



Chapter 5

To meet DXLG quality standards we require all vendors to perform random inspection during the bulk production process. Please note that all bulk testing reports should be approved by DXL Quality Assurance prior to arranging random inspection.

Final Random Inspection (FRI) for Private Label Merchandise

FRI Purpose:

The Final Random Inspection (FRI) is performed to assure all units shipped conform to the approved PP or TOP sample, are first quality merchandise, and are packaged, packed and shipped in full compliance to DXL Group requirements. The on-site inspection is conducted when 100% of goods are produced and 80% packed. Samples are selected at random, according to AQL sampling standards and procedures. The main areas of inspection are:

- Quantity check (order quantity versus shipment quantity). Purchase Order numbers against the total bulk quantity for shipment/order accuracy.
- Conformity of the presented product to the approved sample for style, fabric, and color
- Workmanship (basic function and appearance assessment)
- Product measurements
- Packing/Packaging check: product tags and stickers, barcodes, shipping marks, carton labels, packing method, polybags, carton quality & quantity, etc.
- Pass /fail findings for the total bulk shipment.
- Ensure accuracy of planned production quantity versus the shipment quantity (shortages/overages must be within +/-5% unless otherwise approved by DXLG Buyer).

FRI Timeline:

All vendors and factories must use Bureau Veritas for final random inspections unless otherwise agreed upon between the DXL Group Quality Assurance team and the factory or vendor. It is the vendors' responsibility to book and pay for these inspections. Bureau Veritas inspection services require a 2 week advance booking from the vendor's ex-factory date. DXL Group Quality Assurance team must receive all reports at least 72 hours before the shipments are prepared to exit the factory. Once the FRI reports are approved by the DXL Group Quality Assurance team the shipments may exit the factory. For factories conducting their own FRI's, the reports must be completed and uploaded into PLM and follow the same process as above.

All FRI's must be performed for each individual style and PO. Final random inspections for the same style across multiple PO's may be performed only with prior approval from the DXL Group Quality Assurance team. FRI's cannot consist of multiple styles without prior authorization.

Only factories that are approved by DXL Quality Assurance can conduct their own FRI's. The below DXL Group final random inspection form must be used for approved Vendors.



Testing and FRI forms can be found on the Vendor Guide website.

FRI Procedure: All final random inspections are conducted using a 2.5 AQL – Level II Normal Inspection along with a Compliance (Packaging & Label) Inspection per DXL Group requirements.

Sampling Plans: A sampling plan is based on each individual purchase order. The lot size is based on the number of units presented for inspection. The lot can include all colors and sizes from one style received from the vendor in the purchase order.

Appendix 1 AQL Normal Inspection Plan

Lot or Batch Size	Sample Size at General Inspection Level II	AQL (Single Sampling Plan for Normal Inspection)			
		Major 2.5		Minor 4.0	
		Ac	Re	Ac	Re
91 to 150	20	1	2	2	3
151 to 280	32	2	3	3	4
281 to 500	50	3	4	5	6
501 to 1,200	80	5	6	7	8
1,201 to 3,200	125	7	8	10	11
3,201 to 10,000	200	10	11	14	15
10,001 to 35,000	315	14	15	21	22

Appendix 2 AQL Tightened Inspection Plan

Lot or Batch Size	Sample Size at General Inspection Level III	AQL (Single Sampling Plan for Normal Inspection)			
		Major 1.5		Minor 2.5	
		Ac	Re	Ac	Re
91 to 150	32	1	2	2	3
151 to 280	50	2	3	3	4
281 to 500	80	3	4	5	6
501 to 1,200	125	5	6	7	8
1,201 to 3,200	200	7	8	10	11
3,201 to 10,000	315	10	11	14	15
10,001 to 35,000	500	14	15	21	22

Appendix 3 AQL Reduced Inspection Plan

Lot or Batch Size	Sample Size at General Inspection Level I	AQL (Single Sampling Plan for Normal Inspection)			
		Major 2.5		Minor 4.0	
		Ac	Re	Ac	Re
91 to 150	8	1	2	1	2
151 to 280	13	1	2	1	2
281 to 500	20	1	2	2	3
501 to 1,200	32	2	3	3	4
1,201 to 3,200	50	3	4	5	6
3,201 to 10,000	80	5	6	7	8
10,001 to 35,000	125	7	8	10	11



Product Measurement Audit:

Inspection Sampling Plan: Special Level 3 (S-3)

Acceptable Quality Level (AQL): Cannot exceed 10%, however, if more than 5 measured pieces (same size or in different sizes) are found out of tolerance on the same primary point (key point of the garment), the results will fail.

Lot or Batch Size	Special Inspection Level (S-3)
91 to 150	8
151 to 280	13
281 to 500	13
501 to 1,200	20
1,201 to 3,200	32
3,201 to 10,000	32
10,001 to 35,000	50
35,001 to 150,000	80

Example Scenario for the product measurement audit:

If the lot size is 1200 pieces, the number of samples to be measured is 20 pieces. Of the measured 20 pieces, if each piece has 10 measurement points, the total number of measurement points is 200. If more than 20 points are found out of tolerance, the audit fails.

Additional failure situation: If more than 5 measured pieces (same size or in different sizes) are found out of tolerance on the same primary point (key measurement point of the product), the audit fails. Therefore, if the chest width of 5 measured pieces are found out of tolerance, the audit fails regardless of the percentage of the out of tolerance points found.

Labeling/Packing/Packaging/Shipping Integrity: See chapters 2 & 3 for DXL Group compliance requirements.

Classification of Defects (refer to Appendix 4):

Three defect classifications (**critical, major and minor**) have been selected that will be used to classify types of defects (refer to appendix 4). Only critical and major defects will be considered when applying the sampling plan. The defect descriptions follow:

Critical: Any defect or feature of the product that may pose a safety hazard to the consumer or end user.

Zero tolerance will be applied to the acceptable quantity of critical defects found within a shipment.

Major: Any defect that adversely affects the appearance or performance of a product, including fit or customer satisfaction.

Any defect that is likely to materially reduce the usefulness of the product, or is likely to result in failure, is also a major defect. The consumer would normally be unwilling to accept such a defect, resulting in a return or complaint. Any major defects must be corrected and re-inspected before the shipment leaves the factory floor.

Minor: Any variation from the standard that is not sufficient in degree to be classified as major, and would not provide a discerning customer with justification for return or complaint.

The defect would not materially reduce the usefulness of the product, nor is it likely to result in failure.



Appendix 4 Defect Terms and Classification

Packing and Presentation	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Missing size and care label	X		
Missing hang tag		X	
Missing price tickets, price stickers and PIDs	X		
Price tickets, price stickers and PIDs placed on wrong item	X		
Wrong UCC128 placement			X
Wrong size ratio in pre pack cases	X		
Wrong SKUs mixed in single SKU cases	X		
Improper folding		X	
Soiled/Dirty/Unsealed poly bag		X	
QTY in case does not match QTY on UCC128 label	X		
PID applied in the wrong place on polybag		X	

General	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Use of monofilament sewing thread that will hurt customer's skin	X		
No warning clause on poly bag if required	X		
Any sharp point/sharp edge on accessories	X		
Infestation of live insect	X		
Lack of multi-languages for Fiber Content and Country of Origin (7 languages: English, French, Spanish, Dutch, Italian, German, and Russian). Lack of bi-lingual Care Instructions (French and English) and care symbols:-	X		
Needle detected	X		
Mildew/mold	X		
Strong odor	X		
Wet	X		
Holes		X	
Stains		X	
Mending place		X	
Missing bar tack (at significant area if specified)		X	
Different lots of shade from garment to garment (requires buyer approval).	X		
Cleaning mark		X	
Shank pulls off during inspection pull test	X		



Fabric	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Fabric flaw / run more than 1/2" at obvious part of a garment		X	
Fabric flaw / run more than 1" at non-obvious part of a garment		X	
Hole (any size other than pinhole)		X	
Wrong or slanted grain line		X	
Pills on surface (depends on density)		X	X
Color shade difference within same garment		X	
Printing fault (depends on obviousness)		X	X
Barrenness on knitted fabric (depends on obviousness)		X	X
Permanent crease mark		X	
Different dye lots (Needs buyer approval)	X		

Product Components/Trims	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Any missing accessory		X	
Dimension, color, art work or content not as specified		X	
Button inside out		X	
Button marking not removed		X	
Damaged button		X	
Rusted stud, snap, rivet, buckle, zipper, hook & bar, pins, clips		X	
Paint peel off on stud, snap and buckle		X	
Button and buttonhole not aligned causing bulge (depends on obviousness)		X	X
Buttonhole too small to allow button to pass through		X	
Buttonhole too big		X	
Uncut / partially cut buttonhole		X	
Ragged edges at buttonhole			X
Broken buttonhole stitches		X	
Button thread easily pulled out		X	
Wordings upside down on button / snap		X	X
Gap at zip top / end (depends on size)		X	X
Incomplete adhesive on interlining		X	
Illegible information on accessory		X	
Fusing bubbles/Wrinkled fuse on interlining		X	
Sparse embroidery		X	



Workmanship and Appearance			
***Stitching and Seams	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Irregular stitch density		X	X
Loose / tight stitches		X	X
Crooked stitches (depends on size)		X	X
Skipped stitches		X	
Broken stitches		X	
Run-off stitches 1/4" (depends on size)		X	X
Blind stitching visible (depends on obviousness)		X	X
Needle cutting		X	
Exposed seam grin			X
Insufficient seam allowance		X	X
Pleated seam		X	X
Seam slippage (If found on more than one garment - Critical)	X	X	
Puckering seam (depends on obviousness)		X	X
Open seam (any size)		X	
Seam not fully opened before stitching		X	X
Exposed under ply seam (depends on obviousness)		X	X
Abrasion feed mark (depends on obviousness)		X	X
Uncut thread ends 1" or more		X	
***Assembling	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Mismatched stripes, checks or prints over 1/8"		X	
Asymmetrical collar (depends on obviousness)		X	X
Uneven collar point 1/4"		X	X
Facings pulling up		X	X
Uneven sleeve length 1/2" or more		X	
Uneven leg length 1/2" or more		X	
High/low pockets 1/4" or more		X	
Pocket not smooth / squared (depends on obviousness)		X	X
Pocket flap not centered over pocket 1/4" (depend on length)		X	X
Misaligned of cuff / neck 1/4" (depends on length)		X	X
Uneven hem line (depends on obviousness)		X	X



Common Defects in Specific Products

Shirt	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Collar not symmetrical in size, shape or length (depends on size)		X	X
Exposed under collar at outside of top collar			X
Foreign matter sewn inside the finished collar/yoke/cuff			X
Open seam at collar points		X	
Interlining seen through		X	X
Flap points not fully turned out			X

Jacket/Outerwear	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Puckering seam at hood facing (depends on obviousness)		X	X
Front placket not down to hem 1/4" or more		X	
Uneven fullness at armhole			X
Wrong way insertion of zip (if specified)		X	X
Snap easily pulled off		X	
Uneven or loose elasticity on rib/bottom		X	
Loose quilting stitches		X	
Malfunctioning of buckle/snap/zipper		X	
Fabric easily torn at snap position		X	
A noticeable amount of down percolation on the lining		X	
Down leakage		X	
Exposed drill hole		X	
Incompatible interfacing causing cracking, puckering or bubbling		X	
Corresponding pockets horizontally uneven or misaligned 1/4" or more		X	
Color yarn caught inside shell fabric but obviously seen from outside		X	



Jeans	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
High-low waistband ends 1/4" or more		X	
Waistband corners not folded in right shape			X
Inclined belt loops			X
Mismatched belt loop color (depends on obviousness)		X	X
Pocket bag caught in tack		X	X
Missing bartack (at significant area if specified)		X	
Bulged fly (depends on obviousness)		X	X
Zip exposed when buttoned		X	
Rusted studs / rivets		X	
Twisted leg 1/2" or more		X	
Holes at hem after stone washing 1/4" or more		X	

Knitted T-Shirt	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Neck opening / collar not symmetrical		X	
Asymmetric body shape		X	
Twisted body at side seam 1/2" or more		X	
Twisted/slanted/curved/pleated placket (depends on obviousness)		X	X
Exposed row edge at cuff/hem (depends on obviousness)		X	X
Twisted seam at cuff / bottom (depends on obviousness)		X	X
Untrimmed seam allowance at inside hem (inside garment)			X
Mismatched rib color (depends on obviousness)		X	
Mismatched stripes / checks at shoulder / side seam 1/8" or above (depends on size)		X	X
Neck opening too small (if found in more than 1 garment - Critical)	X	X	
Neck opening too big		X	

Sweaters	Critical	Major	Minor
Wrong knitting pattern	X	X	
Barre		X	
Thin/thick place		X	
Single yarn (depending on seriousness)		X	X
Slub yarn			X
Split yarn			X
Yarn run		X	X
Knots (depending on size and frequency)		X	X
Hole (other than normal loop hole)		X	
Dirty yarn		X	X
Dropped stitches		X	
Garment weight below specification 1/2 lb or above		X	
Neck / opening too small (if found in more than 1 garment - Critical)	X	X	
Twisted sleeve 1/2" or more		X	
Twisted body 1/2" or more at side seam		X	
Shoulder seam / side seam / underarm seam shown at front		X	
High/low placket 1/4" on bottom		X	
Zigzag seaming at armhole			X
Facing exposed at placket			X
Harsh hand feel		X	
Melt or excessive wash		X	
Spirally (10° or more)		X	
Loose linking		X	
Untrimmed seaming thread			X
Tight/Insecure seam end at cuff/hem		X	
Different color of seaming yarn		X	X
Glazed or scorched press at seam		X	X
Flat press at cable		X	X
Shiny press at seaming		X	X
Less elastic at rib cuff/hem		X	X
Irremovable crease line		X	
Pull-out loop		X	

Leather Garments	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Color shade difference within same garment		X	
Needle cutting		X	
Scratch/surgery/brand/burnt/paint/cut/stretch mark		X	
Glue/hammer mark		X	X
Belly/marbled/drawn/discolored grain		X	X
Dead fold mark/setting out pleats		X	
Without silica gel pack or no warning clause on it		X	
Variation in skin thickness across the garment		X	
Weak adhesion		X	
Loose hair on fur		X	
Pencil mark		X	X
Button mark			X
Hanger mark		X	X
Scattered leather		X	
Grain break/peeling/wrinkles/cracks		X	
Pinholes			X
Score		X	
Brine draw		X	
Salt pits		X	
Large hair follicle holes in pig split affecting appearance		X	
Blood stain (if found in more than 1 garment - Critical)	X	X	

PVC Garments	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Fold mark (depending on seriousness)		X	X
PVC torn at button		X	
PVC adhesion		X	
Needle damaged		X	

Socks	<u>Critical</u>	<u>Major</u>	<u>Minor</u>
Uncut thread end			X
Strings joining diamonds less than 1-1/4 inch		X	
Waviness at toe seam		X	
Pattern / embroidery deviated from center		X	
Misplated		X	



Twisted grain / ribs (1/4 inch)		X	
Uneven toe		X	X
Open seam at heel gore		X	
Pilling		X	
Barre		X	X
Uneven sock length (max. 1/4 inch within the pair)		X	X
Uneven sock length (max. 1/2 inch from pair to pair)		X	X
Uneven Top width (max. 1/8 inch within the pair)		X	X
Uneven Top width (max. 1/4 inch from pair to pair)		X	X
Spot		X	
Hole		X	
Wrong hook direction		X	
Misprint / invisible print on capper		X	
Sticker placement not centered (1/4 inch)			X

Vendor Follow-up

Passing FRI Reports: Do not require DXL Group's approval to ship; however, the QA Auditor must acknowledge receipt of the report and advise of any inaccurate findings or missing documents, as applicable.

Global Sourcing Vendors with Failing/Pending FRI Reports: If the report FAILS or is Pending for DXL Group decision, the factory is not allowed to ship the goods. The QA Auditor will review the report to evaluate the failures/pending issues and discuss a corrective action plan with



the DXLG QA team. The QA Auditor will then communicate the corrective action plan/decisions to the vendor/factory.

The vendor/factory must acknowledge the plan/decisions made by DXL Group within 24 hours and provide a timeline to make the advised corrections or re-inspection, as applicable.

Domestic Vendors with Failing/Pending FRI Reports: The QA Auditor/Team must email the Buyer and the DXLG QA team a copy of the report and a summary of the issues found along with a corrective action plan. The DXL team will either approve the action plan or reject the plan. The vendor/factory must acknowledge the plan/decisions made by DXL Group and provide a timeline to make the advised corrections or re-inspection, as applicable.