

AQL (Acceptance Quality Limit) For Esperanza

Major Defects

Knitting Defects:

broken yarn
uneven knitting yarn
Slub yarn
pills
stripes
needle line
laddering
run stitches
drop stitches
loose stitches
Holes (any size of holes)
Fabric torn
Permanent crease lines in fabric
Permanent fold lines in fabric

Cleanliness:

Stain
Oil stain
Oil spots
Water stain
Water spots
Rust stain
Chalk mark
Glue stain
Glue mark
Untrimmed thread ends

Appearance:

Color off tone
Color shade variation
Poor ironing

Glaze
Wrinkle mark
Crease mark
Fold mark
Unmatched stripes
Sewn in wrong fabric side
Sewn in wrong fabric direction
Washing mark
Uneven washing effect
Burned, scorched
Over pressed (seam impressions)
Stretched shape due to pressing
Distorted shape due to pressing
Bubbles due to improper fusing

Seaming Defects:

Open seam
Seam slippage
Pleated seam
Creased seam
Folded seam
Twisted seam
Unaligned seam
Unmatched seam
Puckered seam
Seam not fully opened before top stitching
Seams folded opposite to specified direction
Uneven pleats length
Uneven darts width
Uneven seam length
Twisting in turn ups
Misplaced or missed bar tacks

Insufficient seam allowances

Stitching defects:

Broken stitches

Skipped stitches

Uneven stitching

Irregular stitching

Run-off stitching

Wavy stitching

Loose stitch tension

Uneven stitch density

Uneven stitch tension

Missed stitching

Missed bar tack

Unmatched join stitching

Needle chewing (holes and cutting)

Drill holes or markings exposed

Insecure back stitching

Collar / Neck:

Uneven collar points

Misshaped collar points

Overlapping collar

Unbalanced collar

Uneven collar end

Collar shape not as approved

Seam allowances of the body are visible next to collar seam

Bubble in collar fall

Bubble in collar stand

PLACKET, Buttoning, Fly:

Uneven placket width

Incorrect placket width
Uneven placket length
Visible under placket
Twisted, slanted, curved or pleated placket
Zipper sewn curved
Buttoning (press buttons or Velcro closure) not aligned
Press buttons attached without support fabric or double layer

Button and Button Hole:

Missed button, swing neck button or button hole
Broken button
Insecure button stitching
Incomplete stitching
Wrong button
Uncut or partly cut button hole
Unaligned button and button hole
Misplaced button and button hole
Button stitch not properly locked

Sleeve and Cuff:

Uneven sleeve length
Notches exposed at sleeve slit
Uneven cuff width
Uneven cuff height

Front / Back Shoulder /Yoke:

Excess gathering at yoke seam
Unmatched seams at arm hole
Improper gathering at sleeve cap

Pocket and Pocket Flap:

Wrong pocket

Wrong closure
Wrong top stitching or seam allowances
Unaligned front pockets (high -low pocket)
Slanted pocket
Excess tightness or fullness of pocket
Pocket cloth not smooth when bar tacking
Twisted pocket cloth
Poorly shaped pocket
Poorly shaped pocket corner
Misplaced pocket position
Incorrect pocket position
Exposing pocket corner
Incorrect position of pocket flap

Hem:

Twisted hem
Uneven hem
Wavy hem
Torn at ribbing
Holes at ribbing
Little recovery or no elasticity at ribbing

Lining:

Lining too short or too long
Puckering at lining seam
Twisted lining

Fly:

Uneven fly width
Curved fly edge
Zipper exposed when fly is closed
Construction instructions or pattern markings not followed

Leg:

Twisted leg

Uneven leg
Side seam turned wrongly
Irregular hem width

Labels, Customize labels and Embroideries:

Missed customized logo label or embroidery
Missed marking label
Wrong label or embroidery
Missing size and product number label
Wrong marking label
Wrong or missing Purchase Order Label
Missing CE-Label (CE Garments)
Missing pictograms (CE Garments)
Missing care instruction (CE Garments)
Missing user instruction booklet (CE Garments)
Label insecurely stitched (embroidered label)
Wrong background material (embroidered label)
Label folded by stitching (embroidered label)
Wrong fusible material (embroidered label)
Slippage in label (over lock is mismatching)
Incorrect embroidery stitch density (embroidered logo label)
Label not according to specification (wrong color, size or design)
Label position is not according to Tech Pack
label is attached poorly: Attaching seam labels and hanger loops
Attaching customized logo label:
Stich distance too near the edge (fraying)
Label sewn inverted (label up-side-down) or reversed (label up-side-down)
Wrong size label

Printing Defects in customized logos or print images:

Missed printing
Misplaced printing
printing stain or cracking print result

off printing, white print color translucent
Color off shade or not as specified
Wrong printing

Hang tags and Care Labels:

Missed hang tag /Care label
Wrong hang tag / Care label
Care label – no label

Accessories:

Wrong accessories
Damaged accessories
Scratches
Poor plating
Sharp points
Sharp edges
Rust
Color discharged
Malfunction of zipper
Zipper slider not running smoothly
Missed zipper teeth
Missed zipper puller
Wavy zipper
Poor setting of zipper
Zipper tape too close to fly seam affecting zipper function
Detached ring, socket, stud or post
Press button too tight or loose to close or open
Detached swing neck button or rivet
Fabric torn around press buttons or swing neck buttons
Press buttons sewn upon zipper tape
Missed Velcro tapes
Misplaced Velcro tapes
Reflective bands sewn too close or far away from the edge

Missed shoulder pads
Misplaced shoulder pads

Body:

Excess gathering at any seam
Unmatched seams at arm hole
Improper gatherings at sleeve cap
Deformed shape
Twisted sleeve
Twisted body

Measurement:

Outside tolerance (tolerance is +/- half of next size)
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Diverse Defects:

Mildew
Odor
Wet item
Damp item
Visible or disturbing mending places