QUALITY MANUAL

SUMARY

REVISE 02 – AUGUST 2012

PAGE	02	MAINTAINED
PAGE	03	MAINTAINED
PAGE	04	REVISED 1
PAGE	05	MAINTAINED
PAGE	06	REVISED 2
PAGE	07	REVISED 2
PAGE	08	MAINTAINED
PAGE	09	MAINTAINED
PAGE	10	MAINTAINED
PAGE	11	MAINTAINED
PAGE	12	MAINTAINED
PAGE	13	MAINTAINED
PAGE	14	REVISED 2
PAGE	15	MAINTAINED
PAGE	16	MAINTAINED
PAGE	17	MAINTAINED

GENERAL PROCEDURE FOR INSPECTION OF FABRICS

DEFINITION

The object of this service is to visually inspect the fabric pieces selected at random from a delivery in order to verify their general conformity and aspect with instructions, specifications and / or samples received.

FIELDS OF APPLICATION

All fabrics in greige or finished state.

TYPICAL OPERATIONS PERFORMED

1. Check of width and lengths against specifications

2. Control of:
    a. Designs and shades
    b. Absence of weaving / knitting (and / or dyeing or printing defects / irregularities) outside reasonable and acceptable tolerances.

3. Check as to quantities and markings as per supplier's packing list.

4. Packing / Labeling conditions against specifications.
    a. Tube thickness
    b. Plastic bag thickness
    c. Plastic bag condition
    d. Labels indication and placement
    e. Package situation

5. Stamping / Marking: Pieces selected for inspection are not to be stamped whenever possible. Greige piece goods are to be stamped at piece ends with normal visible ink, next to the normal factory indications such as construction, piece length, maker's name or logo.
    a. First choice goods are to be stamped with FOCUS logo stamp, if required.
    b. Second choice (# of defects above tolerance) with square stamp whilst "rejects" are stamped with triangular stamp onto selvage on various folds, if required.
    c. The repacked bales or cartons containing the inspected rolls / pieces are to be stamped or sealed, thus permitting identification of the lot at shipping shed, if required.

6. When not otherwise specified, it shall be understood that the material is to be examined on one side only, the face.

OPTIONAL OPERATIONS PERFORMED

1. Construction (number of threads per cm / inch) – Using the pick glass for weaving / knitting fabrics.

2. Average weight per linear meter/yard or squared meter/yard. Select and weight 2 rolls per color subject to availability of the calibrated weight scale at site.

3. Skewness condition of the fabric rolls.

NOTE: The importance of a fabric inspection is the determination of "absence of weaving / kinitting defects / flaws and dyeing / printing flaws or irregularities". A fabric may be acceptable as far as width, length, weight, colors, etc. are concerned, but the number of defects may exceed the given instructions / specifications and make it unsuitable for the intended purpose.

REMARKS REGARDING WEAVING / KNITTING DEFECTS

Considering the absence of internationally valid rules for classification of weaving / knitting or other defects (major or minor), we consider for greige sheeting or shirting in principle:

1. Major Defects

Double or multiple ends or picks	Smashes
Cockled yarn (often called slubs)	Starting places
Foreign matters woven-in	Filling bars
Scratching up or combing places	Floats
Slubs (pieces or lumps)	Holes
Missing ends or picks	Slack ends
Pull-ins of over 5 cm	Tangles
Cleaning places	Hanging threads
Snarls or slings	Torn selvedges

2. Minor Defects

Wrong denting if not very visible	Knots
Pull-ins of less than 5 cm	Neps
Gout (or fly) if only occasional	Small spots
Oily or dirty picks or ends	Broken ends / picks

The above listing is incomplete (ASTM Standard D3990:99) and all, according to type of fabric. Certain defects listed above under "major" may be classified as "minor" or vice-versa. Focus stipulates the number of defects tolerated per 100 squared meters (100m²). Practice according to below tables.

DESIGNS AND COLORS

When multiple dye lots are anticipated / disclosed in the production of a particular fabric be they for lot size / color / style or purchase order, an original approved sample for each may be provided to our inspectors. Unless otherwise authorized, our inspectors must approve all dye lots sampled from production before receipt of the goods.

Designs, patterns and colors must be in conformity with the reference samples / color-cards / strike-offs available, according to tolerances below. If not, our inspectors may:

- Obtain design and color swatches from the supplier / seller and mail part of them for approval.
- Obtain design and color swatches from the supplier / seller with written statement on Inspection Report that these samples are within the tolerance to those sent and approved by principals.

TESTING ITEM	1ST GRADE ROLLS (SAME LOT)	1ST GRADE LOTS (SAME COLOR)	TESTING METHOD	NOTES
Shade Grading	Minimum 4/5	Minimum 3/4	Light Box (D65 - 10º)	Grey Scale Shading
Shade Grading	$\partial E \leq 0,6$	$\partial E \leq 1,5$	AATCC 173-2007	CIE L*a*b

SPECIALTY FABRICS

1. Inspector needs to be observant to any irregularity in the thickness or pile density on the surface (matting, pilling, etc.)

2. Sampling needs to be determined by such factors as: color, lot, etc.

SAMPLING FOR PIECE GOODS (FABRICS)

Number of packages selected for inspection = $\sqrt{\text{Total \# of bales / cartons of shipment}}$

Yardage selected for inspection = $8 \times \sqrt{\text{Total yardage of consignment}}$

STANDARD FOR THE WOVEN / KNITTED FABRICS – 4 POINTS SYSTEM

The system is applicable for woven goods and knitted goods. **Defects are penalized to their size without reference to their denomination**. The defect type ascertained and penalty point attribution is to be recorded as it allows a better quality appreciation.

Penalty points are assigned for each defect according to the length thereof as set forth in the following table:

Size of Defects (length in inches)	Number of Penalty Points
3" or less	1
Over 3" but less than 6"	2
Over 6" but less than 9"	3
Over 9"	4

Note:
a) no one meter should have more than 4 penalty points
b) any holes (2 or more broken ends) will be awarded with 4 points
c) any running defect more than 4 continuous meters will cause the roll to be rejected
d) defects appearing within 1" (one inch) of either edge shall be disregarded

GRADING

1. The score counting for individual roll:
   Points / 100 sqd meters (100m²) = $\frac{\text{Total Penalty Points scored in the roll} \times 100}{\text{The width of the roll (m)} \times \text{actual meters inspected}}$.

2. The score counting for bulk:
   Points / 100 sqd meters (100m²) = $\frac{\text{Total Penalty Points scored in the bulk} \times 100}{\text{The bulk average width of the roll (m)} \times \text{actual total meters inspected}}$.

DEFINITION OF GRADE A AND GRADE B

1. GRADE A
    a. Penalty Points within point system's tolerance:
        i. i.e. penalty points / 100m² of the roll is equal or less than table below

    b. Penalty Points within point system's tolerance, but with some discrepancies which are not very serious or affecting the usability of the fabric:
        i. These are such as neps or short coarse yarns. These discrepancies may be of the nature of the characteristic of the fabric. In this case the quality GRADE A is on the penalty point, but the quality of the roll is still pending on the discrepancies for FOCUS acceptance.

2. GRADE B
    a. Penalty Points beyond point system's tolerance:
        i. i.e. penalty points / 100m² of the roll is more than table below.

    b. Penalty Points NOT counted due to a continuous weaving / dyeing / printing / embroidering / finishing defects presented in full length of the roll:
        i. This kind of discrepancies are very serious, visible and render the roll to be used in cutting of garment panels. In this case, the yardage of this roll should not be taken into the calculation of the average penalty points.
        ii. e.g. reed mark, wrong draw-in, missing end, double ends, color variation at selvage, double ends, off printing, dye streaks, missing spangles, etc.

    c. Penalty Points counted plus discrepancies which are continuous visible defect:
        i. Penalty Points are counted because the continuous defects may be generally found or occur in many rolls. If points are not counted and client accepts these general discrepancies, it cannot show the actual defects existing in the rolls. This may apply especially in claim cases.

3. FROM THE ABOVE DEFINITION, THE FOLLOWING TRUE CASES MAY HAPPEN
    a. Grade A
        i. Penalty Points within point system's tolerance
        ii. No additional discrepancies in the roll

    b. Grade A with minor discrepancies pending
        i. Penalty Points within point system's tolerance.
        ii. The discrepancies are very minor and not serious, such as the nature or characteristic of the fabric.

    c. Grade B due to penalty points only
        i. Penalty points beyond point system's tolerance
        ii. No additional discrepancies found

    d. Grade B due to penalty points + minor discrepancies pending
        i. Penalty points beyond point system's tolerance
        ii. With discrepancies which are not serious defects, such as nature or characteristic discrepancies.

    e. Grade B due to major discrepancies (for rolls with no penalty points counted)
        i. No penalty points counted.
        ii. With major discrepancies of the quality / workmanship occurred continuously throughout the whole length, such as weaving / dyeing / printing / embroidering / finishing defects.

    f. Grade B due to penalty points + major discrepancies (for rolls with penalty points counted)
        i. Penalty points within tolerance.
        ii. With major discrepancies in full length.

CONDITION FOR FAIL OF SHIPMENT

1. AVERAGE PENALTY POINTS OF INSPECTED YARDAGE EXCEEDING TABLE BELOW.

2. MORE THAN 10% OF QUANTITY / ROLLS INSPECTED GRADED AS "B".

DEFINITION OF FIRST QUALITY (WOVEN AND KNITTED GOODS)

1st Quality	PD Fabrics (Piece Dyed)	PT Fabrics (Printed)	YD Fabrics (Yarn Dyed)	EMB Fabrics (Embroidery)
Individual Packing	Up to 24 Points/100m²	Up to 27 Points/100m²	Up to 27 Points/100m²	Up to 27 Points/100m²
Inspected Yardage	Up to 14 Points/100m²	Up to 16 Points/100m²	Up to 16 Points/100m²	Up to 16 Points/100m²

FABRIC QUALITY REQUIREMENTS

CONSTRUCTION TEST PERFORMANCES PER FABRIC PRODUCTION PROCESS						
TESTING ITEM	**TOLERANCE ACCORDING TO QUALITY SAMPLE STANDARD OR P/I INFORMATION**				**TESTING METHOD**	**NOTES**
	PD FABRICS	**YD FABRICS**	**PT FABRICS**	**EMB FABRICS**		
1.1) FABRIC WEIGHT PER UNIT AREA	-5% / + 5%	-5% / + 5%	-5% / +10%	-5% / +10%	ASTM D 3776 Option C	-
1.2) FABRIC WIDTH **1.2.1) TOTAL WIDTH** **1.2.2) CUTTABLE WIDTH**	-1% / +2% UP TO 2" LESS	-1% / +2% UP TO 2" LESS	-1% / +2% UP TO 2" LESS	-1% / 2% UP TO 8" LESS	ASTM D 3774	-
1.3) YARN COUNT **1.3.1) STAPLE (Ne)** **1.3.2) FILAMENT FLAT (Denier)** **1.3.3) FILAMENT TEXTURIZED (Dtex)**	-15% / +10% -10% / +15% -10% / +25%	-15% / +10% -10% / +15% -10% / +25%	-15% / +10% -10% / +15% -10% / +25%	-15% / +10% -10% / +15% -10% / +25%	ASTM D 1059	-
1.4) THREADS PER UNIT LENGTH **1.4.1) WARP DENSITY** **1.4.2) WEFT DENSDITY** **1.4.3) SQUARED AREA DENSITY**	-5% / + 5% -5% / + 5% -3% / +3%	-5% / + 5% -5% / + 5% -3% / +3%	-5% / + 5% -5% / + 5% -3% / +3%	-5% / + 5% -5% / + 5% -3% / +3%	ASTM D 3775	-
1.5) FIBER CONTENT	-3% / +3%	-3% / +3%	-3% / +3%	-3% / +3%	AATCC 20A: 2005, base on moisture regained weight	-
1.6) TWIST PER UNIT LENGTH	-10% / +15%	-10% / +15%	-10% / +15%	-10% / +15%	ASTM D 1422 ASTM D 1423	-
1.7) BOW / SKEW (AS RECEIVED) **1.7.1) PLAIN CONSTRUCTION** **1.7.2) TWILL CONSTRUCTION** **1.7.3) SATIN CONSTRUCTION**	UP TO 3% UP TO 5% UP TO 7%	WEFT STRIPPED AND CHECKED DESIGNS: UP TO 1%, OTHERWISE ACCORDING TO PD FABRICS	WEFT STRIPPED AND CHECKED DESIGNS: UP TO 1%, OTHERWISE ACCORDING TO PD FABRICS	WEFT STRIPPED AND CHECKED DESIGNS: UP TO 1%, OTHERWISE ACCORDING TO PD FABRICS	ASTM D 3882	-

COLOR FASTNESS TEST PERFOMANCE PER COLOR INTENSITY				
TESTING ITEM	**SHADE**	**STAIN (ALL FIBERS WHEN APPLICABLE)**	**TESTING METHOD**	**NOTES**
2.1) COLOR FASTNESS TO WASHING(AFTER 3 WASHES) *** The assessment of after 2 washes is based on after 1 wash** *** The assessment of after 3 washes is based on after 2 washes** **2.1.1) LIGHT COLORS** **2.1.2) MEDIUM COLORS** **2.1.3) DARK COLORS**	MINIMUM 4 (AFTER 3 WASHES) MINIMUM 3,5 (AFTER 3 WASHES) MINIMUM 3,0 (AFTER 3 WASHES)	MINIMUM 4 (AFTER 1 WASH) MINIMUM 3,5 (AFTER 1 WASH) MINIMUM 3,0 (AFTER 1 WASH)	ISO 105 C06	METHOD AND OPTION TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
2.2) COLOR FASTNESS TO WATER **2.2.1) DOBBY STRIPE PD FABRICS** **2.2.2) YARN DYED FABRICS** **2..2.3) PRINTED FABRICS** **2.2.4) EMBROIDERY FABRICS**	NO REQUIREMENT	MINIMUM 4	AATCC 107	-
2.3) COLOR FASTNESS TO RUBBING **2.3.1) DRY** **2.3.1.1) LIGHT COLORS** **2.3.1.2) MEDIUM COLORS** **2.3.1.3) DARK COLORS** **2.3.2) WET** **2.3.2.1) LIGHT COLORS** **2.3.2.2) MEDIUM COLORS** **2.3.2.3) DARK COLORS**	NO REQUIREMENT	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 008	-
2.4) COLOR FASTNESS TO HOT PRESSING **2.4.1) DRY** **2.4.1.1) LIGHT COLORS** **2.4.1.2) MEDIUM COLORS** **2.4.1.3) DARK COLORS** **2.4.2) DAMP / WET** **2.4.2.1) LIGHT COLORS** **2.4.2.2) MEDIUM COLORS** **2.4.2.3) DARK COLORS**	MINIMUM 5 MINIMUM 4,5 MINIMUM 4,0 MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 133	PRESSING TEMPERATURE TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
2.5) COLOR FASTNESS PERSPIRATION **2.5.1) LIGHT COLORS** **2.5.2) MEDIUM COLORS** **2.5.3) DARK COLORS**	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5	MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 015	-
2.6) COLOR FASTNESS DRY CLEANNG **2.6.1) LIGHT COLORS** **2.6.2) MEDIUM COLORS** **2.6.3) DARK COLORS**	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5	MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 132	-

STRENGTH TEST PERFOMANCES PER FABRIC WEIGHT

TESTING ITEM	QUALITY STANDARDS REQUIREMENTS				TESTING METHOD	NOTES
	W ≤ 100 G/M²	100 G/M² < W ≤ 150 G/M²	150 G/M² < W ≤ 300 G/M²	W > 300 G/M²		
3.1) TENSILE STRENGTH (WOVEN)					ASTM D 5034; Instron CRE 1"- Grab	-
3.1.1) WARP	111 NEWTONS	111 NEWTONS	155 NEWTONS	222 NEWTONS		
3.1.2) WEFT	111 NEWTONS	111 NEWTONS	155 NEWTONS	222 NEWTONS		
ELONGATION						
3.1.1) WARP	NO REQUIREMENT	NO REQUIREMENT	NO REQUIREMENT	NO REQUIREMENT		
3.1.2) WEFT	NO REQUIREMENT	NO REQUIREMENT	NO REQUIREMENT	NO REQUIREMENT		
3.2) TEAR STRENGTH (WOVEN)					ASTM D 1424	-
3.2.1) WARP YARN TORN	7 NEWTONS	9 NEWTONS	11 NEWTONS	15 NEWTONS		
3.2.2) WEFT YARN TORN	7 NEWTONS	9 NEWTONS	11 NEWTONS	15 NEWTONS		
3.3) SEAM SLIPPAGE (WOVEN) 1/5"					ASTM D 0434	-
WARP	45 NEWTONS	89 NEWTONS	133 NEWTONS	200 NEWTONS		
WEFT	45 NEWTONS	89 NEWTONS	133 NEWTONS	200 NEWTONS		
3.4) BURSTING STRENGTH (KNITTED)	90 NEWTONS	120 NEWTONS	180 NEWTONS	210 NEWTONS	ASTM D 3786	-
3.5) STRETCH & RECOVERY					BS EN 14704-1	-
3.5.1) WOVEN (WITH SPANDEX)						
3.5.1.1) EXTENSION						
3.5.1.1.1) WARP DIRECTION (WHEN APPLICABLE)	MINIMUM 30%	MINIMUM 25%	MINIMUM 20%	MINIMUM 15%		
3.5.1.1.2) WEFT DIRECTION (WHEN APPLICABLE)	MINIMUM 30%	MINIMUM 25%	MINIMUM 20%	MINIMUM 15%		
3.5.1.2) RESIDUAL EXTENSION AFTER 01 MIN RELAXATION						
3.5.1.2.1) WARP DIRECTION (WHEN APPLICABLE)	UP TO 12%	UP TO 10%	UP TO 08%	UP TO 06%		
3.5.1.2.2) WEFT DIRECTION (WHEN APPLICABLE)	UP TO 12%	UP TO 10%	UP TO 08%	UP TO 06%		
3.5.1.3) RESIDUAL EXTENSION AFTER 30 MIN RELAXATION						
3.5.1.3.1) WARP DIRECTION (WHEN APPLICABLE)	UP TO 06%	UP TO 05%	UP TO 04%	UP TO 03%		
3.5.1.3.2) WEFT DIRECTION (WHEN APPLICABLE)	UP TO 06%	UP TO 05%	UP TO 04%	UP TO 03%		
3.5.2) KNITTED (WITH SPANDEX)						
3.5.2.1) EXTENSION						
3.5.2.1.1) OPPOSITE TO SPANDEX DIRECTION	MINIMUM 25%	MINIMUM 20%	MINIMUM 15%	MINIMUM 10%		
3.5.2.1.2) SPANDEX DIRECTION	MINIMUM 100%	MINIMUM 80%	MINIMUM 60%	MINIMUM 40%		
3.5.2.2) RESIDUAL EXTENSION AFTER 01 MIN RELAXATION						
3.5.2.2.1) OPPOSITE TO SPANDEX DIRECTION	UP TO 10%	UP TO 08%	UP TO 06%	UP TO 04%		
3.5.2.2.2) SPANDEX DIRECTION	UP TO 20%	UP TO 16%	UP TO 12%	UP TO 08%		
3.5.2.3) RESIDUAL EXTENSION AFTER 30 MIN RELAXATION						
3.5.2.3.1) OPPOSITE TO SPANDEX DIRECTION	UP TO 04%	UP TO 03%	UP TO 02%	UP TO 01%		
3.5.2.3.2) SPANDEX DIRECTION	UP TO 15%	UP TO 12%	UP TO 09%	UP TO 06%		
3.6) PILLING RESISTANCE (AS RECEIVED)	MINIMUM 3,0	MINIMUM 3,0	MINIMUM 3,0	MINIMUM 3,0	ASTM D 3512	-
3.7) APPEARANCE AFTER WASHING (1 CYCLE / 3 CYCLES)	SATISFACTORY	SATISFACTORY	SATISFACTORY	SATISFACTORY	In House Method	-
3.8) MOFIT / COATING / SEQUINS DURABILITY (TWIN-HOVER WASHER)	SATISFACTORY	SATISFACTORY	SATISFACTORY	SATISFACTORY	In House Method	-

DIMENSIONAL STABILITY TEST PERFOMANCE PER FIBER TYPE

TESTING ITEM	PLAIN FABRIC		KNITTED FABRIC		TESTING METHOD	NOTES
	WARP	WEFT	WARP	WEFT		
4.1) DIMENSIONAL STABILITY TO WASHING					AATCC 135	METHOD AND OPTION TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
4.1.1) 100% SYNTHETIC FIBER (POLYESTER / NYLON)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.1.2) 100% ARTIFICIAL FIBER (RAYON / BAMBOO)	UP TO 5%	UP TO 5%	UP TO 7%	UP TO 7%		
4.1.3) 100% NATURAL FIBER (COTTON / LINEN)	UP TO 4%	UP TO 4%	UP TO 6%	UP TO 6%		
4.1.4) 100% ANIMAL FIBER (WOOL)	UP TO 4%	UP TO 4%	UP TO 6%	UP TO 6%		
4.1.5) SPANDEX ≤ 10% IN COMPOSITION	UP TO 4%	UP TO 4%	UP TO 6%	UP TO 6%		
4.1.6) BLENDED MIXTURE (SYNTHETIC FIBER ≥ 50%)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.1.7) BLENDED MIXTURE (SYNTHETIC FIBER < 50%)	UP TO 3%	UP TO 3%	UP TO 5%	UP TO 5%		
4.2) DIMENSIONAL STABILITY TO IRONING					IN HOUSE METHOD	IRONING TEMPERATURE TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
4.2.1) 100% SYNTHETIC FIBER (POLYESTER / NYLON)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.2.2) 100% ARTIFICIAL FIBER (RAYON / BAMBOO)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.2.3) 100% NATURAL FIBER (COTTON / LINEN)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.2.4) 100% ANIMAL FIBER (WOOL)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.2.5) SPANDEX ≤ 10% IN COMPOSITION	UP TO 4%	UP TO 4%	UP TO 6%	UP TO 6%		
4.2.6) BLENDED MIXTURE (SYNTHETIC FIBER ≥ 50%)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%		
4.2.7) BLENDED MIXTURE (SYNTHETIC FIBER < 50%)	UP TO 3%	UP TO 3%	UP TO 5%	UP TO 5%		
4.3) SKEWNESS CHANGE IN FABRIC AFTER AUTOMATIC HOME LAUNDERING (AFTER 1 WASH)	UP TO 3%		UP TO 5%		AATCC 179, Method 1, Option 1	-

RECOMMENDATIONS FOR FULL FILLING OF REQUIREMENTS

COLOR FASTNESS TEST PERFOMANCES

In order to achieve the required stain according to the color intensity, following suggestions below should be considered in order to avoid reproofs:

1. PD FABRICS

   a. Articles with natural fibers (Cotton / Rayon), more than 10% in total composition:
      i. Reactive Dyestuff should be used for dyeing the natural fibers, specially for Medium / Dark colors (Black / Red / Dark Blue)
      ii. An effective washing process (water + detergent) should be used after dyeing, with temperature around 90 Degrees Celsius.
      iii. In the sequence, an effective washing process (only water) should be used, with temperature around 40-50 Degrees Celsius.
      iv. The washing time and bath relation for all steps above should be calculated according to the color fastness results after process and color intensity.
      v. All steps above have the intention to extract the excess of dyestuff placed upon the fabric surface, responsible for negative color fastness performances.

   b. Articles with Polyester
      i. Disperse dyestuff should be used for dyeing process.
      ii. An effective washing process (Sodium Hydrosulfite NA2S2O4 + Dispersing Agent) should be used after the dyeing process.
      iii. In the sequence, an effective washing process (water + detergent) should be used, with temperature around 90 Degrees Celsius.
      iv. In the sequence, an effective washing process (only water) should be used, with temperature around 40-50 Degrees Celsius.
      v. For multifilament / Micro fiber Polyester yarns, a medium / high reactivity disperse dyestuff (big molecules) should be used, especially for Medium / Dark colors.
      vi. The washing time and bath relation for all steps above should be calculated according to the color fastness results after process and color intensity.
      vii. All steps above have the intention to extract the excess of dyestuff placed upon the fabric surface, responsible for negative color fastness performances.

2. YD / PT / EMB FABRICS

      i. For this kind of articles, usually is highly recommended the yarn bobbins suffer same processes as described above (according to its composition / color intensity) after dyeing, before weaving, so that no staining happens after the finishing process of the fabric.

SLIPPAGE TEST PERFORMANCES

Below, following items which help improving the slippage performance, in case the result is not satisfactory.

   a. The more irregular the yarn surface, higher the friction between the yarns. This can be achieved with:
      i. The more twisted the yarn.
      ii. The more texturized the yarn.

   b. The more tied the fabric construction, higher the friction between the yarns. Below examples from up-low slippage performances divided by construction:
      i. PLAIN (best for slippage performance)
      ii. TWILL (medium for slippage performance)
      iii. SATIN (worst for slippage performance)

   c. The more dense the construction, better the slippage performances. This must be considered while weaving process.
      i. The more dense the weft, the best the slippage performances in warp direction.
      ii. The more dense the warp, the best the slippage performances in weft direction.

   d. The less soft the hand feeling, the best the slippage performance. This is the last solution to be practiced, as soft hand feeling is extremely valuable in fashion articles. Therefore, the 3 items above should be considered as prior actions to be taken in order to solve slippage problems.

INFORMATION

Below, following e-mails to be considered in order to obtain more detailed information about this manual if necessary:

1. Mr. Peak (China) ejian107@sina.com
2. Ms. Phyllis (China) phyllisjll_4@hotmail.com
3. Ms. Ruby (China) rubyxi@hotmail.com
4. Mr. Alexandre (Brazil) alexandre@focustextil.com.br
5. Ms. Amanda (Brazil) amandarossi@focustextil.com.br
6. Mr. Eduardo (Brazil) eduardobarrios@focustextil.com.br
7. Ms. Fatima (Brazil) fatimachahine@focustextil.com.br

CHEMICALS - "RSL" RESTRICTED SUBSTANCES LIST

QUALITY LEGAL REQUIREMENTS - SAFETY REQUIREMENTS - CHEMICALS - RESTRICTED SUBSTANCES LIST

Table of content:

1. Chemical substances, test methods and limits are listed in following order:
    a. Alkylphenols (AP)
    b. Nonylphenols (NP)
    c. Octylphenols (OP)
    d. Alkylphenolethoxylates (APEO)
    e. Nonylphenolethoxylates (NPEO)
    f. Octylphenolethoxylates (OPEO)

2. Dyes: Carcinogenic Dyes
    a. Dyestuffs causing environmental problems
    b. Allergenic Disperse Dyes
    c. Azo Dyes
    d. Biocides
    e. Chlorinated Organic Carriers
    f. Chlorinated paraffins
    g. Di-Methyl-Formamide (DMF)
    h. Flame retardants
    i. Formaldehyde
    j. Heavy Metals =>>
    k. Extractable Heavy Metals
    l. Heavy Metals (total content and releasable) - Lead - test method - update 29.11.07
    m. Organotin compounds
    n. Pentachlorophenol (PCP) & Tetrachlorophenol (TeCP)
    o. Phthalates
    p. Perfluorooctanesulfonates (PFOS)
    q. Polycyclic Aromatic Hydrocarbons (PAHs)]

3. Additional requirements, test methods and limits
    a. Surface Flash
    b. Corrosion
    c. Odour
    d. Polystyrene
    e. pH Value
    f. PVC

APEO'S	TEST METHOD	LIMIT
1) ALKYLPHENOLS (AP) 1.1) NONYLPHENOLS (NP) 1.2) OCTYLPHENOLS (OP)	ANALYSIS GC-MS OR LC-MS	30 MG/KG
2) ALKYLPHENOLETHOXYLATES (APEO) 2.1) NONYLPHENOLETHOXYLATES (NPEO) 2.2) OCTYLPHENOLETHOXYLATES (OPEO)		500 MG/KG

CARCINOGENIC DYES : THE FOLLOWING DYESTUFFS ARE CLASSIFIED TO BE CARCINOGENIC				
GENERIC NAME	C.I. STRUCTURE NUMBER	CAS NUMBER	TEST METHOD	LIMIT
C.I. ACID RED 26	C.I. 16 150	3761-53-3	TLC AND LC-MS DIN 54231 (DRAFT) [PREVIOUSLY KNOWN AS DIN NMP 512]	NOT DETECTED
C.I. BASIC RED 9	C.I. 42 500	569-61-9		
C.I. DIRECT BLACK 38	C.I. 30 235	1937-37-7		
C.I. DIRECT BLUE 6	C.I. 22 610	2602-46-2		
C.I. DIRECT RED 28	C.I. 22 120	573-58-0		
C.I. DISPERSE BLUE 1	C.I. 64 500	2475-45-8		
C.I. DISPERSE YELLOW 3	C.I. 11 855	2832-40-8		
C.I. BASIC VIOLET 14	C.I. 42 510	632-99-5		
C.I. DISPERSE ORANGE 11	C.I. 60 700	82-28-0		

THE FOLLOWING DYESTUFFS CAUSE ENVIRONMENTAL PROBLEMS				
GENERIC NAME		INDEX NR.	TEST METHOD	LIMIT
NAVY BLUE 018112		611-070-00-02	EXTRACTION TLC	BANNED DURING PRODUCTION

ALLERGENIC DISPERSE DYES : THE FOLLOWING DYESTUFFS ARE CLASSIFIED TO BE ALLERGENIC				
GENERIC NAME	C.I. STRUCTURE NUMBER	CAS-NUMBER	TEST METHOD	LIMIT
C.I. DISPERSE BLUE 1	C.I. 64 500	2475-45-8	TLC AND LC-MS DIN 54231 (DRAFT) [PREVIOUSLY KNOWN AS DIN NMP 512]	NOT DETECTED
C.I. DISPERSE YELLOW 3	C.I. 11 855	2832-40-8		NOT DETECTED
C.I. DISPERSE YELLOW 23	C.I. 26 070	6250-23-3		5 MG/L
C.I. DISPERSE BLUE 3	C.I. 61 505	2475-46-9		
C.I. DISPERSE BLUE 7	C.I. 62 500	3179-90-6		
C.I. DISPERSE BLUE 26	C.I. 63 305	3860-63-7		
C.I. DISPERSE BLUE 35		12222-75-2		
C.I. DISPERSE BLUE 102		12222-97-8		
C.I. DISPERSE BLUE 106		12223-01-7		
C.I. DISPERSE BLUE 124		61951-51-7		
C.I. DISPERSE BROWN 1		23355-64-8		
C.I. DISPERSE ORANGE 1	C.I. 11 080	2581-69-3		
C.I. DISPERSE ORANGE 3	C.I. 11 005	730-40-5		
C.I. DISPERSE ORANGE 76/37		12223-33-5		
C.I. DISPERSE ORANGE 149		85136-74-9		
C.I. DISPERSE RED 1	C.I. 11 110	2872-52-8		
C.I. DISPERSE RED 11	C.I. 62 015	2872-48-2		
C.I. DISPERSE RED 17	C.I. 11 210	3179-89-3		
C.I. DISPERSE YELLOW 1	C.I. 10 345	119-15-3		
C.I. DISPERSE YELLOW 9	C.I. 10 375	6373-73-5		
C.I. DISPERSE YELLOW 39		12236-29-2		
C.I. DISPERSE YELLOW 49		54824-37-2		

AZO DYES FROM WHICH ARYLAMINES CAN BE SPLIT OFF UNDER REDUCTIVE CONDITIONS				
	INDEX NR.	CAS-NUMBER	TEST METHOD	LIMIT
BIPHENYL-4-YLAMIN 4-AMINOBIPHENYL XENYLAMINE	612-072-00-6	92-67-1	TEXTILES IN GENERAL: EN 14362-1 TEXTILES FROM PES: EN 14362-2 LEATHER: ISO/TS 17234	30 MG/KG
BENZIDINE	612-042-00-2	92-87-5		
4-CHLORO-O-TOLUIDINE		95-69-2		
2-NAPHTYLAMINE	612-022-00-3	91-59-8		
O-AMINOAZOTOLUENE 4-AMINO-2',3-DIMETHYLAZOBENZENE 4-O-TOLYLAZO-OTOLUIDINE	611-006-00-3	97-56-3		
5-NITRO-O-TOLUIDINE		99-55-8		
4-CHLOROANILINE		106-47-8		
4-METHOXY-M-PHENYLENEDIAMINE		615-05-4		
4,4'-METHYLENEDIANILINE 4,4'-DIAMINODIPHENYLMETHANE	612-051-00-1	101-77-9		
3,3'-DICHLOROBENZIDINE 3,3'-DICHLOROBIPHENYL-4, 4'-YLENEDIAMINE	612-068-00-4	91-94-1		
3,3'-DIMETHOXYBENZIDINE O-DIANISIDINE	612-036-00-X	119-90-4		
3,3-DIMETHYLBENZIDINE 4,4'-BI-O-TOLUIDINE	612-041-00-7	119-93-7		
4,4'-METHYLENEDI-O-TOLUIDINE	612-085-00-7	838-88-0		
6-METHOXY-M-TOLUIDINE P-CRESIDINE		120-71-8		
4,4'-METYLENE-BIS- (2-CHLORO-ANILINE) 2,2'-DICHLORO-4,4'-METHYLENEDIANILINE	612-078-00-9	101-14-4		
4,4'-OXYDIANILINE		101-80-4		
4,4'-THIODIANILINE		139-65-1		
O-TOLUIDINE 2-AMINOTOLUENE	612-091-00-X	95-53-4		
4-METHYL-M-PHENYLENEDIAMINE	612-099-00-3	95-80-7		
2,4,5-TRIMETHYLANILINE		137-17-7		
O-ANISIDINE 2-METHOXYANILINE	612-035-00-4	90-04-0		
4-AMINO AZOBENZENE	611-008-00-4	60-09-3		

BIOCIDES	TEST METHOD	LIMIT
TRICLOSAN	EXTRACTION USING ORGANIC SOLVENT, DETERMINATION BY GC-MS	USAGE BAN

CHLORINATED ORGANIC CARRIERS	TEST METHOD	LIMIT
DICHLOROBENZENES	EXTRACTION WITH DICHLORMETHAN, GC-MS	1.0 MG/KG (TOTAL)
TRICHLOROBENZENES		
TETRACHLOROBENZENES		
PENTACHLOROBENZENES		
HEXACHLOROBENZENE		
CHLOROTOLUENES		
DICHLOROTOLUENES		
TRICHLOROTOLUENES		
TETRACHLOROTOLUENES		
PENTACHLOROTOLUENE		

	TEST METHOD	LIMIT
CHLORINATED PARAFFINS SHORT-CHAIN 2002/45/EC	EXTRACTION WITH ORGANIC SOLVENT DETERMINATION BY GC-MS	100 MG/KG

	TEST METHOD	LIMIT
DI-METHYL-FORMAMIDE (DMF)	SOLVENT EXTRACTION ANALYSIS BY GC-MS OR LC-MS	USAGE BAN

FOLLOWING FLAME RETARDANTS ARE FORBIDDEN :			
	CAS NUMBER	TEST METHOD	LIMIT
TRIS-(2,3-DIBROMOPROPYL)- PHOSPHATE (TRIS)	126-72-7	EXTRACTION WITH MEOH / LC-MS	NOT DETECTED
TRIS - (AZIRIDINYL) - PHOSPHINEOXIDE (TEPA)	5455-55-1	EXTRACTION WITH KOH/HEADSPACE/GC-MS	NOT DETECTED
POLYBROMOBIPHENYLS (PBB)	59536-65-1	EXTRACTION WITH MEOH / GC-MS	NOT DETECTED
BIS(2,3-DIBROMOPROPYL ETHER) OF TETRABROMOBISPHENOL (BDBPT)	21850-44-2	EXTRACTION WITH GC-MS	NOT DETECTED
BIS(2,3-DIBROMOPROPYL) PHOSPHATE (BBP)	5412-25-9	EXTRACTION WITH GC-MS	NOT DETECTED
OCTABROMODIPHENYL ETHER (OCTABDE)	32536-52-0	EXTRACTION WITH GC-MS	NOT DETECTED
PENTABROMODIPHENYL ETHER (PBDE)	32534-81-9	EXTRACTION WITH GC-MS	NOT DETECTED

FORMALDEHYDE	TEST METHOD	LIMIT	
- TEXTILES :	DIN EN ISO 14184-1 (1999-02) (SIMILAR TO JAPANESE LAW 112)	- BABYWEAR - WORN NEXT TO THE SKIN - OUTERWEAR	20 MG/KG 75 MG/KG 300 MG/KG
- LEATHER :	PR DIN 53315, 06/96		150 MG/KG
- WOOD :	EMISSION TEST DIN EN 717 - PART 1		0,1 PPM V/V

EXTRACTABLE HEAVY METALS	TEST METHOD	LIMIT
ANTIMONY	EXTRACTABLE CONTENT : EXTRACTION WITH ACID PERSPIRATION ACCORDING TO DIN EN ISO 105-E04	30 MG/KG (NO LIMIT FOR DECORATION MATERIALS)
ARSENIC		0,2 MG/KG (BABY MERCHANDISE) 1,0 MG/KG
CADMIUM		0.1 MG/KG
CHROMIUM		1,0 MG/KG (BABY MERCHANDISE) 2,0 MG/KG
COBALT		1,0 MG/KG (BABY MERCHANDISE) 4,0 MG/KG
COPPER		25,0 MG/KG (BABY MERCHANDISE) 50,0 MG/KG
LEAD		90 MG/KG (TOY MATERIALS & GARMENT ACCESSORIES (E.G. ZIPPERS, BUTTONS, RIVETS, DECORATIVE GLASS BEADS/JEWELLERY, METAL JEWELLERY, LEAD CRYSTAL)
MERCURY		0,02 MG/KG
NICKEL		1,0 MG/KG (BABY MERCHANDISE) 4,0 MG/KG

HEAVY METALS (TOTAL CONTENT AND RELEASABLE) UPDATE 29.11.07	TEST METHOD	LIMIT
CADMIUM	EN 1122	100 MG/KG
CHROMIUM VI	DIN 53314 - PRE-EXTRACTION FOR COLOURED LEATHER - USE OF DIONEX	3 MG/KG 3 MG/KG (AFTER AGEING PROCEDURE UNDER FOLLOWING CONDITIONS: 24H / 80℃ / 20% R.H.)
LEAD	DIN EN 13346 (CLASSIC VERSION OR MICROWAVE) DETERMINATION: DIN EN ISO 11885 / DIN EN ISO 17294-2	100 MG/KG (TEXTILES, LEATHER, PLASTIC, ELECTRONICS, PACKAGING)
NICKEL	EN 12472, EN 1811, PREN 12471 RUBBING TEST	CONSUMER GOODS SUCH AS JEWELLERY, SNAP FASTENERS, PRESS BUTTONS, ZIP FASTENERS, ETC., WHICH CAN COME INTO CONTACT WITH THE HUMAN SKIN FOR A LONGER PERIOD MUST NOT RELEASE MORE THAN 0.5 µG NICKEL PER CM² PER WEEK. ADDITIONAL- ARTICLES SHOULD NOT SHOW POSSITIVE RESULT ACCORDING TO PREN 12471, RUBBING TEST

ORGANOTIN COMPOUNDS	TEST METHOD	LIMIT	
TRIBUTYLTIN (TBT)	EXTRACTION WITH WATER/ETHANOL/HEXAN, DIN 38407	BABY MERCHANDISE OTHER MERCHANDISE	0,5 MG/KG 1,0 MG/KG
DIBUTYLTIN (DBT)		BABY MERCHANDISE OTHER MERCHANDISE	1,0 MG/KG 1,0 MG/KG

	TEST METHOD	LIMIT
PENTACHLOROPHENOL (PCP) TETRACHLOROPHENOL (TECP)	PRINTED POLYESTER : 1 - EXTRACTION WITH ASE OR ALKALINE EXTRACTION (KOH) 2 - SAMPLE PREPARATION ACCORDING TO METHOD PARAGRAPH35 LMBG B 82.02-08 , DATED 06/2001 3 - DETERMINATION ACCORDING TO METHOD PARAGRAPH35 LMBG B 82.02-08 , DATED 06/2001 WITH GC-MS (OR WITH GC-ECD). TEXTILES AND LEATHER : 1 - EXTRACTION AND SAMPLE PREPARATION ACCORDING TO METHOD PARAGRAPH35 LMBG B 82.02-08 , DATED 06/2001 2 - DETERMINATION ACCORDING TO METHOD PARAGRAPH35 LMBG B 82.02-08 , DATED 06/2001 WITH GC-MS (OR WITH GC-ECD).	0.5 MG/KG

	TEST METHOD	LIMIT
PHTHALATES	EXTRACTION WITH ORGANIC SOLVENTS GC/LC-MS	FOR DELIVERIES FROM 01.01.2005 : THE SUM OF FOLLOWING PHT MAY NOT EXCEED THE LIMIT OF 0,1% (1000 MG/KG) ABBREVIATION NAME CAS - NR. DINP DI-ISO-NONYLPHTHALAT 28553-12-0 DNOP DI-N-OCTYLPHTHALAT 117-84-0 DEHP DI (2-ETHYLEXYL)PHTHALAT 117-81-7 DIDP DI-ISO-DECYLPHTHALAT 26761-40-0 BBP BUTYLBENZYLPHTHALAT 85-68-7 DBP DIBUYLPHTHALAT 84-74-2 THIS RESTRICTION IS VALID FOR ALL ARTICLES, FOR ALL AGES AND WHETHER OR NOT DESIGNED FOR, OR INDEED CAPABLE OF, BEING PLACED IN THE MOUTH.

	TEST METHOD	LIMIT
PERFLUOROOCTANESULFONATES (PFOS)	SOLVENT EXTRACTION/ LC-MS	1 MICROGRAM/M2 ON TEXTILES AND OTHER COATED MATERIALS

	TEST METHOD	LIMIT		
POLYCYCLIC AROMATIC HYDROCARBONS (PAHS)	EXTRACTION WITH ORGANIC SOLVENT, DETERMINATION BY GC/MS, DIN ISO 18287.		INTENDED USE, SKIN CONTACT LESS THAN 30 SECONDS	INTENDED USE, SKIN CONTACT MORE THAN 30 SECONDS
		BENZO[A]PYRENE MG/KG	20	1
		SUM OF 16 PAHS* (EPA) MG/KG	200	10
		*ACENAPHTENE, ACENAPHTYLENE, ANTHRACENE, BENZO(A)PYRENE (BAP), DIBENZO(AH)ANTHRACENE, BENZO(B)FLUORANTHENE, BENZO(GHI)PERYLENE, BENZO(K)FLUORANTHENE, CHRYSENE, FLUORANTHENE, FLUORENE, INDENO(123-CD)PYRENE, NAPHTHALENE, PHENANTHRENE, PYRENE, BENZO(A)ANTHRACENE,	

ADDITIONAL REQUIREMENTS	TEST METHOD	LIMIT
SURFACE FLASH IN PILE MATERIALS AND HAIRY CELLULOSIC OR CELLULOSIC BLEND MATERIALS	EN 1103 BEFORE AND AFTER WASHING	THE FIRST MARKER THREAD MAY NOT BE PASSED
CORROSION OF METAL PARTS	EN 344-1 PART 5.5.2	METAL PARTS MUST NOT SHOW CORROSION
ODOUR	SNV 195 651	3 (= CLEAR)
POLYSTYRENE IN PLASTIC PARTS	ISO 3175-1	WHEN DRY-CLEANING IS REQUIRED PLASTIC PARTS CONTAINING POLYSTYRENE (PS) ARE NOT ALLOWED
PH VALUE	ISO 3071-1980	BABY / CONTACT WITH THE SKIN : 4.0 - 7.5 NO SKIN CONTACT : 4.0 - 9.0
PVC - POLYVINYL CHLORIDE	• COMMITTED TO MEETING THE EXPECTATIONS OF OUR CUSTOMERS, EMPLOYEES, AND INTEREST GROUPS IN THE FIELDS OF HUMAN ECOLOGY AND THE ENVIRONMENT • IN LINE WITH GROWING CONCERNS WHICH ARE REGULARLY ADDRESSED BY CONSUMERS, BY NGO'S AND THE MEDIA, IT CONTINUES TO BE OUR STRATEGY TO WORK TOGETHER WITH OUR SUPPLIERS TO DEVELOP ALTERNATIVES TO PVC (POLYVINYL CHLORIDE) IN OUR PRODUCTS, AND IN PRODUCT-RELATED PACKAGING. • APPLIED A NON-PVC STRATEGY IN OUR BABYWEAR COLLECTIONS FOR MANY YEARS ALREADY, AND IN MID 2004 COMMUNICATED REQUIREMENTS TO SUPPLIERS THAT ALL CLOTHING (MENS, WOMENS AND CHILDRENS) DELIVERED TO C&A STORES AS FROM 01.01.05, SHOULD NOT CONTAIN PVC.	

LABELING / PACKING / PIECE LENGTH

ROLL IDENTIFICATION (LABELS)

1. Each roll must provide 03 (three) labels:
   a. 2 labels indicating fabric information.
   b. 1 label indicating Care Label Symbols (according to PI indication).

2. Position of labels:
   a. Fabric information labels (02) must be placed at each extremity of the roll, inside the plastic bag, sizing no larger than the roll diameter.
   b. Care Label Symbols (01) must be placed inside the plastic bag.
   c. Self sticker labels may be used directly on the fabric surface, unless for delicate fabric surfaces.

3. Handwritten, albeit partially, will not be accepted by Focus Têxtil. Labels should be printed out by computer and / or stumpers.

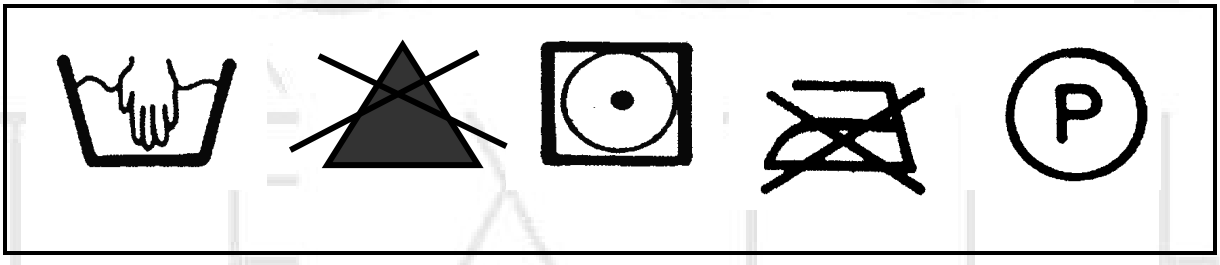
4. Focus Têxtil requires not to write anywhere by any means in the fabric, tags or wrapping as follows:
   a. Factory / Supplier name
   b. Anything in English language
   c. Chinese or Korean letters

5. Fabric information label must contain exactly following fields, and **all fields indicated in RED color should size no shorter than 5mm after printing**. **All fields of the labels must be printed out in BLACK color**.
   a. **Fabric Information Label fields and format – real size (11,5cm x 10,0 cm):**

IMPORTADOR:EXCIM IMPORTAÇÃO EXPORTAÇÃO SA
CNPJ: 02.384.871/0001-81
COMPOSIÇÃO: (Percentage / fiber content in extension way)

QUANT. GROSS (KG): (means gross quantity for knitted goods in kilos)
QUANT. NET (KG): (means net quantity for knitted goods in kilos)
QUANT. (M): (means quantity for woven goods in meters)
COR NR: (means color #) **COR NOME:** (means color name in Portuguese)
DES. NR: (means design#)
LARG. TOTAL(M): (Article total width in meters)
ORD. NR: (means order #) **PESO (G/M²):** (Article weight in g/m²)
ART. NR: (means article #) **LOT NR:** (means lot #)
ROL. NR: (means roll #)
PAÍS DE ORIGEM: (means country of origin)
QUANT. PONTOS: (means points quantity found for the roll) - OPTIONAL
PONTOS / 100 M²: (means conversion into points qty / 100m²) - OPTIONAL

   b. **Care label format (16,0cm x 3,5cm)** (All the below symbols are **only for an example**. The article symbols should be printed according to PI indication – MINIMUM 5 SYMBOLS MUST BE INDICATED)



6. Fiber content translated from English to Portuguese, to be used when describing fabric composition on Label:

	ENGLISH	PORTUGUESE
a.	T or PES:	POLIÉSTER
b.	NY or PA:	POLIAMIDA
c.	CO:	ALGODÃO
d.	LINEN:	LINHO
e.	CV:	VISCOSE
f.	RAYON:	RAYON VISCOSE
g.	PAC / ACRYLIC:	ACRÍLICO
h.	SPANDEX / PUE:	ELASTANO
i.	METALIC:	METÁLICO
j.	WOOL:	LÃ

ROLL PACKING / BREAKDOWN QUANTITIES

1. Packing touch must be soft and cold.
2. Loose packing: Rolls must be packed with a resistant plastic bag or two (2) plastic bags to avoid damages.
3. **Plastic bag thickness required minimum 0,08mm.**
4. **Single plastic bag sheerness of minimum 70%.**
5. The roll diameter size should be enough to allow information label sticking.
6. BULK ORDER – Breakdown of quantities proportionally per color as pre a agreement **(unless otherwise required in the CA order)**:

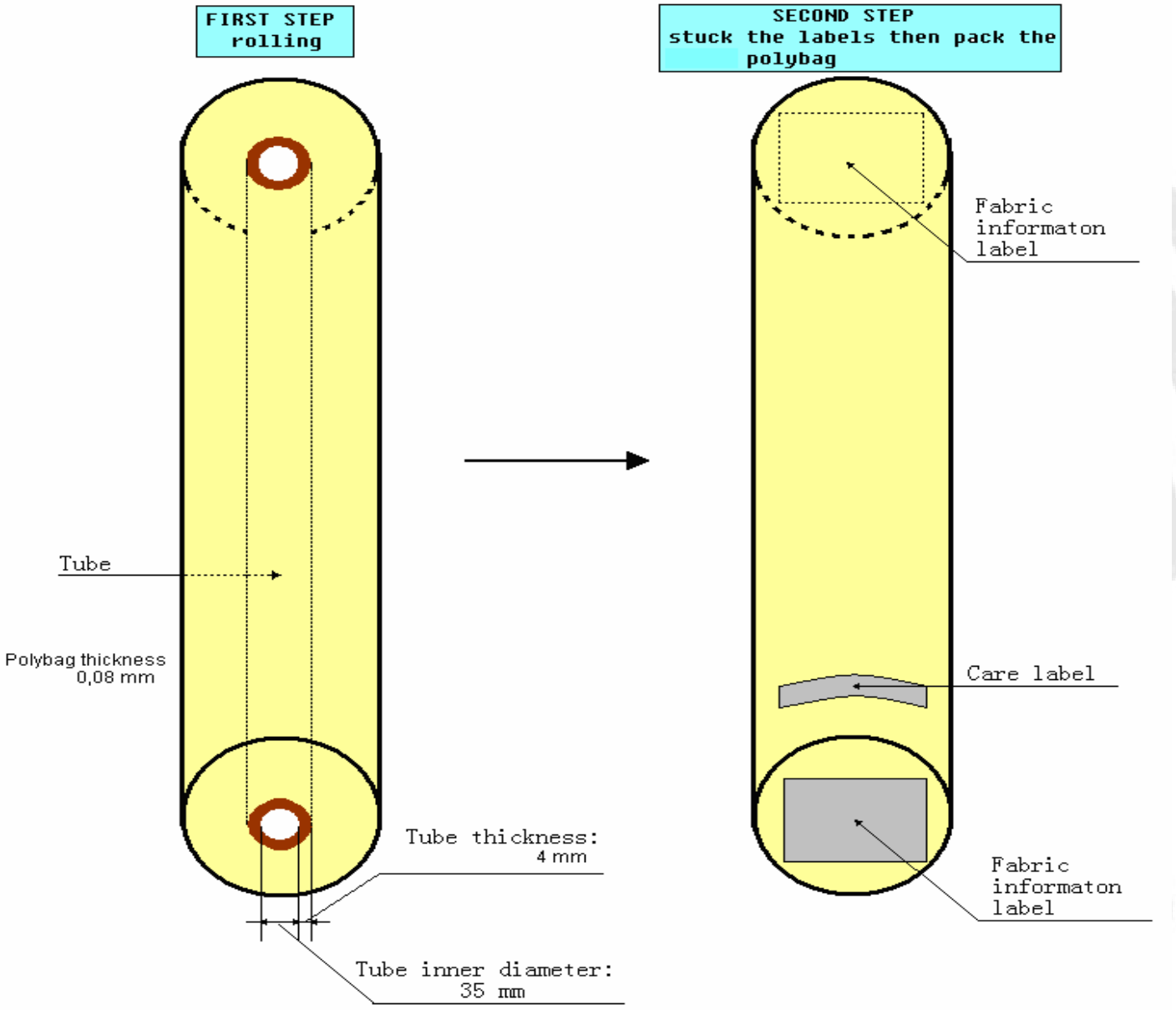
		ROLL LENGTH / WEIGHT	
		WEGHT ≤ 100g/m²	**WEGHT > 100g/m²**
WOVEN + KNITTED (NEGOTIATED IN METER)	PIECE DYED YARN DYED EMBROIDERY	70 – 120m. ≥ 80% 30 – 70m. < 20%	30 – 70m. = 100%
	PRINTED	70 – 120m. ≥ 70% 30 – 70m. < 30%	30 – 70m. = 100%
KNITTED (NEGOTIATED IN KG)	ALL	16 – 24Kg. = 100%	

7. TAILORING ORDER (1.000m.) – Breakdown of quantities proportionally per color as pre a agreement **(unless otherwise required in the CA order)**:

	ROLL LENGTH / WEIGHT
WOVEN + KNITTED (NEGOTIATED IN METER)	20 – 30m. = 100%
KNITTED (NEGOTIATED IN KG)	06 – 10Kg. = 100%

8. No fabric should be rolled on a tube in such manner as to have more than 1" of the tube extending beyind the selvage of the fabric on either end of the roll.
9. Tubes narrower than the fabric total width will not be accepted.
10. **Tubes required with minimum 4mm thickness.**

a. Packing method and step sheet



b. Tube requirement

CARE LABEL SYMBOLS

LIST 1 - WASHING SYMBOL

Care Symbol	Care Instructions
	- Water temperature should not exceed 95 º C. - Normal mechanical action.
	- Water temperature should not exceed 95 º C. - Delicate mechanical action.
	- Water temperature should not exceed 70 º C. - Normal mechanical action.
	- Water temperature should not exceed 60 º C. - Normal mechanical action.
	- Water temperature should not exceed 60 º C. - Delicate mechanical action.
	- Water temperature should not exceed 50 º C. - Normal mechanical action.
	- Water temperature should not exceed 50 º C. - Delicate mechanical action.
	- Water temperature should not exceed 40 º C. - Normal mechanical action.
	- Water temperature should not exceed 40 º C. - Delicate mechanical action.
	- Water temperature should not exceed 40 º C. - Very delicate mechanical action.
	- Water temperature should not exceed 30 º C. - Normal mechanical action.
	- Water temperature should not exceed 30 º C. - Delicate mechanical action.
	- Water temperature should not exceed 30 º C. - Very soft mechanical action.
	- Hand wash. - Water temperature should not exceed 40 ºC.
	- Do not wash.

LIST 2 - BLEACHING SYMBOL

Care Symbol	Care Instructions
	- Bleach when Needed. Any commercially available bleach product may be used in the laudering process.
	- Non-chlorine bleach when needed. Only a non chlorine, color-safe bleach may be used in laudering process. Chlorine bleach may not be used.
	- Do not bleach. No bleach product may be used. The article is not colorfast or structurally able to withstand any bleach.

LIST 3 - DRYING SYMBOL

Care Symbol	Care Instructions
	- Tumble dry. - Medium heat.
	- Tumble dry. - Low heat.
	- Do not tumble dry.

LIST 4 - IRONING SYMBOL

Care Symbol	Care Instructions
	- Regular ironing, may be performed at high setting - 200 ºC.
	- Regular ironing, may be performed at medium setting - 150 ºC.
	- Regular ironing, may be performed at low setting - 110 ºC. Steam ironing may cause damages for article.
	- Do not iron.

LIST 5 - DRY CLEANING SYMBOL

Care Symbol	Care Instructions
	- Must be professionally dry cleaned with tetrachloroethylene and all F symbol solvent restriction. - Normal mechanical action.
	- Must be professionally dry cleaned with tetrachloroethylene and all F symbol solvent restriction. - Delicate mechanical action.
	- Must be professionally dry cleaned with hydrocarbon (distillation temperature between 150 ºC and 210 ºC, fulgency point between 38ºC and 70 ºC) - Normal mechanical action.
	- Must be professionally dry cleaned with hydrocarbon (distillation temperature between 150 ºC and 210 ºC, fulgency point between 38ºC and 70 ºC) - Delicate mechanical action.
	- Do not dryclean.
	- Must be professionally moist cleaned. - Normal mechanical action.
	- Must be professionally moist cleaned. - Delicate mechanical action.
	- Must be professionally moist cleaned. - Very delicate mechanical action.

PACKING LIST

DETAILED PACKING LIST (JUST EXAMPLE)

Inv. No: **DATE:**

COLOR:ROSA BEBE				
ROLL	**LOT**	**N.W(KG)**	**G.W (KG)**	**QTY(M)**
1	1	11,5	12,5	34,8
2	1	11,5	12,5	34,8
3	1	11,5	12,5	34,8
4	1	11,5	12,5	34,8
5	2	11,5	12,5	34,8
6	2	11,5	12,5	34,8
7	2	11,5	12,5	34,8
8	2	11,5	12,5	34,8
9	2	11,5	12,5	34,8
10	3	11,5	12,5	34,8
11	3	11,5	12,5	34,8
12	3	11,5	12,5	34,8
13	3	11,5	12,5	34,8
14	3	11,5	12,5	34,8
TTL: 14 ROLLS		161,0KGS	175,0KGS	487,8MTS

COLOR:AÇO				
ROLL	**LOT**	**N.W(KG)**	**G.W (KG)**	**QTY(M)**
1	1	12,2	13,2	52,1
2	1	12,2	13,2	52,1
3	1	12,2	13,2	52,1
4	1	12,2	13,2	52,1
5	2	12,2	13,2	52,1
6	2	12,2	13,2	52,1
7	2	12,2	13,2	52,1
8	2	12,2	13,2	52,1
9	3	12,2	13,2	52,1
10	3	12,2	13,2	52,1
11	3	12,2	13,2	52,1
12	3	12,2	13,2	52,1
TTL: 12 ROLLS		146,4KGS	158,4KGS	625,2MTS

COLOR:CINZA				
ROLL	**LOT**	**N.W(KG)**	**G.W (KG)**	**QTY(M)**
1	1	13,5	14,5	57,6
2	1	13,5	14,5	57,6
3	1	13,5	14,5	57,6
4	1	13,5	14,5	57,6
5	2	13,5	14,5	57,6
6	2	13,5	14,5	57,6
7	2	13,5	14,5	57,6
8	3	13,5	14,5	57,6
9	3	13,5	14,5	57,6
10	3	13,5	14,5	57,6
TTL: 10 ROLLS		135,0KGS	145,0KGS	576,0MTS

RESUME				
COLOR	**ROLLS**	**TTL - NW**	**TTL - GW**	**TTL - QTY**
1 ROSA BEBE	14	161,00	175,00	487,83
2 AÇO	12	146,40	158,40	625,20
3 CINZA	10	135,00	145,00	576,00

TOTAL :	**36,00**	**442,40**	**478,40**	**1.689,03**