

FABRIC INSPECTION GUIDELINES

FABRIC INSPECTION POLICIES

The purpose of fabric inspection is to determine the quality and acceptability for our garments.

It also allow us to prevent loss of material and time during the garment manufacturing process.

Fabric inspection, mapping or marking defects is important prior to spreading and cutting because:

- Spreading can be done more quickly because the spreader is not also inspecting the fabric.
- A cutter's productivity will increase because the defects are already marked.

Nordstrom requires that all production fabric to be inspected according to the 4-Point System. Fabric inspection is conducted at the mill, and the cutting and sewing facility.

4-POINT SYSTEM

The 4-Point System assigns 1, 2, 3 and 4 penalty points according to the size and significance of the defect. Points are assigned according to the following criteria:

4-POINT SYSTEM DEFECT EVALUATION		
Assigned Points	Size of Defects	
	(In inches)	(In cm)
1	< 3"	< 8 cm
2	> 3" < 6"	> 8 cm < 15 cm
3	> 6" < 9"	> 15 cm < 23 cm
4	> 9"	> 23 cm

- No more than 4 penalty points can be assigned for any single defect.
- No linear yard or meter can contain more than 4 points, regardless of the number of defects within that yard or meter.
- A continuous running defect which exceeds 9 inches (23 cm) should be assigned 4 points. In the event there is an additional defects within the same linear yard or meter it should be considered as a separate defect and assigned defect point accordingly.
- Any continuous defect (i.e., roll to roll shading, narrow or irregular width, creasing, uneven finish, barre', skew, etc.) should be assigned a maximum of 4 points for every yard or meter within a shipment.
- Each full width defect should assign 4 points.
- Obvious, noticeable and severe defects are to be assigned 4 points for each yard or meter in which they occur, regardless of size.

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FABRIC SAMPLING PLAN

The following sampling plan lists the minimum quantity of fabric for each pattern, color way, or print, which must be inspected. All rolls to be sampled will be randomly selected by the inspector. Once a roll has been selected, no adjustments will be made.

SAMPLE PLAN				
Lot Size Yards	Inspection Yards	Lot Size Meters	Inspection Meters	Percent of Total Lot
0 - 2,500	not less than 500	0 - 2,300	not less than 460	20%
2,501 - 5,000	251 - 500	2,301 - 4500	230 - 450	10%
5,001 - 20,000	400 - 1,600	4,501 - 18,300	360 - 1465	8%
20,001 - 30,000	1,200 - 1,800	18,301 - 27,400	1,100 - 1,645	6%

All inspected rolls will be identified with an inspection tag. This tag may not be removed by anyone prior to the production cutting.

POINT CALCULATION

For an Individual Roll:

$$\text{Points per 100 Square Yards} = \frac{\text{Total Points for the roll} \times 3600}{\text{Inspected Yards} \times \text{Cuttable Fabric Width (inch)}}$$

$$\text{Points per 100 Square Meters} = \frac{\text{Total Points for the roll} \times 100,000}{\text{Inspected Meters} \times \text{Cuttable Fabric Width (MM)}}$$

For a Shipment:

$$\text{Total Shipment Points per 100 Sq. Yards} = \frac{\text{Total Average Points per Linear Yard} \times 3600}{\text{Shipment Inspected Yards} \times \text{Cuttable Fabric Width (inch)}}$$

$$\text{Total Shipment Points per 100 Sq. Meters} = \frac{\text{Total Average Points per Linear Meter} \times 10,000}{\text{Shipment Inspected Meters} \times \text{Cuttable Fabric Width (MM)}}$$

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NPG ACCEPTABLE POINTS PER CLASSIFICATION

Individual rolls exceeding the points allowed are removed from the shipment. A shipment is rejected if the point total exceeds the allowable limit.

GROU P NO.	DESCRIPTION	POINTS ALLOWED PER INDIVIDUAL ROLL	POINTS ALLOWED PER SHIPMENT
I	Dress Shirting's - >50/1 Worsted/Woolens All Tailored Suiting Fabrics Open End Denim 12-16 oz./ yd ² All Synthetics Filament Rayon Twills Poplin/Oxford/Gingham Shirting Light weight Denim 4-8oz./yd ² Mid weight Denim 9-12oz./yd ²	20 points/100 yard ² 24 points/100 meter ²	15 points/100 yard ² 18 point/100 meter ²
II	Ring spun Denim 12-16oz./yd. ² Canvas Corduroy/Velvet Flannel Woven's with Spandex/Elastane Seersucker, Dobby, Jacquard Chambray/Indigo Yarn Dyes All Silk Basic Knits	25 points/100 yard ² 30 points/100 meter ²	20 points/100 yard ² 24 points/100 meter ²
III	All Specialty Knits	30 points/100 yard ² 36 points/100 meter ²	25 points/100 yard ² 30 points/100 meter ²
IV	Linen Linen Blends Rayon Blends	40 points/100 yard ² 48 points/100 meter ²	32 points/100 yard ² 38 points/100 meter ²
V	Madras Muslin	60 points/100 yard ² 72 points/100 meter ²	50 points/100 yard ² 60 points/100 meter ²

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DOCUMENTATION

To ensure proper documentation on the Inspection report the following should be correctly recorded.

- Mill Name
- Fabric P.O. Number
- Mill / Supplier roll number
- Roll length
 - Ticketed
 - Actual
 - Difference between ticketed and actual
- Recorded cuttbale width
 - 1st Measurement – At the start of the roll at least 2 meters or yards into the roll
 - 2nd Measurement – At the middle of the roll
 - 3rd Measurement – At the end of the roll at least 2 meters or yards before the end
- Number of defect points per roll by 4 point system
- Defect result calculated by roll in points/ 100 Sq Yards/Meters
- Inspector comments if any per roll.

Note: Nordstrom reserves the right to request copies of documentation at any time.