



PAKISTAN NAVY SPECIFICATION 07/2021
PROMULGATION DATE: 18 JUNE 2021

SOCKS COTTON **BLACK AND WHITE**

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PROMULGATION ORDER

1. This specification is hereby approved and promulgated for information, guidance and compliance by the relevant person.
2. The details contained in the specification are to be studied, interpreted and implemented with due regards to the interest of the Service.

SUGGESTIONS FOR AMENDMENT

1. The specification has been prepared to bring the test methods and procedures in line with up-to-date PN requirements and facilities held in Pakistan. CINS may request to amend any test requirement/ test procedure in light of the experience emanating from its inspection history, through the feedback form placed at Annex E. However, such an alteration will be effective when the amendment is promulgated by this Directorate, and will be effective on the contracts which materialize after the promulgation date of respective amendment.

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RECORD OF CHANGES/ AMENDMENT

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0101 **DESIGNATION**

1. Sock Cotton Black & White.

0102 **USAGE**

1. These Sock Cotton Black & White will be worn by Officers, CPOs/Sailors of Pak Navy.

0103 **INTRODUCTION**

1. This specification is prepared by Directorate of Indigenous Technical Development, Karachi, to provide necessary guidance to the potential manufacturers/ suppliers of the items mentioned herein. This specification is to be used for testing and deciding upon acceptance, or otherwise, of the items mentioned. Any alteration or addition in this specification can be suggested to ITD wing (NRDI). However, it cannot be implemented without prior approval from NS Dte. Promulgated earlier in relation to the item mentioned herein.
2. This specification booklet includes 07 Annexes and consists 22 pages, including the cover.

0104 **SCOPE**

1. This specification covers the technical/ manufacturing requirements of Sock Cotton Black & White worn by Officer, CPOs/ Sailors. It defines and lays down the quality standards, details of materials, workmanship and finish. It also defines briefly requirement and process of sampling, testing, inspection acceptance/rejection, marking, preservation, packing and delivery etc.
2. The supplier/ manufacturer shall comply in every respect with the terms of this specification and ensure that the stores conform to it, in all respects. This specification lays down the standard to which the store shown under designation above should.

0105 **RELATED DOCUMENTS**

1. The latest standards documents that have been referred to in this specification are:

a.	AATCC-20 A	Fiber Analysis –Qualitative.
b.	AATCC 79	Method for absorbency of Textiles
c.	ASTM D 4850	Terminology related to Fabric and Fabric test.
d.	ASTM D 3990	Terminology related to fabric Defects
e.	ISO 7211/2	Number of treads per unit length
f.	ISO 7211/5	Linear density of yarn removed from fabric.
g.	BS EN ISO 6330 4 N	Domestic washing and drying procedure
j.	ISO 12947	Abrasion resistance of fabric
k.	ISO 3801	Determination of Mass per unit Length
l.	ISO 13934	Determination of maximum force and elongation.

m.	ISO 7211/2	Determination of no of threads per unit length
p.	ISO 105-E01	Colour fastness to water.
q.	ISO 105 E02	Colour fastness to sea water
r.	ISO 105 E03	Colour Fastness to Chlorinated Water (Swimming Pool)
s.	ISO 105 X 12	Colour fastness to Rubbing
t.	ISO 105 E04	Colour Fastness To Perspiration
u.	ISO 105 J03	Method for Calculating a Colour Difference

0106 **TERMS & DEFINITIONS**

1. Definitions for the terms used in this standard are given at Annex A of this specification.

0107 **TECHNICAL DETAILS OF SOCK COTTON BLACK & WHITE**

1. The Technical Details of Sock Cotton Black & White s are mentioned at Annex B of this specification.

0108 **GUIDE LINE FOR SOCK COTTON BLACK & WHITE MANUFACTURING**

1. Socks are manufactured from yarn dyed (Black) and bleached yarn (White) terry design with Y type heel.
2. The drawing and dimension details are mentioned at Annex C and D respectively.
3. The socks has three main portions i.e. Foot, Leg & Ribbed portion.
4. Socks are manufactured in a form that welt part in leg portion consists of Rib.
5. Foot part consists of terry.
6. Linear density of yarn is 24/2 CDD (Count Double Decrease) for Cotton and 150 Denier & 48 filament for Polyester.
7. Thread count of course and wales are 481 (top to toe) & 108 number of needles respectively.
8. Socks shall have cross stretch of 21-22 cm.
9. Number of Gores at heel position should be 11 ± 1 .

0109. **QUALITY OF WORKMANSHIP AND FINISHING**

1. The Workmanship and finish of Sock Cotton Black & White shall be best in quality and to the entire satisfaction of the Inspector.

0110. **TESTING**

1. The stores/ material during manufacture and after delivery shall be tested and examined as the Inspector may consider necessary in order to determine whether they conform to Annex B of this specification. Inspecting authority reserves the right to get any B/R samples tested from any reputable Laboratory other than PN.

0111. **DRAWING OF SOCK COTTON BLACK & WHITE FROM BULK AS REPRESENTATIVE SAMPLES**

1. No of samples drawn from bulk quantity for inspection/ testing are as per instruction of Inspecting Officer (if deemed appropriate) or as per following table:

Lot Size	No. Sample
300 ≥ 500	03
501 ≥ 800	05
801 ≥ 1300	07
1301 ≥ 3200	10
3201 ≥ 8000	15
8001 ≥ 22000	30
22001 ≥ 110000	40

0112. **TENDER SAMPLE**

1. Tender sample to be approved by TSR Committee.
2. For each contract following material shall be supplied by the manufacturer at the time of tendering:

a.	Sock Cotton Black & White	10 x samples of each colour
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0113. **ADVANCE SAMPLE**

1. Advance sample or pre-production sample, when required, shall be submitted in accordance with terms of the contract for inspection, as per Annex B, C and D and approved by CINS.
2. Whenever Tender, Advance or pre-production sample is not required, the suppliers /manufacturer are advised in their own interest to submit to the Inspecting Officer or his representative an initial delivery of One % of the contract or 10 meters for inspection and testing.
3. The approval of the sample, authorizes the commencement of bulk production but does not relieve the suppliers/ manufactures from compliance with all the provisions of this specification. One approved sample shall be properly sealed by INS and returned to the firm for guidance; rest of the approved sample shall be retained by INS for future use in bulk Inspection (if deemed necessary).
4. The Pre-production sample shall be manufactured by the manufacturer with the same facilities which will be used for manufacture of the bulk items.
5. Firm shall provide advance sample along with quality verification reports from an accredited laboratory, whenever asked/ required by Inspecting authority to ensure compliance of quality assurance parameters during production/ final internal inspection.

0114. **INSPECTION**

1. Bulk representative sample (B/R) random sampling will be carried out as per rules in vogue.

2. Sock Cotton Black & White shall be tested and examined during manufacturing /Stage inspection as Inspector may consider necessary, to determine whether they conform to PN specification or not.
3. **Inspection of Sock Cotton Black & White.** The guidelines for Inspector w.r.t general defects are defined at Annex E. and Inspection Criteria is defined at Annex F. The Cloth of Sock Cotton Black & White shall be examined to ensure correctness of material, shade width evenness of dyes and other constructional details.
4. **Inspection/ Acceptance and Rejection of Stores.** Inspection/ acceptance is to be carried out to the entire satisfaction of Chief Inspector of Naval Stores or as per instruction/ procedure laid down in unit/ department Order.
 - a. **Stamping of accepted stores.** Each acceptable store shall be stamped with Inspectors individually acceptance mark close to contractor marking.
 - b. **Stamping of rejected stores.** The rejected stores shall be marked with inspectors rejection mark close to contractor marking to avoid resubmission by the supplier.
5. If on examination of 5% of any delivery, 20% of those examined from bulk supply are found NOT CONFORMING to this specification in respect of the pattern, dimensions, workmanship and finish, the whole consignment may be rejected without any compromise.
6. All stores and packing NOT fully in accordance with this specification shall be rejected.
7. **Responsibility for Inspection.** The supplier is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. PN reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.
8. **Responsibility for Compliance.** The inspection set forth in this specification shall become a part of the supplier's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to PN for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements. However, this does not authorize submission of known defective material, either indicated or actual, nor does it commit PN to acceptance of defective stores (material).
9. **Replacement by the Contractor.** The supplier is responsible for replacement of the consignment or any part thereof, whenever it is found to be not

conforming to this specification. The supplies so tendered in replacement, shall be subjected to testing/ Inspection and acceptance by the Inspecting Officer.

10. **Responsibility for Safety.** The supplier/ manufacturer is fully responsible for the safety of supplies during inspection, storage at firm's premises, proper packing, dispatch and delivery up to consignee.

11. The CINS is the authority in all matters pertaining to Inspection.

0115. **SPECIAL INSTRUCTIONS**

1. **Care Label Instructions.** Following care instructions in the form of leaflet OR attached with Sock Cotton Black & White shall be provided in English and Urdu:

- a. % of fiber content
- b. Machine normal wash
- c. Tumble dry
- d. Size:
- e. Stain removing bleach should be avoided.
- f. Prolonged contact with sunlight should be avoided etc.

0116. **PACKING AND PRESERVATION DETAILS**

1. Quality of packing shall be examined/ tested as the Inspector may consider necessary in order to determine whether they conform to this specification.

a. **Packing.** The store when ordered to be delivered 'PACKED' shall be distributed evenly in each carton.

- (1) The pair of socks shall be packed in a neat, dry and clean condition in standard polythene packing.
- (2) The pair of socks shall be further packed in a thick card board box.
- (3) Each card board box shall be securely and properly packed.

c. **Packing Slip.** A Packing Slip shall be enclosed in each package giving full details about the store packed i.e. Cat No. designation, quantity packed, contract No, Challan No and date I/Note No or Voucher No. and date, consignee, consignor, date of packing and packer's signature, Package No and weight of the individual Package.

0117. **IDENTIFICATION LABEL**

1. Each Sock Cotton Black & White shall bear following clear and indelible information on both ends:

- a. Item name/ item description with size and NSN/ patt no.
- b. Contract number and Date.
- c. Year of manufacture.
- d. Firm's name, initials, or trade mark.
- e. Batch no.

0118. **PACKING LIST**

1. Firm is bound to provide a packing list of store offered for inspection along with the challan, which include complete details about the store i.e. Pattern No., Description of stores, size, quantity, contract No., and Date, Challan No. date and I/Note No. or voucher no. and date, consignee, Manufacturer/ firm's name, date of packing and packer's signature, QA certificate /Lab test report from any accredited lab.

0119. **MARKING OF STORES**

1. Each bolt of Sock Cotton Black & White will stenciled with quick drying Black indelible ink/ print in clearly define characters as per followings:

a. On Front and Top:

- (1) Consignee Address.
- (2) Contract No and date.
- (3) Description of Stores Packed and NSN/Patt No.
- (4) Stowage / Stacking Instructions.
- (5) Quantity of the Item packed.
- (6) Signature along with stamp of Packaging Manager/ rep of firm.

b. On Back:

- (1) Manufacturers name / Firm's name.
- (2) Voucher No. or Inspection note no. and date.
- (3) The No. of individual Package and the total No of Packages in the consignment joined by the word 'of 'e.g. 2 of 300.
- (4) Weight of the package.
- (5) Month and year of packing.
- (6) Destination i.e. Railway station/ (Navy).

0120. **DELIVERY**

1. The consignment of store will be delivered in accordance with the terms of contract.

2. The store shall be delivered in Brand new, clean and dry condition.

3. The contractor/ manufacturer is fully responsible for the safety of the supplies during inspection, stage inspection, storage at firm's and consignee premises, proper packing, dispatch and delivery up to consignee.

XXXXXXSDXXXXX

BURHAN AHMAD
Captain Pakistan Navy
DID

Annexes:

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TERMS & DEFINITIONS

- a. **CINS:** Chief Inspector of Naval Stores
- b. **ITD Wing:** Indigenous Technical Development (Wing)
- c. **NS Dte:** Directorate of Naval Store
- d. **NRDI:** Naval Research and Development Institute
- e. **PNCSD:** Pakistan Navy Clothing Store Depot
- f. **PNCTA:** Pakistan Navy Central Testing Authority
- g. **Inspector:** The term inspector shall include the "inspection Authority", inspecting officer and their representatives, duly authorized for the purpose of discharging inspection duties involved.
- h. **Inspection Authority:** Chief Inspector of Naval Stores (CINS). His verdict in respect of Sealed Inspection matters is to be taken as final.
- j. **Inspecting Officer:** An officer nominated by the CINS for carrying out inspection of stores supplied by the supplier, against a specified contract or order, in accordance with the particulars stipulated therein.
- k. **Acceptance Quality Level (AQL):** It represent allowable limit/ tolerance of defects or non-conformities in an offered store/ lot/batch. It represent in percentage, also known as Allowable Quality Limits.

ANNEX B TO
PN SPECIFICATION NO 07/2021
PROMULGATION DATE 18 JUN 21

TECHNICAL DETAILS FOR SOCK COTTON BLACK AND WHITE

S NO	ITEM	STANDARD/METHOD	RESULTS	
	MATERIAL SPECIFICATIONS			
1.	Fiber Content a. Cotton b. Polyester c. Spandex/Lycra	AATCC-20A	75% ± 2% 20% ± 2% 5% ± 2%	
2.	Color a. Black b. White	ISO 105J03	19-4006 TCX Berger Value 125 ± 5%	
3.	Thread Count a. Course(top to toe) b. Wales	ISO-7211/2	481 ± 1 108 ± 1	
4.	Linear Density a. Cotton b. Polyester	ISO-7211/5	24/2 ± 1 Ne 177 ± 1 Denier	
5.	No. of needles	ISO-7211/2	108 ± 5	
6.	Weight per pair	Visual analysis	64 ± 5 gm	
7.	Nature of dye a. Black b. White	Chemical analysis	Reactive+Disperse dye Bleached	
8.	Finish	Chemical analysis	Anti-bacterial finish	
	PERFORMANCE TESTING			
1.	Appearance after 3 Laundering (3A)	BS EN ISO 6330	Satisfactory	
2.	Dimensional Stability after 3 machine washing (3A) and flat drying a. Foot b. Leg Ribbed portion	BS EN ISO 6330	Length ±5% ±5%	Width ±5% ±5%
3.	Pilling Resistance (face part) after 2000 cycles	ISO 12945-2	Grade= 3 or better	
4.	Abrasion (Socks face part) 3000 cycles	ISO 12947	No thread break	
5.	Color fastness to Perspiration for black a. Color change b. Staining i. Wool ii. Acrylic iii. Polyester iv. Nylon v. Cotton vi. Acetate	ISO 105 E04	GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5	

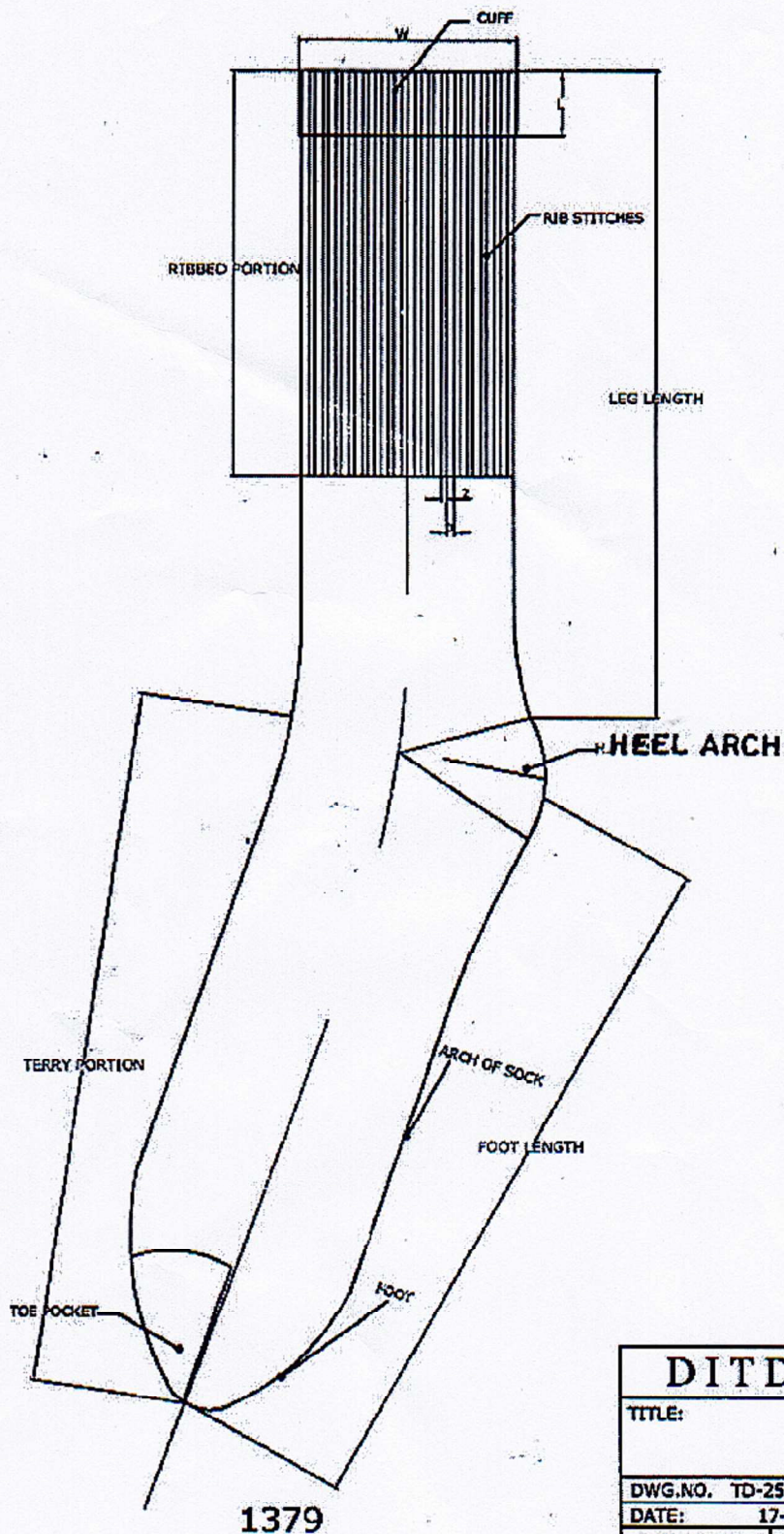
6.	Colorfastness to washing C03 for black a. Color change b. Staining i. Wool ii. Acrylic iii. Polyester iv. Nylon v. Cotton vi. Acetate	ISO 105 C03	GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5	
7.	Color fastness to Seawater for black a. Color change b. Staining i. Wool ii. Acrylic iii. Polyester iv. Nylon v. Cotton vi. Acetate	ISO 105 E02	GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5 GS=4/5	
8.	Color fastness to Crocking for black a. Dry b. Wet	ISO 105-X12	GS=4/5 GS=4/5	
9.	pH level (22.8°C)	ISO 3071	4-5	
10.	Air Permeability a. Leg side (mm/sec) b. Foot side (mm/sec)	ISO-9237	870 ± 20 1010 ± 20	
11.	Absorbency a. Leg side b. Foot side	AATCC 79-2010	Front 02 ± 1 sec 02 ± 1 sec	Inner 02 ± 1 sec 02 ± 1 sec
SUSTAINABILITY				
1.	Color fastness to Bleach	ISO 105-NO1	GS=4/5	
2.	Color fastness to Non-Chlorine Bleach a. Powder b. Liquid	ISO 105-NO2	GS=4/5 GS=4/5	

ANNEX C TO
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MEASUREMENTS AND DIMENSIONS

S NO	DESCRIPTION	MEASUREMENT In mm
a.	Cuff (1) Width (2) length	85 22
b.	Leg Length	240
c.	Rib Portion (1) Length	180
d.	Foot Length (Terry Portion)	270
e.	Toe Pocket (1) Length (2) Width	50 90

ANNEX D TO
PN SPECIFICATION NO 07/2021
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NOTE:
FOR FURTHER DETAILS SEE STOCK/APPROVED SAMPLE

DITD KARACHI		
TITLE: SOCK		
DWG.NO. TD-2572/2020	DIMENSIONS: mm	
DATE: 17-03-2021	SCALE: NTS	
DRAWN BY HDM M. ASGHAR I/c DWG.	CHECKED BY Fov LT SANA KANWAL SO, TEXTILE	APPROVED BY CAPTAIN BURHAN AHMAD DITD

GENERAL DEFECTS
(ASTM D-3990)

<u>S. No</u>	<u>Defects</u>	<u>Definition</u>
<u>FABRIC</u>		
a.	Abrasion Mark (bruise, Chafe Mark or rub) :	An area of fabric damaged by friction Damaged due to abraded or uneven surface in a machine
b.	Barré Mark:	An unintentional, repetitive visual pattern of continuous bars and stripes usually parallel to the filling of woven fabric or to the courses of circular knit fabric. Barré can be caused by physical, optical, or dye differences in the yarns, geometric differences in the fabric structure, or by any combination of these differences.
c.	Blotch	An off colored area of any shape caused by grease or Oil. (Syn. oil spot). Cause due to leakage/slippage .from machine.
d.	Bow	A fabric condition resulting when filling yarns or knitting courses are displaced from a line perpendicular to the selvages and form one or more arcs across the width of fabric.
e.	Broken filament	In multifilament yarn, breaks in one or more filaments.
f.	Float	In woven fabrics, the portion of a weft or filling yarn the extends unbound over two or more weft or filling yarns, in knitted fabrics, that portion of a yarn that is not knitted into loops.

g.	Frosting	A change in color in a limited area of fabric caused by abrasive wear.
h.	Hole	In fabric, imperfection, wear one or more yarn or sufficiently damaged to create an aperture.
j.	Fuzzy	Characterized by a hair appearance due to protruding broken fibers or filaments.
k.	Messiness	Surface distortion in a fabric characterized by objectionable unevenness due to many minor deformations.
l.	Pin Hole	In fabric, a very small hole, approximately the size of the cross section of the pin.
m.	Shiner	A streak, usually short caused by a lustrous section of filament yarn.
n.	Skew	A fabric condition resulting when filling yarns or knitted course are angularly displaced from a line perpendicular to the edge or side of the fabric.
p.	Snag	In fabrics, a yarn or part of a yarn pulled or plucked from the surface.
q.	Thin Place	In fabric, an intentional in a fabric appearance characterized by a small area of loosely placed yarn or by a congregation of thin yarn as compared to the adjacent construction.

ANNEX F TO
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ACCEPTABLE QUALITY LEVELS (AQL)

1. Acceptable Quality Level (AQL) is maximum average defective items in a lot or limit / percentage of defective items in product /offered store. It is expressed in a percentage. Number of average defective items is determined by following formula:

$$\text{Average defective item} = \frac{\text{No.of defective item found during inspection}}{\text{Total no.of item to be inspected}} \times 100$$

2. AQL process: it is used for inspection of finished product by the QC professionals. AQL standard is depend on the quality of the product to be inspected, random sampling, and experience of inspector. Normally lower figure AQL standard e.g. 01% is used for high quality products and high figure AQL standard e.g. 10% for low quality product. AQL standard 2.5% means that allowable limit of defective item is 2.5 % of total items inspected .Usually AQL 2.5% is used for major defects, AQL 4.0 % is used for minor defects and AQL 6.5% is used for slight defects, however zero acceptance for critical defects Allowable limit of Major defects are less than minor defects and it depends upon nature of item /offered store. It can be less than 01% or greater than 10%. .Following AQL table is used to determine lot size/ offered store quantity, least No. of sample to be inspected, AQL %, and acceptance & rejection points:

<u>SINGLE SAMPLING PLAN FOR NORMAL INSPECTION OR AS PER ORDER OF INSPECTING OFFICER.</u>											
Lot size	Least No. of sample to be Inspected	Allowable Quality levels(AQL) %									
		<ul style="list-style-type: none"> Acceptable/ Allowable defective sample (Ac) Rejected /Exceed allowable limit of defective item (Re) 									
		1.5%		2.5%		04%		6.5%		10%	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
281-500	20-80	1-3	2-4	1-5	2-6	2-7	3-8	3-10	4-11	5-14	6-15
501-1200	32-125	1-5	2-6	2-7	3-8	3-10	4-11	5-14	6-15	7-21	8-22

1201-3200	50-200	2-7	3-8	3-10	4-11	5-14	6-15	7-21	8-22	10-21	11-22
3201-10000	80-315	3-10	4-11	5-14	6-15	7-21	8-22	10-21	11-22	14-21	15-22
10001-35000	125-500	5-14	6-15	7-21	8-22	10-21	11-22	14-21	15-22	21	22
35001-150000	200-800	7-21	8-22	10-21	11-22	14-21	15-22	21	22	21	22
150001-500000	315-1250	10-21	11-22	14-21	15-22	21	22	21	22	21	22
500001-above	500-2000	14-21	15-22	21	22	21	22	21	22	21	22

3. If the inspector have time constrain then AQL is beneficial/ helpful in inspection of whole lot/ offered store. It safe time, cost and give effective/ statistical result of product /offered store **e.g.** If inspector needs 1 minutes to check the item , the quantity to be inspected is 50,000 items then it took 833 hours to check the whole consignment/ offered store.it means 35 days approx. for one store. Calculation is as follows:

$$\frac{1 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 50,000 \text{ items} = 833.33 \text{ hrs} \cong 35 \text{ days}$$

After Implementing AQL standard so the sample taken from the lot/ offered store is 1000 items/ sample:

$$\frac{1 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 1000 \text{ items} = 16.66 \text{ hrs} \cong 01 \text{ day}$$

4. Quality parameters/ AQL limits may be defined by Inspecting Authority (if deemed appropriate) and communicate to the manufacturer, so the manufacturer set their quality levels (AQL limits) accordingly for their internal audit. Therefore, good quality product is ready for inspection.

FEED BACK FORM

Unit Name: _____

Item Description#: _____

Issue/Problem occurred: _____

PN SPEC #: _____

Possibility to resolve Issue: _____

Any Other Remarks: _____

Note:

- It's good to give feedback for improvement in any clothing Item.
- Recurring problem will also be intimated through this form.

Name Stamp

COUNTERSIGNED By CO/Admin Authority

Name Stamp

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