Production Flow of Socks (Block Diagram)
Knitting
Logical definition of knitting is that it is an art of constructing the socks on needles inside the cylinder of the knitting machine, by the interlooping of one or more series of connected loops hanging on and supporting one another.
Knitting is an art of converting yarn into loops. Sock knitting is circular knitting. Circular knitting means fabric made on a circular knitting machine, i.e. one which has its needles arranged in a circle thus producing the fabric in tubular form. A circular knitting machine may be used to produce full width fabrics or narrow shaped components such as for hosiery.

Single Cylinder Knitting
A weft knitting machine having straight needle beds carrying independently operated, usually latch needles. Knitting operation is performed only on one side of the needles. Mostly sports socks are produced on single cylinder knitting machines.

Double Cylinder Knitting
A circular weft knitting machine with two cylinders one superimposed above the other. It is equipped with one set of double ended needles (Needles having an operative hook at each end) that can be caused to knit in either cylinder as required to make plain, rib, or purl structures. This arrangement is commonly used in hosiery knitting machines and garment-length knitting machines. Mostly dress socks are made on double cylinder knitting machines.

Types of Machines with Respect to Brand
1.3.1. Lonati 1.3.2. Conti
1.3.3. Sanjiacomo 1.3.4. Monofort
1.3.5. Angee 1.3.6. Korean
1.3.7. Bentley 1.3.8. Savio Metic

Types of Machines with Respect to Needles
1.4.1. 84 Needles 1.4.2. 96 Needles
1.4.3. 108 Needles  1.4.4. 120 Needles
1.4.5. 132 Needles  1.4.6. 144 Needles
1.4.7. 168 Needles  1.4.8. 176 Needles
1.4.9. 200 Needles

Above mentioned machines are used commonly in the socks industry. However there may be other machines with different capacity of needles.

**Types of Machines with Respect to Cylinder**

1.5.1. Single Cylinder Knitting Machine.
1.5.2. Double Cylinder Knitting Machine.

**Types of Machines with Respect to Diameter**

1.6.1. 3" Diameter  1.6.2. 3.5" Diameter
1.6.3. 4" Diameter  1.6.4. 4.5" Diameter
1.6.5. 5" Diameter

**Knitting Machines (Pictures)**
Double Cylinder Machine

Double Cylinder Machine
Production Activities
Knitting is the basic section from where the production of the socks starts. The knitting section follows the size specs and yarn description provided by the sampling section. The knitting section produces the socks as per order requirements provided by the Production Planning and Control department. To maintain the quality of the socks is parallel activity of the knitting quality section controlled by the quality manager of the factory. The knitting section works according to a shift wise schedule. The knitting section issues the production to both sections batch section and greige store. The production which is to be batched immediately is sent to batching section and production which is to be batched later is sent to the greige store.

Reports
The knitting department prepares the following reports.
1.9.1. Daily Knitting Plan
1.9.2. Daily Machine Wise Production Report
1.9.3. Order Wise Production Report
1.9.4. Machines Efficiency Report
1.9.5. Waste Report. (Daily & Monthly)
<table>
<thead>
<tr>
<th>Machine Wise Knitting Production Report</th>
</tr>
</thead>
<tbody>
<tr>
<td>Company Name Here</td>
</tr>
<tr>
<td>M. No. Order No.</td>
</tr>
<tr>
<td>Style Description Dhz. Dhz.</td>
</tr>
<tr>
<td>Target Prod. Waste. Slacks</td>
</tr>
<tr>
<td>Sticker Remauns</td>
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<tr>
<td>Prepared By:</td>
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<tr>
<td>Checked By:</td>
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