

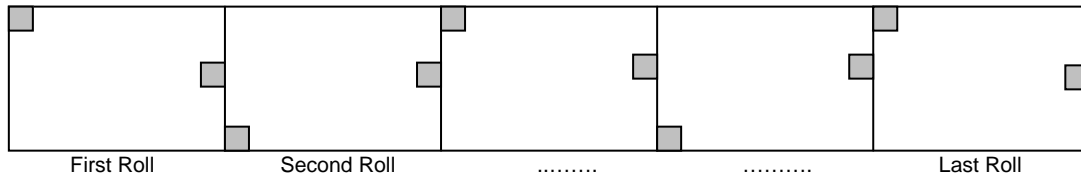
Introduction to Fabric Inspection at Debs Corporation

A. The Inspection Method

All fabric from Debs Corporation is 100% inspected at the mill prior to being shipped. The inspection includes fabric defect inspection, shading inspection, batch-to-batch inspection, and quality inspection.

Fabric defect inspection is performed using the Japanese Inspection Standard formally recognized by the Japanese government and the Japanese Textile Foundation. Most factories in Japan use this method. In the past correlation tests have been performed to compare this method against the 4-point system. The results have shown that the Japanese method is relatively similar to the 4-point system and can thus be used interchangeable. Details of the Japanese Inspection Standard are provided in the next part of this document.

Shading inspection is performed in a way specific to requirements of Debs Corporation. Each dyelot is checked for shading by taking a cutting from the beginning and end of each roll as per the following diagram. The swatches are then checked under a lightbox for color consistency.



Batch to batch inspection is performed in a similar manner. Four (4) cuttings are taken from the first roll of a batch, 4 from the middle of the batch, and 4 from the end of the batch. These are placed on shadecards and checked for color consistency.

Finally quality inspection is performed by first examining the handfeel and touch of the fabric against the approved quality standard.

B. The Japanese Inspection Standard (Related Text Only)

The Japanese Inspection Standard establishes the basic for visual inspection of polyester (filament) fabric. As a rule, shipment inspection is 100% inspection.

According to this Inspection method, products that conform to the standards indicated in Table 1 will pass. Products that do not conform to these standards will fail (C-Grade).

Table 1: Grading Basis

Focus Points	Criteria for Passing
Yarn Type Yarn Denier Fabric Composition	Products which conform to the approved standard and specs
Width & Length Density	Products which conform to the approved standard and specs
Yarn & Yarn Processing Weaving Slippage	Products which conform to the approved standard and specs
Handling	Products with no conspicuous reference compared with the original sample
Bow & Skew	Products for which bow and skew are within 2% of total width of the fabric
Color & Colorfastness	Products which conform to standards
Selvage	Products for which there is no visible difference in tension between the fabric selvage and the center
Total Defects	Products which are clean throughout most of the length. However, partial defects which are continuous or repetitive and whose length exceeds 10% of the total length shall be classified as total defects.
Partial Defects	(a) Products without any particular severe or obvious defect that has a diameter of 3 cm or more (b) Products whose defects fall in the range indicated in Table 2

Table 2: Partial Defect Permissible Limits

Nominal Width	Permissible Points to Pass (Based on 100 mts Length)
Less Than 127 cm (50 inch)	34
More Than 127 cm (50 inch)	38

Note: For products whose length is not standard, the number of points per standard length shall be applied proportionally (e.g. if 110 mts length, permissible points will be 42 for wide width).

Table 3: Defect Point Grading System

Defect	Defective Items	Defect Size	Defect Points
Visible Lines (Warp)	End Outs Yarn Faults	Up to 13 cm	1 pt
		From 13 cm to 25 cm	2 pt
		From 25 cm to 50 cm	4 pt
Visible Lines (Weft)	Faulty Picks	Up to 13 cm	1 pt
		From 13 cm to 25 cm	2 pt
		From 25 cm to 50 cm	4 pt
Area Defects	Stains Slippage	Up to 3 cm	1 pt
		Above 3 cm Note: maximum 4 points covers an area length of 0.5 mts	4 pt
Others	Hole Tear	Up to 1 cm	1 pt
		From 1 cm to 3 cm	4 pt
		Above 3 cm	not allowed

Note:

- (a) The product shall be rated as either passing or failing according to where the total number of defect points falls in Table 2
- (b) If 2 or more defects are found within a length of 0.5 mts, they shall be calculated as 4 points (the maximum)

Unfinished products with holes or tears shall fail.