



**MAS ACTIVE**  
**LINEA INTIMO**

**HACKING MEETING PROCESS**

21<sup>ST</sup> 10 2016



# Content

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# Purpose of the Hacking Meeting

The hacking meeting is called out to review each and every sample Concept, proto type, size sets, DS samples and to identify & rectify the technical, and feasibility challenges we might face during bulk production or next round of samples



# Time lines & Rules

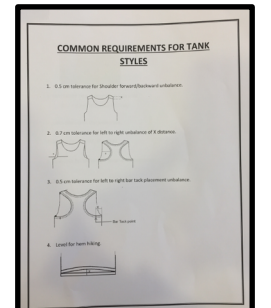
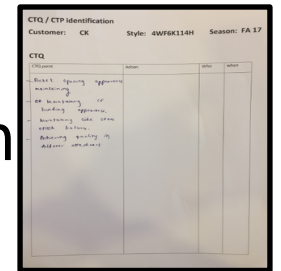
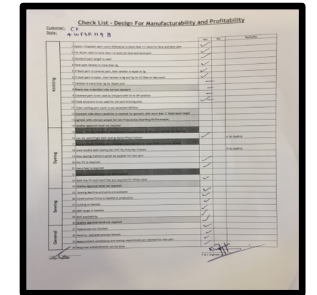
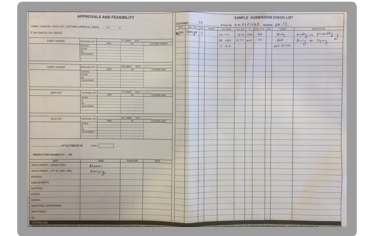
- Time line – Every Tuesday & Thursday 4.00 P.M to 5.00 P.M
- 8 styles will be discussed. It could be a mix of brands.

# Responsible Departments

- Development
- Marketing
- Knitting
- IE
- Yarn Tech
- Dye house
- Sewing
- Packing
- Quality

# Hacking Meeting Documents

- Risk analysis document
- Manufacturability & profitability Design check list
- Critical to process (CTP) & Critical to Quality (CTQ) Document
- Common requirement form for each silhouette



# Risk analysis document for Knitting ,Dying & Swing Department

APPROVALS AND FEASIBILITY					SAMPLE SUBMISSION CHECK LIST										
FABRIC HANGERS/ MOCK UPS CUSTOMER APPROVAL NEEDS    YES   NO					CUSTOMER : CK      STYLE NO 4 W F K I L Q H    SEASON FA 17										
If yes specify the details															
FABRIC HANGERS	RESPONSIBLE DEPT	1ST SUBMIT- DATE			DATE	SUB TYPE	SIZE	FAB REF	FAB COMPS	ALIC SHA	VL	FEED TYPE	SAY	COMPO	PROCESS FLOW
	KNITTING	NAME	SIG	CUSTOMER COMMENT											
	DYEING														
	QA DEVELOPMENT														
FABRIC HANGERS	RESPONSIBLE DEPT	2 ND SUBMIT- DATE													
	KNITTING	NAME	SIG	CUSTOMER CMNT											
	DYEING														
	QA DEVELOPMENT														
MOCK UPS	RESPONSIBLE DEPT	1 ST SUBMIT- DATE													
	SEWING	NAME	SIG	CUSTOMER CMNT											
	IE														
	QA DEVELOPMENT														
MOCK UPS	RESPONSIBLE DEPT	2 ND SUBMIT- DATE													
	SEWING	NAME	SIG	CUSTOMER CMNT											
	IE														
	QA DEVELOPMENT														
STYLE FREEZE IN    STAGE															
PRODUCTION FEASIBILITY : OK															
DEPT	NAME	SIGNATURE	DATE												
DEVELOPMENT ( DESIGN ENG)	Niswan														
DEVELOPMENT ( FIT & CONS. ENG)	Koranga,														
BONDING															
EMBLSHMENTS															
KNITTING															
DYEING															
SEWING															
INDUSTRIAL ENGINEERING															
MAINTANACE															
QA															
CONTROLLED															

The challenges occurred during knitting, dying and sewing processes will be updated to this document and thereafter the challenges will be analyzed and rectified or it will be communicated to the customer through the review sheet.

# Manufacturability & profitability Design check list

**Check List - Design For Manufacturability and Profitability**

Customer: CK  
Style: 4-60 F&K H & H

	Yes	No	Remarks
Knitting	1. Machine Parameter yarn count difference is more than 1-3 ratio for face and back yarn	✓	
	2. For Nylon ratio is more than 1-2 ratio for face and back yarn	✓	
	3. Standard yarn length is used	✓	
	4. Face yarn tension is more than 1g	✓	
	5. If back yarn is covered yarn, then tension is equal to 1g	✓	
	6. If back yarn is nylon, then tension is 4g and 2g for 22 Shaw or less count	✓	
	7. Tension is more than 1g for staple yarn	✓	
	8. Rowed size is decided with correct standard	✓	
	9. Covered yarn is not used as 1st yarn with 0% in OFF position	✓	
	10. Flank structure is not used for 2nd yarn for 22 Shaw	✓	
	11. Total knitting yarn count is not exceeded 20000	✓	
	12. Garment take down capability is checked for garment with more than 3" waist band height	✓	
	13. Agreed with relevant people for new Process (Gao Beorling/Techonple)	✓	
	14. Quality approval level not required	✓	
Dyeing	15. Color, Tension, material, chemical, mechanical, and environmental are checked	✓	
	16. Can be used single bath dyeing (Nylon/Poly/Cotton)	✓	If NO RefP10
	17. Measurement consistency checked after addition for single bath dyeing	✓	
	18. Used double bath dyeing (Nylon/Poly/Cotton)	✓	If NO RefP15
	19. New dyeing method is given by supplier for new yarn	✓	
	20. Dry Fit is required	✓	
	21. Hand feel is required	✓	
	22. Both Dry Fit and Hand feel are required	✓	
	23. Both Dry Fit and Hand feel are required for White color	✓	
	24. Quality approval level not required	✓	
Sewing	25. Sewing Machine and parts are available	✓	
	26. Construction/Times is feasible in production	✓	
	27. Cutting is feasible	✓	
	28. WAF range is feasible	✓	
	29. Sewing availability	✓	
General	30. Quality approval level not required	✓	
	31. Tolerances are checked	✓	
	32. Need to adjust process factors	✓	
	33. Measurement consistency and testing requirement are checked for new yarn	✓	
	34. Required embellishments can be done	✓	

Design Engineer: [Signature]

P & C Engineer: [Signature]

This form comprises with critical points which will directly affect the profitability producing a particular garment through its design and textures. Which will be analyzed and acknowledged by the **Fit and Construction Engineer** and the **Design Engineer**.

# Critical to Process Points & Critical to Quality Points CTP & CTQ – Documents

CTQ / CTP identification

Customer: CK      Style: 4WF6K114H      Season: FA 17

CTQ

CTQ point	Action	Who	when
- Pocket opening appearance maintaining			
- Maintaining CF bonding appearance.			
- Maintaining side seam stitch balance.			
- Achieving quality in foldover attachment.			

CTP – The development department will mention the critical points in order to have a keen attention when producing the next sample round or the production.

CTQ - The development department will mention the critical points in order to have keen attention on quality criteria or points

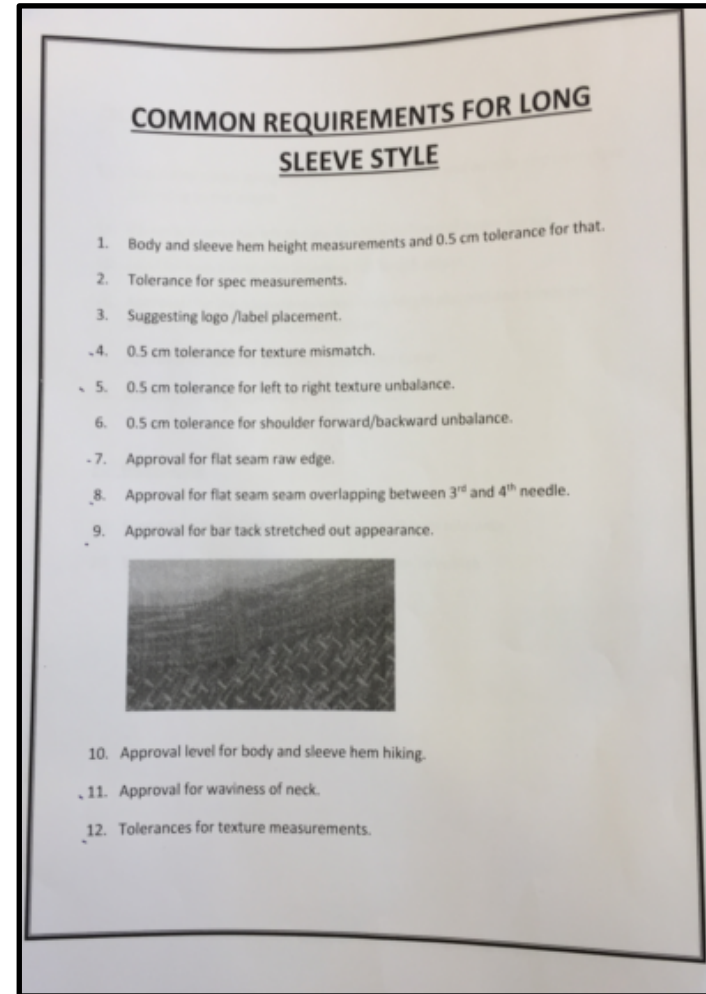
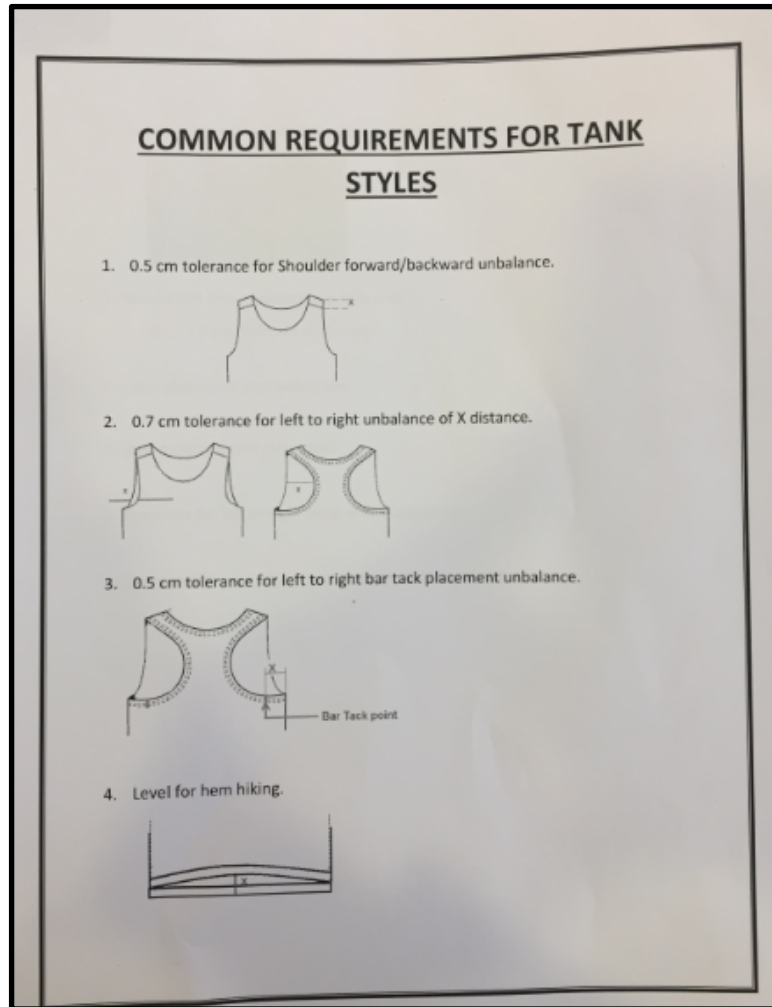
CTQ / CTP identification

Customer: CK      Style: 4WF6K114H      Season: FA 17

CTP

CTP point	Action	Who	when
- Foldover attachment			
- Laying Method			
- Segregate process for bra and tank.			

# Common requirement form for each silhouette



Common Requirement document comprises with all critical areas of which has been rectified technical and production challenges for a particular silhouette.

This replicates a manual.

Any challenges raised in the hacking meeting should not be a common requirement or issue which is already mentioned in the Common requirement sheet.

## Important notes

It is a must for a development merchant to attend the Hacking meeting ,give feedback for their respective styles and get feedback and have a full awareness of their respective styles

THANK YOU