1.1. Each product code should have a separate specification for:

- Construction
- Bill of Materials
- Measurement and Tolerance
- Finishing Package
- Physical and Chemical Properties

1.2 Each raw material should have a separate specification for:

- Physical and Chemical Properties
- Measurement and Tolerances
- Packaging

1.3. Product Development in conjugation with Quality Control issues each specification.

2.1. The construction specification should include drawings in addition to detailed description of operations and should highlight special features.

2.2. The construction specification should include quality features which should be maintained.

2.3. The construction specification to be used should be, or should be based on, the "Construction and Specifications" for standard lines issued by the Product Development Department.

3.1. The measurement procedure is issued and maintained by Product Development Department and Quality Control (ref. Section 9).

3.2 The Product Development and Quality Control, taking into account market demand and process capabilities will determine measurement tolerances.

4.1. Jeans Constructions Characteristics

- Waistband construction to be 2 piece (seam along top edge as well as assembling seam).
- Close Front Pocket is a single needle lock-stitch operation and it is stitched, turned, and re-stitched. The shape of the closed pocket is squared rather than tapered towards the crotch.
- The front pocket is attached to the front panel with a single needle, turned and re-stitched with a double needle.
- The front pocket facing is stitched to the pocket lining with a 2 needle flat lock-stitch machine.
- 5 pocket garments have 4 rivets in the front (2 on each front pocket). Rivets may or may not be used on the back pockets.
- The watch pocket is attached with a double needle lock-stitch machine along sides. The hem of the watch pocket is caught in 2 needle flat lock-stitch in the same operation during pocket facing is attached of pocket lining.
- The tack on the watch pockets should be placed on hemstitch. The tack should be 3/8" gauge and placed at top of pocket.
- Belt loops to be 1/2" wide stitched with 2 needle cover-stitch. Bottom edge of belt loop to be caught in waistband assembling seam. Loops to be tacked 3/8" gauge at top & bottom of loop. Tack should cover the width of the loop.
- The inseam is either felled or safety stitched followed with edge stitch.
- The side-seam panels are either overlocked, or incorporate the selvage of the fabric (depending on the type of fabric being used). The side-seam is joined with a single needle chain (lock stitch is also authorised) and then seam busted.
- The back pocket is attached with lock stitch machine (either regular or automated) and is stitched around twice. The stitch gauge is either 1/4" or 3/16" around sides and bottom of pocket.
- The tack on the back pocket should be placed on the hemstitch. The tack should be 1/2" gauge and placed at the top of the pocket.
- Garments should have a leather patch on the band above the right back pocket. The patch may be authentic or imitation leather.
- Garments are to have the accurate design on back pockets.
- The high hip area of the side-seam is to be corded (where applicable).

- The inseam is to be tacked at the point where the join crotch and seat seam meet. The tack is not required on garments with a felled inseam.
- The fly (zip or buttoned) require 3/8” gauge tacks. One tack should be placed horizontal approx. 3/8” above end of fly. Other tack should be placed vertical approx. 5/8” above end of zip on inner 2 needle topstitch.
- Front and back panels can be merged together on the inside of garment at the hip area.
- Cuff to have double fold. Single lock-stitch 1/2” gauge.

5.1. All components used to manufacture R.M.Williams products are tested for physical properties according to the individual specifications (where relevant) or the end use of the product.

5.2 The relevant components specifications are available at the Quality Control Department.

5.3. Fabric and trim standards before and after finishing treatment are also available at the Quality Control Department.

5.4 Distribution of standards is at the discretion of the Quality Manager.

5.5. Sealed Samples of R.M.Williams® and Stockyard® products are the property of R.M.Williams Pty. Ltd and cannot be distributed without authorisation.

6.1. All the new components (new leather, fabric, fit, construction, finishing treatments and trims) must follow the Sample Approval Process (SAP).

6.2. All samples have to be fully approved before the bulk production can take place. This is to ensure production gets good quality and correct components/materials which assure good quality end product and customer satisfaction.

6.3. The Sample Approval Process (SAP) is based on the following criteria:

**Clothing**

* SAP Visual:
    * Base colour
    * Cast
    * Panel abrasion
    * Seam abrasion
    * Local abrasion
    * Photographic Guidelines
    * Trims Appearance Acceptability
    * Any other standard related to a certain product

* SAP Manufacturing:
    - Construction specifications
    - Measurement and tolerances
    - Trims appearance acceptability
    - Colour/ Wash appearance
    - Physical performance

**Footwear**

- SAP Visual
    - Leather and other relevant components colour
    - Selection / Appearance acceptability
    - Softness and feel
    - Colourfastness
    - Any other standard related to a certain product

- SAP Manufacturing
    - Cutting efficiency
    - Blocking
    - Lasting
    - Substance

    - Laboratory approval (all components and products)

6.4. Approved samples are signed off by:

- Product Development for finished product
- Quality Control for Lab testing
- Product Development for measurement and construction

**Any evaluation completed after the initial approval of components or finished product (such as rejects for physicals, rejects for measurements) can cancel the initial approval.**

6.5. An approved sealed sample for any relevant component or a completed product is sent to the manufacturing facility. This sealed sample is to be used to monitor bulk production.

6.6. All cross sourced samples have to match the signed off sealed sample (within the established limits where applicable). These additional items are handled by Sourcing, Product Development and Quality Control.

## 7.1 Scope

This procedure applies to any product or component not passing generic physical standards, whether it is during development or in bulk-production and whether it is temporary or for the whole production.

## 7.2 Overall Process

Whenever the substandard element is detected, the Manager in charge of the development or of the production of the element must fill in a "Request for Standard by Exception (SBE)" (annex A4.1) and send it to Quality Control. QC finalizes the document, sign and submits for sign off by the Product Manager and Commercial Operations.

## 7.3 Specific Guidelines

*Product Safety*: In case the substandard performance can have an impact on consumer's health, the Quality Control Manager must sign off. This applies in cases such as poor crocking, pH or any substance listed in the Restricted Substance List and/or the REACH Regulation out of standard range, uncommon smell, and fabrics too stiff.

*Commitment for improvement*: Any commitment to improve trim(s), a leather/fabric, a finish or a fit performance must be signed off by the Developer.
If a deadline for improvement is part of the agreement, it is the role of the Developer/Quality specialist in charge of the area to improve and advise the Quality Control, Product Development and Sourcing on final results. Would the performance not be in line with the commitment, the SBE procedure needs to be re-initiated by the Developer.

*Carry-over leathers/fabrics or products*: Unless the Standard By Exception specifically covered several seasons, a new request must be submitted for sign-off in case any component or product is carried over from one season to another.

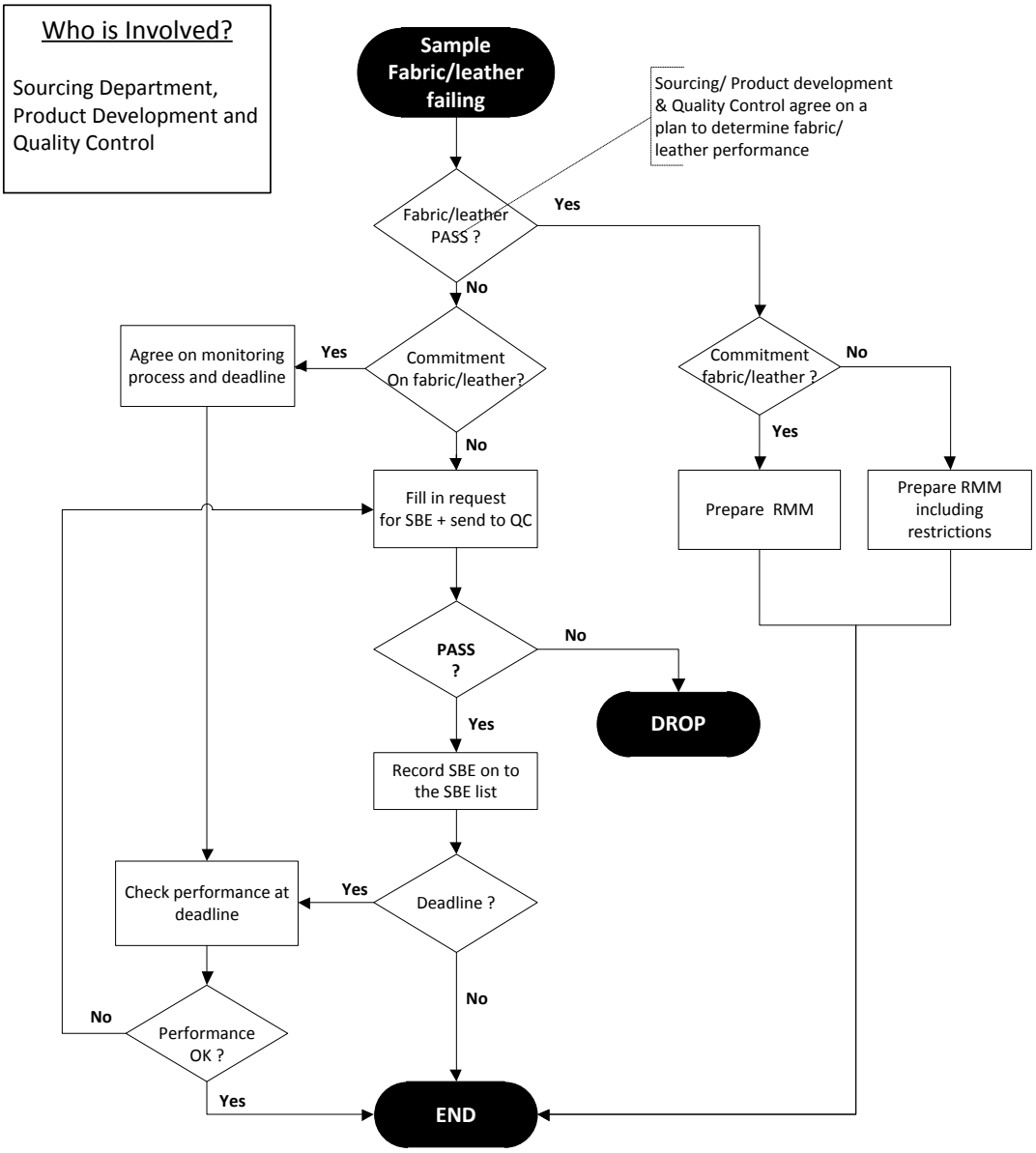
**Detailed processes**

Depending on the nature of the substandard performance, different processes must be applied, as described below:

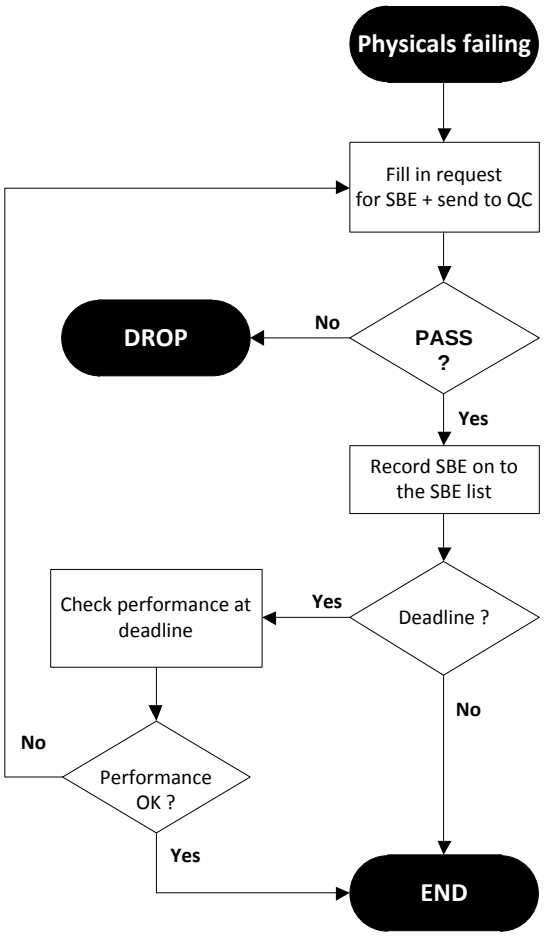
- The leather/fabric fails at development stage
  ➔ see 7.4.1
  *The Developer/Product Development fills in the request form.*
- The finished footwear/garment/leather good/Trims fail at development stage
  ➔ see 7.4.2
  *The Developer/Product Development fills in the request form.*
- The leather/fabric fail at production stage
  ➔ see 7.4.3
  *The supplier/QC fills in the request form.*

- The finished footwear/garment/Trims fail at production stage
  ➔ see 7.4.4
- *The supplier/QC fills in the request form.*

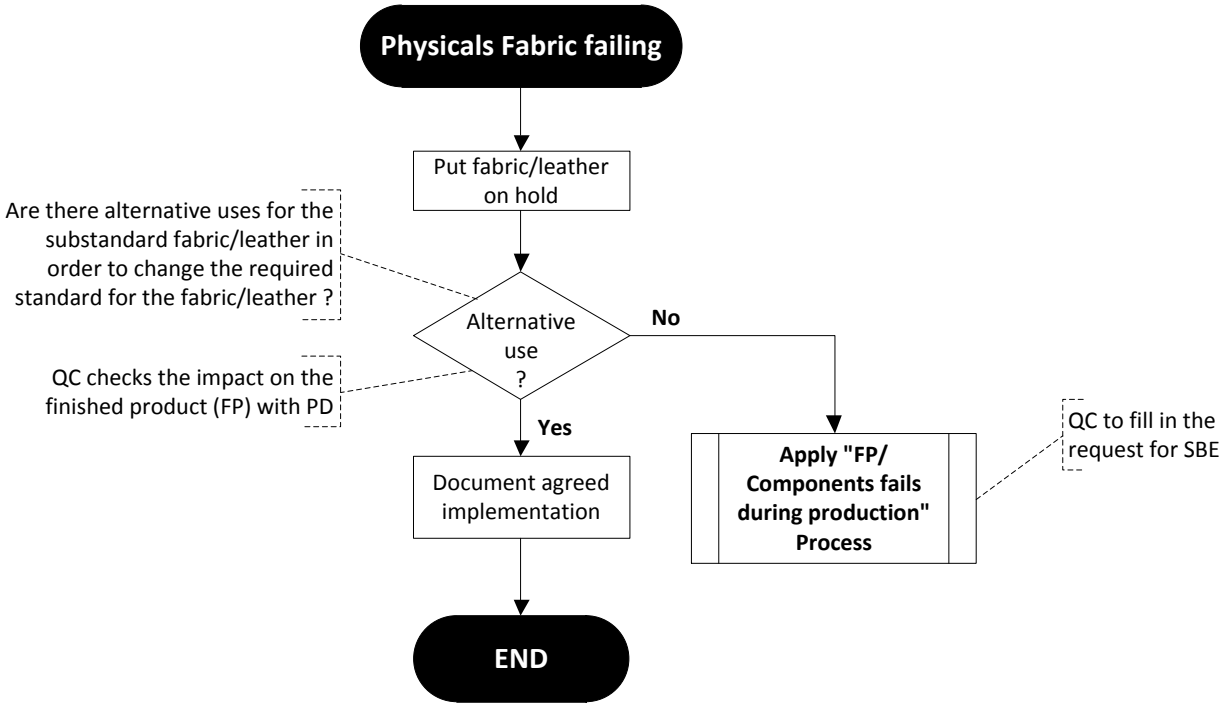
### 7.4.1 The leather/fabric fails at development stage



## 7.4.2 The finished garment/sundry fails at development stage



### 7.4.3 The fabric fails at production stage



## 7.4.4 The finished garment/sundry fails at production stage