4	5.7	5.3	5.8	5.3	6.2	5.3
50524		5.5	6.2	5.1	5.5	5.8	5.9	6.0	5.5	5.7	5.5	5.4
50561		6.3	21.9	6.7	6.1	7.9	6.7	-	-	-	-	-
50347		-	-	5.7	4.7	4.1	4.4	5.1	5.3	5.5	5.4	5.6
52204		-	-	-	10.9	40.5	4.1	3.2	4.8	4.6	3.1	5.1
530205		-	-	-	-	15.9	5.6	5.0	5.0	4.9	4.7	6.5
60105		-	-	-	-	21.8	5.95	5.4	5.2	5.4	5.7	5.2
60203		-	-	-	-	-	9.0	7.0	6.1	5.3	5.6	5.7
60207		-	-	-	-	-	-	9.4	6.5	5.8	5.6	5.4
60210		-	-	-	-	-	-	9.8	6.4	6.1	5.5	5.5

MENDING MISTAKES (1985 - 1986)

Operator / Month	Oct.	Nov.	Dec	Jan.	Feb.	Mar.	Apr	May.	Jun.	Jul.	Aug.
21196	0.3	0.4	0.2	0.6	0.5	0.6	0.3	-	-	1.7	-
30343	0.7	0.7	0.0	1.3	1.2	0.9	1.1	1.3	1.9	1.2	1.4
31219	1.2	1.7	2.7	1.4	2.6	1.9	1.6	2.0	1.3	1.9	2.4
<u>REST GRADING</u>											
30342	0.3	0.8	1.2	0.6	0.6	0.6	0.3	0.3	0.5	0.1	0.3

(Tab 25)

