

# QUALITY CONTROL



Our QC department and systems are the backbone of our business. At the heart of Acme's business is the most important thing to understand "**What our Customers wants**" and to ensure that we deliver the same "**Effectively**", "**Consistently**" and "**On time**".

Every factory that we choose and work with is personally audited by our QC team based on our in-house 3M Formula:

- 1) **Management**: - To us people are the most important thing. The thinking and the attitude of the owner / people who run the factory is the key is to ensure that factory is in sync with you/your customers thinking.
- 2) **Material**: - The various quality Raw Materials which the factory use to make the final product are essential because only a good raw material can result to a good final product.
- 3) **Machinery**: - The manufacturing settings and the machinery used at various level of the manufacturing process are the key of the final quality. It is not important to have the latest machinery but is important to have good and well maintained machine with the correct settings.

Acme's QC teams believes in auditing the factory based on this 3M Formula and once the factory is selected, it becomes a part of our wide Galaxy of partner factories with whom we like to develop our business relationship.

Acme's QC team is formed with people who have technical back-ground and vast experience in the manufacturing field and relevant experience. Our QC team are strategically located in North India, Central India, West India and South India (as indicated in the diagram) to ensure that at any point of time our QC team can reach any factory in India within 24 hours. This goes as an edge to us as well as to our customers in providing a more faster and prompt services / responses.



The quality control procedures adopted by our various product divisions are briefly listed below:

- 1) **Raw Cotton** - Our cotton testing team is well experienced in manually checking the cotton by hand to judge its various parameters. After contract our cotton selectors visits the ginning factories for manually checking and approving the cotton which is **passed for approval. / offered for passing.** Moisture level is checked by moisture metre . Once the lot is passed by manual selection, cotton samples are drawn randomly from the same lot and submitted to an independent laboratory also to test the same on HVI mode, to ensure that the HVI parameters are in confirmative with the agreed norms with buyer as well as trash content is check on trashanalyser.
- 2) **Yarn** - Online inspection is done whereby our QC inspector visits the factory when the yarn production is been started to ensure that the initial production is matching as per customers laid specs and if required to advise spinning factories of changes if required in the machine settings to achieve the desired quality level. Once the lot is ready final inspection is conducted whereby 20 cones are selected randomly for laboratory test in which all critical yarn parameters like RKM, U%, Imperfections, Classimat, Hairiness, etc.. are checked and ensured that they match with specs committed to buyer. At the same time full cones are taken our from the final lot to make knitted fabric which is then dyed and bleached to check the problem of contamination, bariness and un-evenness. Rewinding test is done to check the winding performance and splice strength. Once quality is found to be as per achieved norms, the lot is Okayed for shipment.

### 3) **Fabrics (Woven and Knits):**

1) **Woven:** In woven fabric our QC team normally inspects the fabric based on the American 4 Point inspection system and the report on this made and submitted to buyer. Normally about 10% of the quantity is taken for inspection and lot report is prepared based on same. Fabric is also tested in laboratory for count , construction , GLM , skew test , breaking strength , width shrinkage, colour fastness .Upon customers request we can also arrange inspection as per Japanese 10 point system.



2) **Knits:** 10% of the lot size is taken for manual inspection on the table and is inspected for various parameters like slub, thick / thin places , contamination , barre etc. Also the knitted fabric is cut to check GSM & stitch length . For finished fabrics various tests like shrinkage , colourfastness are also done. Individual machine wise lot is given which is properly segregated by using separate color of Poly-bag for each lot.

4) **Garments and Home Textiles** - The procedure adopted is as listed below. The standards of control are as desired by the clients on the level of AQL's.

- 1) Pre-production activity report
- 2) Fabrics, Trims and accessories report
- 3) Marker, spreading and cutting quality report
- 4) In process manufacturing and control processes observation
- 5) Finishing, pressing & packaging report
- 6) Final product audit procedure

In every stage we maintain a product audit observation and with that the Action plans for the next stage agreed with the Factory Merchandiser / QA

**Other Recommendations on:**

- House keeping and maintenance
- General management and observations
- Health, fire, safety and labor rights
- Other remarks and comments

