



PAKISTAN NAVY SPECIFICATION 09/2021  
PROMULGATION DATE: 20 AUGUST 2021

## **RIBBON CAP SEAMAN**

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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 F. 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

**PN SPECIFICATION 09/2021  
(RIBBON CAP SEAMAN)**

**0101      DESIGNATION**

1. Ribbon Seaman used with Cap Seaman.

**0102      USAGE**

1. These Ribbon Seaman used with Cap Seaman and worn by 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 DNS.

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

**0104      SCOPE**

1. This specification covers the technical/ manufacturing requirements of Ribbon used with Cap Seaman, worn by Sailors. It defines and lays down the quality standards, details of materials, workmanship and finish. It also defines brief requirement and process of sampling, testing, inspection acceptance/rejection, marking, preservation, packing and delivery etc, of ribbon cap seaman.

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 3990	Terminology related to fabric Defects
e.	ISO 7211/5	Determination of linear density of yarn removed from fabric.
f.	ISO 3801	Determination of Mass per unit Length
g.	ISO 13934	Determination of maximum force and elongation.
h.	ISO 7211/2	Determination of threads per unit length

j.	ISO 13934-01	Determination of Tensile Strength
k.	ISO 105-C10	Color Fastness to Washing
l.	ISO 105-E01	Colour fastness to water.
m.	ISO 105 E02	Colour fastness to sea water
n.	ISO 105-NO1	Colur fastness to Bleach
p.	ISO 105 X 12	Color fastness to Rubbing
q.	ISO 105 E04	Colour Fastness To Perspiration

#### 0106 TERMS & DEFINITIONS

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

#### 0107 TECHNICAL DETAILS OF RIBBON CAP SEAMAN

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

#### 0108 GUIDE LINES FOR MANUFACTURING OF RIBBON CAP SEAMAN

1. Dyed Yarn Black & golden used for manufacturing of Ribbon Cap Seaman.
2. The Ribbon used with Cap Seaman woven uniformly with firm and regular selvedges.
3. Ribbon Cap Seaman shall be free from weaving defects.
4. The amount of size shall be minimum possible and no weighting material shall be used.
5. The Ribbon Cap Seaman shall be well scoured and bleached before dyeing and said process have no deleterious effect on cloth.
6. Fastness properties of Ribbon Cap Seaman is as per Annex B.

#### 0109. QUALITY OF WORKMANSHIP AND FINISHING

1. The Workmanship and finish of Ribbon Cap Seaman shall be best in quality and to the entire satisfaction of the Inspector.

#### 0110. TESTING

1. The stores/ material during manufacturing 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 wherever considered important by Inspecting Authority.

#### 0111. BULK REPRESENTATIVE SAMPLING OF RIBBON CAP SEAMAN

1. No of samples drawn from bulk quantity for inspection/ testing are as per instruction of Inspecting Officer (if deemed appropriate) 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. **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 advance or pre-production sample, authorizes the commencement of bulk production but does not relieve the suppliers/ manufacturers 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 facilitates which will be used for manufacturing 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.

0113. **INSPECTION**

1. Bulk representative sample (B/R) random sampling will be carried out as per rules in vogue.
2. Ribbon Cap Seaman shall be tested and examined during manufacturing/ Stage inspection as Inspector may consider necessary, to determine whether they conform to PN specification w.r.t quality or not.
3. **Inspection of Ribbon Cap Seaman** The guidelines for Inspector w.r.t General defects are defined at Annex D and Inspection Criteria is defined at Annex E. Ribbon Cap Seaman 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.
- Stamping of accepted stores:** Each acceptable Bundle of Ribbon Cap Seaman shall be stamped with Inspectors individually acceptance mark close to contractor marking.
  - Stamping of rejected stores:** The rejected items 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.

0114. **SPECIAL INSTRUCTIONS**

1. **Care Label Instructions** Following care instructions in the form of leaflet OR attached with Ribbon Cap Seaman 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. Prolonged contact with sunlight should be avoided etc.

#### **0115. 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) Each Ribbon Cap Seaman will be packed and wrapped in Polythene bag having thickness of 0.005 (0.127 mm).

(2) The Polythene shall be of sufficient size to ensure Ribbon Cap Seaman are protected.

(3) 10 x Ribbon Cap Seaman further packed in polyethene Bag and secured with tape.

(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) 100 x Bundles of Ribbon Cap Seaman will be packed neatly in suitable carton.

(6) Label (Identification & care) will be printed on a suitable fabric and stitched on inner side of Ribbon Cap Seaman i.a.w Annex C.

- 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.

#### **0116. IDENTIFICATION LABEL**

1. Each Ribbon Cap Seaman 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.

#### **0117. 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.

#### 0118. **MARKING OF STORES**

1. Each bolt of Ribbon Cap Seaman 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).

#### 0119. **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.

XXXXXSDXXXX

**MUHAMMAD AFSAR**  
Captain Pakistan Navy  
DID

**Annexes:**

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**ANNEX A TO**  
**PN SPECIFICATION NO.09/2021**  
**PROMULGATION DATE 20 AUG 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.

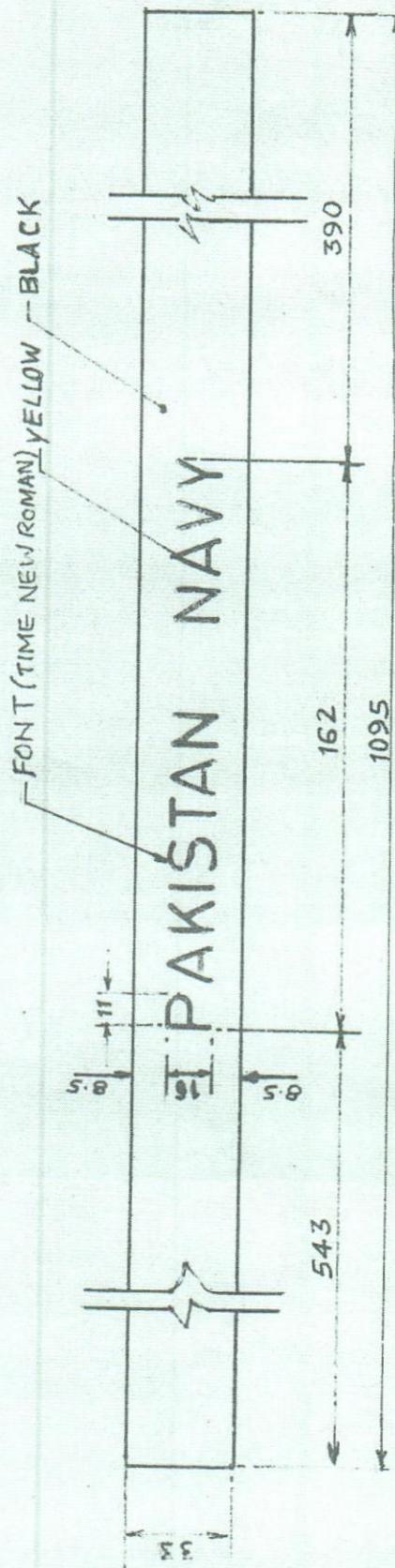
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**ANNEX B TO**  
**PN SPECIFICATION NO 09/2021**  
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**TECHNICAL DETAILS OF RIBBON CAP SEAMAN**

S.NO	ITEMS	STANDARD	RESULT	
1.	Material Composition a. Black b. Yellow	AATCC 20A	Polyester Polyester	
2.	Weight	Visual analysis	173gm ± 5gm	
3.	Linear Density a. Black Thread b. Yellow Thread	ISO 7211/5	85 ± 5 Denier 90 ± 5 Denier	
4.	Nature Dyes	Chemical analysis	Disperse dye	
5.	Shade a. Black (Caviar) b. Yellow (Lemon Drop)	Visual analysis	Pantone 19 4006 TCX Pantone 12-0736 TCX	
6.	Color Fastness to Water a. Change in Shade b. Staining  1) Wool 2) Acrylic 3) Polyester 4) Nylon 5) Cotton 6) Acetate	ISO-105-E01	<u>Black</u> 4 or better  4 or better 4 or better 4 or better 4 or better 4 or better 4 or better	<u>Yellow</u> 4 or better  4 or better 4 or better 4 or better 4 or better 4 or better 4 or better
7.	Color Fastness to Sea Water a. Change in Shade b. Staining  1) Wool 2) Acrylic 3) Polyester 4) Nylon 5) Cotton 6) Acetate	ISO-105-E02	<u>Black</u> 4 or better  4 or better 4 or better 4 or better 4 or better 4 or better 4 or better	<u>Yellow</u> 4 or better  4 or better 4 or better 4 or better 4 or better 4 or better 4 or better
8.	Color Fastness to Washing a. Change in Shade b. Staining  1) Wool 2) Acrylic 3) Polyester 4) Nylon 5) Cotton	ISO 105-C10 C(3)	<u>Black</u> 4 or better  4 or better 4 or better 4 or better 4 or better	<u>Yellow</u> 4 or better  4 or better 4 or better 4 or better 4 or better 4 or better

	6) Acetate		4 or better	4 or better
9.	Tensile Strength (Full Width x B.G 7")	ISO 13934-01	129 lbs ± 3 lbs	
10.	Color Fastness to Dry Cleaning a. Change in Shade b. Staining  1) Wool 2) Acrylic 3) Polyester 4) Nylon 5) Cotton 6) Acetate	ISO 105-D01	<u>Black</u> 4 or better 4 or better 4 or better 4 or better 4 or better 4 or better	<u>Yellow</u> 4 or better 4 or better 4 or better 4 or better 4 or better 4 or better
11.	Color Fastness to Bleach a. Change in Shade b. Staining  1) Wool 2) Acrylic 3) Polyester 4) Nylon 5) Cotton 6) Acetate	ISO 105-N01	<u>Black</u> 4 or better 4 or better 4 or better 4 or better 4 or better 4 or better	<u>Yellow</u> 4 or better 4 or better 4 or better 4 or better 4 or better 4 or better



DITD NHQ KARACHI

TITLE

CAP RIBBON SEAMAN  
BLACK / YELLOW

DWG. NO. TD-2586/21 DIMENSION: mm  
DATE: 25-06-2021, SCALE: NTS

DRAWN BY CHECKED BY APPROVED BY  
HDM M. MASGHAR LT. YOUSAF SANA KANWAL M. SHAHZAD  
1/GD/21 SO. TEX D.D.I.D.

1393

2  
3



ANNEX D TO  
PN SPECIFICATION NO 09/2021  
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**GENERAL DEFECTS**  
**(ASTM D-3990)**

S. NO	DEFECTS	DEFINITION
<b>FABRIC</b>		
a.	<b>Abrasion Mark (bruise, Chafe Mark or rub) :</b>	An area of fabric damaged by friction Damaged due to abraded or uneven surface in a machine
b.	<b>Barré Mark:</b>	An unintentional, repetitive visual pattern of continuous bars and stripes usually parallel to the filling of woven 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.	<b>Blotch,</b>	An off colored area of any shape caused by grease or Oil. (Syn. oil spot). Cause due to leakage/slippage from machine.
d.	<b>Bow</b>	A fabric condition resulting when filling yarns are displaced from a line perpendicular to the selvages and form one or more arcs across the width of fabric.
e.	<b>Broken filament,</b>	In multifilament yarn, breaks in one or more filaments.
f.	<b>Clip mark:</b>	An open place causing a streak of variable length approximately parallel of the length of width.
g.	<b>Decanting Mark</b>	A crease marks or impression extending across the cloth near the beginning or end of a piece Due to the thickness of the fabric leader seam.
h.	<b>Double Pick</b>	In woven fabrics, two picks wrongly place in the same shade.
j.	<b>Draw Back</b>	A weave distortion characterized by tight and stack places in the same warp yarn.
k.	<b>End out</b>	A void caused by a missing warp yarn.
l.	<b>Float</b>	In woven fabrics, the portion of a warp or filling yarn that extends unbound over two or more warp or filling yarns.
m.	<b>Frosting</b>	A change in color in a limited area of fabric cause by abrasive wear.
n.	<b>Hole</b>	In fabric, imperfection, wear one or more warp or filling yarns sufficiently damaged to create an aperture.
p.	<b>Fuzzy</b>	Characterized by a hair appearance due to protruding broken fibers or filaments.

q.	<b>Let-off Mark</b>	In woven fabrics, a corrugated defect pattern distributed across the fabric width.
r.	<b>Loom fly</b>	Waste fibers create during weaving that are woven into a fabric.
s.	<b>Loop Salvage</b>	An improperly woven salvage of uneven width or a salvage containing irregular filling loops extending beyond the outside edges.
t.	<b>Messiness</b>	Surface distortion in a fabric characterized by objectionable unevenness due to many minor deformations.
u.	<b>Pin Hole</b>	In fabric, a very small hole, approximately the size of the across section of the pin.
v.	<b>Scalloped Salvage</b>	An abrupt, narrow indentation in the salvage.
w.	<b>Shiner</b>	A streak, usually short caused of a lustrous section of filament yarn.
x.	<b>Smash</b>	In woven fabrics, relatively large hole characterized by broken yarn ends and floating picks.
y.	<b>Skew</b>	A fabric condition resulting when filling yarns are angularly displace from a line perpendicular to the edge or side of the fabric.
z.	<b>Snag</b>	In fabrics, a yarn or part of a yarn pulled or plucked from the surface.
aa.	<b>Thin Place</b>	Fabric appearance characterized by a small area of loosely placed yarn or by a congregation of thin yarn as compared to the adjacent construction.
ab.	<b>Tight Salvage</b>	In woven fabrics, salvage yarn shorter than warp yarn in the body of the fabric.
ac.	<b>Streak</b>	An extended unintentionally strips narrow width, often a single yarn.
ad.	<b>Tram Mage</b>	In woven crepes, a puckered area in which a filling yarn has twist running in the same direction for several picks instead of alternating S and Z twist.
ae.	<b>Temple Mark</b>	In woven fabrics, small holes or distortions adjacent to the salvage.
af.	<b>Tender Mark</b>	A visible deformation on the side edge or body of a fabric due to pressure for clips or pins.

**ANNEX E TO**  
**PN SPECIFICATION NO 09/2021**  
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**Acceptable Quality Levels for Ribbon Cap Seaman**

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 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>Lot/Batch Size</u>	<u>Sample Size</u>	<u>Materials</u>	<u>Finished Ribbon Cap Seaman</u>							
			• Acceptable/ Allowable defective sample (Ac)				• Rejected/ Exceed allowable limit of defective item (Re)			
			Critical Defects		Major Defects		Minor Defects			
			<u>Ac</u>	<u>Re</u>	<u>Ac</u>	<u>Re</u>	<u>Ac</u>	<u>Re</u>	<u>Ac</u>	<u>Re</u>
2 - 8	2	0	1	0	1	1	0	1	0	1
9 ~ 15	3	0	1	0	1	1	0	1	0	1
16 ~ 25	5	0	1	0	1	1	1	2	1	2
26 ~ 50	8	0	1	0	1	1	1	2	1	2
51 ~ 90	13	1	2	1	2	1	2	2	2	3
91 ~ 150	20	1	2	1	2	2	3	3	3	4
151 ~ 280	32	2	3	2	3	3	4	5	5	6
281 ~ 500	50	3	4	3	4	5	6	7	7	8
501 ~ 1200	80	5	6	5	6	7	8	10	10	11
1201 ~ 3200	125	7	8	7	8	10	11	14	14	15
3201 ~ 10000	200	10	11	10	11	14	15	21	21	22

10001 ~ 35000	315	14	15	14	15	21	22	21	22
35001 ~ 150000	500	21	22	21	22	21	22	21	22
150001 ~ 500000	800	21	22	21	22	21	22	21	22
500001 ~ Over	1250	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 save time, cost and give effective/ statistical result of product /offered store. e.g. If inspector needs 1 minute to check the item , the quantity to be inspected is 2,500 items then it took 42 hours to check the whole consignment/ offered store. It means 26 days approx. for one store. Calculation is as follows:

$$\frac{1 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 2,500 \text{ items} = 42 \text{ hrs} \cong 02 \text{ days}$$

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

$$\frac{1 \text{ min} \times 1 \text{ hr}}{1 \text{ item} \times 60 \text{ min}} \times 2,00 \text{ items} = 3.33 \text{ hrs} \cong \text{half quarter od a day}$$

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.

**ANNEX F TO**  
**PN SPECIFICATION No 09/2021**  
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**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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