

Supporting Material

2.7_3 Defect List for Hotel and Healthcare Textiles

The three types of defects defined:

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

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

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.

4 Minor defects = 1 Major Defect.

Please note that the list below is not all inclusive, and there might be other variables to check depending on the type of product.

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

Defect Description	Critical	Major	Minor
Product doesn't match Approval sample, Product / Technical specification, or purchase order		X	
Material Defects - Woven materials			
Weaving Faults - (broken yarn)		X	
Weaving Faults – (missed yarn)		X	
Weaving Faults – (rough yarn)		X	
Weaving Faults – (uneven yarn)		X	
Weaving Faults – (contamination)		X	
Weaving Faults – (thick place)		X	
Weaving Faults – (thin place)		X	

Weaving Faults – (thick bar)		X	
Weaving Faults – (thin bar)		X	
Holes	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, if not specified)		X	
Knitting Faults – (pills)		X	
Knitting Faults – (dye bars)	X		
Knitting Faults – (uneven stripes)	X		
Knitting Faults – (running stitches)	X		
Knitting Faults – (needle line)		X	
Knitting Faults – (dropped stitches)		X	
Knitting Faults – (loose stitches)		X	
Holes	X		
Fabric torn	X		
Permanent crease lines in fabric	X		
Permanent fold lines in fabric	X		
Cleanliness			
Stain		X	
Oil spots	X		
Oil stain	X		
Water spots		X	
Water stain		X	
Rust stain	X		
Pen mark	X		
Pencil mark	X		
Chalk mark		X	
Glue stain	X		
Glue mark	X		
Untrimmed thread ends			X
Loose thread		X	
Dust fibers attached on fabric surface			x
Loose fibers attached on fabric surface			X
Appearance			
Color or white shade variation		X	
Color off tone / white off tone against specification		X	
Glaze, shiny surface if not defined		X	
Crease spot	X		

Wrinkled outlook		X	
Faulty folding against specification			X
Unmatched checks against specification		X	
Unmatched stripes against specification		X	
Sewn in wrong fabric direction against specification		X	
Sewn in wrong fabric side against specification		X	
Burned, scorched	X		
Uneven washing effect		X	
Washing wrinkles	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	
Run-off stitching	X		
Uneven stitching		X	
Irregular stitching		X	
Wavy stitching		X	
Insecure back stitching, against specification		X	
Loose stitch tension		X	
Uneven stitch tension		X	
Uneven stitch density		X	
Missed stitching		X	
Missed bar tack, against specification	X		
Unmatched join stitching		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		
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	

Uneven darts width		X	
Misplaced or missed bar tacks	X		
Uneven seam length	X		
Twisting in turn ups	X		
Labels, Customized labels & Embroideries, against specification			
Missed Lindström/Comforta seam label or hanger loop	X		
Missed customized logo label or embroidery		X	
Missed / wrong marking label		X	
Wrong label, hanger loop or embroidery	X		
Missing size and product number label	X		
Visual label quality			
Label insecurely stitched (embroidered label)		X	
Label folded by stitching (embroidered label)		X	
Wrong background material (embroidered label)		X	
Slippage in label (overlock color is not matching)		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 specification		X	
Attaching seam labels and hanger loops: label is attached poorly		X	
Attaching customized logo label, against specification:			
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		
Transponder placed wrong	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		
PATIENT WEAR			
Collar / Neck Patient Wear, Bathrobe, against specifications			
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, against specifications			
Uneven placket width		X	
Incorrect placket width		X	
Uneven placket length		X	
Visible under placket		X	
Twisted, slanted, curved or pleated placket		X	
Zipper sewn curved or with wrong ease		X	
Buttoning (press buttons or Velcro closure) not aligned		X	
Press buttons attached without support fabric or double layer		X	
Button & Button Hole			
Missed button, swing neck button or buttonhole	X		
Broken button or swing neck button	X		
Insecure button stitching		X	
Wrong button		X	
Incomplete stitching		X	
Uncut or partly cut buttonhole		X	
Unaligned button and buttonhole		X	
Misplaced button and buttonhole		X	
Button stitch not properly locked		X	
Sleeve & Cuff			
Uneven sleeve length		X	
Uneven sleeve placket length		X	
Uneven sleeve placket width		X	
Notches exposed at sleeve slit		X	
Wrong attachment of sleeve lining		X	
Uneven cuff width		X	
Uneven cuff height		X	
Front/Back Yoke/Shoulder			
Excess gathering at yoke seam		X	

Unmatched seams at armhole		X	
Improper gathering at sleeve cap		X	
Pocket & Pocket Flap			
Wrong pocket, closure, top stitching or seam allowances		X	
Unaligned front pockets (hi-low pocket)		X	
Slanted pocket		X	
Excess tightness or fullness of pocket		X	
Pocket cloth not smooth when bar tacking		X	
Twisted pocket cloth		X	
Poorly shaped pocket		X	
Poorly shaped pocket corner		X	
Misplaced pocket position		X	
Incorrect pocket position		X	
Exposing pocket corner		X	
Incorrect position of pocket flap		X	
Waistband & Belt Loops, Hangering band			
Uneven waistband (Hi-low waistband)		X	
Poor waistband finishing		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	
Wrong or improper position of belt loop		X	
Missing hangering 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	
Body			
Excess gathering at any seam		X	
Unmatched seams at armhole		X	
Improper gatherings at sleeve cap		X	
Deformed shape		X	
Twisted sleeve		X	
Twisted body		X	
Size / Measurement			

Outside tolerance (tolerance is +/- half of next size)		X	
Accessories			
Wrong accessories		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	
Missed zipper teeth		X	
Missed zipper puller		X	
Wavy zipper		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	
Fabric torn around press buttons or swing neck buttons	X		
Press buttons sewn upon zipper tape		X	