3.3 Final Quality Control

3.3.1 Final Random Inspection (FRI)

The primary goal of the finished goods audit or final random inspection is to be able to determine at the factory whether a shipment is passed or failed to the inspection criteria. There should be no inspections pending buyer's approval; a passed inspection is approved to ship on confirmed delivery, a failed inspection must be re-inspected for any defect or other non-compliance.

While audits or inspections conducted at the factory are intended to assess adherence to Zulily's Quality Standards, the performance of such audit or inspection does not constitute Zulily's waiver of any defect or other non-compliance.

Zulily reserves the right to RTV in-stock merchandise and remove from Events within a reasonable time after it becomes aware of such non-compliance, up to and including after resale to its customers.

The inspection takes place when the merchandise is 100% complete and ready for final packing. For Workmanship & Measurement, a random sample of finished goods is selected, and the inspection conducted with reference to:

- ANSI/ASQZ1.4-2003: Inspection Method: Attributes For Workmanship Single Sampling Plan
    - Sample size - Normal Inspection Level II
    - Acceptable Quality Levels
        - Critical Defects: AQL 0
        - Major Defects: AQL 2.5
        - Minor Defects: AQL 4.0

QUALITY INSPECTION TABLES

ANSI/ASQ Z 1.4 - 2003

(Equivalent to MIL-STD 105E, BS 6001, ABC 105, NFX 06-22, DIN 40.080, ISO 2859)

Sample Size

Lot or Batch Size			Special Inspection Levels			General Inspection Levels		
			S-2	S-3	S-4	I	II	III
26	to	50	3	3	5	5	8	13
51	to	90	3	5	5	5	13	20
91	to	150	3	5	8	8	20	32
151	to	280	5	8	13	13	32	50
281	to	500	5	8	13	20	50	80
501	to	1200	5	13	20	32	80	125
1201	to	3200	8	13	32	50	125	200
3201	to	10000	8	20	32	80	200	315
10001	to	35000	8	20	50	125	315	500
35001	to	150000	13	32	80	200	500	800
150001	to	500000	13	32	80	315	800	1250
500001	and	Over	13	50	125	500	1250	2000

SINGLE SAMPLING PLAN FOR NORMAL INPSECTION

Sample Size	Acceptable Quality Levels (Normal Inspection)										
	0.065	0.10	0.15	0.25	0.40	.065	1.0	1.5	2.5	4.0	6.5
	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
3	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0	0
5	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0	⇕	⇕
8	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0	⇕	⇕	1
13	⇩	⇩	⇩	⇩	⇩	⇩	0	⇕	⇕	1	2
20	⇩	⇩	⇩	⇩	⇩	0	⇕	⇕	1	2	3
32	⇩	⇩	⇩	⇩	0	⇕	⇕	1	2	3	5
50	⇩	⇩	⇩	0	⇕	⇕	1	2	3	5	7
80	⇩	⇩	0	⇕	⇕	1	2	3	5	7	10
125	⇩	0	⇕	⇕	1	2	3	5	7	10	14
200	0	⇕	⇕	1	2	3	5	7	10	14	21
315	⇕	⇕	1	2	3	5	7	10	14	21	⇧
500	⇕	1	2	3	5	7	10	14	21	⇧	⇧
800	1	2	3	5	7	10	14	21	⇧	⇧	⇧
1250	2	3	5	7	10	14	21	⇧	⇧	⇧	⇧
2000	3	5	7	10	14	21	⇧	⇧	⇧	⇧	⇧

⇩ = Use first sampling plan below arrow

⇧ = Use first sampling plan above arrow

Ac = Acceptance number

The inspection takes place when Defect Classification- Workmanship

> **Critical Defect**: A defect which could result in hazardous or unsafe conditions for individuals using the product, as well as defects that violate legal regulations. Examples of critical defects include: broken needle parts in garment, incorrect country of origin label, incorrect care/content label.
>
> **Major Defect**: A defect that is likely to result in failure, or reduce materially the usability of the product for its intended purposes, or making it not possible for sale. Examples of major defects include holes, broken stitches.
>
> **Minor Defect**: A defect that is not likely to reduce materially the usability of the product for its intended purposes, or is a departure from established standards having little bearing on the product's effective use. An example of a minor defect is untrimmed threads.

An inspection of finished garments is primarily concerned with defects in workmanship and measurement although inspectors evaluate overall quality with a view to ensuring contract specifications are met.

Product is inspected for workmanship and construction defects. Inspection starts with measurement, followed by workmanship, then color.

Measurement (Apparel and Non-Apparel Textiles):

Samples are selected from the workmanship inspection sample and must be in purchased size & color ratio. If by meeting the purchased size & color ratio requirement in (a) the number of units to be measured exceeds the relevant inspection sample size in the chart above, the auditor should increase the number of units measured to the next sample size & accept/reject accordingly.

- All units in the measurement sample are measured for primary points of measurement .
- Two units per size and color are measured for all points.
- Points that are not identified as primary measurements are considered secondary measurement points.
- Measurements outside of tolerance for primary points count as a failed garment and the defect is counted in the statistical quality audit as a major defect.
- A sample with a measurement and a workmanship defect will be counted in both the respective inspection results.

Measurement (Hardlines):

- Measurement samples for Hardline goods are selected at final assembly to ensure are components are attached and secured in place for safety.
- As with apparel and non-apparel goods, key primary measurements are taken.

Workmanship Inspection (Apparel Specific):

- Inspectors thoroughly check all garment seams for stitching defects or notched fabric under stitches.
- Construction is as specified – all gauges/stitch types/tacks/stitches per inch
- Multiple defects – A sample with more than one defect will have the worst defect only count towards the total defects. A sample with one major and one minor defect will be counted as one major defect.
- Inspected samples with multiple defects will be noted on the inspection report.
- Only one (the worst) workmanship or measurement defect is counted per inspected sample
- Buttons, rivets, and snaps are checked for secure attachment.
- Fasteners (buttons, zippers, Velcro, etc.) are checked for proper functioning.
- Embellishment is as specified.
- Shading within the garment.
- Stripe Match as specified
- Tapes and linings as specified

- **Color Management (Apparel and Textiles):**
- Item-to-item shade band continuity and number of shades are checked.
- The assortment of colors and sizes is checked against the purchase order requirement.
- Correct labeling, including care and content, size, and color code etc.
- Fabric/finish/wash (are to be taken under Color Management)
- Packaging/hangtags/spare trims/shipping marks, etc. (are to be taken under Color Management}

FRI should be conducted in a dedicated space and workers trained in FRI standards.

- All workers performing inspections should receive training and have written inspection procedure and criteria available for reference.
- Inspection records and results and should be kept for 18 months.

Sample Audit Template

FINAL RANDOM INSPECTION REPORT

INSPECTION REPORT #:		INSPECTION TYPE	
DATE OF INSPECTION:		OVERALL INSPECTION RESULT	

ATTN:		C.C	
SUPPLIER :		FACTORY:	
FTY. ADDRESS:			
P/O :		TICKET NAME:	
COO:			
STYLE NO:		DESCRIPTION	
STYLE NAME :		ORDER QTY:	
SHIPPING QTY:			
CONFIRMED DLVY /NDC:		XFTY :	
X-COUNTRY		BY SEA ☐	BY AIR ☐
COLORS :		NO. OF SHADES:	

I. INSPECTION SUMMARY	PASS	FAIL
QUANTITY AVAILABLE	☐	☐
PRODUCT DESCRIPTION	☐	☐
WORKMANSHIP	☐	☐
MEASUREMENT	☐	☐
COLOR/SHADING	☐	☐
PACKING	☐	☐
SHIPPING MARK	☐	☐
HAND FEEL:	☐	☐
GARMENT WT, SWEATERS ONLY	☐	☐
CARTON AUDIT	☐	☐

PRODUCT FRONT PHOTO

UNIT PACKING PHOTO

II. ANSI/ASQZ1.4-2003-WORKMANSHIP-SAMPLING PLAN LEVEL II = AQL. Critical 0.0, MAJOR 2.5, 1 MINOR =1/2 MAJOR.

PO QTY	SHIP QTY	PACKED	UNPACKED	SAMPLE SIZE	DEFECTS ALLOWED	DEFECTS FOUND	RESULT

III, MEASUREMENT: SAMPLING PLAN-S4 (MINIMUM 20 PCS.) AQL 2.5, 1 MINOR = ½ MAJOR

SAMPLE SIZE	DEFECTS ALLOWED	DEFECTS FOUND	RESULT

IV. CARTON AUDIT. AQL.0.0, MIN 1 CTNS /SIZE

NO. OF CTNS SELECTED	RESULT

V. CARTON NO. SELECTED FOR AUDIT:

VI. THE CAPTIONED ORDER HAS BEEN INSPECTED AND FOLLOWING DEFECTS / DISCREPANCIES ARE FOUND:-

DEFECTS / DISCREPANCIES / COMMENTS	MAJOR	MINOR
TOTAL		
ACCUMULATED DEFECTS AFTER CONVERTING MINOR TO MAJOR		

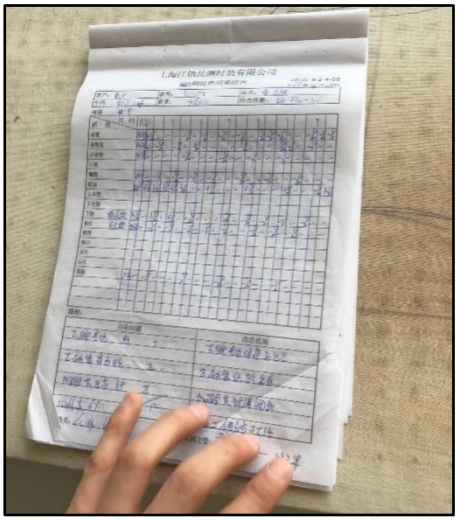
REMARKS :			VENDOR TO REFURBISH/MAKE ALL CORRECTIONS AS PER LISTED POINTS

Good Final Random Inspection examples:

Dedicated FRI space with AQL standard clearly

Finished products being checked against product specifications

Clearly labeled racks for conforming, repairable, and defective products



Measurement check records

3.3.2 Defective and Non-Conforming Products

Defective or non-conforming materials found in FRI inspection need to be clearly identified to prevent mixing with conforming materials.

- A designated area with clear signage should be set up the OQC area.
- Rework goods are to be clearly labeled, defects identified, and sent to separate rework area
    - Rework goods should go through FQC inspection after corrections have been made.

Good non-conforming identification examples:


Bins labeled for non-conforming goods and temporary labels for non-conforming