

DEFECT	ANALYSIS	MINOR	MAJOR	CRITICAL
<b>Weaving - Towel</b>				
Pick Short	Due to missing of weft	Less than 1”	Greater than 1”	
End Short/ Pile missing	Due to missing of warp/ pile yarn.	Up to 4 cm one side	Greater than 4 cm	
Fancy Height	Wrong construction, shrinkage	0.5 cm	Greater than 1 cm	
Low Pile	Wrong weft, tight pile beam etc.	Eye observation	Eye observation	
Oil Spot	Oiling mistake, mechanical problem	2mm solid or 5mm Blur	Greater than 2mm solid or greater than 5mm Blur	
<b>Dyeing - Towel</b>				
Color Stain, Handling Stain White spot, Bleaching Spot	Machine cleaning, neutralization problem, color feeding in short time, handling	2mm solid or 5mm Blur	Greater than 2mm solid or greater than 5mm Blur	
Dye Patch	Due to leveling agent problem, color feeding in short time, Temperature	2mm solid or 5mm Blur	Greater than 2mm solid or greater than 5mm Blur	
Luster	Phototropic effect of dyes	Difference visible less pronounced	Difference visible pronounced	
Harshness	Softener problem, uncompleted washing of soda, Water hardness	Feeling harsh (depend on the type of yarn used)	Feeling Very Harsh and rough	
Shade Variation	Due to quantity, temperature, water quantity, hardness and time duration	Eye observation	Eye observation	
Damage	Mechanical problem,	-	Any sort of damage or cut	
Bowing	Due to dryer	Upto 1” on every 50cm length	Greater than 3”	

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<b>Knitting /Weaving</b>		4 Point System		
Broken Stitch / Drop Stitch	Needle problem, thread problem, machine problem	<3” 1 Point >3” & <6” 2 Point		
Loose Stitch	Due to tension post,	>6” & <9” 3 Point >9” 4 Point		
Hole	Due to Needle Problem	<1 cm 2 Points >1 cm 4 Points		
<b>Dyeing – Knit /Woven</b>		4 Point System		
Color Stain, Handling Stain White spot, Bleaching Spot	Due to handling, color fixing, soda ash mark, softner fixing	<3” 1 Point >3” & <6” 2 Point		Wrong dye stuff Chemical ration out of limit allowed
Dye Patch / Luster	Uneven dyeing, leveling agent problem	>6” & <9” 3 Point >9” 4 Point		
Harshness	Softner problem	Slightly harsh Minor crease	Feel harsh to end user Crease major	
Shade Variation	Parameter control time, temperature, water ratio	Slightly change	More than 3/ 4 shade difference.	
<b>Printing</b>				
Miss Printing	Due to improper transfer of dye stuff	Slight miss print but not clearly traceable	More than .5 cm miss print. Improper transfer , improper fixing	Legal status changed
Tilt Print	Due to handling problem	Not visually traceable	Visually traceable more than 1 cm on each 30 cm	
Design Deviation	Designing and assurance fault	Under 3 % deviation but in whole print not in any specific component	More than 3% deviation in whole or any single component of print.	
Placement Deviation	Due to handling problem	Up to 1 cm in width Up to 2 cm in length	More than 1 cm in width More than 2 cm in length	
Fastness / Specification	Due to improper process control / content control	Poor but acceptable result after washing.	Improper transfer	Wrong type of printing ink ,
<b>Accessories / Trim</b>				
Shade	Sewing Thread	Visually a little different from required Shade	Visually distinct from required Shade	Wrong composition, Wrong Count, Wrong Ply
Printing Problem	All printed labels, Tags, Belly bands, Poly bags, Carton	Slightly placement out Light print Hardly readable some minor area Ghost print Over printing Shade minor different	Miss print contents Garbage print Placement out Major shade difference	Content of care symbol changed, origin of country changed, due to misprint any wording adverse impact legality or regularity status of trim, Wrong composition like PP instead of PE , polyester instead of cotton. Lead printing
Wrong Label / Barcode	All barcodes inclusive part of a trim or separate barcode	-	misprint but readable	Any Wrong wording / item description /content and other
Dimension Out	All Cartons, poly bags, belly bands etc	1 cm in cartons and poly 0.5 mm in inlay and tags, labels	>1 cm in poly and carton >0.5 cm in inlay and Tags, labels	
Functionality fail	Zipper , buttons	-	Reject if functionality fails like zippers not working or button do not fix.	Wrong type Wrong content (like ferrous in metallic trims etc)
Specification Failure	All poly, carton, zippers, buttons, elastic, Tags, etc	Content changed as per internationally allowed tolerance which do not effect labeling.	No of thread changed in Elastic, major Reed / warp deviation in labels, trims do not full fill temperature, pressure and other physical requirement	Content changed, or deviation from CPSC / Reach acceptance list of restricted chemical or children product safety law.