



PN SPECIFICATION NO 02/2019

PAKISTAN NAVY SPECIFICATION 02/2019

PROMULGATION DATE: **23 April 2019**

SHOES BLACK LEATHER **OXFORD STYLE**

Prepared by:

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AMENDMENT RECORD

Amd No	Date	Text Effected	Signature and Date

REVISION NOTE

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 F. However, such an alternation 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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1. **DESIGNATION**

1.1. Shoes Black Leather Oxford Style.

2. **USAGE**

2.1. These shoes will be used by Officers and CPOs/ Sailors for general purpose.

3. **INTRODUCTION**

3.1. 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 Directorate. However, it cannot be implemented without prior approval of DNS. This specification supersedes and replaces PN Specification PN/SPECS/SHOES BLACK/01/08 and ITD/SPECS/SHOES BLACK LEATHER OFFICERS/03/09 issued earlier in relation to the item mentioned herein. These specifications are based on sample approved by Dress Committee.

3.2. This specification booklet includes 06 Annexes and consists 21 pages, including the cover.

4. **SCOPE**

4.1. This specification covers the technical/ manufacturing requirements of Shoes Black Leather Oxford Style to be used by Pakistan Navy. It defines and lays down the quality, standard and details of materials, workmanship and finish. It also lays down briefly the requirement of sampling, testing, inspection/ rejection, marking, preservation, packing and delivery etc.

4.2. 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.

5. **RELATED DOCUMENTS**

5.1. The standards and documents that have been referred to in this specification are:

- | | | |
|----|-----------------|--------------------------------------------------------------------------|
| a. | AATCC-20 | Determination of fiber quality. |
| b. | ASTM E- 478 | Standard test method for chemical analysis of Copper alloys. |
| c. | D2240-04 | Test method for Rubber Property- Durometer Hardness. |
| d. | BS ISO 1817 | Rubber Vulcanized. Determination of effect of liquid. |
| e. | SATRA TM 92 | Resistance of footwear to flexing. |
| f. | SATRA STD 185 | Sole Adhesion tester. |
| g. | SATRA TM77 | Flexing Machine- Water Penetration test. |
| h. | SATRA STM 461 | Circular Rub Fastness Tester. |
| i. | BS ISO EN 20344 | Abrasion resistance of insole and in sock. |
| j. | ISO 3377-2 | Tear strength of upper or lining for leather. |
| k. | ISO 4674 – 1 | Tear strength of upper or lining for textile and coated fabric method B. |

- m. ISO 17131 :2012 Leather – identification of leather with microscopy.
- n. ISO 1833 Textile – Quantitative chemical analysis.
- o. ISO 3801 Determination of mass per unit length and area.
- p. ISO 7211/2 Determination of number of threads per unit length.
- q. ISO 7211/5 Determination of linear density of yarn removed from fabric.
- r. ASTM D 2810-13 Standard test method for pH of Leather.
- s. ASTM D 3970-17 Standard test method for volatile matter (moisture) of leather by oven drying.
- t. ISO 10195: 2018 Leather – Chemical determination of Chromium (VI) content in leather.
- u. ASTM D 523 Standard test method for Specular gloss
- v. ISO 3377-2 Leather - Determination of tear load.
- w. ISO 4674 – 1 Rubber or plastic – coated fabrics- Determination of tear resistance. Constant rate of tear method.
- x. ISO 13934-01 1999 Textile- Determination of maximum force and elongation at maximum force using the strip method.
- y. ISO 13937-01 1999 Textile- Determination of tear force using ballistic pendulum method (Elmendorf).

6 TERMS & DEFINITIONS

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

7 TECHNICAL DETAILS OF SHOES BLACK LEATHER OXFORD STYLE

7.1. The Technical Details of Shoes Black Leather are mentioned at Annex B of this specification.

8. MANUFACTURING DETAILS OF SHOES BLACK LEATHER OXFORD STYLE

8.1. LAST

8.2. All sizes of last should be equal to the one mentioned at Annex C to this specification. While manufacturing the shoes a hard material of 3.2 mm thick is to be added on the bottom of the last in order to provide a space for inserting a detachable sock.

8.3. The suppliers/ manufacturer must intimate the size roll of the last/ moulding foot in their possession conforming to the specified particulars and must get representative samples of Last approved by the Inspecting Authority before commencing manufacture.

8.4. Details of dimensions of the specified last of various sizes i.e. from 04 to 13 are given at Annex C of this specification.

- 8.5. **CONSTRUCTION** Shoe Black leather shall be of Oxford style with separate toe and shape as shown in drawing attached at Annex D.
- 8.6. Measurement details of height of upper are indicated as Annex C of this specification.
- 8.7. The thermoplastic toe cap shall be incorporated in the footwear in such a manner that they cannot be removed without damaging the footwear. Thermoplastic Toe cap shall be as per dimension mentioned at Annex C to this specification.
- 8.8. Leather used in making upper shall be of good quality full Chrome Cow corrected Leather. The minimum thickness of various components of upper should be as that mentioned in Annex B of this specifications.
- 8.9. Lining used in vamp shall be of suede / soft leather with interlining of drill cloth and are bonded to the thermo plastic toe cap.
- 8.10. Good quality Polyester laces with plastic tip should be used.
- 8.11. Insole should be permanently attached and it shall not be possible to remove it without damaging the footwear. Full socks made up of EVA sheet covered with Rexene, which could be detachable and washable.
- 8.12. All seams should be properly hammered off and all loose ends secured properly.
- 8.13. The upper components shall be properly skived and fitted. Skiving on the grain side is prohibited.
- 8.14. The upper components shall be closed by lock stitching.
- 8.15. Five pairs of Eyelets of Brass Black shall be fitted on each side / facing which will clinch properly without being distorted or de-shaped.
- 8.16. The counter stiffeners shall be skived properly so that no ridge is formed in the finished shoes. They shall be reinforced and made hard.
- 8.17. The insole shall be properly feathered, snuffed and moulded to the bottom shape (contour) of the last.
- 8.18. The shoes shall remain on the last at least for 24 Hours.
- 8.19. The vulcanization of sole to the upper shall be done by high-pressure type Moulding Machine, provided with the thermo-regulated heater in bottom and the two sided moulds Pressure control/gauge and auto time controlling devices. A piece of compounded Rubber cut to the approximate shape of the sole and correct height for the size of the Mould known as sole Mould in the machine. The Blank may be pre-heated in a cabinet upto desired temperature immediately before moulding.
- 8.20. Flash and spew on edge of the moulding last and the surplus material on the sole and heel shall be properly trimmed off/removed.

8.21. A Spare pair of laces round polyester with plastic tip 38 inch shall be supplied with each pair of shoes. Finish of tips shall be good.

8.22. The vamp shall not develop wrinkles after pressing.

8.23. Edges of collar are manufactured from turning/folding of upper leather. No binding shall be used on edges.

Note: Usage of nails in manufacturing of shoes Black Leather shall be strictly prohibited.

9. **QUALITY OF WORKMANSHIP AND FINISHING**

9.1. Workmanship and finish of the shoes shall be equal to the sealed sample. It shall be best of its class and to the entire satisfaction of the inspector. Sealed/ Approved sample is either held with DNS/ CINS or accepted/approved from bulk supply held with CINS.

10. **TESTING**

10.1. The material shall be subjected to tests laid down in this specification at Annex B and related documents. At least two pair of shoes of same or different sizes will be required to complete relevant tests mentioned at Annex B of this specification. The material may also be subjected to such tests which are deemed necessary by the inspection authority in order to determine their suitability. Inspecting Authority reserves the right to get the B/R samples tested from any reputable Laboratory other than PN. However, any test considered important by Inspecting Authority other than Annex B may also be conducted in order to check its suitability.

11. **TENDER SAMPLE**

11.1. Tender sample to be approved by TSR Committee

11.2. For each contract following material shall be supplied by the manufacturer at the time of tendering.

i. Shoes (Black Leather)	05 in No.(two different sizes)
ii. Manufacturing last	One pair
iii. Pattern (cut component complete set)	One set of same size
iv. Leather for uppers	1' x 1' (02 pieces)
v. Thread for upper closing	50 gms
vi. Eyelets	06 in number
vii. Laces	02 in Nos.
viii. Lining Material	02 meters
ix. Sole	02 Pairs (two different sizes)
x. Socks	02 Pairs (two different sizes)
xi. Insole	02 Pairs (two different sizes)
xii. Toe puff and counter Stiffener	02 Pairs (two different sizes)

12. **ADVANCE SAMPLE**

12.1. Advance sample or pre-production sample, when required, shall be submitted in accordance with terms of the contract for inspection and testing as per Annex B, C and D and approved by CINS. The minimum quantities required are 03 pairs alongwith samples of materials used in manufacturing of Black Leather shoes for inspection as mentioned above.

12.2. 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 pairs, which ever are more alongwith samples of materials for inspection.

12.3. The approval of the sample mentioned in Para 11 & 12 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 after rectification of all observations highlighted by Inspecting Officer 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.

12.4. The Pre-production sample shall be manufactured by the manufacturer with the same facilitates which will be used for manufacturing of the bulk items.

12.5. Firm shall provide advance sample along with quality verification reports of shoes from an accredited laboratory.

13. **INSPECTION**

13.1. **Bulk representative sample.** B/R random sampling will be carried out as per rules in vogue.

13.2. **Bulk Inspection.** Bulk inspection will be carried out after satisfactory completion of Visual Examination and Testing of B/R Sample as per Annex B, C and D.

13.3. **Inspection of Shoes.** 100% of the offered store shall be inspected. The guide lines for such examination/inspection are listed at Annex E. Stage inspection of Shoes black leather may be carried out by CINS if deemed necessary.

13.4. **Inspection/ Acceptance and Rejection of Stores.** Inspection/ acceptance is to be carried out to the satisfaction of Chief Inspector Naval Stores.

13.5. The shoes shall be examined for the correctness of material, shape, design, dimension, size, workmanship and finish.

13.6. All shoes shall be inspected in pairs and shall be accepted and rejected as pairs. Defective lasting, mouldings and damages to upper and insoles during moulding are to be especially checked.

13.7. CINS 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 to this specification.

13.8. 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 material, pattern, dimensions, workmanship and finish, the whole consignment may be rejected without any compromise.

13.9. All stores and packing NOT fully in accordance with this specification shall be rejected.

13.10. Shoes with major defects as described in Annex E of this specification will be rejected.

13.11. **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.

13.12. **Replacement by the Contractor.** The supplier manufacture 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.

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

14. **STAMPING OF ACCEPTED/ REJECTED STORES BY THE INSPECTOR**

14.1. Following instructions are to be followed:

14.2. **Stamping of Accepted Stores.** The acceptable shoes shall be stamped with Inspector's Individual Acceptance Mark's. The stamping shall be legible.

14.3. **Stamping of Rejected Stores.** The rejected shoes shall be marked with Inspector's Rejection Mark's to avoid re-submission by the supplier.

14.4. The Inspector is the authority in all matters pertaining to inspection.

15. **SPECIAL INSTRUCTIONS**

15.1. **CARE LABEL INSTRUCTIONS** Shoes Black leather is capable of being cleaned by using conventional means to maintain smart & functional appearance. Following care instructions in the form of leaflet shall be provided in English and Urdu with each pair of shoe:

- Clean the shoes with a damp cloth using a solution of water and mild soap.
- To extend the life and maintain suppleness of the upper apply a shoe care product appropriate to the upper.

- The sole of shoes shall be cleaned frequently when feel necessary using conventional means to maintain smart and functional appearance.

Note: Firm shall provide usage warranty of one year at the time of inspection.

16. **PACKING DETAILS**

16.1. The store when ordered to be delivered 'PACKED' shall be packed as follows:

- The pair of shoes shall be packed in a wrapping paper in a neat, dry and clean condition. Each pair of shoe further packed in standard packaging card board shoe box as per drawing at Annex D.
- Ten pairs of Shoes of one size only shall be packed in a thick corrugated carton. Packing of mixed sizes shall be avoided and shall not be permitted.
- Each carton is to be closed by strong masking tape.
- The empty spaces if any shall be filled with suitable cushioning materials.
- Strapping shall be done in accordance with the instruction of Inspecting officer.
- The total weight of package shall not exceed 35kg.
- Each Box Board packing shall be securely and properly packed.

17. **IDENTIFICATION LABEL**

17.1. Size of shoe shall be embossed on sole as indicated in drawing at Annex D with contractors name and year of manufacture and batch no. on socks. Following minimum information shall be printed on the shoe box:

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

18. **PACKING LIST**

18.1. Firm is bound to provide a packing list of store offered for inspection alongwith the challan, which include complete details about the store i.e Pattern No. Description of store, size, quantity, contract No, and Date, Challan No. and Date. A packing list shall be enclosed after completion of inspection with each packed box giving full details about the stores packed i.e. Pattern No. Description of store, size, quantity, contract No, and Date, I/Note No. or voucher No. and date, consignee, Firms name, Date of packing and packer's signature.

19. **MARKING OF STORES**

19.1. In addition to any special marking required by contract or order, the marking of packages shall be stenciled with quick drying Black ink/ Paint in accordance with Specification No. NS/MISC/002/80 with clearly defined characters as described below:

- a. On Front and Top

- (1) Consignee Address.
- (2) Contract No and date.
- (3) Description of Stores Packed and NSN/Patt no.
- (4) Quantity of the Item packed.

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.

20. **DELIVERY**

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

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

20.3. The contractor/ manufacturer is fully responsible for the safety of the supplies during inspection, storage at firms premises proper packing, dispatch and delivery up to consignee.

XXXXXS D XXXXXX

ASIF ALI PIRZADA

Commander Pakistan Navy
Director ID

Annexes:

- A. Terms & Definitions
- B. Technical Details of Shoes Black Leather
- C. Measurements and Dimensions of Shoes Black Leather
- D. Drawings of Shoes Black Leather and Packing
- E. Guideline for Inspection – General Defects
- F. Feed Back Form

Distribution:

DP (N)

CINS

DNS

CO PNCSD

ANNEX A TO
PN SPECIFICATION NO.02/2019
PROMULGATION DATE 23 April 2019

TERMS & DEFINITIONS

1. **Inspection Authority.** Chief Inspector of Naval Stores (CINS). His verdict in respect of inspection matters is to be taken as final.
2. **Inspecting Officer.** An officer nominated by the Chief Inspector of Naval Stores (CINS) for carrying out inspection of stores supplied by the supplier, against a specified contract or order, in accordance with the particulars stipulated therein.
3. **Inspector.** The term inspector shall include the “Inspection Authority”, inspecting officer and their representatives, duly authorized for the purpose of discharging inspection duties involved.
4. **Sealed Pattern.** It denotes a pattern, sealed and signed by the Inspection Authority & held in his custody, and represents the standard of store in respect of materials, dimensions, design, workmanship and finish, etc. There is only one sealed pattern for each store, which cannot be removed from custody of the inspection authority.
5. **Girth** It is the circumference of the widest part of the toe

ANNEX B TO
PN SPECIFICATION NO.02/2019
PROMULGATION DATE 23 April 2019

TECHNICAL DETAILS OF SHOES BLACK LEATHER FOR OXFORD STYLE

S NO	ITEM	REQUIREMENT
	MATERIAL SPECIFICATIONS	
01.	Make, shape and design	Low shoe Oxford Style 05 Eyelets
02.	Color	Black
03.	Weight per pair of shoe	800-1200 gms approx. as per size
04.	Height of Upper	As per Annex C of this specs measured as per BS EN ISO 20345, 5.2.2
05.	<u>Upper</u>	
	(a) Toe/ Vamp	
	i. Material	Cow Corrected Grain Leather with high gloss finish
	ii. Thickness	1.4 – 1.6 mm
	(b) Quarter	
	i. Material	Cow Corrected Grain Leather with high gloss finish
	ii. Thickness	1.4 – 1.6 mm
	(c) Counter	
	i. Material	Cow Corrected Grain Leather with high gloss finish
	ii. Thickness	1.4 – 1.6 mm
	(d) Tongue	
	i. Material	Cow Corrected Grain Leather with high gloss finish
	ii. Thickness	1.2 – 1.4 mm
06.	Gloss % of upper leather	
	20 ⁰	0.1886
	60 ⁰	3.7892
	85 ⁰	3.9460
07.	<u>Lining Material</u>	
	(a) Vamp/Counter	
	i. Material	Soft suede leather
	ii. Thickness	0.5-1.0 mm
	iii. Color	Brown
	(b) Quarter/Tongue	
	i. Material	Rexene synthetic
	ii. Thickness	1.0-1.2 mm
	iii. Color	Brown
08.	<u>Interlining Material</u>	

	(a) Vamp and Quarter i. Material ii. Weave iii. Thickness iv. Color	Cotton Drill 0.5-1 mm Black
09.	Socks i. Material ii. Thickness	EVA + Rexene brown 2mm + 1mm
10.	Toe puff / Counter Stiffener i. Material ii. Thickness	Thermoplastic 1-1.2mm
11.	Stitching Thread i. Material ii. Count	Nylon 50/3
12.	Eyelets i. Material ii. Diameter	Anodized Brass Black Inner dia 3.5 - 4 mm Outer dia 7.5 - 8 mm
13.	Laces i. Material ii. Length iii. Diameter	Round Polyester black with plastic tip of 13-14 mm 38" 3-4 mm
14	Insole i. Material ii. Thickness	Two layers one is fibre board and one layer of cardboard box 1.75 - 2 mm and 3-3.3 mm
15.	Sole i. Material ii. Color iii. Thickness of fore part iv. Specific gravity	TPR (Thermoplastic rubber) Black 11 ± 1 mm 0.95 – 1.25
16.	Shank i. Material ii. Thickness iii. Dimension	Mild Steel 1mm 1.2 x 12 mm
PERFORMANCE TESTING		
1.	<u>Whole footwear</u> a. Slip resistance requirement b. Flexing Resistance after 80,000 cycles c. Water resistance	In accordance with STM 144 Steel Floor (Dry) Heel : 0.6 Toe : 0.6 Steel Floor (Water) Heel : 0.4 Toe : 0.4 No cracks observed on upper and sole The total wetted area inside the shoes

		shall not be greater than 3cm ² after 100 trough length or after 80 min
2.	Upper (a) pH value (b) Chromium VI content (c) Tear Strength (d) Tensile Strength (e) Circular rub fastness test after 50 cycles in wet and dry conditions (f) Wrinklometer test (g) Lasting test (Grain crack) (h) Moisture (j) Crack-ness of grain (k) Flexing (m) Oil and fats	Not less than 3.2 Not exceeding 3.0 mg/kg, 120 N/mm ² 21 N/mm ² No damage of leather Staining of dry felt or wet felt GS 4 2.00 mm 7 mm 10-16% Shall not crack on double folding Micro finish cracks after 30, 000 flexes 4 - 6%
3.	Vamp and Quarter Lining (a) pH value (b) Abrasion resistance i. 25000 cycles dry ii. 13000 cycles wet (c) Tear Strength	Not less than 3.2 Satisfactory 30 N/mm ² for leather and 15 N/mm ² for fabric
4.	Insole and In sock (a) pH value (b) Water absorption and desorption of insole as per BS EN ISO 20345:2011 (c) Abrasion Resistance i. 25000 cycles dry ii. 13000 cycles wet (d) Tensile strength (e) Flexing (Ross) Cycle i. Along 40,000 ii. Across 15,000	Not less than 3.2 Water absorption > 70 mg/cm ² Water desorption not less than 80 % Satisfactory 70kg/cm ² No cracking No cracking
5.	Out Sole (a) Upper/outsole Bond Strength At Toe At Heel (b) Hardness At Toe At Heel	19 kg Minimum 29 kg Minimum 70 -74 IRHD ± 2 70 -74 IRHD ± 2
6.	Laces (a) Abrasion resistance (b) Tensile strength	BS 953: 1979 clause 8, not less than 11,000 cycles BS 5131: Section 3.7, not less than 500N/mm ² .

ANNEX C TO
 PN SPECIFICATION NO.02/2019
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MEASUREMENTS AND DIMENSIONS
SIZE ROLL OF LAST MEASUREMENTS IN MILLIMETERS

SIZE OF FOOTWEAR	LENGTH OF FOOT	LENGTH OF LAST BOTTOM	LAST FITTING "G"	HEEL HEIGHT
4	228-231	242	222	26
5	236-239	250	228	26
6	244-247	258	234	27
7	253-256	266	240	27
8	261-264	274	246	27
9	269-272	282	253	28
10	277-281	291	258	28
11	287-291	300	264	29
12	296-300	308	270	29
13	306-310	316	276	29

HEIGHT OF UPPER

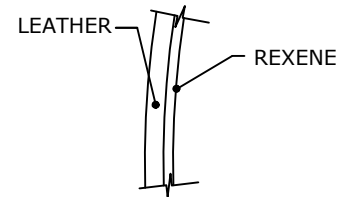
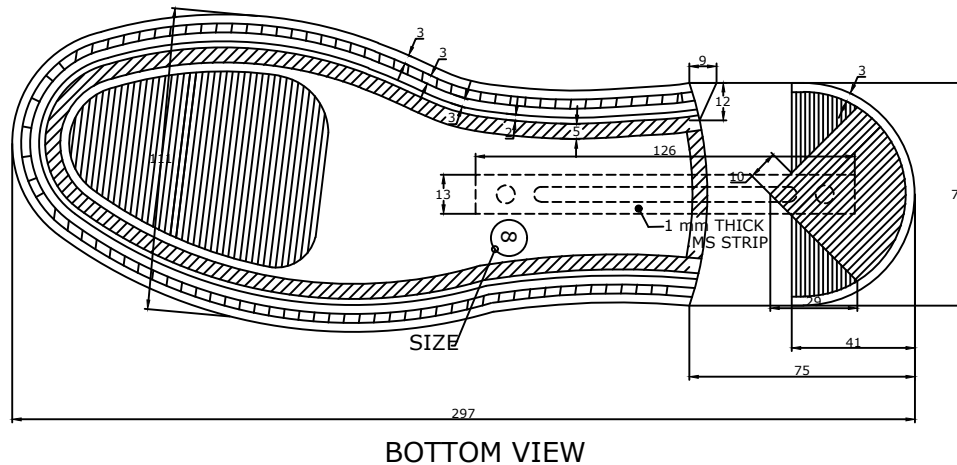
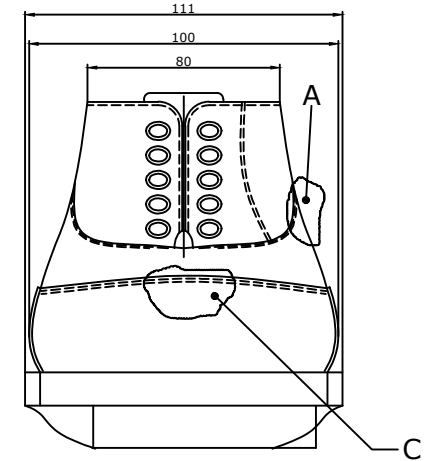
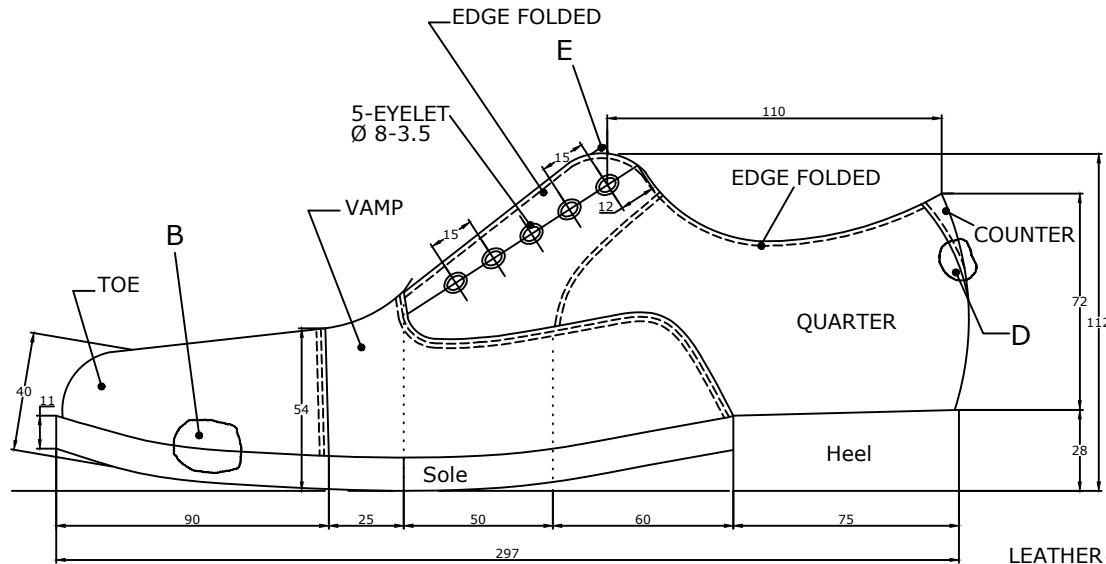
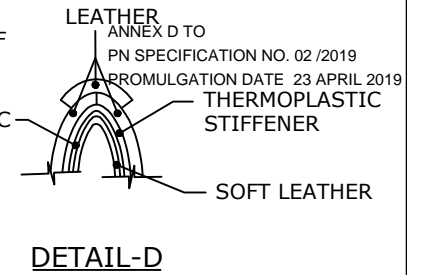
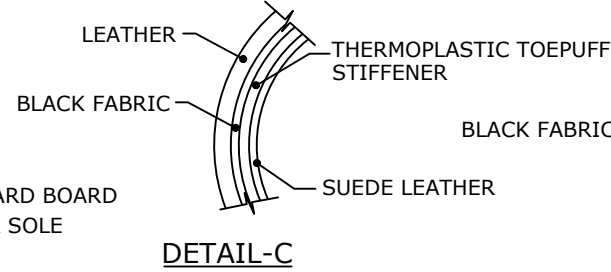
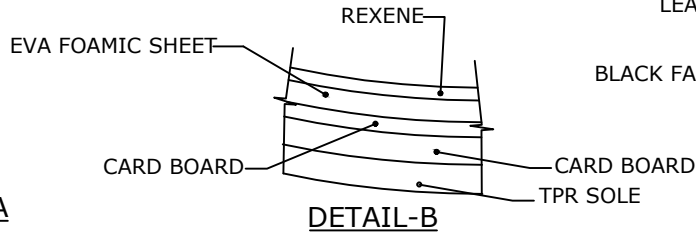
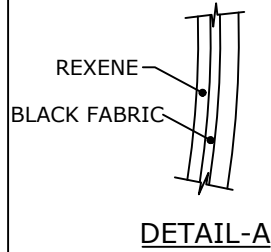
SIZE OF FOOTWEAR	HEIGHT (mm)
4	52
5	54
6	56
7	58
8	60
9	62
10	64
11	66
12	68
13	70

MEASUREMENT OF TOE CAPS

SIZE OF FOOTWEAR	LENGTH OF TOE CAP (mm)
4	52
5	58
6	64
7	70
8	76
9	82
10	88
11	94
12	100
13	106

Note: Tolerance of ± 0.5 mm

DRAWING OF SHOES BLACK LEATHER

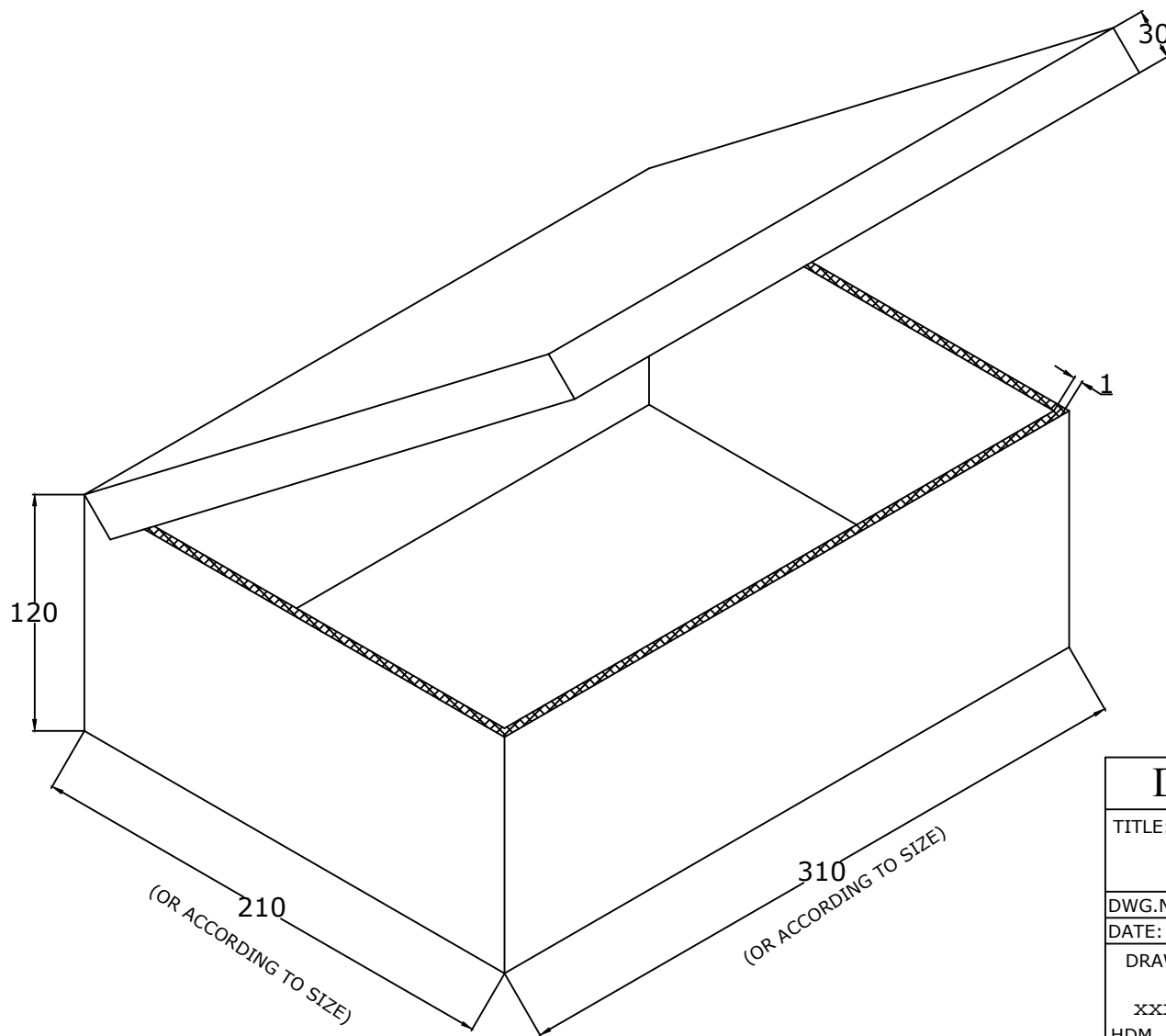


1243

DITD KARACHI

TITLE: SHOE BL (SIZE:9) (OXFORD STYLE)		
DWG.NO. TD-2436 / 2018	DIMENSIONS: mm	
DATE: 04-07-2018	SCALE: NTS	
DRAWN BY ---SD---	CHECKED BY ---SD---	APPROVED BY ---SD---
HDM M.ASGHAR I/c DWG	LT CDR ASMA SOHAIL SO.R&D	CDR AZHAR MIR DITD

NOTE:
FOR FURTHER DETAILS SEE STOCK SAMPLE



1250

DITD KARACHI		
TITLE: SHOES BL PACKING		
DWG.NO. TD-2443/2018	DIMENSIONS: mm	
DATE: 20-08-2018	SCALE: NTS	
DRAWN BY xxxxsdxxx HDM M.ASGHAR I/c DWG	CHECKED BY xxxxsdxxx LTCDR ASMA SOHAIL SO.R&D	APPROVED BY xxxxsdxxx CDR AZHAR MIR DITD

<u>GUIDELINES FOR INSPECTION – GENERAL DEFECTS</u>			
Defect	Description	Major	Minor
Pairing	Not properly paired i.e. right and left not of the same size and fitting	X	
	Wide variation in appearance of colour	X	
Colour cleanliness and finish	Not specified colour	X	
	Colour not uniform, spots and stains clearly noticeable at a distance of 3 feet (914mm)	X	
	Colour not uniform, spots and stains not plainly visible at a distance of 3 feet (914mm)		X
	Sole and heel edges not properly finished		X
Design, pattern size	Not as specified	X	
	Foreign Object Damage (FOD) free as same can cause catastrophic damage particularly while working in confined areas	X	
	Incorrectly lasted upper	X	
Material	Any components or items not fabricated from the specified materials	X	
Upper leather	Leather not chrome Cow corrected Leather deeply snuffed i.e. fibre structure damaged	X	
	One or more of the following imperfections: Grub or tick marks opened or badly healed scratches, flay cut, brands, bony, loose, wrinkles or other inferior leather	X	
	Wrinkles not seriously affecting appearance or serviceability		X
	Stretchy vamp	X	
	Stiff tongue	X	
	Flesh side with rough fiber	X	
	Skiving not done or excessively done	X	
	Damage to upper compounds	X	
Construction and workman ship	Any Component or assembly misplaced. Operation committed or not properly performed seriously affecting serviceability or appearance	X	
	Components poorly positioned	X	
	Excessive roughness	X	
Sole	Poor sole adhesion	X	
	Improper trimming of moulded surface	X	
	Damaged outer sole design	X	

	Improper /wrong size marking	X	
Laces & stitching	Any open seam	X	
	Stitching omitted where required	X	
	Loose tension resulting in puckering or damaging the leather	X	
	Stitching incorrectly finished off	X	
Counters	Soft counter (Stiffeners)	X	
Toe puff Stiffener and its Back seam	Toe soft on top and sides	X	
	Ridges formed on the inside affecting comfort of wearer	X	
Inner sole	Insoles not properly feathered, not likely to affect comfort		X
Eyelets	Not the same number of eyelets in each row	X	
	Eyelets not properly Spaced within the row or misalignment between the rows to an extent interfering proper locking	X	
	Number of eyelets less than specified but each row having the same number	X	
	Not specified size	X	
	Poor quality of eyelets	X	
Marking	Missing incomplete, incorrect, and illegible	X	
	Special instructions are missing	X	
Laces	Missing	X	
	Spare pair of laces missing	X	
	Rough and substandard	X	
Identification label	Missing	X	

FEED BACK FORM

Item Designation: _____

Pattern #: _____

Parent Equipment: _____

PN SPEC #: _____

Problem Faced: _____

Technical Solution: _____

Financial Effect (if any): _____

Name Stamp

COUNTERSIGNED

Name Stamp