

Inspection Report (IPC)

O-cn-0934710

PRODUCT DESCRIPTION	
	Client Name: ABC Clothing Company
	Product Name: Officer Hat
	Inspection location: Tianjin
	Inspection date: 12/31/2011
	Your reference number: 12345
	P/O number: 12345
	Supplier: China Clothing Inc.
	Order quantity: 2000
	Pcs ready for inspection: 20
	Reference sample available: O-cn-0934710

Factory cooperation	Factory organization	Inspector's opinion on the factory
Average	Average	Average

RESULTS					
Specifications Check:	Not OK				
Tests:	Passed				
AQL:	Within AQL		CRI	MAJ	MIN
		Found	0	5	4
		Max	0	7	14
		Checked	200	200	200
OVERALL INSPECTION RESULT:	Failed (Client has the final decision to Reject or Approve)				

IMPORTANT REMARKS / GENERAL DEFECTS
<ol style="list-style-type: none"> The reference sample was provided for comparison during inspection. No weight scale for weighing fabric was available at factory. No equipment for distinguishing fabric content was available on site. One swatch of each type of shell, waterproof cover, lining, outer headband and inner headband was sent to AI for fabric weight and to distinguish the content. There were only finished products for cap sizes 7 1/8, 7 1/4 and 7 3/8, all others were in process. The front mark on the carton did not conform to client's spec. Only one carton was packed on arrival. Other sample sizes were selected from finished and unpacked product.

INSPECTION STANDARDS	
Inspection type	Initial Production Check (IPC)
Sampling standard	ISO 2859-1 (Mil Std 105E)
Sampling level	III
AQL for Critical defective	Not Allowed
AQL for Major defective	1.5
AQL for Minor defective	4.0
Sampling size for Cri/Maj/Min	200/200/200
Nb of inspected pieces	200
Total number of cartons	100cartons
Nb of cartons inspected	1 carton
Nb on the inspected cartons	n/a

No of man-days spent: 1



Inspector: Lijie Wang



Supervisor: Oliver Xu

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Map

QUALITY CRITERIA (CheckL Nb. : AI-WP-TX-04A)

RAW MATERIAL & PRODUCTION PROCESS

1. Raw material quantities

Description / Quantity	Result	Actual findings / comments
To check against ref sample - shell 30%wool/70% polyester, 315-325gsm- as sample.	OK	Conformed to reference sample for shell. No equipment for distinguishing the content was available. No weight scale for fabric was available.
To check against ref sample - lining, polyester - as sample	OK	Conformed to reference sample for lining.
To check against ref sample - waterproof cover, 220-230gsm, as sample	OK	Conformed to reference sample for waterproofing. No equipment for distinguishing the content was available. No weight scale for fabric was available.
To check against ref sample - outer headband - woolblend, min 20% wool.	OK	Conformed to reference sample for headband. No equipment for distinguishing the content was available.
To check against ref sample - All other materials to be as per sample	OK	Conformed to reference sample.

Pictures:



The left was the reference sample



Raw material



Raw material



Raw material

2. General conditions of storage

Expected Result	Result	Actual findings/comments
Client's instructions : In dry, clean shelving /pallets above ground. Covered plastic sheets, to prevent dust and lint sticking to materials.	OK	Please refer to the pictures above.
Is there a warehouse protecting raw materials?		Yes

3. Manufacturing Process

Expected Result	Result	Actual findings/comments
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<p>Client's instructions : Bulk Production to be made ENTIRELY as per the original sample we are sending to you(AI).</p> <p>1) Outer fabric: 30% (min) wool / 70% (max) polyester, weight 315/325 gsm, Color - Black.</p> <p>2) Inside lining, good quality lining, same weight and quality as per sample.</p> <p>3) Inner headband to be of good quality synthetic material, same as used for sample.</p> <p>4) Outer head Band - Wool blend, 20% wool, as per sample.</p> <p>5) Foam padding material (in between shell material and lining) - to be of same quality, thickness, density and weight as per original sample, or as sample.</p> <p>6) Waterproof cover material to be same weight /quality as per samples provided - 220/230gsm. Color: black.</p> <p>In all other aspects to be as per sample. All other materials, Buttons, Sewing Threads, Front Support, etc, to be of a reliable quality.</p> <p>7) Head circumference sizes - must be according to our supplied size chart.</p> <p>8) Special attention to be given that peak is to be assembled accurately to the centre of cap. (must NOT be offset)</p> <p>9) All excess threads should be carefully trimmed clean and no lint to be on finished caps.</p>	<p>n/a</p>	<p>Conformed to reference sample for outer fabric, inside lining, outer headband, and waterproof cover.</p> <p>Could not check the foam padding, due to not cutting the reference sample.</p> <p>Conformed to reference sample in all other aspects.</p> <p>Please refer to dimension part for head circumference size</p> <p>The peak was assembled accurately to the centre of cap</p> <p>Please refer to defect list for uncut thread end</p>
<p>How many workers are dedicated to this production ?</p>	<p>8 workers</p>	
<p>How many machines are used for this production ?</p>	<p>10 machines</p>	

Production line pictures:



Production line



Production line



Production line



Finished products



The left was the reference sample



The left was the reference sample

4. Production Capacity		
Expected Result	Result	Actual findings/comments
<p>Client's instructions : all bulk production units should reach sample cap quality level Please provide the daily capacity for this production.</p>	n/a	Please refer to defect list for quality Daily capacity: 100 pcs
Limiting step / bottleneck (please take picture) :		Please refer to below picture

Pictures:



Production line

FINISHED PRODUCT

1. Quantity

Expected Result	Result	Actual Finding / Comments
7% of the total order quantity must be finished and packed-order qty: 2000 Pcs	Not OK	1% of the total order quantity finished and packed
Quantity of packed products:	20	
Quantity of finished products:	300	
Quantity of semi-finished products:	1680	

Pictures:



Only one carton packed



Finished and unpacked

2. Colours

Expected Result	Result	Pantone Code	Comments
Black-as sample-	OK	19-4005 tpx	Similar to reference sample and pantone color 19-4005 tpx
			

			
<p>Client's comments: 1) When placed on flat surface, should look straight and smart. 2) Peak must be accurately centred 3) Must be clean of excess threads and of lint</p>	<p>1) OK 2) OK 3) Please refer to defect list</p>		<p>Please refer to below pictures</p>

Pictures:



Front with waterproof cover



Side with waterproof cover



Inside



Front (removing waterproof cover)



Side (removing waterproof cover)



Front (removing outer headband)



Side (removing outer headband)



Similar to pantone color 19-4005 tpx



The left was the reference sample



The left was the reference sample

3. Product dimensions

a. Dimensions

Expected Result	Result	Actual Finding / Comments
Inner circumference-according to size chart	OK	Please refer to table below. There were finished products only for cap sizes 7 1/8, 7 1/4 and 7 3/8, others were in process.
Front eyelets (eyelet centre to eyelet centre)-27	OK	Please refer to below table

b. Weight

Expected Result	Result	Actual Finding / Comments
Shell fabric-315 -325 gsm gr.	n/a	No weight scale for weighing fabric was available in the factory
Waterproof cover fabric-220 - 230gsm* gr.	n/a	No weight scale for weighing fabric was available in the factory
Total finished cap weight, including cover for (size 7)-250 - 255 gr.	n/a	No product of size 7 was available, Please refer to below table
Client's comments: * or as per sample		

Winter caps Size /Quantity Assortment. (for contract PDWC3/2009)

Size in cms	54	55	56	57	58	59
Cap size	6 3/4	6 7/8	7	7 1/8	7 1/4	7 3/8
Quantity	200	400	575	575	150	100

Total quantity: 2,000pcs.

MEASUREMENT TABLE - Actual Finding						
	Expected	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5
Inner circumference	According to size chart	57cm (size 57)	58cm (size 58)	59cm (size 59)	59cm (size 59)	59cm(size 59)
Front eyelets (eyelet centre to eyelet centre)	27mm	27mm	27mm	27mm	27mm	27mm
Eyelets from top edge	1.5mm	1.5mm	1.5mm	1.5mm	1.5mm	1.5mm
Weight		255g(cap size 7 1/8)	260g(size 7 1/4)	280g(size 7 3/8)	275g(size 7 3/8)	270g(size 7 3/8)


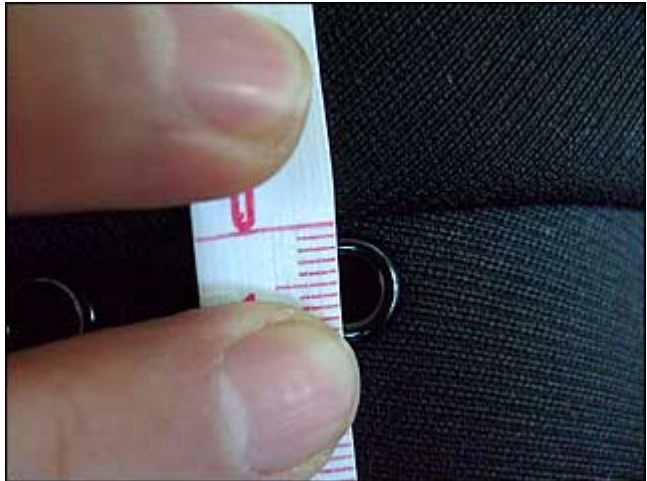
Pictures:





Inner circumference



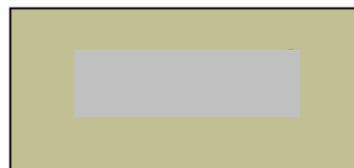
Front eyelets

	
Unit weight	From top edge 1.5mm

4. Artworks		
a. Logo		
Client's comments:		
Did you get an artwork or physical reference of the logo in your hand during Inspection ?	NO	There was no logo on the product.
Pictures:		
n/a		
Artwork or Sample	Bulk product	
b. Label		
Expected Result	Result	Actual Finding / Comments
Main label – XXXX (woven)	OK	Conformed to reference sample and below spec
Inside label – XXXX.2009 (printed)	OK	Conformed to reference sample and below spec

<p>Printed label – Police winter caps</p> <p>Label cut size: 1.5 cms x 2cms. Label size after sewing: 1.5cms x 1.5cms. Color: white with black lettering. Sewing position: at back of inner headband, on edge</p> 		

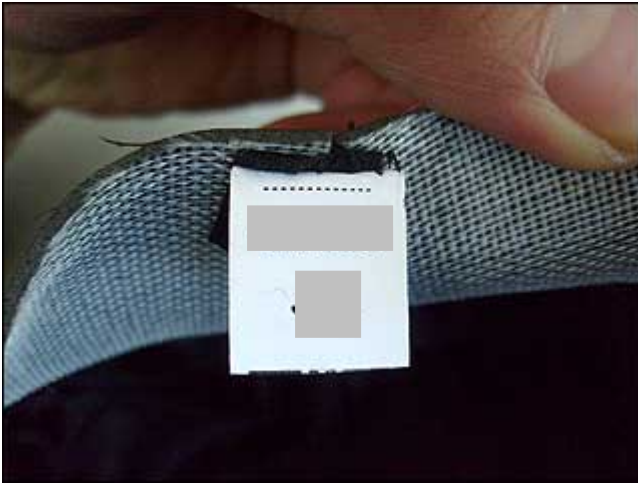
Main label – Police Caps



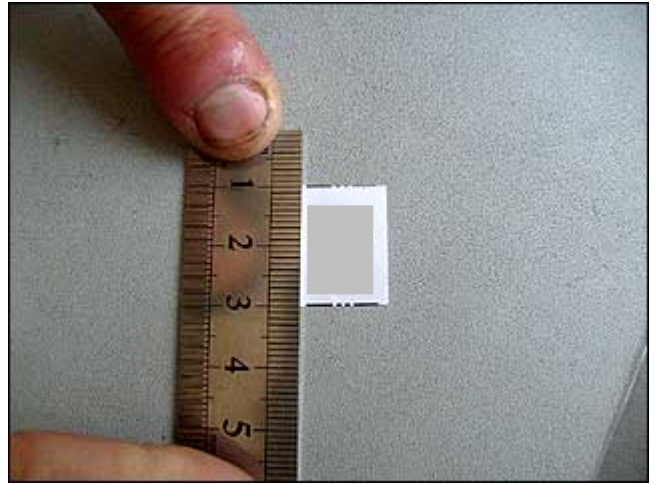
Size : 5.5 X 2.5 cms

Background (approx) color : pantone 16-1110 TPX olive grey
Wording color: black

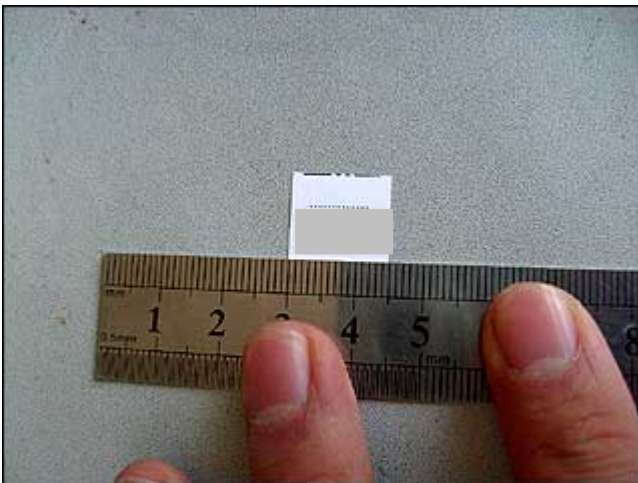
Pictures:



Inside label



Cut size 1.5x2cm for inside label



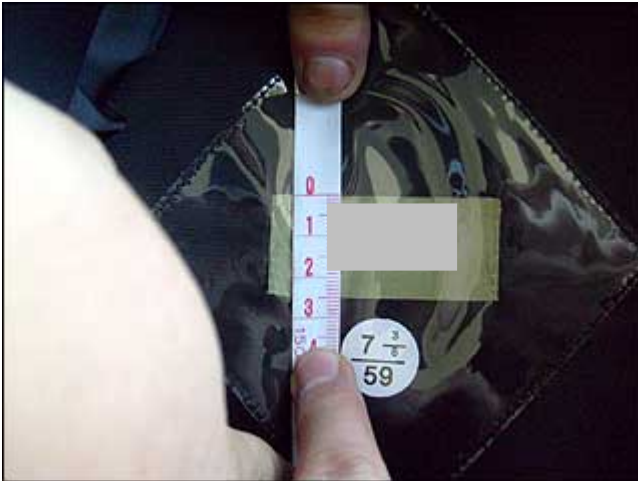
Length 1.5cm after sewing



Main label and size label



Main label size 5.5x2.5cm



Similar to pantone 16-1110tpx

Did the client request a check of the packaging?

Yes

5. Packing and packaging

a. Unit packing:

Expected Result	Result	Actual Finding / Comments
Tied by string from button to button, packed in a plain polybag	OK	Conformed to left spec

Pictures:



Front



Back



String from button to button

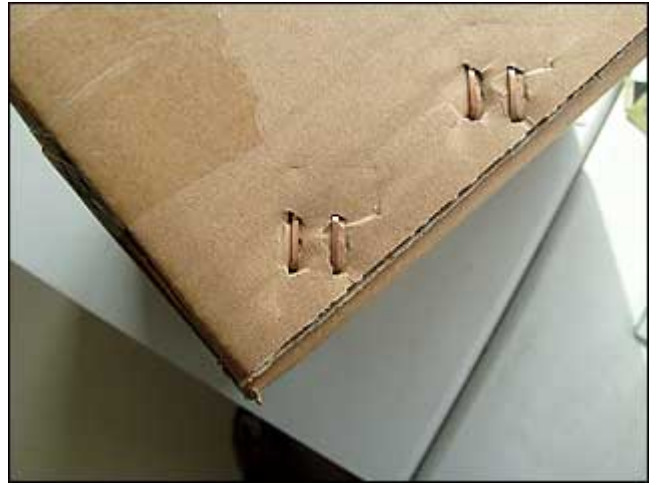
b. Inner packing:

Expected Result	Result	Actual Finding / Comments
2 caps in an inner box, 10 of these boxes in one export carton (20pcs per caton)	OK	Conformed to left specifications. Please refer to the pictures below.

Pictures:



Review



Staples



Single wall corrugated layer



Open



Front mark Printed on two side

c. Outer packing:		
Expected Result	Result	Actual Finding / Comments
Cartons to be strapped or taped securely.	OK	Secured by plastic band, sealed by adhesive tape.
Sealing method (Ex: staples - adhesive - plastic band - metal band):	OK	Fastened by staples, secured by plastic band, sealed by adhesive tape.
Client's comments: Carton material to be of export quality double waved triplex. Export carton to be lined inside with plastic sheet / or large plastic bag.	Not OK	No plastic bag inside export carton

Pictures:



Review



Staples



Open



Double waved triplex



d. Dimensions of export cartons:

Expected Result	Result	Actual Finding / Comments
L: 88cm x W: 34cm x H: 60cm	Not OK	L: 88m x H: 32 cm x W: 58 cm

Pictures:



Length of the carton : 88cm

e. Weight of cartons:

Expected Result	Result	Actual Finding / Comments
n/a (1 kg = 2.2 Lbs / 1 lb = 0.45 kg)	n/a	Not exceed 10kgs

Pictures:



Weight of cartons

Shipping Marks

a. Carton Front Mark

Expected Result	Result	Actual Finding / Comments
SIZE: QUANTITY: COLOR: CARTON NO.:	OK	Conformed to the specifications, please check below picture

b. Carton Side Mark

Expected Result	Result	Actual Finding / Comments
xxxxx	Not OK	Please refer to below picture

Pictures:





Front mark





Side mark

TESTS AND SPECIAL REQUIREMENTS		
Test description	Comments from Inspector	Result
Carton drop test - On 3 cartons – packed products should not get damaged	On 3 cartons from 76cm	Passed
		
Function Test and fatigue test for all the adjustable parts, 20times—S2	On 8 pcs	Passed
		
Color check as per client s requirement or pantone book - same as reference sample Black color- III	On 200 pcs, Please refer to color part	Passed

<p>Function test: Wear the cap a little bit tight and check if you can feel uncomfortable points especially around the peak (edges) - peak edges should not be felt and be comfortable- III</p>	<p>On 200 pcs</p>	<p>Passed</p>
		
<p>Pull test on the to top button of the cap and on the peak-The button is well fixed to the cap chin strap will hold to adjustment. - III</p>	<p>On 200 pcs</p>	<p>Passed</p>
		

Visual check for all accessories and labels-- III	On 200 pcs, Please refer to below pictures and label part	Passed
		
Two eyelets each on front and back	One pc each on left and right	
		
Snap on waterproof cover		
How many stitches per cm -3.5 - 4 stitches per CM- S2	3.5stitches per cm	Passed
		

Seam strength test by hand if applicable-- III	On 200 pcs	Passed
		
Try to fold the peak smoothly-Should return to the initial position- III	On 200 pcs	Passed
		
Reverse the peak and pull on it to check the seaming strength-- III	On 200 pcs	Passed
		
Check for any scratches on the peak -no scratches on peak- III	On 200 pcs	Passed

Reverse the cap and check the inside workmanship-should look clean and no threads should have loose ends-III	Please refer to defect list	n/a
		
Check crown for any bumps -Crown should be flat -III	On 200 pcs	Passed
		
Please take pictures of the Products in the show-room and production line--III	Please refer to raw material and production process part	n/a

Check that cover fits cap correctly.-when cover is on cap, it must not fit too tight nor too loose (Please refer to sample)-III	On 200 pcs	Passed
		
Barcode scanning test if applicable—S2	No barcode for scanning	n/a



CLIENT'S IMPORTANT INSTRUCTIONS ON TESTS

Client's Instructions	<u>Actual Finding / Comments</u>
Size of caps - inner circumference size should be checked against size chart	<u>OK</u>

SAMPLE COLLECTION

<p>[0] pcs of shipment samples were collected by inspector [0] pcs of defective samples were collected by inspector</p>

DEFECTIVES LIST					
		CRI	MAJ	MIN	Picture
	Broken stitch at edge of inner headband	0	3	0	

	Unsecured stitch at edge of inner headband	0	2	0	
	Uncut thread end	0	0	3	

					
	Poor painting button	0	0	1	

DEFECTIVES LIST SUMMARY				
	Cri	Maj	Min	AQL result
Number of Defectives found	0	5	4	Within AQL
Maximum Allowed	0	7	14	
No. of Inspected samples	200	200	200	

- CRI: 0defective pieces found out 0of acceptable among 200 pieces inspected at level Not Allowed
- MAJ: 5defective pieces found out 7of acceptable among 200 pieces inspected at level 1.5
- MIN: 4defective pieces found out 14of acceptable among 200 pieces inspected at level 4.0

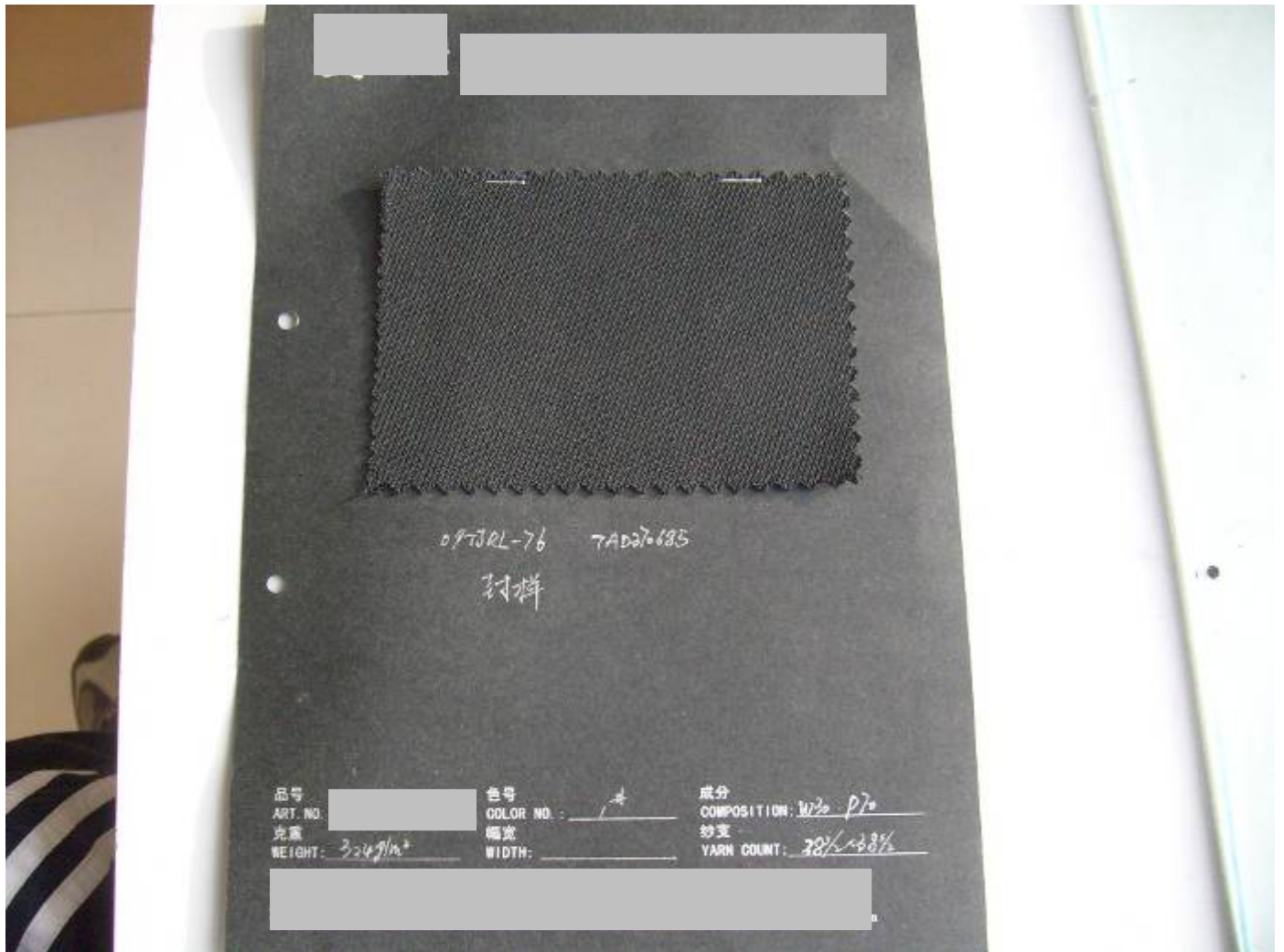
CLIENT'S IMPORTANT INSTRUCTIONS ON AQL	
Client's Instructions	Actual Finding / Comments
N/A	N/A

ADDITIONAL PICTURES

Other Pictures



Defect list



Shell swatch provided by factory

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Inspection Protocol - O-05-00M710V 11/14/2009

Alt Inspection No:	O-05-00M710	Client Name:	[Redacted]
Inspection Date:	11/14/2009	Products:	[Redacted]
Inspector Name (ID):	[Redacted]	POC:	[Redacted]
Factory Name:	[Redacted]	Ref:	[Redacted]

Important Remarks: (Please remark all not OK findings and failed test here)

1. The reference sample was provided for comparison during inspection.
2. We require a scale for weighing fabric pieces available at factory.
3. No equipment for detecting any fabric defects was available on-site.
4. One (1) yard each edge of shell, waterproof, inner lining, outer headband, and inner headband was sent to IQC for accurate fabric and distinguishing fabric content.
5. There were only finished products for cap size of 7 1/8, 7 1/2 and 7 7/8 which in order were in process.
6. The part mark of carton was not confirmed to visit's offer.

Defective List:

Defect ID	Defect Description	Critical	Major	Minor
1	broken seam at edge of inner headband		3	
2	irregular seam at edge of inner headband		2	
3	incorrect thread and			5
4	poor finishing button			1
Total Found		0	5	6
Samples Inspected		20	20	20

Signature: Inspector(s) *Liza Wang* [Redacted]

Factory Representative: [Signature]

This document is purely for information only so the Factory can start re-work its production timely if needed and

Draft report

Cartons

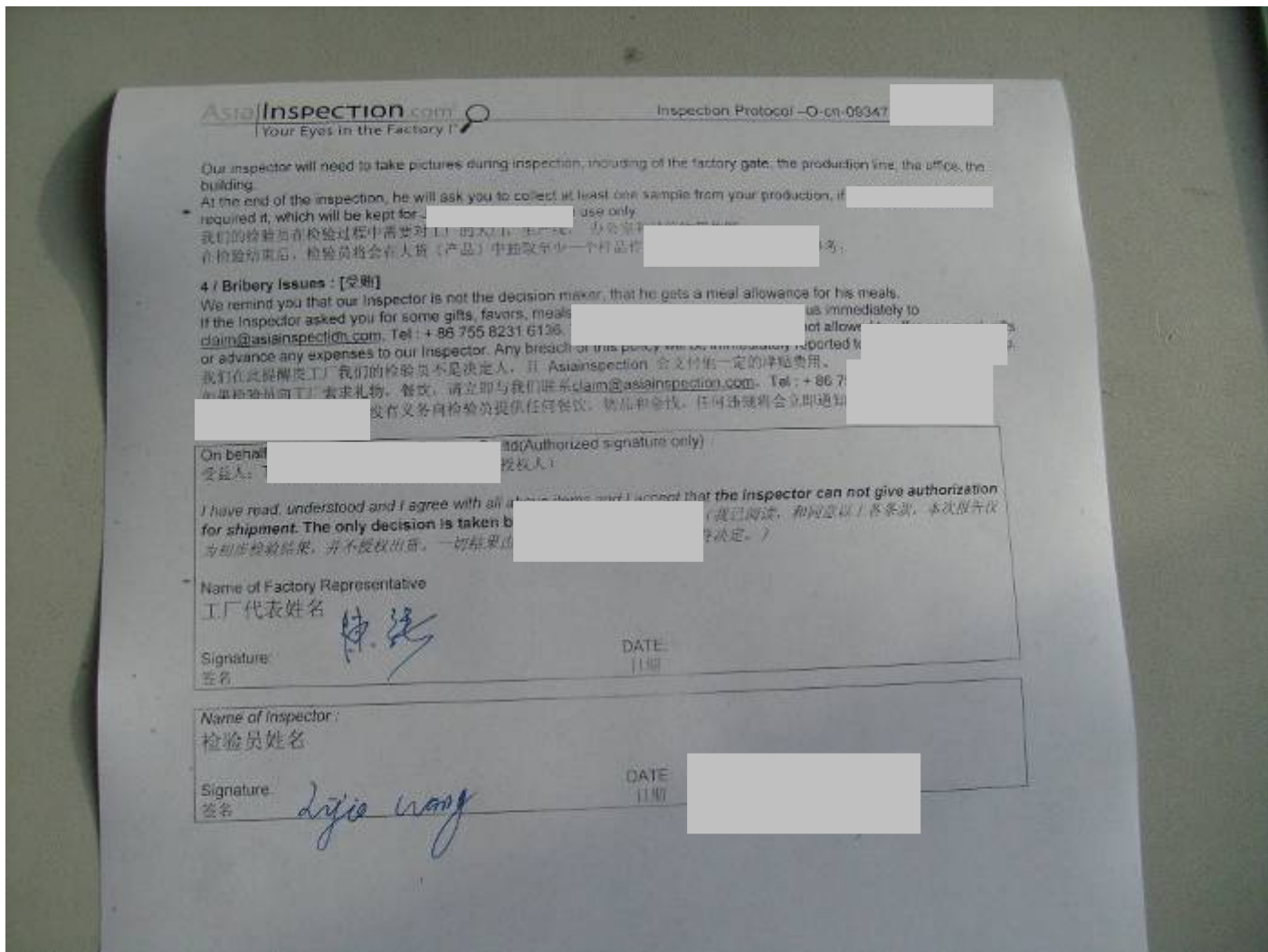


Total cartons



Inspected cartons

Factory Disclaimer



Original signature from Factory Manager accepting AsiaInspection conditions on Shipment authorization and bribery issues

End of the Report