

MONTANA requirement profile for external/internal fabric inspection:

Inspection characteristic:	Test method:	Tolerances:	Procedure:
<i>measure:</i>			
Piece length	Fabric inspection machine	+/- 1% difference in measuring due to different machines	MONTANA pays only for net length measured by fabric inspection
Useful width/ Repeat width/ Repeat length/ Panneux length	measuring	none	marking as 2nd choice
Skewed weft Bow distortion	Tearing	max 3% - over complete width - measured highest deviation	distortion > 3% marking as 2nd choice
<i>colour:</i>			
Check against standard	Only Visual examination relevant Specify dye-lots with related quantities	---	Individual handling / Out of tolerance: rework
Alteration of colour through piece Side to center shading	Only Visual examination relevant Control at the beginning of each piece; check beginning against end of piece	----	Individual handling / Out of tolerance: rework
<i>Handfeel/fabric appearance:</i>			
Check against standard	-----	Same colour outcome and appearance for all goods receipt	Individual handling / Out of tolerance: rework
Weight:	gravimetric	+/- 5%	Out of tolerance: rework

Laboratory test

Test method:	in general:	
Maßänderung:	Längs:	Quer:
<ul style="list-style-type: none"> • Hoffman-Test • Commercial washing 30°C • Commercial dry-cleaning 	-3% -5 % (for knitwear)	-3% -5 % (for knitwear)
Speed of fabric inspection machine:	In general:	
Individual handling depending on fabric-type	max. 12 m/min	

Annotation:

This is a general policy; bearing in mind that different kinds of fabric need different treatments

In terms of defect frequency: position and spreading of defects have to be considered

In terms of inspection speed: subjected to fabric-characteristics/ quality level/ defect frequency
(i.e. high defect frequency means low inspection speed).

Allowances for defects:

Defect classification:	Defect:	Allowance:	Indication:
Small defects	„spots“ e.g.: <ul style="list-style-type: none"> • impurities • small weaving defects/ stains/slubs 	10 cm	green
Medium defects	<ul style="list-style-type: none"> • cumulation of small defects/ spots • holes • big weaving defects 	30 cm	yellow
Heavy defect	<ul style="list-style-type: none"> • weft bar • defects over complete width 	50 cm	red
Distance-defect	e.g.: <ul style="list-style-type: none"> • weaving defects in warp direction • creases 	Subjected to the length of defects	Beginning of defect- end of defect red
Warp-defect	e.g.: missing warp	Reduce usable width	Beginning of piece position of warp- defect piece: red label

Number of defects Per piece (50m)
max. 8 small defects and/or 3% defectiveness = 2nd choice

Inspection report:

Piece no. supplier	Piece no. Fabric inspection	Dye-lot	Quality	Gross quantity supplier	Net quantity supplier	Gross quantity fabric inspection	Net quantity fabric inspection	defects					weight reference	Weight as-is	Useful width reference	Useful width as-is	Kind of defect
								small	medium	big	distance	% defect					

Head of inspection report:

- suppliers article and colour
- internal article and colour number
- inspection report number
- Date

Conclusion of inspection report:

- Total quantity supplier (gross / net)
- Total quantity fabric inspection (gross / net)
- Total quantity 1st and 2nd choice (gross / net)
- Sum of pieces and useful widths (total quantity of each useful width)

Samples for QA:

QA has to receive the following samples for each inspection report

- Sample for each dye lot (ca. 20 x 10cm)
- If there is a deviation in handfeel or appearance send ca. 0,3m over complete width
- Skewed weft or bow distortion send 0,5m over complete width
- Repeating defects: marked sample of defect with defect description and related piece number

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Invoice:

Issuing an invoice correct:

- Internal article and colour number as well as suppliers article and colour number
- Inspection report number
- Issued quantity fabric inspectin (measured gross quantity)
- Quantity rejected from QA
- Name correct division (BB/GB/VM)
- Unit price (costs for: packaging, quality inspection, dimension stability to steaming)

Debit note for inspection costs:

We debit inspection costs to fabric supplier if delivered quality is out of tolerance. If fabric inspection detects 2nd choice we reserve the right to debit inspection costs to fabric supplier also if we accept fabric in question with tolerance