

**Report On**  
**Operational Processes and Practical Exposure During Internship at**  
**Epyllion Knitwears Industry-HW**

By  
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An internship report submitted to the Executive Development Center, BRAC Institute of Governance and Development (BIGD), BRAC University in partial fulfillment of the requirements for the degree of  
Post-Graduation Diploma in Knitwear Industry Management (PGD-KIM)

Executive Development Center, BIGD  
BRAC University  
November 2025

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## **Declaration**

It is hereby declared that-

1. The internship report submitted is my own original work while completing degree at Brac University.
2. The report does not contain material previously published or written by a third party, except where this is appropriately cited through full and accurate referencing.
3. The report does not contain material which has been accepted, or submitted, for any other degree or diploma at a university or other institution.
4. I have acknowledged all main sources of help.

**Student's Full Name & Signature:**

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**Shornali Akter Rumky**  
24281077

**Supervisor's Full Name & Signature:**

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**Syeda Salina Aziz**  
Fellow of Practice, BRAC Institute of Governance and Development (BIGD)  
BRAC University

## **Letter of Transmittal**

Syeda Salina Aziz  
Fellow of Practice,  
BRAC Institute of Governance and Development (BIGD)  
BRAC University  
66 Mohakhali, Dhaka-1212

Subject: Submission of internship report

Dear Madam,

This is my pleasure to submit my final industrial attachment on “Operational Processes and Practical Exposure during Internship at Epyllion Knitwears Limited.-HW” as a part of completion degree of Post Graduate Diploma in Knitwear Industry Management (PGD-KIM).

I have attempted my best to finish the report with the essential data and recommended proposition in a significant compact and comprehensive manner as possible.

I trust that the report will meet the desires.

Sincerely yours,

---

Shornali Akter Rumky  
24281077  
Executive Development Center, BIGD  
BRAC University  
17<sup>th</sup> November, 2025

## **Non-Disclosure Agreement**

This agreement is made and entered into by and between **Epyllion Knitwears Limited- HW** (A sister concern of **Epyllion Group**) and the undersigned student **Shornali Akter Rumky** at EDC, BIGD, Brac University.

There is no denial of the fact that during my internship period, I have come across a lot of confidential information related to the management, operation and many other aspects of the organization which is strictly prohibited to share with unauthorized personnel. I agree not to disclose any of such private and confidential information, both oral and written, to anyone else unless the person is an approved one by the respective authority. I am also well aware of the fact that any violation of this confidentiality may lead to disciplinary action or legal action taken against me. I, hereby, declare in sense that I accept all the terms and conditions of the organization regarding its confidentiality policy and am ready to take the responsibility in case of any violation of its privacy for the sake of any of my action.

**Student's Full Name & Signature:**

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Shornali Akter Rumky

ID: 24281077

**Industry Supervisor's Full Name & Signature:**



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Parvez Ahmed

Deputy Manager, Printing

Epyllion Knitwears Limited- HW

## **Acknowledgement**

I would like to express my sincere gratitude to **BRAC University** for providing me with the opportunity to undertake the Post Graduate Diploma internship and gain practical exposure in the apparel manufacturing industry. This industrial training has been a significant part of my academic and professional development.

I am deeply grateful to my academic supervisor, **Ms. Syeda Salina Aziz**, for her continuous guidance, constructive feedback, and valuable support throughout the preparation of this report titled “*Operational Processes and Practical Exposure during Internship at Epyllion Knitwears Limited – HW.*” Her encouragement and suggestions have greatly enhanced the quality of my work.

I would also like to extend my heartfelt appreciation to my industrial supervisor, **Mr. Parvez Ahmed**, for providing me with the opportunity to observe and learn from various operational departments at Epyllion Knitwears Limited – HW. His mentorship, practical insights, and cooperation made my learning experience meaningful and effective.

My sincere thanks go to all the officials, executives, and staff members of **Epyllion Knitwears Limited – HW** who supported me during my internship and willingly shared their knowledge, operational practices, and industry experience. Their guidance helped me bridge the gap between theoretical understanding and real-world application.

Finally, I am thankful to my family, friends, and classmates for their encouragement and inspiration throughout this journey.

## **Executive Summary**

This report presents the findings and learning outcomes of my industrial internship at **Epyllion Knitwears Limited – HW**, undertaken as part of the Post Graduate Diploma program at BRAC University. The internship aimed to provide practical exposure to the operational systems of a modern knitwear industry and to enhance my understanding of real-world factory practices beyond classroom-based theoretical learning.

During the internship period, I had the opportunity to observe the **overall functions of the factory**, including HR, Admin & Compliance, Planning, Quality, Maintenance, MCD, PDC, Embroidery. While the report provides detailed discussion on five core departments — **Merchandising, Industrial Engineering (IE), Cutting, Sewing, and Printing** — my observations extend to the broader workflow of the entire manufacturing unit. This holistic exposure helped me understand how different departments are interconnected and how coordinated operations contribute to timely production and shipment.

The executive sections of the report highlight the key tasks I followed up in each major department, practical differences from theoretical concepts, and the operational challenges commonly encountered in a large-scale apparel manufacturing setup. A critical assessment is included to reflect how academic knowledge from generic and industry-specific courses supported my understanding during the internship. Additionally, several constructive suggestions have been proposed for process improvement based on in-field observations.

The internship significantly strengthened my analytical skills, technical understanding, communication ability, and problem-solving mindset. Overall, the experience at Epyllion Knitwears Limited – HW provided meaningful professional exposure and deepened my understanding of integrated knitwear manufacturing operations, preparing me for future responsibilities within the RMG sector.

**Keywords:** Operational processes; Knitwear manufacturing; Industrial internship; Departmental assessment; Process optimization; Practical learning outcomes.

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## **List of Acronyms**

|       |                                                |
|-------|------------------------------------------------|
| RMG   | Ready-Made Garments                            |
| PP    | Pre- Production                                |
| IE    | Industrial Engineering                         |
| T&A   | Time and Action                                |
| CM    | Cost of Making                                 |
| FOB   | Free on Board                                  |
| PO    | Purchase Order                                 |
| QCO   | Quick Changeover                               |
| AQL   | Acceptable Quality Level                       |
| CTPAT | Customs Trade Partnership<br>Against Terrorism |
| CTS   | Computer to Screen (Printing<br>Technology)    |
| SNLS  | Single Needle Lock Stitch                      |
| PD    | Product Development                            |
| MCD   | Material Control Division                      |
| SMV   | Standard Minute Value                          |

## **Glossary**

|                |                                                                                                   |
|----------------|---------------------------------------------------------------------------------------------------|
| AQL            | A quality standard that defines the maximum number of defects allowed during inspection.          |
| Consumption    | The calculated amount of fabric required to produce a garment, including allowances.              |
| Line Balancing | The method of distributing tasks evenly across operators to improve sewing line efficiency.       |
| Marker         | A layout sheet that arranges pattern pieces on fabric to minimize wastage during cutting.         |
| PP Meeting     | A meeting held prior to bulk production to finalize technical requirements and quality standards. |
| SMV            | The standard time required for a skilled operator to complete a sewing operation.                 |

## **Chapter 1: About Organization**

The Ready-Made Garment (RMG) industry of Bangladesh has been a central pillar of the national economy since its expansion in the late 1970s. As the largest industrial sector of the country, it contributes substantially to export earnings, female employment, and the development of backward and forward linkages within the manufacturing economy. The sector has played a key role in accelerating industrialization by integrating Bangladesh into global value chains and enabling the growth of vertically integrated apparel enterprises. . *[World Bank (2017). “Bangladesh: Toward Accelerated, Inclusive and Sustainable Growth—Opportunities and Challenges.”]*

Within this broader industrial context, **Epyllion Group** was established in 1994 as a knit apparel manufacturing and exporting organization. Over time, it has evolved into a diversified conglomerate with operations spanning knit garments, textile production, wet processing, and garment accessories. The Group’s vertically integrated structure—including yarn dyeing, knitting, fabric processing, and garment manufacturing—supports standardized production, facilitates quality control, and reduces lead-time variability.

**Epyllion Knitwears Limited – HW**, one of the key sister concerns of Epyllion Group, operates as a specialized knitwear manufacturing unit. This facility plays a significant role in the Group’s production network by handling large-scale garment manufacturing for various international buyers. The unit functions within the Group’s central strategic framework, emphasizing compliance, process efficiency, and continuous improvement across its operational departments.

Epyllion Group and its concerns, including Epyllion Knitwears Limited – HW, maintain collaborations with global apparel brands from Europe, the USA, Asia, and Africa. The organization places importance on sustainability practices, environmental compliance, worker well-being, and skills development—all of which align with the evolving expectations of the global apparel market. Through these integrated practices and structured operational systems, Epyllion continues to contribute meaningfully to Bangladesh’s RMG sector while maintaining relevance within the global textile and apparel supply chain.

## 1.1 Overview of Epyllion

The organizational philosophy of Epyllion Group is centered on the idea of the **“Human Spirit,”** which refers to the energy, creativity, and resilience of its workforce. The company believes that employee well-being and a positive work environment are critical to achieving long-term objectives. By focusing on human resource development, the organization has sought to enhance motivation, job satisfaction, and overall productivity.

Epyllion began its journey with only 2 sewing lines and around 200 employees in Mirpur, Dhaka. Over the past three decades, it has expanded significantly, now employing more than 22,000 people across multiple production facilities in Dhaka, Gazipur, and Narayanganj. Its operations include backward linkages such as textiles, dyeing, and accessories, making it a vertically integrated organization capable of producing high-quality knit apparel.

The company’s business practices highlight both quality assurance and sustainability. For example, Epyllion has implemented initiatives in environmental protection and has developed facilities that align with green industry standards. These efforts, combined with its emphasis on innovation, have contributed to its steady growth in the competitive global market.

At the core of this development are the employees, who are positioned according to their skills and capabilities. The organization’s emphasis on human capital has played a vital role in shaping its operational excellence and reputation within the Bangladeshi RMG industry.

## 1.2 Vision & Mission of Epyllion Group

- **Vision:** Epyllion Limited aims to be the industry leader in accessories, prioritizing its employees, community, and society. The company strives to achieve production accuracy, timely delivery, and exceptional service for both direct and indirect customers and suppliers.
- **Mission:** Epyllion Group's mission is to become the premier provider of comprehensive solutions for related industries. The company aims to achieve this by harmonizing human spirit with technological advancements.

## 1.3 Goals & Objective:

- ✓ To gain insights into the industrial work culture.
- ✓ To enhance communication skills and build professional relationships.
- ✓ To acquire hands-on knowledge of textile processing and garment manufacturing techniques.
- ✓ To comprehend the responsibilities and duties properly.
- ✓ Immerse myself in the dynamic work environment of Epyllion Group.
- ✓ To get know about cross functional departments along with own department.

#### 1.4 Organizational Structure of Epyllion Group

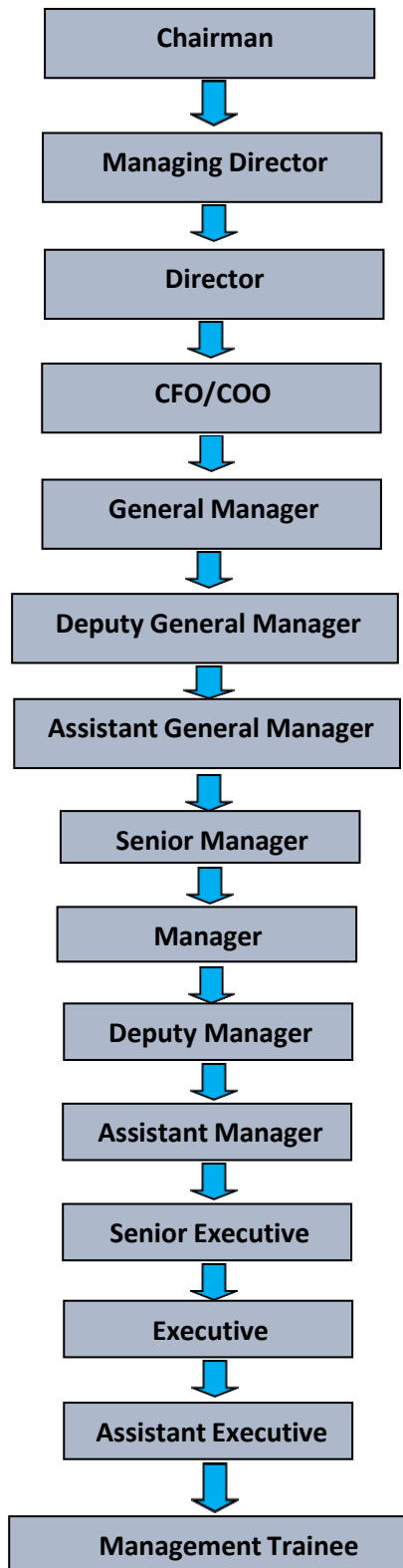


Chart 1: Organizational Structure of Epyllion Group

## **1.5 Timeline of different establishments of Epyllion Group**

Epyllion Group has established itself as a significant global apparel manufacturer. The company's journey began with a primary focus on garment manufacturing, and over time, it expanded into various segments of the textile industry, including textile mills, knitting facilities, and wet processing units. This gradual diversification has allowed Epyllion to strengthen its supply chain and respond effectively to the evolving demands of the international apparel market.

- **1994:** Establishment of **Dekko Knitwears Ltd.**
- **2000:** Formation of *Epyllion Ltd.*
- **2003:** Establishment of *Epyllion Knitex Ltd.*
- **2004:** Launch of *Epyllion Knitwears Ltd.*
- **2006:** Expansion with *Epyllion Fabrics Ltd.* and *Epyllion Style Ltd.*
- **2008:** Addition of multiple units, including *Dazzling Dresses Ltd.*, *Epyllion Washing Ltd.*, *Epyllion Ltd.–Extension*, and *Nina Holding Ltd.*
- **2012:** Development of *Epyllion Testing Laboratory* to strengthen quality assurance.
- **2013:** Establishment of *Epyllion Food & Beverage Ltd.* as part of business diversification.
- **2015:** Formation of *Epyllion Holding Ltd.* and launch of its retail brand *Sailor*.
- **2020:** Expansion with *Epyllion Knitwears Ltd.–HW*

Today, Epyllion is recognized for its emphasis on quality, innovation, and sustainability. The company has built collaborative relationships with international brands and continues to invest in its workforce and infrastructure to ensure long-term growth. Through this steady expansion and

integration of operations, Epyllion has evolved into a diversified conglomerate that contributes to both the Bangladeshi RMG sector and the global apparel supply chain.

## **1.6 Different Departments**

- ✓ Human Resource Management, Admin & Compliance
- ✓ Garments Planning
- ✓ Merchandising
- ✓ Material Control Division
- ✓ Production Development Center
- ✓ Industrial Engineering
- ✓ Maintenance
- ✓ Cutting
- ✓ Embellishment
- ✓ Sewing
- ✓ Finishing

## 1.7 Products/ Services of Epyllion Group

| Knitted Fabrics                                                                                                                                                                                                                                                                                                                  | Garments Items                                                                                                                                                                                                                                                                                                                                                                   | Accessories                                                                                                                                                                                                                                                                                                            |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>✓ Single Jersey</li> <li>✓ Single Lacoste</li> <li>✓ Polo Pique</li> <li>✓ Double Lacoste</li> <li>✓ 1x1 Rib</li> <li>✓ Ottoman Rib</li> <li>✓ Terry: 2T Fleece, 3T Fleece</li> <li>✓ Double Jersey</li> <li>✓ Design Jersey</li> <li>✓ Auto Stripe</li> <li>✓ Jacquard Fabric</li> </ul> | <ul style="list-style-type: none"> <li>✓ Men's Knit Polo, T-Shirt, Sweatshirt, Cardigan, Knitted Bottom</li> <li>✓ Boy's Knit Polo, T-Shirt, Sweatshirt and Cardigan</li> <li>✓ Lady's T-Shirt, Long sleeve shirt, sweatshirt, Cardigan</li> <li>✓ Polo T-Shirt, Sweatshirt, Cardigan of girls</li> <li>✓ Kid's &amp; Baby's Knit Polo, T-Shirt, Sweatshirt, Cardigan</li> </ul> | <ul style="list-style-type: none"> <li>✓ Label</li> <li>✓ Drawstring</li> <li>✓ Twill Tape</li> <li>✓ Elastic</li> <li>✓ Price Ticket</li> <li>✓ Poly</li> <li>✓ Gum Tape</li> <li>✓ Auto Carton</li> <li>✓ Manual Carton</li> <li>✓ Printing Press</li> <li>✓ Jacquard Tape</li> <li>✓ Plastic Accessories</li> </ul> |

**Table 1: Products/ Services of Epyllion Group**

- **1994–2000:** Started mainly with *basic knitwear items* (T-shirts, Polo shirts). Early buyers were mostly European (Germany, Netherlands, UK).
- **2000–2006:** Expanded to *diversified knit fabrics* (jersey, pique, rib) and garments for *men, women, and kids*. Buyers expanded to the USA and Japan alongside European markets.
- **2008–2012:** Introduced *value-added products* like fleece, sweatshirts, cardigans, as well as backward linkages (washing, fabric mills, testing labs). This period marks entry into more *fashion-focused retailers* in Europe (e.g., H&M, C&A, Next).
- **2013–2015:** Business diversification (Food & Beverage, Sailor retail brand). Garments line included *fashionable kidswear* and *ladies' long-sleeve shirts*. Buyers included *Walmart (USA), Lindex (Sweden), Tesco (UK)*.
- **2016–Present:** Epyllion started emphasizing *sustainable fabrics, recycled yarn, and green factories*. Product categories like *Jacquard fabrics, auto stripe knits, and performance wear* gained traction, targeting *premium buyers in Europe and North America*

## 1.8 Buying Partners of Epyllion Group



Fig. 1: Buying Partners of Epyllion Group

## **Chapter 2: Description of Task Accomplishment**

During my internship at **Epyllion Knitwears Ltd – HW Unit**, I had the opportunity to observe and participate in various operational and managerial activities across different departments. My primary objective was to gain practical knowledge about the overall functioning of the apparel production process and understand how theoretical concepts are applied in real industry practices. Throughout the internship period, I was involved in several key areas such as merchandising, industrial engineering (IE), cutting, sewing, and embellishment departments. In each department, I closely followed up specific processes, assisted in day-to-day activities, and learned about different methods used to ensure quality, efficiency, and timely production.

### **Sample that described:**

- Merchandizing
- Industrial Engineering
- Cutting
- Embellishment
- Sewing

## **2.1 Merchandising Department**

The merchandising department plays a vital role in the garment industry as a bridge between the buyer and the factory. It ensures that customer requirements are understood, translated into production activities, and delivered on time with the desired quality and cost efficiency. Merchandisers are responsible for coordinating all departments—such as fabric sourcing, sample development, production planning, and shipment—so that the order is executed smoothly from start to finish.

### **Overall Function of Merchandising**

The core function of merchandising is to manage the order from buyer inquiry to shipment. This includes communication, costing, sampling, approvals, production follow-up, and shipment coordination. Merchandising can be divided into **two main categories**:

- **Marketing Merchandising** – dealing with buyers, taking orders, and negotiating price and delivery.
- **Production Merchandising** – following up on production, quality, and shipment schedules.

### **Process of Merchandising**

#### **1. Buyer Communication and Order Enquiry**

The process begins when a buyer sends an enquiry or tech pack for a potential order. The merchandiser studies the specifications, including fabric type, styling, trims, quantity, and delivery date. Proper communication is maintained with the buyer to clarify all details.

#### **Key Activities:**

- Receiving buyer's order sheet or tech pack.
- Checking garment details, size range, measurements, and trims.
- Clarifying any unclear points with the buyer.
- Preparing a consumption report.

## **2. Costing and Price Negotiation**

Once all details are understood, the merchandiser prepares the garment costing by calculating fabric consumption, trims, accessories, CM (cost of making), overhead, and profit margin. After management approval, the price is quoted to the buyer.

### **Key Activities:**

- Fabric and trims cost calculation.
- Labor and overhead cost estimation.
- Preparing cost sheet and FOB/CM pricing.
- Negotiation with buyer and final confirmation of price.

## **3. Sample Development and Approval**

Buyers usually require several types of samples before confirming bulk production, such as proto sample, fit sample, size set, pre-production (PP) sample, and shipment sample. The merchandiser coordinates with the sample section to make these samples and send them to the buyer for approval.

### **Key Activities:**

- Sample request forwarding to sampling department.
- Arranging materials for sample making.
- Sending samples to buyer and getting comments.
- Making necessary corrections as per buyer feedback.

## **4. Material Sourcing and Booking**

After the order is confirmed and sample approved, the merchandiser proceeds with sourcing or booking of all raw materials such as fabric, trims, labels, threads, and packaging materials. Coordination is done with the commercial department for import or local purchase.

**Key Activities:**

- Fabric and accessory booking with suppliers.
- Preparing purchase orders (PO).
- Follow-up with suppliers to ensure on-time delivery.
- Checking materials against approved standards.

**5. Pre-Production Activities**

Before bulk production starts, a **Pre-Production (PP) Meeting** is held with representatives from all related departments — merchandising, cutting, sewing, quality, and production — to discuss the order plan, quality points, and critical issues.

**Key Activities:**

- Conducting PP meeting.
- Discussing buyer comments, construction details, and quality requirements.
- Issuing production files with approved samples and technical data.
- Confirming production start date.

**6. Production Follow-Up**

During production, merchandisers continuously monitor progress to ensure everything runs according to the approved standards and timeline. They communicate any changes or issues to the buyer and coordinate with production and quality teams.

**Key Activities:**

- Daily follow-up with cutting, sewing, finishing, and washing departments.
- Monitoring production status and solving technical problems.
- Ensuring quality consistency and on-time delivery.
- Updating buyer on order progress (T&A report).

## **7. Quality Control and Inspection**

The merchandiser coordinates with the quality team and buyer's nominated inspectors to carry out inline and final inspections. Any quality issues are discussed and corrected promptly.

### **Key Activities:**

- Arranging internal quality checks.
- Coordinating buyer's final inspection.
- Ensuring packing and labeling meet buyer's standards.
- Handling any corrective action if inspection fails.

## **8. Shipment and Documentation**

Once the order is ready, the merchandiser ensures smooth shipment through the commercial and logistics department. All shipping documents are prepared accurately as per buyer's requirements.

### **Key Activities:**

- Booking vessel or air shipment.
- Preparing invoice, packing list, and shipping documents.
- Sending documents to buyer or bank.
- Closing the order after shipment completion.

## **9. Post-Shipment Follow-Up**

After the goods are shipped, the merchandiser follows up for buyer feedback and payment status. Any issues raised by the buyer are recorded for future improvement.

### **Key Activities:**

- Buyer feedback and complaint handling.
- Shipment performance analysis & updating internal records and T&A summary.

## **2.2 Industrial Engineering**

**The Industrial Engineering (IE)** department in a garments section plays a critical role in optimizing processes and enhancing efficiency.

### **Function:**

#### **Style and Process Review:**

- ✓ **Activity:** Collaborates with the production team and technicians to review garment styles and processes. This includes evaluating the operation bulletin to ensure that all production steps are optimized and aligned with the required specifications.

#### **Layout Design:**

- ✓ **Activity:** Develops efficient layouts for production lines, including the arrangement of machines and manpower. This is crucial for maximizing workflow efficiency and ensuring that production processes are streamlined.

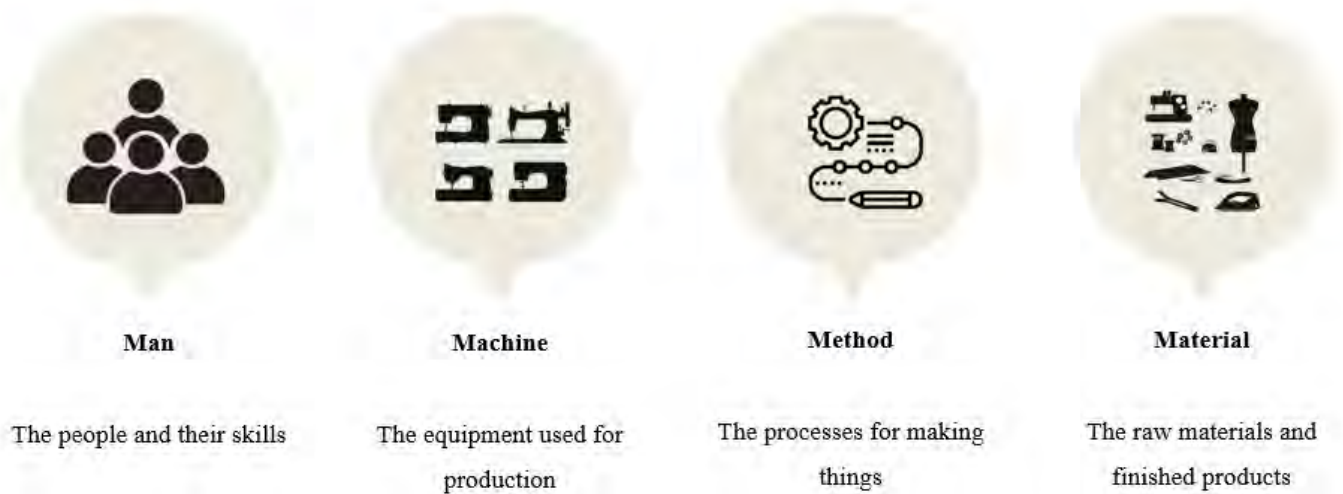
#### **Style Fitting and Machine Arrangement:**

- ✓ **Activity:** Initiates the sewing process by submitting style specifications to maintenance for machine setup and to the production team for implementation. Ensures that machines are arranged and adjusted according to the style requirements before production begins.

#### **Production Capacity:**

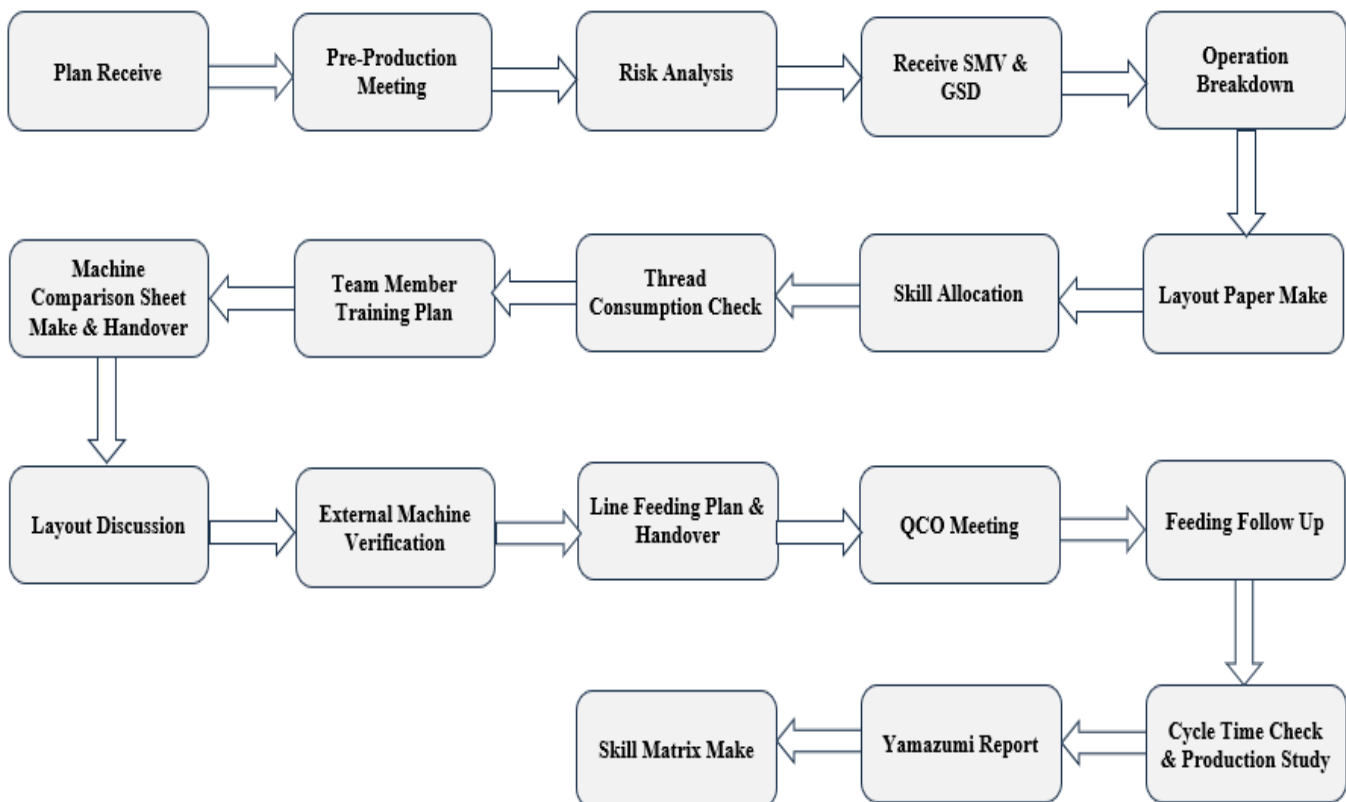
- ✓ **Capacity:** Manages production lines with the capability to produce over 6,500 pieces per line, across 49 lines and 9 total units.
- ✓ **Objective:** Focuses on enhancing production capacity and minimizing waste through efficient processes and layout planning.

## The 4M's of Industrial Engineering



**Fig 2: The 4M's of Industrial Engineering**

## Process Flow Chart (IE)



**Chart 2: Process Flow Chart (IE)**

## 2.3 Cutting

Garments cutting is a crucial stage in the apparel manufacturing process, serving as the foundation for creating well-crafted and precisely fitting clothing. This phase involves the strategic transformation of fabric rolls into pattern pieces that will eventually come together to form a complete garment. The art and science of garments cutting require a meticulous understanding of patterns, fabrics, and the intended design, as precision at this stage significantly influences the overall quality of the final product.



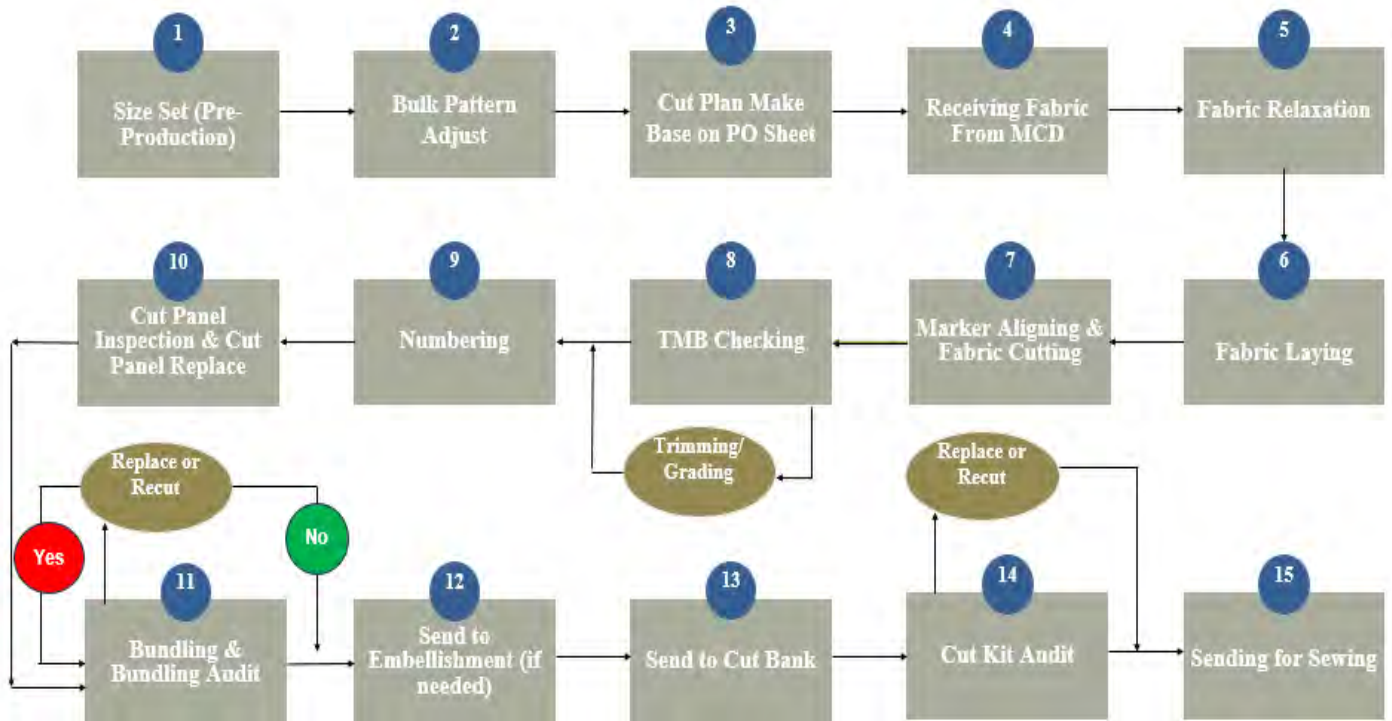
**Fig 3: Cutting Section**

### **Machines use in cutting**

Different types of machines used in cutting section are-

1. Auto cutter machine
2. Auto spreader machine
3. Band Knife machine
4. Edge cutter machine
5. Straight Knife machine
6. Auto piping machine
7. Steam relaxation machine
8. Label maker machine

### Process Flow Chart of Cutting:



**Chart 3: Process Flow Chart of Cutting**

## **2.4 Sewing**

Garment sewing is a critical phase in the apparel manufacturing process, where fabric pieces cut during the earlier stages are assembled into finished garments. This stage involves the use of sewing machines, skilled operators, and a keen attention to detail to ensure that the final product meets design specifications, quality standards, and fits the intended purpose. The sewing process plays a pivotal role in transforming individual components into cohesive and wearable garments.

### **Machineries of Sewing:**

- ✓ Single Needle Lock Stitch Machine/ PLAIN Machine
- ✓ Three Thread Overlock Machine
- ✓ Four Thread Overlock Machine
- ✓ Flat Lock Machine

### **Process Details:**

#### **Feeding Plan**

- ✓ The sewing process begins with the development of a feeding plan, outlining the specific requirements for each production line.
- ✓ Considerations include the types of garments to be produced, the volume of production, and any special instructions from the buyer.

#### **Line Layout Making**

- ✓ Based on the feeding plan, the line layout is designed to optimize the workflow and accommodate the different stages of garment assembly.
- ✓ This involves arranging sewing machines, workstations, and other equipment in an organized and efficient manner.

#### **Receive Input through Andon System**

- ✓ The Andon system is utilized to receive real-time input and updates from the production line.
- ✓ Operators use the Andon system to signal any issues, requests for materials, or other relevant information.

### **QCO Meeting (Quick Change Over)**

- ✓ Reducing the time and resources required for the changeover process

### **Line Feeding**

- ✓ Raw materials, including cut fabric pieces, trims, and other components, are fed into the production line according to the feeding plan.
- ✓ This stage is crucial for maintaining a continuous and efficient workflow.

### **Endline Table Check**

- ✓ An endline table check is performed to verify that all necessary components have been accurately placed and attached during the sewing process.
- ✓ This checkpoint ensures that each garment meets the specified design and quality requirements.

### **Ironing**

- ✓ Garments undergo ironing to remove any wrinkles or creases and to ensure a polished appearance.
- ✓ Ironing is a critical step in achieving the desired finish and presentation of the garments.

### **Getup Check**

- ✓ The getup check involves a thorough inspection of each garment to assess its overall appearance, stitching quality, and adherence to design specifications.
- ✓ Any issues identified at this stage are addressed promptly.

### **Folding**

- Once garments pass the getup check, they proceed to the folding stage.
- Folding is carried out according to specified standards, ensuring neat and uniform presentation.

### **AQL Audit (Acceptable Quality Level)**

- ✓ The Acceptable Quality Level (AQL) audit is conducted to assess a random sample of garments for quality compliance.
- ✓ This step helps ensure that the entire production batch meets or exceeds the acceptable quality standards.

### Cartooning

- ✓ Garments are carefully packed into cartons, following specific packing guidelines.
- ✓ This stage involves organizing garments in a way that ensures protection during transportation and facilitates easy handling.

### CTPAT (Customs Trade Partnership Against Terrorism)

- ✓ The CTPAT process involves compliance with security measures and standards to secure the international supply chain against potential threats.
- ✓ Epyllion Knitwear Limited adheres to CTPAT requirements to ensure the security and integrity of its shipments.

### Process Flow Chart of Sewing Production

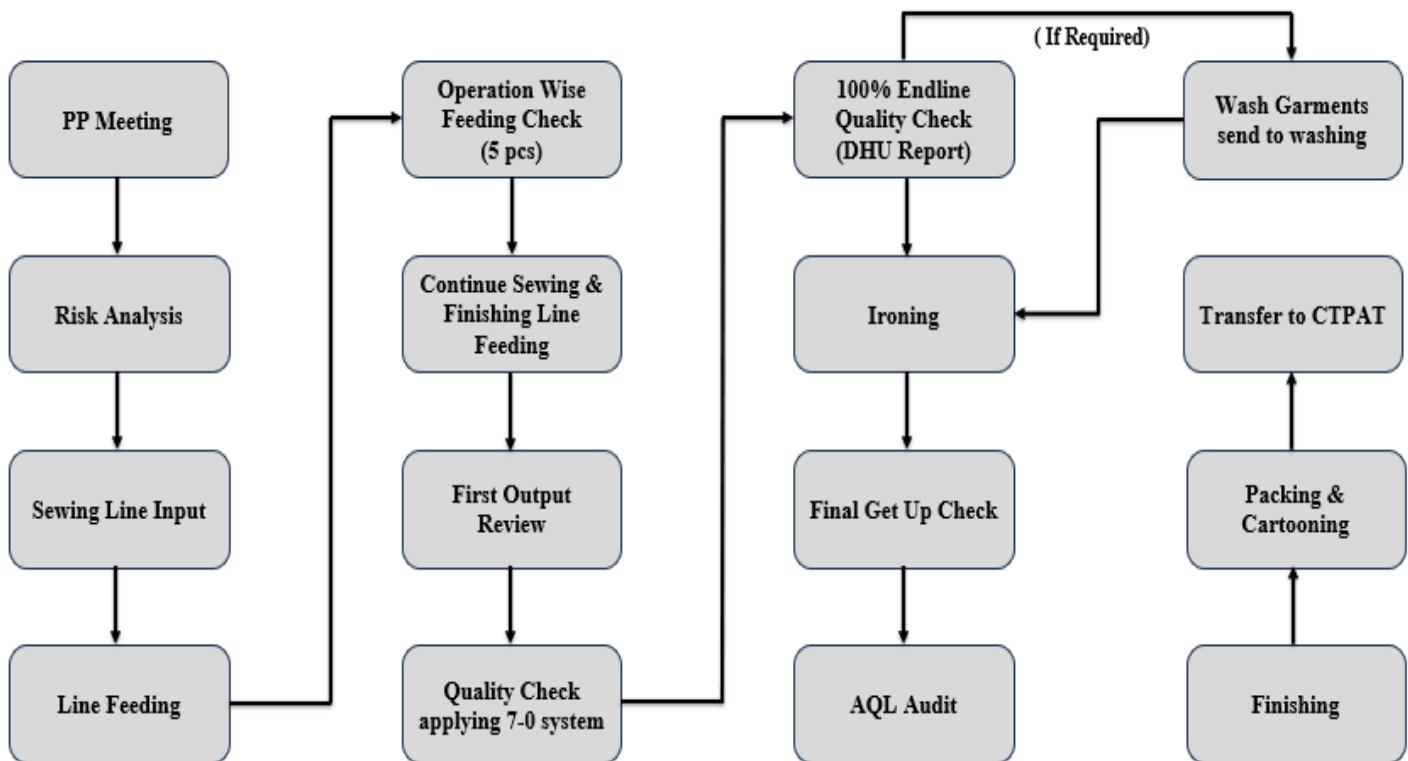


Chart 4: Process Flow Chart (Sewing Production)

## Process Flow Chart (Sewing Quality)

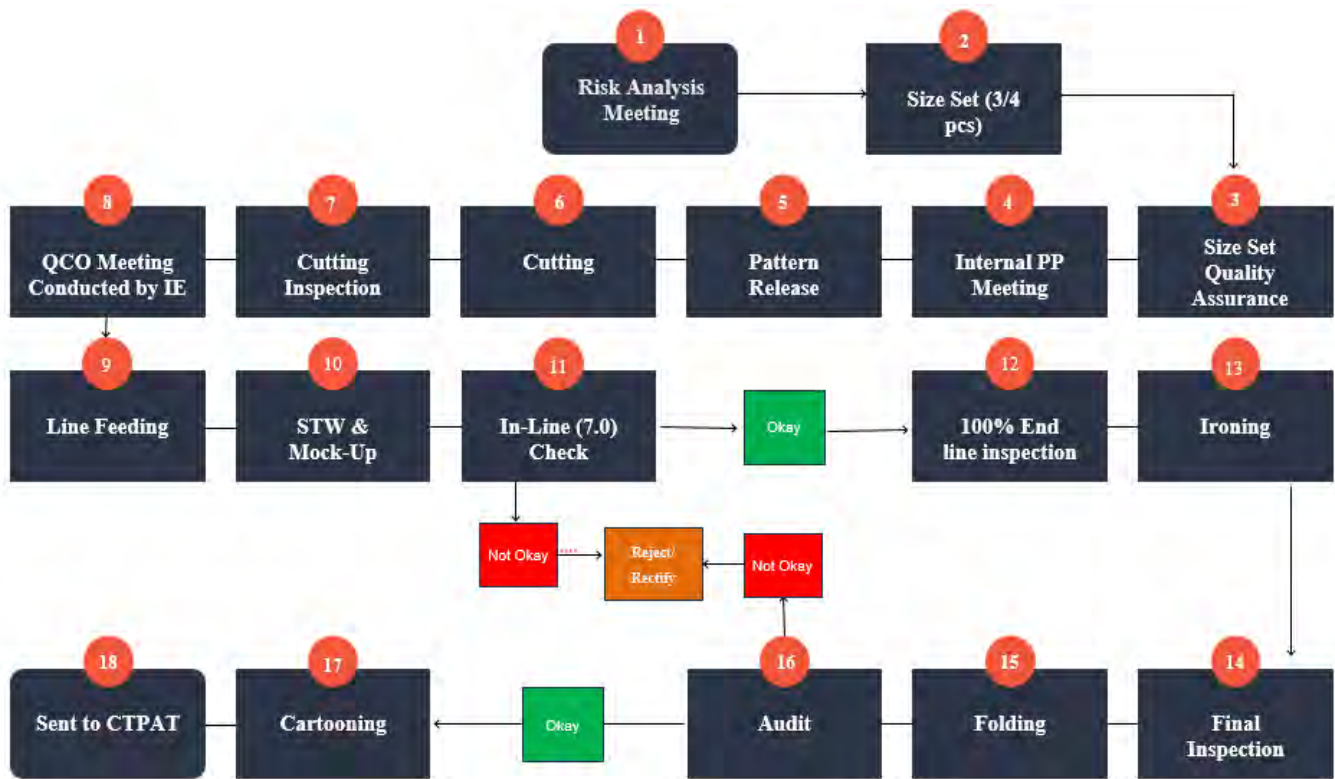
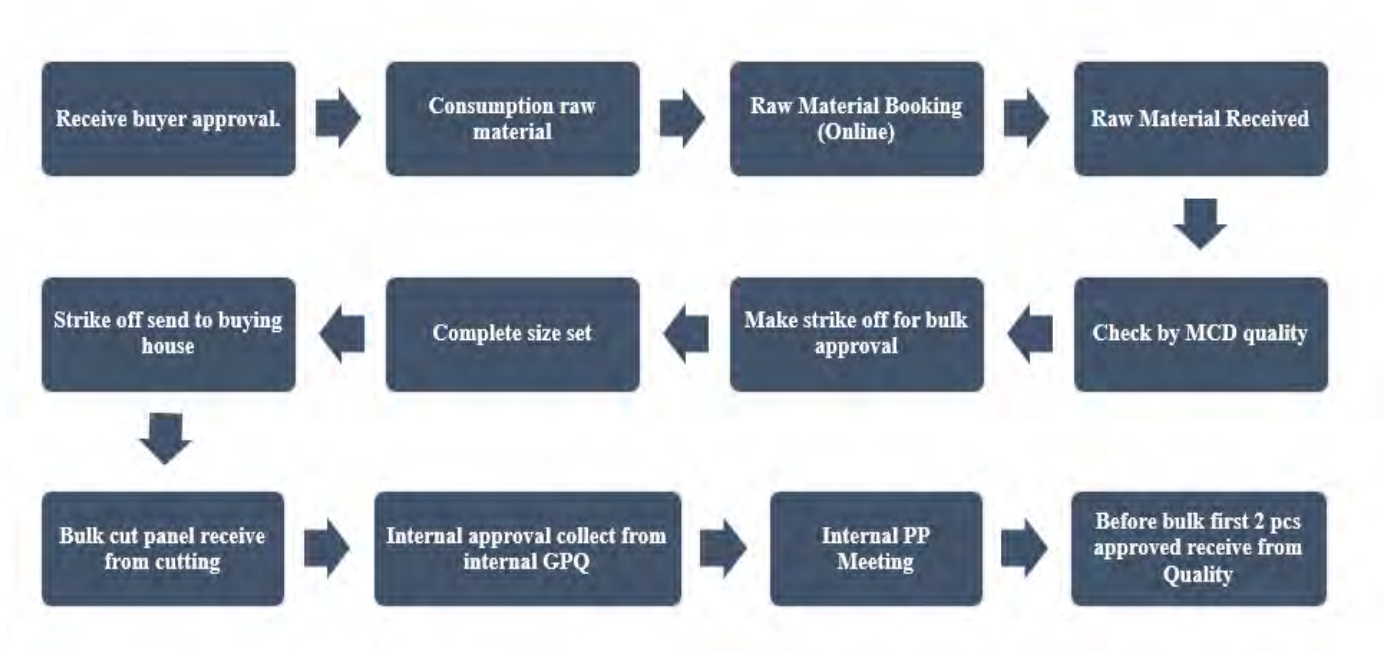


Chart 5: Process Flow Chart (Sewing Quality)

## 2.5 Printing

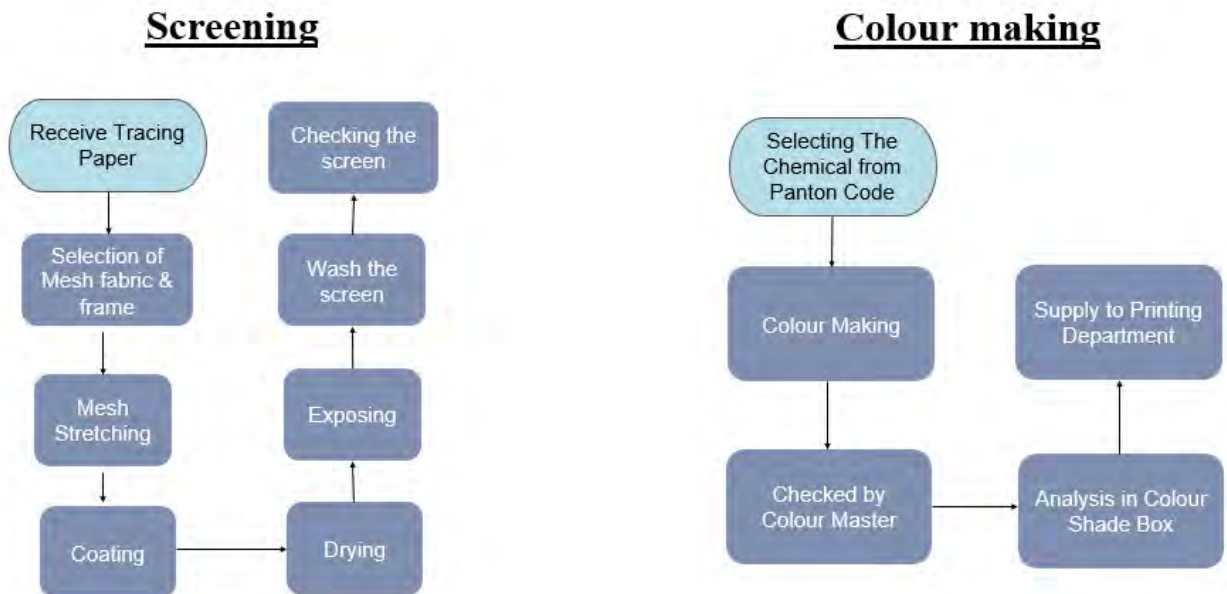
### Pre- Production Process of Printing



**Chart 6: Pre- Production Process of Printing**

## Process Flowchart of Printing (Production)

(Before)



(After)

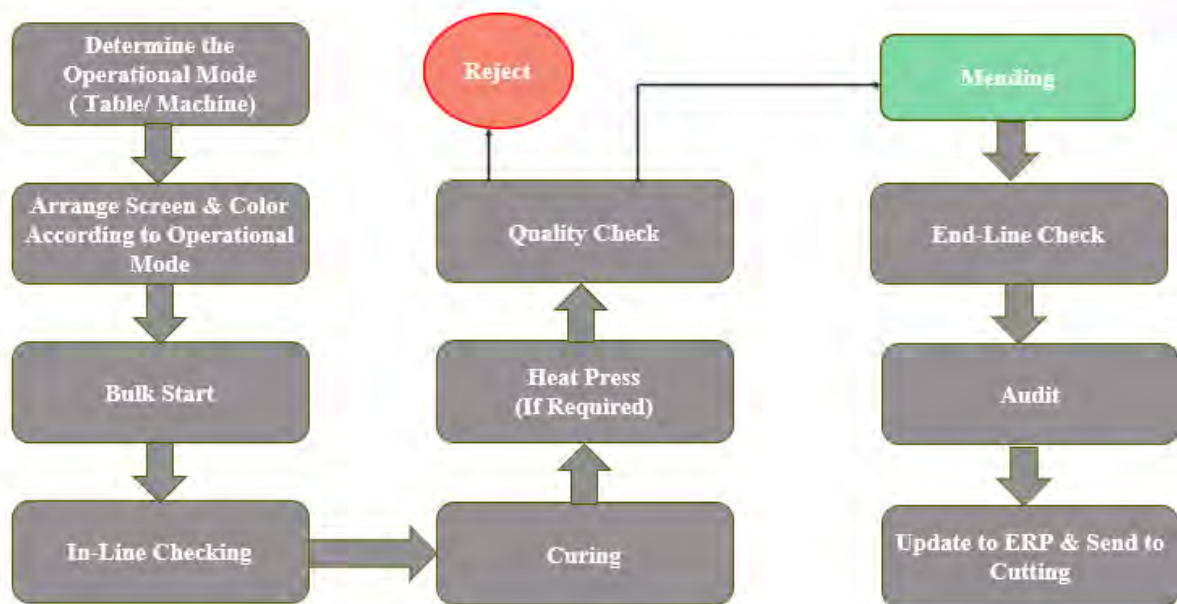


Chart 7: Process Flow Chart of Printing (Production)

**Print Types & Machineries:**

|                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                             |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Types of Printing-</b> <ul style="list-style-type: none"><li>✓ Pigment Print</li><li>✓ Semi Rubber Print</li><li>✓ Rubber Print</li><li>✓ Crack Print</li><li>✓ Silicon Print</li><li>✓ Gel Print</li><li>✓ Glitter Print</li><li>✓ Puff Print</li><li>✓ Sued Puff Print</li></ul> | <b>Machine For Printing-</b> <ul style="list-style-type: none"><li>✓ Carousel Machine: 5</li><li>✓ Oval Machine: 1</li><li>✓ Manual Table: 4</li><li>✓ Sample Table: 1</li><li>✓ 3D Injection Molding machine: 2</li><li>✓ Heat Press Machine: 4</li><li>✓ Curing Machine: 3</li><li>✓ CTS Machine: 1</li><li>✓ Manual Expose Machine: 1</li><li>✓ Auto Screen Washing Machine: 1</li></ul> |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

**Table 2: Print Types & Machineries**

## **Chapter 3: Critical Assessment of Internship Work**

Throughout this three-month internship, I have gained exposure to many new topics that were previously unfamiliar to me. The PGD-KIM program provided a strong theoretical foundation, and this internship allowed me to connect those theoretical concepts with real industrial practices. As I worked across different departments, I was able to clearly understand and relate the lessons taught by my course instructors to actual operational processes.

Visiting multiple departments also enabled me to observe diverse workplace environments, which significantly broadened my understanding of industrial operations. This practical engagement enhanced my self-confidence and strengthened my professional outlook. I developed a better sense of professional behavior, technical competencies, and practical problem-solving approaches. Overall, the internship contributed substantially to my personal development, professional growth, and understanding of the knitwear manufacturing industry.

### **3.1 Application of Generic and Industry-Specific Courses During Internship**

During my internship at Epyllion Knitwears Ltd. (HW Unit), I had the opportunity to apply both theoretical and industry-specific knowledge learned during my academic courses. Each department provided practical exposure that helped me relate classroom concepts to real industry operations.

- During my internship in the **Merchandising Department**, I applied my academic knowledge from the course **Production Management & Merchandising (KIM-203)**. This course taught me the fundamentals of buyer communication, order costing, and sourcing strategy. During my internship, I used these concepts to follow up on ongoing styles, observing how buyer requirements are handled from sample development to shipment confirmation. I also applied my understanding of **T&A (Time and Action)** planning, consumption calculation, and communication protocol to assist in daily follow-ups, which enhanced my ability to manage order timelines efficiently.
- In the **Industrial Engineering Department**, I applied my learning from the course **Industrial Engineering (KIM-201)**. The course emphasized time and motion study,

efficiency calculation, and process optimization — all of which I observed being practically implemented on the sewing floor. I followed up on the efficiency tracking process, studied line balancing, and identified bottlenecks in production flow. This experience helped me bridge the gap between theoretical IE methods and their real-world applications in improving operator performance and productivity.

- My coursework in **Introduction to Garments Industry Knitwear (KIM-201) & Quality Management (KIM- 204)** provided insights into fabric characteristics, shrinkage, and cutting accuracy. These learnings were crucial during my internship in the **Cutting Section**, where I followed up on fabric spreading, marker checking, and bundle preparation. I observed how operators manage fabric variation and control defects to maintain cutting precision. The hands-on experience deepened my understanding of practical cutting operations, beyond the theoretical aspects learned in class.
- In the **Sewing Department**, I applied my academic knowledge from the course **Introduction to Garments Industry Knitwear (KIM-201) & Quality Management (KIM- 204)**. The course introduced me to sewing line balancing, operation breakdown, and in-line quality inspection systems. During the internship, I followed up on daily production reports, observed line setup, and monitored how supervisors manage operators to meet production targets. I also observed quality teams conducting in-line inspections, which helped me relate classroom theories of quality management to real-life production practices .
- Finally, in the **Printing Department**, I utilized my learning from **Introduction to Garments Industry Knitwear (KIM-201) & Quality Management (KIM- 204)**. This course focused on print development, color management, and curing methods, which I found directly applicable during my internship. I followed up on print approval processes, color matching, and curing temperature control. Observing real-time printing operations helped me understand the importance of precision and consistency in achieving buyer-approved print quality.

### **3.2 Suggestions for Industry Improvement**

Although Epyllion Group maintains an advanced and structured system, I identified a few minor areas for improvement during my internship:

- Although Epyllion's merchandising system is well-organized, I noticed that coordination between merchandising and the production floor sometimes faces minor delays in information flow, especially during style changes. Strengthening internal communication through more frequent short coordination meetings and standardized progress updates could further minimize these delays and improve on-time delivery.
- I noticed that while the IE team closely monitors efficiency, some data is still manually collected. Implementing a more structured daily performance summary shared across related departments could help improve transparency and quicker decision-making. Additionally, periodic operator skill assessments could support better line balancing and manpower allocation.
- Although Epyllion's cutting section operates efficiently, I noticed that material movement between the spreading and cutting tables could be optimized. Introducing a better fabric handling layout and ensuring clear visual labeling for shade lots could help minimize confusion and reduce rework. Regular maintenance checks of cutting blades would also ensure consistent cutting quality.
- While the sewing lines are well-organized, I noticed occasional bottlenecks during style changes. Pre-production line trials and short refresher training for operators before new styles start could reduce downtime and adjustment errors. Additionally, closer coordination between sewing and finishing sections could enhance workflow smoothness.
- I observed that print rejections occasionally occurred due to temperature or curing inconsistencies. Maintaining a detailed record of color formulation and curing settings for each style could help standardize repeat orders and minimize variations. Better ventilation and regular screen cleaning could also improve print quality and worker safety.

### **3.3 Learning for Self-Improvement**

- I improved my professional communication, organizational, and observation skills. I learned how a merchandiser manages multiple orders simultaneously and how attention to detail, time management, and negotiation are essential for maintaining buyer satisfaction and smooth workflow.
- Through daily observation, I developed a better understanding of production efficiency and practical line balancing. I also improved my analytical thinking by identifying how small layout or motion changes can lead to significant productivity gains. This experience taught me to view efficiency as a continuous improvement process rather than a fixed target.
- I learned how to relate theoretical marker efficiency with real fabric utilization. My observation and planning skills improved as I understood how practical challenges like fabric width variation and human error affect efficiency and quality.
- I learned how to monitor line efficiency practically and how communication among supervisors, IE, and quality teams directly affects performance. This section improved my leadership awareness, real-time decision-making, and understanding of how teamwork drives output consistency.
- I improved my technical understanding of printing quality control and developed patience and attention to detail. I learned how coordination between design, quality, and production teams ensure accuracy and timely delivery of printed fabrics.

## **Chapter 4: Conclusion**

The internship experience provided a practical platform to apply theoretical knowledge gained through academic coursework in a real industrial environment. Working in a large-scale apparel manufacturing organization allowed me to understand how different departments coordinate to achieve production efficiency, product quality, and timely delivery.

Throughout the internship, I was involved with five key departments — **Merchandising, Industrial Engineering (IE), Cutting, Sewing, and Printing**. Each department offered distinct learning opportunities and helped strengthen my understanding of the overall garment production process. In the merchandising section, I observed how buyer communication, order planning, and costing is managed in practice. The IE department provided hands-on exposure to efficiency measurement, line balancing, and capacity study — areas that had previously been understood only through theory. In the cutting and sewing departments, I learned how fabric handling, marker efficiency, and operational control directly affect productivity and product quality. The printing department introduced me to the technical aspects of color matching, print quality inspection, and curing, helping me connect classroom concepts with real applications.

Through this internship, I also realized that theoretical models often assume ideal conditions, while practical situations require constant adjustments and coordination among various teams. Observing real-time production processes helped me develop a deeper understanding of problem-solving, decision-making, and adaptability — essential skills for industrial operations. This experience contributed significantly to my professional and personal growth. I improved my observation, communication, and analytical abilities while learning to work effectively within a structured organizational system. The internship also enhanced my appreciation of quality management, process control, and time management, which are critical in the ready-made garment (RMG) sector.

In conclusion, the internship program was an important academic learning phase that allowed me to integrate theoretical knowledge with practical experience. It provided insights into the complexities of apparel production and management, strengthened my understanding of industrial processes, and prepared me to apply academic learning to professional practice with greater confidence and competence.

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