



PAKISTAN NAVY SPECIFICATION 04/2021
PROMULGATION DATE: 06 MAY 21

CAP BERET

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Prepared by:

Directorate of Indigenous Technical Development
Naval Headquarters, NSSD,
West Wharf Road
KARACHI

Tel: 021 48508410
Fax: 021 99214765

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 G. 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

[illegible]

0101 **DESIGNATION**

1. Cap Beret

0102 **USAGE**

1. These Cap Beret (Black, Blue, Maroon and Red) will be used by Officers, CPOs/Sailors of General Service, Pak Marines SSG (N) and PN Provost Personnel, respectively.

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 DNS. This specification supersedes and replaces PN Specification No ITD/SPEC/Cap Beret/Black/01/10. Dated 18 Sep 09, PN/UNIFORM/10/2002 for Cap Beret (Navy Blue) and PN/UNIFORM /11/ 2002 for Cap Beret (Maroon colour), Promulgated earlier in relation to the item mentioned herein. These specifications are based on sample approved by Dress Committee.

1. This specification booklet includes 07 Annexes and consists 23 pages, including the cover.

0104 **SCOPE**

1. This specification covers the technical/ manufacturing requirements of Cap Beret (Black, Blue, Maroon and Red) to be used by Officer, CPOs/Sailors of General Service, Pak Marines, SSG (N) and PN Provost Personnel with relevant uniforms. 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. | ASTM D 4850 | Standard terminology related to Fabric and Fabric test. |
| c. | ASTM D 3776 | Test method for mass per unit Area (Weight) of fabric. |
| d. | ASTM D 1777 | Test method for thickness of Textile |
| e. | ISO 72112 | Number of treads per unit length |

| | | |
|----|-------------|---|
| f. | ISO 7211/5 | Determination of linear density of yarn removed from fabric. |
| g. | ISO 105-E01 | Colour fastness to water. |
| h. | ISO 105 E02 | Colour fastness to sea water |
| j. | ISO 105 E03 | Colour Fastness to Chlorinated Water (Swimming Pool) |
| k. | ISO 105 E04 | Colour Fastness To Perspiration |
| l. | ISO 105 J03 | Method for Calculating a Colour Difference |
| m. | P-SC/ 432 | Tape Textile Silk Corded 25mm wide. |
| n. | P-SG/ 913 | Naphthalene |
| p. | BS 4736 | Determination of Dimensional Change of Fabrics induced by Cold Water Immersion. |

0106 **TERMS & DEFINITIONS**

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

0107 **TECHNICAL DETAILS OF CAP BERET**

1. The Technical Details of Cap Beret are mentioned at Annex B of this specification.

0108 **SCHEDULE OF MEASUREMENT**

1. All measurement schedule of Cap Beret is given at Annex C.

0109 **DRAWINGS**

1. All dimension of drawing is given at Annex D

0110 **GUIDE LINE FOR BERET MANUFACTURING**

1. The beret shall be fabricated from the materials detailed at Annex B
2. The Berets shall be knitted from 100 percent pure Merino Wool 13-14 skeins on machine set to 144 needles and made to the design and shape of the respective Drawings/ sealed pattern.
3. The process of milling shall be approximately of two hours duration. The fabric of berets shall be slightly sheared and have a firm cloth finished.
4. The Berets shall be lined with Artificial Silk Jet Black conforming to Pantone shade.
5. The lining at the crown shall be in one piece and at the bevel shall be in two pieces as shown in the Drawing /Sealed Pattern.

6. The crown of Berets shall be circular in shape and the diameter measurements shall be in proportion to the (Head) size as per Annex C.

7. The finished dimensions of Bow shall be 32 mm in length, 12.5 mm in width, and 6mm width of binding loop. The Tape, Textile Silk Corded 25.4mm wide black shall be folded so as the selvages join at the center and are secured by hand stitching. The Binding loop shall be made by folding Tape Textile Silk Corded 25.4mm and attached by center of the Bow.

8. The dimensions of Pad for retaining Cap Badge shall be 57mm in length, 38mm in width at the top and 25.4mm wide at base. The corners of the Pad at top shall be rounded off.

9. The Berets shall be fabricated with machine stitching using sewing Thread Polyester 2/31.5Tex Jet Black regulated at not less than 9-12 stitches/ 25.4mm.

10. Metallic Air Vents (02) shall be used at right side of cap badge pad as per Drawing/ sealed pattern.

11. External / internal audit may be conducted of items (Beret) by manufacturer / firm through any reliable resource.

NOTE: Certificate of Merino Wool shall be provided to Inspectors of CINS.

0111. **QUALITY OF WORKMANSHIP AND FINISHING**

1. The Workmanship and finish of Beret shall be equal to sealed pattern. It shall be best of class and to the entire satisfactory of the Inspector. It shall be the best of its class and to the entire satisfaction of the INS.

0112. **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. However, any test considered important by inspecting Authority other than Annex B i.e Bursting Strength of Beret Fabric, linear density and tear strength of lining etc. Firm is liable to pay all the testing charges.

0113. **DRAWING OF BERET SAMPLES FROM LOTS/BATCHES**

1. No of samples drawn from bulk quantity for inspection/ testing are as per instruction of Inspecting Officer 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 |

0114. **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. | Beret | 05 x samples of each colour |
| b. | Tap Textile Silk Corded 25mm Wide | 18 Meters |
| c. | Sewing Thread Polyester 2/31.5 Tex | 01 Tube |
| d. | Artificial Silk | 03 Meters |
| e. | Rexene | 0.5 Meters |
| f. | Carton Card Board | 02 Nos |
| g. | Naphthalene Balls | 01 Kg |

0115. **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 ten samples along with samples of accessories/ materials 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.

0116. **INSPECTION**

1. Bulk representative sample (B/R) random sampling will be carried out as per rules in vogue.
2. Beret 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 Beret.** The guidelines for Inspector w.r.t general defects are defined at Annex E.
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 Standing Order.
5. INS reserves the right to reject the whole supply in case, upon examination, material or packing of any sample or portion of the consignment is found NOT CONFORMING the parameters laid down in this specification or the quality of product does not seems up to the mark.
6. 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.
7. All stores and packing NOT fully in accordance with this specification shall be rejected.
8. **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.
9. **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).
10. **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.

11. **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.

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

0117. **SPECIAL INSTRUCTIONS**

1. **Care Label Instructions.** Beret are capable of being cleaned by using conventional means to maintain appearance. Following care instructions in the form of leaflet OR attached with Beret shall be provided in English and Urdu :

- a. To be washed/ rinsed delicately
- b. Warm/ hot water not to be used for washing
- c. Delicate clean method with mild soap /detergent solution to be adopted whenever required
- d. Stain removing bleach should be avoided.
- e. Ironing on beret should be avoided.
- f. Direct contact of sunlight should be avoided.

0118. **PACKING AND PRESERVATION DETAILS**

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

- a. **Preservation.** 57gms of Naphthalene balls (i.e about 18 numbers) shall be distributed evenly in each carton.
- b. **Packing** The store when ordered to be delivered 'PACKED' shall be distributed evenly in each carton.

(1) Each Cap Beret will be packed in Polythene bag.

(2) 50 Beret will be packed in card board carton which in turn will be packed in 0.127mm polythene sheet/ bag

(3) Each package shall contain one size only.

(4) Packing, marking and preservation will be done by the supplier as per specification and with adhesive tape of 10cm width of the best quality.

(5) The binding and wiring of the carton card board shall be done in accordance with the instructions of the Inspecting Officer.

- 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.

0119. **IDENTIFICATION LABEL**

1. Each Beret shall bear following clear and indelible information on Main Label attached at inside of Crown of Beret:

- 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.

0120. **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.

0121. **MARKING OF STORES**

1. Each Beret shall be clearly and indelibly marked with contractor's name, initial or recognized trade mark, the year of manufacture, Cat No Designation and size.

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).

0122. **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
DITD(S)

Annexes:

| | |
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| A. Terms & Definitions | 9 |
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ANNEX A TO
PN SPECIFICATION NO.04/2021
PROMULGATION DATE 06 MAY 21

TERMS & DEFINITIONS

- a. **CINS:** Chief Inspector of Naval Stores
- b. **DITD :** Directorate of Indigenous Technical Development
- c. **DNS:** Directorate of Naval Store.
- d. **PNCSD:** Pakistan Navy Clothing Store Depot
- e. **PNCTA:** Pakistan Navy Central Testing Authority
- f. **Inspector:** The term inspector shall include the "inspection Authority", inspecting officer and their representatives, duly authorized for the purpose of discharging inspection duties involved.
- g. **Inspection Authority:** Chief Inspector of Naval Stores (CINS). His verdict in respect of Sealed Inspection matters is to be taken as final.
- h. **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.
- j. **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 04/2021
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TECHNICAL DETAILS OF CAP BERET

| <u>S NO</u> | <u>ITEM</u> | <u>REQUIREMENTS</u> |
|--------------------|--|---|
| a. | Color Pantone Shade 1) Black 2) Maroon 3) Blue 4) Red | 19-4006 TCX 19-1724 TCX 19-3924 TCX BCC 210 or equivalent Pantone Shade |
| b. | Body of Beret 1) Material 2) Quality of wool 3) Weight of Knitted Body 4) Nature of Dye 5) Light Fastness 6) Washing fastness (Test no 2) 7) Perspiration 8) Dry Cleaning 9) Water wash | 100% pure Merino wool 60 ^s -64 ^s 593 GSM Chrome or 1:2 Metal Complex GS 4 or better GS 4 or better GS 4 or better GS 4 or better GS 4 or better |
| c. | Dimension stability (Wool shrinkage) | 2% max |
| d. | Lining of Beret 1) Material 2) Weave 3) Color 4) Washing 5) Perspiration 6) Sea Water 7) Water 8) Nature of Dye 9) Weight (GSM) | Artificial Silk. Satin 19-4006 TCX GS 4 or better GS 4 or better GS 4 or better GS 4 or better Disperse dyes 60± 2 grams |
| e. | Binding | Tape textile Silk Corded 25 mm wide |
| f. | Thread for stitching 1) Material 2) Colour 3) Linear Density 4) Direction of Twist 5) Breaking Strength 6) Nature of Dye | Polyester Matched with binding /Tape 2/31.5 TEX S/Z 4.92 Lbs (2.23 Kg) Disperse Dyes. |

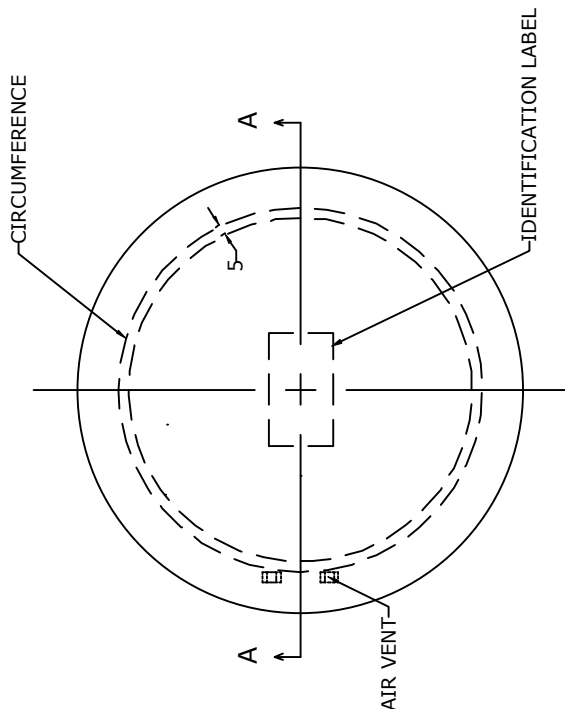
| | | |
|----|--|-------------------------------------|
| | 7) Stitch/inch (2.54cm) | 9-12 |
| g. | Pad for Retaining Cap Badge 1) Material 2) Thickness | Rexene of best trade quality 1mm |
| h. | Eyelets | Metallic (Stainless Steel/ Brass) |

ANNEX C TO
PN SPECIFICATION NO 04/2021
PROMULGATION DATE 06 MAY 21

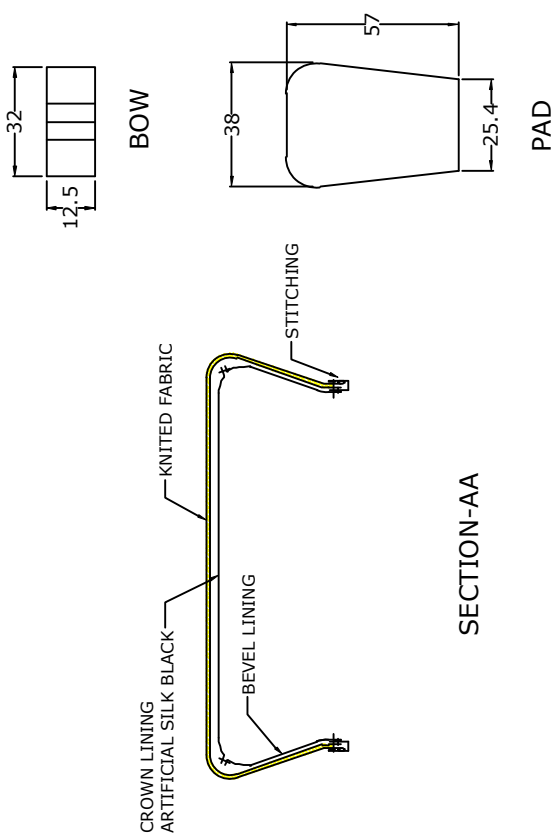
SCHEDULE OF MEASUREMENTS

| S.No | Size No. | Circumference (Internal) in Cm | Diameter in Cm |
|------|----------|--------------------------------|----------------|
| 1. | 6-1/4 | 50 | 23.5 |
| 2. | 6-1/2 | 52 | 24.1 |
| 3. | 6-3/4 | 54 | 24.8 |
| 4. | 7 | 56 | 25.4 |
| 5. | 7-1/4 | 58 | 26.0 |
| 6. | 7-1/2 | 60 | 26.7 |
| 7. | 7-3/4 | 62 | 27.3 |

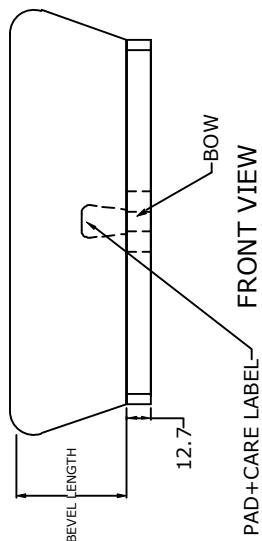
Annex D To
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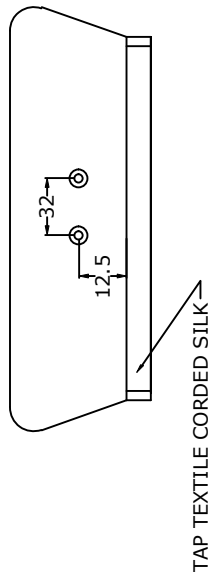
TOP VIEW



SECTION-AA



FRONT VIEW



SIDE VIEW

| | | | |
|------------------|--------------|-------------------------|-------------|
| DITD KARACHI | | | |
| TITLE: CAP BERET | | | |
| DWG.NO. | TD-2554/2021 | DIMENSIONS: | mm |
| DATE: | 08-02-2021 | SCALE: | NTS |
| DRAWN BY | -- SD -- | CHECKED BY | -- SD -- |
| HDM | M. ASGHAR | LT | SANA KANWAL |
| I/c DWG. | | SO. | TEXTILE |
| | | CAPTAIN BURHAN AHMAD PN | |
| | | DITD | |

NOTE:
FOR FURTHER DETAILS SEE STOCK/APPROVED SAMPLE

ANNEX E TO
PN SPECIFICATION NO 04/2021
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COMMON DEFECTS

| <u>S.No</u> | <u>Defects</u> | <u>Possible Cause</u> | <u>Type of Defects</u> <u>Major/Minor</u> |
|--------------------|---|---|--|
| 1. | <u>FABRIC</u> | | |
| a. | Barre: horizontal stripes of uniform or variable width in Fabric or periodic lateral irregularity | <ul style="list-style-type: none"> • Possible due to lower tension in one of the feeders, loops formed in the knitted cycle initiated by that particular feeder were slightly larger than the rest thus causing an embossed appearance in the form of stripes. • Individual yarns differ w.r.t count properties or structure. • Different course Length. | Major |
| b. | Skewed fabric: The shape of the fabric is distorted. Wales and courses are angular. | <ul style="list-style-type: none"> • This can be a result of uneven take down roller setting. It is a generic feature of circular knits because of the spiral movement of the needles. | Within allowable limit then minor otherwise major. |
| c. | Foreign Fly between loops of constructed fabric | <ul style="list-style-type: none"> • Unclean environment or improper maintenance of machine can cause fly to end up in the knitting zone where it becomes part of the fabric. | Major if it is visible. |
| d. | Thin Yarn/ Thick yarn | <ul style="list-style-type: none"> • One of the feeder is receiving yarn from a spool that has finer yarn or coarser yarn. | Major |
| e. | Horizontal band of different color | <ul style="list-style-type: none"> • This happens due to a change of bobbin in the knitting machine. Different lots of yarn can have slight shade variations which can produced shade differences in fabric. | Major |
| f. | Laddering: Vertical stripes can be observed as longitude lineal gap in fabric | <ul style="list-style-type: none"> • Continued knitting with a broken needle. • Incorrect closing of the hook by the latch. • Shift latches and needles. • | Major |
| g. | Deliberate cut placed in fabric | A rib defect occurred during knitting which was detected by QC who placed a cut on the defect to ensure that the garment does not go through further stages. | Major |
| h. | Hole: Crack of yarn or breakage | <ul style="list-style-type: none"> • High yarn irregularity, poorly lubricated yarn, weak knot or slub present in yarn. | Depend upon the size. If it's visible and larger in size then its major. |

| | | | |
|-----------|---|--|--|
| | | | |
| 2. | PRE-TREATMENT | | |
| a. | Pinhole | <ul style="list-style-type: none"> The presence of Fe^{2+} ions accelerates peroxide bleaching. If the fabric has just residue on it or localized iron contamination the bleaching process will damage the fibers causing a hole. | Depend upon the frequency of the fault, if it occur frequently then its major. |
| 3. | DYEING | | |
| a. | Shade difference | <ul style="list-style-type: none"> This occur due to the variation in dye or dyeing procedure. Improper cutting of pieces, bundling and numbering. Different batch mixing. | Major |
| b. | Stain of oil, food, drink, ink etc. | <ul style="list-style-type: none"> This occur due to spill of oil, ink, food, drinks on the garment. | If it is easily washable then minor. |
| | 4. STITCHING | | |
| a. | Seam puckering: gathering of a seam either just after sewing or after laundering. | <ul style="list-style-type: none"> Due to uneven stitching on to plies of fabric, improper thread tension, wrong sewing thread etc. | Minor when it is not visible |
| b. | Open Seam or broke seam: Portion of garment that has not been covered by sewing thread. | <ul style="list-style-type: none"> Due to improper handling of the part/ piece of fabric, improper setting and timing between needle and looped or rook etc. | Major |
| c. | Broken Stitch: Non continuous Sewing thread | <ul style="list-style-type: none"> Due to improper timing or machine usage. | Minor |
| d. | Drop stitched/ skipped Stitched Irregular stitching along the seam | <ul style="list-style-type: none"> It appears due to improper handling of cut pieces or machine usage. | Minor |

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 / garment by the QC professionals. AQL standard is depend on the quality of the product to be inspected, random sampling, and experience of inspector. 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 5 minutes to check the item , the quantity to be inspected is 2,500 items then it took 208 hours to check the whole consignment/ offered store.it means 26 days approx. for one store. Calculation is as follows:

$$\frac{5 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 2,500 \text{ items} = 208.33 \text{ hrs} \cong 26 \text{ days}$$

After Implementing AQL standard so the sample taken from the lot/ offered store is 200 items/ sample:

$$\frac{5 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 2,00 \text{ items} = 16.66 \text{ hrs} \cong 02 \text{ days}$$

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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PN SPECIFICATION 04/2021