

AQL Defect List for Service Line Comforta

Three types of defect

Critical Defect - A defect that is likely to result in a hazardous or unsafe condition for an individual or anyone around him using the product or that contravenes mandatory regulations.

Tolerance limits for defects (size, repeatability, quality, significance) will be defined later.

The appearance of a critical defect stops the production.

Major Defect – A defect that is likely to result in failure; reducing the usability of the product and obvious appearance defects affecting the sale ability or shorten the life cycle of the product.

Tolerance limits of defects (size, repeatability, quality, significance) will be defined later.

4 Major defects -> 1 critical defect -> stop the production.

Minor Defect – A defect that does not reduce the usability of the product but is nevertheless a workmanship defect beyond the defined specifications or construction requirements.

Tolerance limits for defect (size, repeatability, quality, significance) will be defined later.

Patient Wear and Bathrobe specific defect are marked with blue color at the end of the list!

4 Minor defects -> 1 Major Defect.

Defect Description	Critical	Major	Minor
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Product

Product not matching Approval sample, technical specification or order		X	
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Material Defects - Woven materials

Weaving Faults - (broken yarn)		X	
Weaving Faults – (missed yarn)		X	
Weaving Faults – (rough yarn)		X	X
Weaving Faults – (pills)		X	
Weaving Faults – (color stripes)		X	
Weaving Faults – (thick place)		X	
Weaving Faults – (thin place)		X	
Weaving Faults – (thick bar)		X	
Weaving Faults – (thin bar)		X	
Holes (any size of hole)		X	
Fabric torn		X	
Permanent crease lines in fabric		X	
Permanent fold lines in fabric		X	

Material Defects – Knitted materials

Knitting Faults – (broken yarn)		X	
Knitting Faults – (uneven knitting yarn)		X	
Knitting Faults – (rough yarn)	X		
Knitting Faults – (slub)		X	
Knitting Faults – (pills)		X	
Knitting Faults – (dye bars)		X	

Knitting Faults – (stripes)	X	
Knitting Faults – (run stitches)	X	
Knitting Faults – (needle line)	X	
Knitting Faults – (laddering)	X	
Knitting Faults – (drop stitches)	X	
Knitting Faults – (loose stitches)	X	
Holes (any size of holes)	X	
Fabric torn	X	
Permanent crease lines in fabric	X	
Permanent fold lines in fabric	X	

Cleanliness

Stain	X	X
Oil spots	X	X
Oil stain	X	X
Water spots	X	X
Water stain	X	X
Rust stain	X	X
Pen mark	X	X
Pencil mark	X	X
Chalk mark	X	X
Glue stain	X	X
Glue mark	X	X
Untrimmed thread ends		X
Loose thread		X
Dust fibers attached on fabric surface		X
Loose fibers attached on fabric surface		X

Appearance

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

Stitching Defects

Broken stitches	X	
Skipped stitches	X	X
Run-off stitching	X	X
Uneven stitching	X	X
Irregular stitching	X	X

Wavy stitching	X	X
Insecure back stitching	X	
Loose stitch tension	X	X
Uneven stitch tension	X	X
Uneven stitch density	X	X
Missed stitching	X	
Missed bar tack	X	
Unmatched join stitching	X	X
Needle chewing (cutting and holes)	X	
Drill holes or markings exposed	X	
Seaming Defects		
Open seam, missing stitch	X	
Seam slippage	X	
Puckered seam	X	X
Pleated seam	X	
Folded seam	X	
Twisted seam	X	
Seams folded opposite to specified direction	X	
Unaligned seam	X	
Unmatched seam	X	
Seam not fully opened before top stitching	X	
Insufficient seam allowances	X	
Uneven pleats length	X	X
Uneven darts width	X	X
Misplaced or missed bar tacks	X	
Uneven seam length	X	X
Twisting in turn ups	X	X
Hem		
Uneven hem	X	X
Twisted hem	X	
Wavy hem	X	X
Torn at ribbing	X	
Holes at ribbing	X	
Little recovery or no elasticity at ribbing	X	
Labels, Customized labels & Embroideries		
Missed Comforta seam label or hanger loop	X	
Missed customized logo label or embroidery	X	
Missed marking label	X	
Wrong label, hanger loop or embroidery	X	
Missing size and product number label (knitwear)	X	
Wrong marking label	X	X
Visual label quality:		
Label insecurely stitched (embroidered label)	X	X
Label folded by stitching (embroidered label)	X	X
Wrong back ground material (embroidered label)	X	
Slippage in label (over lock is mismatching)	X	
Incorrect embroidery stitch density (embroidery or embroidered logo label)	X	
Label not according to specification (wrong color, size or design)	X	
Label position is not according to Technical specification		X
Attaching seam labels and hanger loops: label is attached poorly	X	

Attaching customized logo label:		
Stich distance too near the edge (fraying)	X	
Label sewn inverted (label up-side-down) or reversed (label up-side-down)	X	
Wrong size label	X	
Transponder		
Missed transponder	X	X
Transponder placed wrong	X	X
Labels and Hangtags - non rental garments		
Missed label or hangtag	X	
Wrong label or hangtag	X	
Country of Origin – no label	X	
Country of Origin – label inaccessible and no details elsewhere	X	
Country of Origin – letter height under 1.5mm	X	
Country of Origin – does not comply with legal specification	X	
Fibre Composition– no label	X	
Fibre Composition – label inaccessible and no details elsewhere	X	
Fibre Composition– letter height under 1.5mm	X	
Fibre Composition – does not comply with legal specification	X	
Miscellaneous Defects		
Odor	X	
Mildew	X	
Wet item	X	
Damp item	X	
Visible or disturbing mending places	X	
Unwanted objects in garment, like needle or piece of metal	X	
Collar/Neck Patient Wear - Bathrobes		
Uneven collar points	X	
Misshaped collar points	X	
Unbalanced collar	X	
Overlapping collar	X	
Bubble in collar fall	X	
Bubble in collar stand	X	
Uneven collar end	X	
Collar shape not as approved	X	
Seam allowances of the body are visible next to collar seam	X	
Placket, Fly, Buttoning		
Uneven placket width	X	X
Incorrect placket width	X	
Uneven placket length	X	X
Visible under placket	X	X
Twisted, slanted, curved or pleated placket	X	X
Zipper sewn curved or with wrong ease	X	X
Buttoning (press buttons or Velcro closure) not aligned	X	X
Press buttons attached without support fabric or double layer	X	
Button & Button Hole		
Missed button, swing neck button or button hole	X	
Broken button or swing neck button	X	
Insecure button stitching	X	
Wrong button	X	

Incomplete stitching	X	
Uncut or partly cut button hole	X	
Unaligned button and button hole	X	X
Misplaced button and button hole	X	X
Button stitch not properly locked	X	
Sleeve & Cuff		
Uneven sleeve length	X	X
Uneven sleeve placket length	X	X
Uneven sleeve placket width	X	X
Notches exposed at sleeve slit	X	
Wrong attachment of sleeve lining	X	
Uneven cuff width	X	X
Uneven cuff height	X	X
Front/Back Yoke/Shoulder		
Excess gathering at yoke seam	X	X
Unmatched seams at armhole	X	X
Improper gathering at sleeve cap	X	X
Pocket & Pocket Flap		
Wrong pocket, closure, top stitching or seam allowances	X	
Unaligned front pockets (hi-low pocket)	X	X
Slanted pocket	X	X
Excess tightness or fullness of pocket	X	X
Pocket cloth not smooth when bar tacking	X	X
Twisted pocket cloth	X	
Poorly shaped pocket	X	
Poorly shaped pocket corner	X	
Misplaced pocket position	X	X
Incorrect pocket position	X	
Exposing pocket corner	X	
Incorrect position of pocket flap	X	
Waistband & Belt Loops, Hanger band		
Uneven waistband (Hi-low waistband)	X	X
Poor waistband finishing	X	X
Waistband stitching broken when stretched	X	
Little recovery or no elasticity at waistband	X	
Missing button or bar tack in adjustable waistband	X	
Missed belt loop	X	
Uneven belt loop	X	X
Wrong or improper position of belt loop	X	
Missing hanger band inside waist	X	
Fly		
Uneven fly width	X	
Curved fly edge	X	
Zipper exposed when fly is closed	X	
Construction instructions or pattern markings not followed	X	
Leg		
Twisted leg	X	
Uneven leg	X	
Side seam turned wrongly	X	
Irregular hem width	X	X

Body

Excess gathering at any seam	X	X
Unmatched seams at armhole	X	X
Improper gatherings at sleeve cap	X	X
Deformed shape	X	
Twisted sleeve	X	
Twisted body	X	

Measurement

Outside tolerance (tolerance is +/- half of next size)	X	
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Accessories

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

Please note the above list is not all inclusive and is to be used as a guide only.