	Procedure	Document No <b>A0373</b>	Version <b>11</b>	Page: 1/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020
				Effective until: 14 Feb 2022
<b>3<sup>rd</sup> Party Inspection Procedure (FTW)</b>				

Document Owner:  
Hoang Do, Senior Manager Quality Assurance Programs and Systems. Footwear Sourcing.


Author:  
Eric Jeandin,  
Senior Manager FW Quality adidas Herzo

Approval:  
Robert Fessele,  
Senior Director Quality FW

Updates since Jan 2020:  
Hoang Do,  
Senior Manager Quality Assurance Programs  
and Systems. Footwear Sourcing.


Departments Affected:  
All Sourcing LOs, FTW Quality teams  
All FTW T1 Supply Partners  
3<sup>rd</sup> Party Inspection Institutes

Version	Date	Modifications	Page
01	09/05/2007	All new	all
02	03/09/2007	2.1 3 <sup>rd</sup> party inspection criteria 2.7 Inspection preparation 2.8 Selecting the Random Sampling 2.9 Packing integrity 2.10 Inspection quantity 2.11 Inspection cannot be stopped 2.14 Intertek identification and sealing procedure 3. Finished shoe inspection process 3. IV Final Random Inspection Report - revised	2 4 4 5 5 5 6 9 9
03	20/03/2008	claim influence in 3 <sup>rd</sup> Party Inspection percentage PO selection process	2 4
04	20/11/2008	Adding CPSC certificate to required documents for US orders	3
05	03/12/2008	Changing PO selection responsibilities for ITS inspection	4
06	01/10/2009	2.1. 3 <sup>rd</sup> party inspection criteria	2
07	25/10/2012	New document owner, Renamed Head of Quality to Senior Quality Manager	
08	15/04/2013	Updated Intertek contact 2.g Required Documents Inspection Certificate 3. Finished Shoe Inspection Process 4. Policies and Procedures	1 4 4,6,9 9 9
09	15/04/2014	Updated to SOM and SMM Added 2.a., exceptional 3 <sup>rd</sup> party inspection criteria	2
10	25/07/2017	Clarified and reorganized point 2.) Procedure Updated job titles	2-7 Various

	Procedure	Document No A0373	Version 11	Page: 2/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020
3 <sup>rd</sup> Party Inspection Procedure (FTW)				
11	15/01/2020	Update Defect List Update Approved 3 <sup>rd</sup> Party Inspection Company List		7,8,11-13 10

## Table of Content

1	Purpose	9	Annex
2	Reasons for 3 <sup>rd</sup> party inspection	Annex 1	3 <sup>rd</sup> Party Inspector Training Tracking Form
2a	General reasons for 3 <sup>rd</sup> party inspection	Annex 2	3 <sup>rd</sup> Party Inspection Process
2b	Claim-based reason for 3 <sup>rd</sup> party inspection	Annex 3	Inspection Certificate, IC
2c	Exceptional reason for 3 <sup>rd</sup> party inspection	Annex 4	Defect List
3	3 <sup>rd</sup> Party Inspectors	Annex 5	Approved 3 <sup>rd</sup> Party Testing Institutes
3a	3 <sup>rd</sup> party inspectors training and certification	10	Abbreviations
3b	Rotation of 3 <sup>rd</sup> party inspectors		
3c	Performance feedback for 3 <sup>rd</sup> party inspectors		
4	Factory Responsibilities		
4a	Booking of 3 <sup>rd</sup> party inspectors		
4b	Manufacturing confirmation samples and other documents		
4c	Inspection certificates, AQL level and sampling sizes		
4d	POs for inspections		
5	Inspection Process		
5a	Random Selection of POs		
5b	Random Selection of Outer Cartons		
5c	Completion of inspection certificates		
5d	Shoe handling during inspections		
5e	Defect review		
5f	3 <sup>rd</sup> party identification and sealing procedure		
6	Defect Disagreement Handling		
6a	Defect disagreement		
6b	PO decision making		
6c	Re-inspection after repairing or repacking		
7	Report Distribution and Storage		
8	Factory Accountability		

	Procedure	Document No A0373	Version 11	Page: 3/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020
				Effective until: 14 Feb 2022
3 <sup>rd</sup> Party Inspection Procedure (FTW)				

## 1) Purpose

The adidas Footwear Quality Department requires under certain circumstances the execution of AQL Inspections of purchase orders prior shipment by a 3<sup>rd</sup> party Inspection ("3<sup>rd</sup> party inspection"). Random samples according to Acceptable Quality Level (AQL) Plans will be selected and inspected for various characteristics.

The entire lot will either be accepted or rejected. The decision will be based on specified criteria and the number of defects or defective units found in the sample.

## 2) Reasons for 3<sup>rd</sup> party inspection

### a) General reasons for 3<sup>rd</sup> party inspection

In case an existing T1 supplier did not participate yet in 3<sup>rd</sup> party inspection or a new T1 supplier is requested to participate in 3<sup>rd</sup> party inspection, 10% of the total number of completed POs per month will initially be inspected by 3<sup>rd</sup> party inspection institute:

- If there is no rejection by 3<sup>rd</sup> party inspection during one entire month; the inspection percentage will go down by 2,5%. In the ideal case a factory will be out of 3<sup>rd</sup> party Inspection until further notice after 4 months continuous 3<sup>rd</sup> party inspections without a PO rejection
- If there is one rejection during one month the inspection percentage will stay the same
- More than one rejection during one month the inspection percentage will go up by 2,5%

### b) Claim-based reason for 3<sup>rd</sup> party inspection


When claims arise, they are used to set the PO inspection percentage for 3<sup>rd</sup> party inspection in the following manner:

- In case a factory is receiving one claim in one respective month the inspection level is going up by 2,5% for the following month
- In case a factory is receiving multiple claims in one month
  - different claim reasons will be treated individually, and each claim leads to a 2,5% increase for each claim.
  - Same claim reason in different claims will only lead in a general increase of 2,5%.

Once 3<sup>rd</sup> party inspection is implemented, the same rules as under section 2.a.) are applied, i.e.:

- If there is no rejection by 3<sup>rd</sup> party inspection during one entire month; the inspection percentage will go down by 2,5%
- If there is one rejection during one month the inspection percentage will stay the same
- More than one rejection during one month the inspection percentage will go up by 2,5%

Note:

	Procedure	Document No <b>A0373</b>	Version <b>11</b>	Page: 4/13	
				Approval Date: 20 Feb 2020	
				<b>3<sup>rd</sup> Party Inspection Procedure (FTW)</b>	Effective: 20 Feb 2020
					Effective until: 14 Feb 2022

A claim must have “settled” status in the claim tracking lists from the claim desks in order to trigger 3<sup>rd</sup> party inspection. However, VPS, SDOM, DM, SDQ or DQ can decide to implement 3<sup>rd</sup> party inspection prior to the official claim settlement, e.g. if there are delays receiving the complete information about affected pairs from markets, but it is confirmed that the affected PO has a quality issue.

### c) Exceptional reason for 3<sup>rd</sup> party inspection

Under exceptional circumstances roles responsible for quality in production (i.e., VPS, SDOM, DM, SDQ or DQ) have the authority to increase or decrease the 3<sup>rd</sup> party inspection level by more than 2.5%:

Examples include (but are not limited to):

- A manufacturer has on-going and/or severe quality issues
- Rapid start up or ramp up of a new or existing factory/facility
- Starting up or ramping up of technically challenging, strategically important products in new factories/facilities

## 3) 3<sup>rd</sup> Party Inspectors

### a.) 3<sup>rd</sup> party inspectors training and certification

All 3<sup>rd</sup> party inspectors who inspect adidas products must be trained and certified for adidas quality standards and inspection procedures:

- DQ of respective LO is overseeing and monitoring training status
- 3<sup>rd</sup> party institute has train new inspectors internally for shoe inspections
- Afterwards new inspectors are trained at a factory according to Annex 1, 3<sup>rd</sup> Party Inspector Training Tracking Form - DQ of respective LO arranges factory for training
- DQ of respective LO certifies 3<sup>rd</sup> party inspectors at end training

### b.) Rotation of 3<sup>rd</sup> party inspectors


3<sup>rd</sup> party institute is responsible to rotate 3<sup>rd</sup> inspectors between factories. There must be at least 2 3<sup>rd</sup> inspectors rotating at any given factory. The 3<sup>rd</sup> party institute decides which inspector goes to which factory.

### c.) Performance feedback for 3<sup>rd</sup> party inspectors

Any feedback regarding the performance or knowledge of 3<sup>rd</sup> party inspectors must be directed to the Director Quality of the respective LO.

## 4) Factory Responsibilities

### a) Booking of 3<sup>rd</sup> party inspectors

	Procedure	Document No <b>A0373</b>	Version <b>11</b>	Page: 5/13	
				Approval Date: 20 Feb 2020	
				<b>3<sup>rd</sup> Party Inspection Procedure (FTW)</b>	Effective: 20 Feb 2020
					Effective until: 14 Feb 2022

The respective factory is responsible to inform 3<sup>rd</sup> party inspectors 4 days (can be lowered to 2 days with a local agreement) prior to when an inspection should take place, including the total number of completed POs which are ready for inspection and how many POs must be inspected.

The PO inspection quantity per inspector is determined by following guideline:

- Inspection time: 30-40 seconds per pair
- Quantity per day: 500-650 pairs, including time for picking up the carton
- Number of PO's per day:
  - if POs quantity is 900 to 3,000 pairs: 5-15 POs
  - if POs smaller than 900 pairs: 20-35 POs

#### **b) Manufacturing confirmation samples and other documents**

Factory must provide:

- Approved MCS in good condition for every article which is inspected
- Grading sheet to check e.g. size grouping of lace length and logo dimensions
- SHAS & Packing Manual to check packing integrity

#### **c) Inspection certificates, AQL level and sampling sizes**

Factory provides an inspection certificate including AQL level and sampling size for the respective POs, which means they prepare the frame work of the inspection according to Table I, II, III.

The framework should be identical to the procedure the factory has uses to conduct internal factory AQL inspections by the factory AQL Inspectors.


Therefore 3<sup>rd</sup> party inspectors start their inspections with their carton selection in the warehouse and are not double-checking or responsible for:

- AQL level selection
- To be inspected quantity
- Size calculation
- Maximum acceptable defects according to AQL Level selection

#### **d) POs for inspections**

To minimize the time needed for selecting products for 3<sup>rd</sup> party inspections and to ensure random sampling, it must be ensured that:

- Only POs inspected by factory AQL Inspectors can be inspected by 3<sup>rd</sup> inspectors
- The POs to be inspected must be complete and in one physical location. This should be verified by the inspector prior to selecting samples
- The POs need to be clearly laid out & identified in the warehouse, so that cartons can be easily selected

	Procedure	Document No <b>A0373</b>	Version <b>11</b>	Page: 6/13	
				Approval Date: 20 Feb 2020	
				<b>3<sup>rd</sup> Party Inspection Procedure (FTW)</b>	Effective: 20 Feb 2020
					Effective until: 14 Feb 2022

- No cleaning or repairing is allowed during or prior the inspection process
- There must be at least twice the number of POs which 3<sup>rd</sup> party has to inspect in the warehouse to guarantee a random selection

## 5) Inspection Process

Annex 2, 3<sup>rd</sup> Party Inspection Process describes the overall process of an inspection and surrounding conditions.

### a) Random Selection of POs

To guarantee that there is a random selection, there is not (pre-)selection of POs by adidas or factory employees. 3<sup>rd</sup> party inspectors select randomly POs which they will inspect upon arrival at the factory.

### b) Random Selection of Outer Cartons


- 3<sup>rd</sup> party inspector selects randomly in FG WH outer cartons for inspection. Outer carton numbers and shoe sizes on recorded on the inspection certificate
- The selected outer cartons must be marked with a 3<sup>rd</sup> party stamp or a personal 3<sup>rd</sup> party inspector sticker on the barcode end of each carton as it is pulled from the PO
- The outer cartons are taken into the AQL inspection room under the supervision of the 3<sup>rd</sup> party inspector
- If outer cartons are not identified properly in FG WH or outer cartons are missing, the inspection should not continue

### c) Completion of inspection certificates

- Quality standards and defect types are based on the defect list (please refer to annex 3) as listed in Quality Claim Procedure FTW
- All defects found during 3<sup>rd</sup> party inspection is identified and notified on the inspection certificate
- If several defects are detected on one pair only the most serious one is recorded
- If the found defects are exceeding the acceptable number of defects for the respective PO after a relatively low number of inspected shoes, the inspection has to be fully (100%) completed and it is not allowed to stop the inspection earlier
- 3<sup>rd</sup> party inspectors are not authorized to B-Grade or C-Grade products. Results will only be reported

### d) Shoe handling during inspections

- Defective shoes found during the 3<sup>rd</sup> party inspection is clearly marked with red, orange and yellow arrow stickers for Critical, Major and Minor defect
- Defective shoes are stored on a specific defective rack, separated by defects types
- All shoes without defects will be returned to original lot and repacked into the outer cartons by factory assistant.

	Procedure	Document No A0373	Version 11	Page: 7/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020
3 <sup>rd</sup> Party Inspection Procedure (FTW)				

#### e) Defect review

- Defective shoes found during the 3<sup>rd</sup> party inspection is clearly marked with red, orange and yellow arrow stickers for Critical, Major and Minor defect then stored in a separate, defective rack.
- After the 3<sup>rd</sup> party inspection is finished the defective shoes will be reviewed with T1 and adidas production team. Adidas production team makes the decision if shoes can be repaired or must be replaced
  - Replacement shoes must be checked by 3<sup>rd</sup> party inspector before they can be added to the outer carton
  - All open outer cartons must stay in the inspection room until the cartons are filled with replacement shoes and can be closed and sealed by 3<sup>rd</sup> party inspector
  - If not all replacement shoes are available within the standard working hours, 3<sup>rd</sup> party inspector does not have to seal outer cartons with missing shoes. The factory is then responsible to complete the PO and to close the outer cartons with grey tape and QIP inspected stickers

#### f) 3<sup>rd</sup> party identification and sealing procedure

- For each inspected and released pair of shoes the inner box must be marked with a small rectangular personalized 3<sup>rd</sup> party inspector sticker on the inside of the carton. The personalized 3<sup>rd</sup> party inspector sticker must
  - have at least a unique personal identifier of the 3<sup>rd</sup> party inspectors
  - be temper proof, which means it cannot be take away and/or moved to a different inner box
- Each outer carton must be resealed with the grey tape by the factory assistant. Then it is marked with a rectangular 3<sup>rd</sup> party outer carton sticker which is placed half on the tape and half on the outer carton on the top side of the carton. The 3<sup>rd</sup> party outer cartons sticker must be temper proof, which means it cannot be take away and/or moved to a different outer carton box.  
Additionally, a temper proof personalized 3<sup>rd</sup> party inspector sticker has to be place half on the 3<sup>rd</sup> party outer carton and half on the outer carton on the top side of the outer carton

## 6) Defect Disagreement Handling

#### a) Defect disagreement

In case of a disagreement with defects during the defect review, especially in case a PO is rejected:

- 3<sup>rd</sup> party inspector does not change their original evaluation and list all defects on their report. The 3<sup>rd</sup> party inspection result serves as basis for decision making for the adidas DQ
- 3<sup>rd</sup> party inspector does not have to wait for repaired or replacements shoes and does not seal the outer carton
- T1 or adidas production team has to contact DQ for further evaluation

adidas	Procedure	Document No A0373	Version 11	Page: 8/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020
				Effective until: 14 Feb 2022
3 <sup>rd</sup> Party Inspection Procedure (FTW)				

#### b) PO decision making

- DQ is authorized to decide after reviewing the defects and/or the 3<sup>rd</sup> party inspection result to release a PO.
- In case a PO remains rejected, the DQ is authorized to decide if the PO must be repaired, repacked or B-graded
- In case the DQ is not available, the respective SDOM or DM is authorized to make a final decision

#### c) Re-inspection after repairing or repacking

3<sup>rd</sup> party inspector is not required to conduct a re-inspection of any PO which they already inspected. The factory is responsible for re-inspecting POs after repairing or repacking.

### 7) Report Distribution and Storage

- All 3<sup>rd</sup> party ICs which are completed must be signed on the inspection day by 3<sup>rd</sup> party inspector and adidas personnel. Copies must be given immediately to the factory personnel and the adidas SMP
- An official typed report will be sent by 3<sup>rd</sup> party institute the following day only to the attention of the respective SDOM, DM, SPM and DQ
- Reports must be kept a minimum 12 month after completion

### 8) Factory Accountability


The factory is accountable and responsible for all delays in shipments due to manufacturing quality problems (if it disables adidas from meeting its commitments to its customer required delivery date within shipping policy, shipment by air freight is on factories expense).

If legitimate claims are made against any shipment by an adidas customer, the severity of the problems must be determined, and samples of the defective shoes should be sent to the liaison office.

TABLE I: *sample - size code letters*





	Procedure	Document No <b>A0373</b>	Version <b>11</b>	Page: 10/13	
				Approval Date: 20 Feb 2020	
				<b>3<sup>rd</sup> Party Inspection Procedure (FTW)</b>	Effective: 20 Feb 2020
					Effective until: 14 Feb 2022

### Method ANSI / AQL Calculation Table III

P/O No	CUST. NAME	CUST. ORD	MODEL NAME	ART	ETD	6	6-	7	7-	8	8-	9	9-	10	10-	11	11-	12	12-	13	13-	QTY	Inspection Level / Multiplication %
						60	90	90	90	110	140	170	170	130	90	90	70	80	20			1400	Level2 / K
To-be inspected sample qty per size						5,4	8,0	8,0	8,0	9,8	12,5	15,2	15,2	11,6	8,0	8,0	6,3	7,1	1,8			125	8,9%
Selected Qty						5	8	8	8	10	13	15	15	12	8	8	6	7	2			125	

## 9) Annex

Annex 1: 3<sup>rd</sup> Party Inspector Training Tracking Form

Annex 2: 3<sup>rd</sup> Party Inspection Process

Annex 3: Inspection Certificate, IC

Annex 4: Defect List

Annex 5: Approved 3<sup>rd</sup> Party Inspection Companies


- Intertek (ITS) and IMPACTIVA are the world-wide approved 3<sup>rd</sup> party Inspection Companies for adidas T1 suppliers
- Adidas FTW Quality (DQs) will have right to recommend/direct in selection of approved 3<sup>rd</sup> party inspection company to support T1s.
- FTW Quality also reserves the right to appoint under special circumstances to appoint a different external supplier to perform 3<sup>rd</sup> party inspection

#### Intertek

Contact Europe Daniel Kafitz <a href="mailto:Daniel.Kafiz@intertek.com">Daniel.Kafiz@intertek.com</a> Gregory Baxter <a href="mailto:Gregory.Baxter@intertek.com">Gregory.Baxter@intertek.com</a>	Contact LO China Anny Li <a href="mailto:anna.yy.li@intertek.com">anna.yy.li@intertek.com</a>
Contact LO Indonesia Nuriana Apriani <a href="mailto:Nurina.apriani@intertek.com">Nurina.apriani@intertek.com</a>	Contact LO Vietnam Huyen Nguyen <a href="mailto:Huyen.nguyen@intertek.com">Huyen.nguyen@intertek.com</a>

#### IMPACTIVA

Contact Global Mathieu Vassal <a href="mailto:mvassal@impactiva.com">mvassal@impactiva.com</a> Cécilia Rie <a href="mailto:crie@impactiva.com">crie@impactiva.com</a>	Contact LO China Name: Anna Email: <a href="mailto:ayang@impactiva.com">ayang@impactiva.com</a>
Contact LO Indonesia Name: Manmohan	Contact LO Vietnam Name: Karthik


	<b>Procedure</b>	Document No <b>A0373</b>	Version <b>11</b>	Page: 11/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020 Effective until: 14 Feb 2022

## 3<sup>rd</sup> Party Inspection Procedure (FTW)

Email: [makumar@impactiva.com](mailto:makumar@impactiva.com)

Email: [gkarthik@impactiva.com](mailto:gkarthik@impactiva.com)


Code	Defect Classification (Page 1/3)	Description ==>	MINOR DEFECT	MAJOR DEFECT	CRITICAL DEFECT
<b>100</b>	<b>PACKING AND LABELING</b>		<b>2.5</b>	<b>1.5</b>	<b>0.0</b>
100.01	OUTER CARTON DAMAGED / DIRTY (INCLUDE LABELING AND LABELING OFF CENTER)		X		
100.02	INNER BOX DAMAGED / DIRTY (INCLUDE LABELING, LABELING OFF CENTER AND PACKING MATERIALS)	<2 dots, <2mm	X		
100.03	INNER BOX DAMAGED / DIRTY (INCLUDE LABELING, LABELING OFF CENTER AND PACKING MATERIALS)	>2 dots, >=2mm		X	
100.04	ACCESSORIES/ATTACHMENTS MISSING OR IN BAD QUALITY		X		
100.05	<b>ODD PAIR (BOTH LEFT/RIGHT SHOES IN PAIR, DIFFERENT SIZE IN ONE PAIR, SHOE SIZE NOT AS LABEL/STICKER)</b>				X
100.06	SIZE LABEL AND HANGTAG IN BAD QUALITY (PEEL OFF, UNCLEAR, ETC.) OR MISSING			X	
100.07	<b>WRONG MATERIAL CONTENT LABEL OR HANGTAG</b>				X
<b>200</b>	<b>INSIDE THE SHOE</b>				
200.01	CONTAMINATION (STAINS, CEMENT, etc.)	<2 dots, <2mm	X		
200.02	CONTAMINATION (STAINS, CEMENT, etc.)	>2 dots, >=2mm		X	
200.03	<b>METAL PIECE/SHARP PIECE OR Any foreign item that could cause harm/injury to the consumer</b>				X
200.04	MINOR/SOFT FOLDS, WRINKLES IN LINING OR LOOSE LINING		X		
200.05	NOTICEABLE/MAJOR/HARD FOLDS, WRINKLES IN LINING OR LOOSE LINING			X	
200.06	LINING MATERIAL DAMAGED		X		
200.07	LINING NOT SECURED BY STROEBEL STITCHING OR LASTING		X		
200.08	SOCKLINER POOR QUALITY OF PRINT, EMBOSS, LOGO			X	
200.09	SOCKLINER OFF-SPEC (THICKNESS, LENGTH)		X		
200.10	POOR CEMENTING SOCKLINER TO INSOLE BOARD		X		
200.11	MINOR/SOFT WRINKLED SOCKLINER/INSOLE BOARD		X		
200.12	NOTICEABLE/MAJOR/HARD WRINKLED SOCKLINER/INSOLE BOARD			X	
200.13	MISSING SOCKLINER			X	
200.14	WRONG COLOR OF LINING, SOCKLINER, LOGO OR PRINT		X		
200.15	DELAMINATION SOCKLINER COVER			X	
200.16	WRONG SIZE OR POSITION OF HEEL COUNTER/DAMAGED OR POOR TOE BOX			X	
200.17	OTHER DEFECTS				
<b>300</b>	<b>UPPER</b>				
<b>310</b>	<b>UPPER MATERIALS</b>				
310.01	LEATHER DEFECTS (LOOSE GRAIN, PEELING, ORANGE PEEL, EDGES NOT DYED AS REQUESTED, ETC.)			X	
310.02	MATERIAL BROKEN/POOR MATERIAL QUALITY (TEXTILE, SYNTHETIC, MESH, ETC.)/POOR LEATHER (HAIRY, FRAYED EDGE)			X	
310.03	COLOR DIFFERENCE/LEATHER GRAIN DIFFERENCE BETWEEN LEFT AND RIGHT SHOE			X	
310.04	<b>SHARP EDGE/POINT (for children's shoes) OR Any foreign objects that could cause ham/injury to consumer</b>				X
<b>320</b>	<b>UPPER STITCHING</b>				
320.01	WRONG STITCH LENGTH	not 9-10 stitches/inch	X		
320.02	WRONG ZIG-ZAG STITCH LENGTH	not 8 stitches/inch	X		
320.03	POOR STITCHING MARGIN, POOR STITCH EDGE DISTANCE (1mm < adidas edge distance's standard < 2.5mm)		X		
320.04	BROKEN STITCHING/LOOSE STITCHING/SKIPPED STITCHING/OPEN SEAM			X	
320.05	INSECURE BACK/LOCK-STITCH		X		
320.06	WAVY/INCONSISTENT STITCHING		X		
320.07	NEEDLE HOLES / CUTS			X	
320.08	THREAD ENDS	>2mm	X		
320.09	WRONG THREAD OR WRONG COLOR			X	
<b>330</b>	<b>UPPER TREATMENTS (LOGO, EMBROIDERY, HF WELDING, DE- AND EMBOSS, PRINT, COMPONENTS, etc.)</b>				
330.01	WRONG COLOR/ COLOR DIFFERENCE		X		
330.02	MISSING		X		
330.03	POOR SYMMETRY/OFF POSITION/WRONG SIZE		X		
330.04	POOR DEFINITION, NOT CLEAN, NOT CLEAR, DELAMINATION			X	
<b>340</b>	<b>UPPER APPERANCE</b>				
340.01	CONTAMINATION (Stains, printing mark)	<2 dots, <2mm	X		
340.02	CONTAMINATION (Stains, printing mark)	>2 dots, >=2mm		X	
340.03	OVER CEMENTING OR PRIMING	<4mm length, <2mm width	X		
340.04	OVER CEMENTING OR PRIMING	>=4mm length, >=2mm width		X	
340.05	POOR TOUCH UP/PAINTING, MARKING LINE		X		
340.06	COLOR CHANGE/MIGRATION/BLEEDING		X		
340.07	OFF CENTER TOE TO HEEL / CROOKED	<=3mm	X		
340.08	OFF CENTER TOE TO HEEL / CROOKED	>3mm		X	
340.09	POOR SHAPE (WRINKLES/COLLAPSING/TOE SPRING)			X	
340.10	<b>PATTERN VARIATION different between LEFT and RIGHT shoes (when not intended by MCS)</b>				X
340.11	POOR SKIVING/X RAY/PRESSING MARKS		X		
340.12	TONGUE MISPLACED, LOOSE/EYESTAY NOT ALIGNED, HOLES NOT PUNCHED PROPERLY		X		
340.13	MIS-MATCHING/INCORRECT MEDIAL, LATERAL QUARTER AND BACK HEIGHT	<=3mm	X		
340.14	MIS-MATCHING/INCORRECT MEDIAL, LATERAL QUARTER AND BACK HEIGHT	>3mm		X	
340.15	UNEVEN COLLAR TOP LINE		X		

	<b>Procedure</b>	Document No <b>A0373</b>	Version <b>11</b>	Page: 12/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020 Effective until: 14 Feb 2022

## 3<sup>rd</sup> Party Inspection Procedure (FTW)

<b>350</b>	<b>LACES / VELCROS/ SPEED LACE</b>				
350.01	LACE LACE LENGTH OUT OF SPEC (TOO SHORT OR LONG)	<= 3cm	X		
350.02	LACE LACE LENGTH OUT OF SPEC (TOO SHORT OR LONG)	> 3cm		X	
350.03	VELCRO / SPEED LACE LENGTH OUT OF SPEC (TOO SHORT OR LONG)	<= 2cm	X		
350.04	VELCRO / SPEED LACE LENGTH OUT OF SPEC (TOO SHORT OR LONG)	> 2cm		X	
350.05	LACE / VELCRO / SPEED LACE WRONG COLOR, WRONG MATERIAL, DAMAGED, BROKEN OR NOT FUNCTIONING			X	
350.06	CONTAMINATION		X		
350.07	FRAYING		X		
<b>360</b>	<b>OTHER DEFECTS (THAT NEED REPORT AND CONSULT WITH ADIDAS PRODUCTION/QUALITY)</b>				

Code	Defect Classification (Page 2/3)	Defect Type ==>	MINOR DEFECT	MAJOR DEFECT	CRITICAL DEFECT
<b>400</b>	<b>BOTTOM AND STOCKFITTING (attaching midsole and components to outsole)</b>				
400.01	CONTAMINATION (Stains)	<2 dots, <2mm	X		
400.02	CONTAMINATION (Stains)	>2 dots, >=2mm		X	
400.03	OVER CEMENTING OR PRIMING	<4mm length, <2mm width	X		
400.04	OVER CEMENTING OR PRIMING	>=4mm length, >=2mm width		X	
400.05	POOR TOUCH UP/PAINTING, MARKING LINE		X		
400.06	WRONG OR POOR OUTSOLE STITCHING	not 8-10mm/stitch	X		
400.07	<b>COLOR RELATED (WRONG COLOR, BLEEDING, MIGRATION, YELLOWING, ETC.)</b>				X
400.08	<b>VISIBLE FILM / BLOOMING ON RUBBER</b>				X
400.09	POOR MID-/OUTSOLE QUALITY (UNEVEN TOP LINE, TRIMMING, AIR BUBBLES, SCRATCHES, WRINKLES, ETC)			X	
400.10	POOR TREATMENT (PAINTING, LOGO)			X	
400.11	<b>COMPONENTS DELAMINATION</b>	>4mm length and depth			X
400.12	COMPONENTS DELAMINATION	<=4mm length and depth		X	
400.13	MISMATCHING, INCORRECT POSITIONING, WRONG SIZES			X	
400.14	DIMENSION/HARDNESS OUT OF SPEC			X	
<b>500</b>	<b>ASSEMBLING (attaching BOTTOM TO UPPER)</b>				
500.01	OFF CENTER / INCORRECT POSITIONING (SOLE LAYING)/LONG OR SHORT OUTSOLE		X		
500.02	<b>BONDING GAP</b>	>2mm length and depth			X
500.03	BONDING GAP	<=2mm length and depth			
500.04	WRONG BOTTOM/UPPER SIZE			X	
<b>600</b>	<b>CLEATS AND SPIKES</b>				
600.01	WRONG TYPE / WRONG COLOR / WRONG SIZE			X	
600.02	MISSING OR DAMAGED			X	
600.03	LOOSE OR NOT TIGHTENED		X		
600.04	NOT PROPERLY INSERTED (NOT 90 DEGREE ANGLE TO OUTSOLE PLATE OR WRONG DIRECTION)		X		
600.05	RECEPTACLE NOT PROPER COUNTERSUNK			X	
600.06	<b>RUSTY PARTS</b>				X
<b>700</b>	<b>BOOST</b>				
700.01	UNBLOWN BEAD		X		
700.02	SEMI UNBLOWN BEAD	MAX 1 PER PIECE	X		
700.03	YELLOWING BEAD BUT NO SIGNIFICANT COLOR DIFFERENCE	MAX 1 PER PIECE	X		
700.04	UNFILLED BEAD FOR NON-COLOR BOOST	±8MM X 6MM X 4MM, MAX 3		X	
700.05	UNFILLED BEAD FOR COLOR BOOST	±4MM X 3MM X 2MM, MAX 3		X	
700.06	CONTAMINATION BUT WITHOUT SIGNIFICANT COLOR DIFFERENCE TO STANDARD BOOST COLOR	MAX 1	X		
<b>800</b>	<b>VULCANIZED / vulcanized "look"</b>				
800.01	YELLOWISH ON FOXING EDGE		X		
800.02	OVER CEMENT ON QUARTER/COLLAR LINING (AFTER VULCANIZING)		X		
800.03	SCRATCHED FOXING	>3MM LENGTH		X	
800.04	UNSMOOTH FOXING (AIR BUBBLES INSIDE)		X		
800.05	OVERLAPPED FOXING CONNECTION		X		
800.06	GAP AT FOXING CONNECTION			X	
800.07	FOXING LABEL ATTACHING OFF CENTER	>3MM	X		
800.08	POOR FOXING TRIMMING			X	
<b>900</b>	<b>CARBON 4D</b>				
900.01	PRINTED DEFECT AT VISIBLE AREA		X		
900.02	BROKEN LATTICE	2 OR MORE		X	
900.03	SHIFT LINES		X		
900.04	EXCESS RESIN	OUTSIDE FOREFOOT		X	
900.05	SURFACE FINISH CLUMBS AT VISIBLE AREA		X		
900.06	CONTAMINATION	>1MM	X		
900.07	COLOR DIFFERENCE, MISMATCH			X	
900.08	YELLOWING		X		

	<b>Procedure</b>	Document No <b>A0373</b>	Version <b>11</b>	Page: 13/13
				Approval Date: 20 Feb 2020
				Effective: 20 Feb 2020 Effective until: 14 Feb 2022

## 3<sup>rd</sup> Party Inspection Procedure (FTW)

<b>1000</b>	<b>DIRECT SOLING</b>				
1000.01	DOUBLE SKIN		X		
1000.02	DOUBLE PRESSING LINE ON OUTSOLE		X		
1000.03	PU OVER-FLOW TO OUTSOLE		X		
1000.04	AIR BUBBLE	>1MM		X	
1000.05	UN-FILLED TPU	>8 DOTS/INCH <sup>2</sup>		X	
1000.06	PU OVER-FLOW TO INSOLE BOARD (NOT COVERED BY SOCKLINER)		X		
1000.07	POOR PARTING LINE TRIMMING	>1MM	X		
1000.08	UPPER PINCHING/DAMAGE	BROKEN		X	
1000.09	RELEASE AGENT MARKING AT VISIBLE AREA (CONTAMINATION)		X		
1000.10	PU OVER-FLOW TO UPPER	>1MM		X	
1000.11	MERGED UPPER TO PU MIDSOLE	>1MM	X		
1000.12	FLOW MARKING	CLEARLY VISIBLE	X		
1000.13	HIGH/LOW BACK		X		
1000.14	BONDING GAP PU & TPU			X	
1000.15	DAMAGED PU/TPU			X	
1000.17	TORN MATERIAL			X	
<b>1100</b>	<b>SLIDES/SANDALS</b>				
1100.01	DIFFERENT FOOTBED LENGTH	<= 3MM	X		
1100.02	DIFFERENT TOE/HEEL SPRING	>=3MM	X		
1100.03	OFF HEIGHT/WIDTH BETWEEN LEFT AND RIGHT THONG/FLIP-FLOP	>=3MM	X		
1100.04	OUTSOLE SUNKEN/COLLAPSING			X	
<b>Code</b>	<b>Defect Classification (Page 3/3)</b>	<b>Defect Type ==&gt;</b>	<b>MINOR DEFECT</b>	<b>MAJOR DEFECT</b>	<b>CRITICAL DEFECT</b>
<b>1200</b>	<b>KNITTING UPPER</b>				
1200.01	FRAYING OUT		X		
1200.02	BROKEN / COLOR VARIATION			X	
1200.03	HOT MELT YARN ACCUMULATES INTO GRANULES		X		
1200.04	UPPER PATTERN NOT SYMMETRY BETWEEN LEFT & RIGHT SHOE		X		
<b>1300</b>	<b>NO SEW</b>				
1300.01	DELAMINATION/PEEL OFF/CRACKING ON PRINTING			X	
1300.02	OVERFLOWING CEMENT	>0.5MM	X		
1300.03	NOT SYMMETRY BETWEEN LEFT & RIGHT SHOE		X		
1300.04	YELLOWING/WHITENING			X	
1300.05	COLOR DIFFERENT			X	
1300.06	BURN NO SEW			X	
1300.07	WRONG PRESSING POSITION / PRESSING MARKED		X		
<b>1400</b>	<b>OTHER DEFECTS (THAT NEED REPORT AND CONSULT WITH ADIDAS PRODUCTION/QUALITY)</b>				

## 10) Abbreviations

Sample	Quantity of product selected randomly from each lot
FGT	Finished Goods Testing
AQL	Acceptable Quality Level
MCS	Manufacturing Confirmation Sample
SHAS	Special Handling at Source
QIP	Quality Integration Project
PO	Production Order
IC	Inspection Certificate
VPS	Vice President Sourcing
SDOM	Senior Director Operations Management
DM	Director Manufacturing
SMP	Senior Manager Production
SDQ	Senior Director Quality
DQ	Director Quality
SQM	Senior Manager Quality