

# FOCUS TEXTILE QUALITY MANUAL SUMMARY

## How To Control Fabric Workmanship Quality?

### CONTROL STANDARD – AMERICAN 4 POINTS SYSTEM

The system is applicable for woven and knitted fabric. Defects are penalized to their size without reference to their denomination. Penalty points are assigned for each defect according to the following table:

Size of Defects (length in inches)	Number of Penalty Points
Defects ≤3"	1
3" > Defects ≤ 6"	2
6" > Defects ≤9"	3
Defects > 9"	4

- 【Note】**
- a) No one meter should have more than 4 penalty points
  - b) Any holes (2 or more broken yarns) will be awarded with 4 points
  - c) Defects appearing within 1" (one inch) of either edge can be disregarded

#### 【Score calculation method】

The score counting for individual roll:

$$\text{Points} / 100 \text{ sqd meters (100m}^2\text{)} = \frac{\text{Total Penalty Points scored in the roll} \times 100}{\text{The width of the roll (m)} \times \text{roll length inspected (m)}}$$

The score counting for bulk:

$$\text{Points} / 100 \text{ sqd meters (100m}^2\text{)} = \frac{\text{Total Penalty Points scored in the bulk} \times 100}{\text{The bulk average width of the roll (m)} \times \text{actual total meters inspected}}$$

### 1<sup>st</sup> QUALITY (GRADE A) REQUIREMENT

#### 【1<sup>st</sup> QUALITY PENALTY DEFINITION SCORE AS BELOW TABLE】

1st Quality (Grade A)	General Piece Dyed Fabrics	Other Items Fabrics
Individual Roll	Up to 24 Points/100m <sup>2</sup>	Up to 27 Points/100m <sup>2</sup>
Average of bulk	Up to 14 Points/100m <sup>2</sup>	Up to 16 Points/100m <sup>2</sup>

#### 【CONDITION FOR FAIL OF SHIPMENT】

Focus requires do random inspection on the beginning or during production (DUPRO) and after suppliers finish bulk packing/label (FRI). And judge the condition for fail of shipment as below two points.

※AVERAGE PENALTY POINTS OF INSPECTED YARDAGE EXCEEDING TABLE ABOVE.

※MORE THAN 10% OF QUANTITY / ROLLS INSPECTED ARE NOT 1<sup>ST</sup> QUALITY WHICH BE GRADED AS "B".

### COLOR SHADE BATCH OF THE ROLLS REQUIREMENT

※Designs, patterns and colors must be in conformity with the reference samples / color-cards / strike-offs available, according to tolerances below.

TESTING ITEM	1ST GRADE ROLLS (SAME LOT)	1ST GRADE LOTS (SAME COLOR)	TESTING METHOD	NOTES
Shade Grading	Minimum 4/5	Minimum 3/4	Light Box (D65 - 10°)	Grey Scale Shading

## How To Control Fabric Physical (Test) Quality?

Focus requires our suppliers to control the bulk physical quality as following test requirements.

Focus always does following tests for Quality sample during developing stage and Bulk sample when the order production is finished.

CONSTRUCTION TEST REQUIREMENT			
TESTING ITEM	TOLERANCE	TESTING METHOD	NOTES
1.1) FABRIC WEIGHT PER UNIT AREA 1.1.1) PIECE DYED / PRINTING FABRIC 1.1.2) COATING / FLOCKING / EMBROIDERY FABRIC	-5% / + 5% -5% / + 10%	ASTM D 3776 Option C	FOLLOW PI REQUIREMENT IF IT IS NEGOTIATED SPECIALLY
1.2) FABRIC WIDTH 1.2.1) TOTAL WIDTH 1.2.2) CUTTABLE WIDTH	-1% / +2% UP TO 2" LESS	ASTM D 3774-	FOLLOW PI REQUIREMENT IF IT IS NEGOTIATED SPECIALLY
1.3) YARN COUNT 1.3.1) STAPLE 1.3.2) FILAMENT FLAT (FDY) 1.3.3) FILAMENT TEXTURIZED (DTY)	-15% / +10% -10% / +10% -10% / +15%	ASTM D 1059	
1.4) THREADS PER UNIT LENGTH (DENSITY) 1.4.1) WARP / WALE DENSITY 1.4.2) WEFT / COURSE DENSITY 1.4.3) SQUARED AREA DENSITY	-5% / + 5% -5% / + 5% -3% / +3%	ASTM D 3775	
1.5) FIBER CONTENT	-3% / +3%	AATCC 20A	
1.6) TWIST PER UNIT LENGTH	-5% / +10%	ASTM D 1422 / ASTM D 1423	-
1.7) BOW / SKEW (AS RECEIVED) 1.7.1) WOVEN PLAIN/DOBBY/JACQUARD 1.7.2) WOVEN TWILL 1.7.3) WOVEN SATIN 1.7.4) KNITTING	UP TO 3% UP TO 5% UP TO 7% UP TO 5%	ASTM D 3882	WEFT STRIPPED AND CHECKED DESIGNS: UP TO 1%, OTHERWISE ACCORDING TO PD FABRICS
1.8) THICKNESS (FOR COATING ARTICLE)	+/- 0.05mm	ASTM D 1777	

COLOR FASTNESS TEST REQUIREMENT				
TESTING ITEM	SHADE CHANGE	STAIN	TESTING METHOD	NOTES
2.1) COLOR FASTNESS TO WASHING(1 WASH) 2.1.1) LIGHT COLORS 2.1.2) MEDIUM COLORS 2.1.3) DARK COLORS	MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4	MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	ISO 105 C06	METHOD AND OPTION TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
2.2) COLOR FASTNESS TO WATER	NO REQUIREMENT	MINIMUM 4	AATCC 107	
2.3) COLOR FASTNESS TO RUBBING 2.3.1) DRY 2.3.1.1) LIGHT COLORS 2.3.1.2) MEDIUM COLORS 2.3.1.3) DARK COLORS 2.3.2) WET 2.3.2.1) LIGHT COLORS 2.3.2.2) MEDIUM COLORS 2.3.2.3) DARK COLORS	NO REQUIREMENT	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 008	
2.4) COLOR FASTNESS TO HOT PRESSING 2.4.1) DRY 2.4.1.1) LIGHT COLORS 2.4.1.2) MEDIUM COLORS 2.4.1.3) DARK COLORS 2.4.2) DAMP / WET 2.4.2.1) LIGHT COLORS 2.4.2.2) MEDIUM COLORS 2.4.2.3) DARK COLORS	MINIMUM 5 MINIMUM 5 MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4	MINIMUM 4,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 133	PRESSING TEMPERATURE TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
2.5) COLOR FASTNESS PERSPIRATION 2.5.1) LIGHT COLORS 2.5.2) MEDIUM COLORS 2.5.3) DARK COLORS	MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4	MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	ISO 105 E04	-
2.6) COLOR FASTNESS DRY CLEANING 2.6.1) LIGHT COLORS 2.6.2) MEDIUM COLORS 2.6.3) DARK COLORS	MINIMUM 4,5 MINIMUM 4,5 MINIMUM 4	MINIMUM 4 MINIMUM 3,5 MINIMUM 3,0	AATCC 132	METHOD AND OPTION TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE

**DIMENSIONAL STABILITY TEST REQUIREMENT**

TESTING ITEM	WOVEN FABRIC		KNITTED FABRIC		TESTING METHOD	NOTES
	WARP	WEFT	WARP	WEFT		
<b>4.1) DIMENSIONAL STABILITY TO WASHING (1 WASH)</b> 4.1.1) 100% SYNTHETIC FIBER (POLYESTER / NYLON) 4.1.2) 100% ARTIFICIAL FIBER (RAYON / BAMBOO) 4.1.3) 100% NATURAL FIBER (COTTON / LINEN) 4.1.4) 100% ANIMAL FIBER (WOOL) 4.1.5) SPANDEX ≤ 15% IN COMPOSITION 4.1.6) BLENDED MIXTURE (SYNTHETIC FIBER ≥ 50%) 4.1.7) BLENDED MIXTURE (SYNTHETIC FIBER <50%)	UP TO 3%	UP TO 3%	UP TO 5%	UP TO 5%	ISO 6330	METHOD AND OPTION TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
<b>4.2) DIMENSIONAL STABILITY TO IRONING</b> 4.2.1) 100% SYNTHETIC FIBER (POLYESTER / NYLON) 4.2.2) 100% ARTIFICIAL FIBER (RAYON / BAMBOO) 4.2.3) 100% NATURAL FIBER (COTTON / LINEN) 4.2.4) 100% ANIMAL FIBER (WOOL) 4.2.5) SPANDEX ≤ 15% IN COMPOSITION 4.2.6) BLENDED MIXTURE (SYNTHETIC FIBER ≥ 50%) 4.2.7) BLENDED MIXTURE (SYNTHETIC FIBER <50%)	UP TO 2%	UP TO 2%	UP TO 4%	UP TO 4%	IN HOUSE METHOD	IRONING TEMPERATURE TO BE APPLIED ACCORDING TO CARE LABEL SYMBOLS OF ARTICLE
<b>4.3) DIMENSIONAL STABILITY TO DRY CLEANING</b>	UP TO 5%	UP TO 5%	UP TO 7%	UP TO 7%	COMMERCIAL METHOD	IN CASE THE WASH IS NOT ALLOWED
<b>4.4) SKEWNESS CHANGE IN FABRIC AFTER AUTOMATIC HOME LAUNDERING (AFTER 1 WASH)</b>	UP TO 3%		UP TO 5%		ISO 16322-2	-

**STRENGTH TEST REQUIREMENT**

TESTING ITEM	TOLERANCE				TESTING METHOD	NOTES
	W ≤ 100 G/M <sup>2</sup>	100 G/M <sup>2</sup> < W ≤ 150 G/M <sup>2</sup>	150 G/M <sup>2</sup> < W ≤ 300 G/M <sup>2</sup>	W > 300 G/M <sup>2</sup>		
<b>3.1) TENSILE STRENGTH (WOVEN) – BASED ON GROUND FABRIC WEIGHT</b> 3.1.1) WARP 3.1.2) WEFT  <b>ELONGATION</b> 3.1.1) WARP 3.1.2) WEFT	111 N 111 N	155N 133 N	200 N 178 N	222 N 222 N	ASTM D 5034; Instron CRE 1"- Grab	-
<b>3.2) TEAR STRENGTH (WOVEN) – BASED ON GROUND FABRIC WEIGHT</b> 3.2.1) WARP YARN TORN 3.2.2) WEFT YARN TORN	7 N 7 N	9 N 9 N	13 N 13 N	15 N 15 N	ASTM D 1424	-
<b>3.3) SEAM SLIPPAGE (WOVEN) 1/5" – BASED ON GROUND FABRIC WEIGHT</b> WARP WEFT	45 N 45 N	89 N 89 N	133 N 133 N	200 N 200 N	ASTM D 0434	-
<b>3.4) BURST STRENGTH (KNITTED) – BASED ON GROUND FABRIC WEIGHT</b>	90 N	120 N	180 N	210 N	ASTM D 3786	-
<b>3.5) STRETCH &amp; RECOVERY</b> 3.5.1) WOVEN (WITH SPANDEX) 3.5.1.1) EXTENSION 3.5.1.1.1) WARP DIRECTION (WHEN APPLICABLE) 3.5.1.1.2) WEFT DIRECTION (WHEN APPLICABLE) 3.5.1.2) RESIDUAL EXTENSION AFTER 01 MIN RELAXATION 3.5.1.2.1) WARP DIRECTION (WHEN APPLICABLE) 3.5.1.2.2) WEFT DIRECTION (WHEN APPLICABLE) 3.5.1.3) RESIDUAL EXTENSION AFTER 30 MIN RELAXATION 3.5.1.3.1) WARP DIRECTION (WHEN APPLICABLE) 3.5.1.3.2) WEFT DIRECTION (WHEN APPLICABLE) 3.5.2) KNITTED (WITH SPANDEX) 3.5.2.1) EXTENSION 3.5.2.1.1) OPPOSITE TO SPANDEX DIRECTION 3.5.2.1.2) SPANDEX DIRECTION 3.5.2.2) RESIDUAL EXTENSION AFTER 01 MIN RELAXATION 3.5.2.2.1) OPPOSITE TO SPANDEX DIRECTION 3.5.2.2.2) SPANDEX DIRECTION 3.5.2.3) RESIDUAL EXTENSION AFTER 30 MIN RELAXATION 3.5.2.3.1) OPPOSITE TO SPANDEX DIRECTION 3.5.2.3.2) SPANDEX DIRECTION	NO REQUIREMENT NO REQUIREMENT  UP TO 08% UP TO 08%  UP TO 05% UP TO 05%	NO REQUIREMENT NO REQUIREMENT  UP TO 08% UP TO 08%  UP TO 05% UP TO 05%	NO REQUIREMENT NO REQUIREMENT  UP TO 08% UP TO 08%  UP TO 05% UP TO 05%	NO REQUIREMENT NO REQUIREMENT  UP TO 08% UP TO 08%  UP TO 05% UP TO 05%	BS EN 14704-1 ASTM D2594	-
<b>3.6) PILLING RESISTANCE (AS RECEIVED)</b>	MINIMUM 3,0	MINIMUM 3,0	MINIMUM 3,0	MINIMUM 3,0	ASTM D 3512	-
<b>3.7) APPEARANCE AFTER WASHING (1 CYCLE FOR GENERAL ARTICLE / 10 CYCLES FOR COATING)</b>	SATISFACTORY / MINIMUM 4,5 CROSS STAINING	SATISFACTORY / MINIMUM 4,5 CROSS STAINING	SATISFACTORY / MINIMUM 4,5 CROSS STAINING	SATISFACTORY / MINIMUM 4,5 CROSS STAINING	In House Method	-

## SPECIFIC TESTS FOR BONDED, LAMINATED AND COATED FABRICS

STRENGTH TEST REQUIREMENT			
TESTING ITEM	TOLERANCE	TESTING METHOD	NOTES
1.1) BONDING STRENGTH FOR BONDED AND LAMINATED FABRICS	≥ 20 x 20 OZ/INCH	AATCC 136-2013	
1.2) ADHESION OF COATING TO FABRIC (BEFORE AGING)		ASTM D 751:2006	
1.3) APPEARANCE AFTER WASHING (10 CYCLES)	COLOR CHANGE ≥ 4 PILLING ≥ 4 SELF STAINING ≥ 4-5 DELAMINATION CRACKING COATING LOST CREPE OTHER APPEARANCE	IN HOUSE	
1.4) APPEARANCE AFTER ACCELERATED HEAT AGING (1 WEEK - 70 °C)	COLOR CHANGE ≥ 4 PILLING ≥ 4 SELF STAINING ≥ 4-5 DELAMINATION CRACKING COATING LOST CREPE OTHER APPEARANCE	IN HOUSE	
1.5) ADHESION OF COATING TO FABRIC (AFTER AGING)		ASTM D 751:2006	

## How To Label?

We have two label systems as below for supplier choice. In case 1st option label system can't be used, 2<sup>nd</sup> option label style will be considered.

### 1<sup>ST</sup> OPTION: NEW LABEL SYSTEM

1. Supplier register and get the user login name and password from Focus site: <http://focuswebchina9775.cloudapp.net/>
2. Print the fabric information label (a) as below shown from the site, according to site guide indication. The system will made 1 label per roll.
3. Prepare the colored lot number label (b) as below shown by supplier selves.

<b>PRODUTO</b> P31TP0189E20242 TRANSP FLOW PRT 02-006 VERDE JOIA			
<b>COMPOSIÇÃO</b> 100.00% POLIESTER			
<b>LARGURA TOTAL M</b> 1.500 1.47 A 1.53	<b>PESO GM2</b> 47 44.65 A 49.35	<b>OZ</b>	<b>REND. GM2</b>
<b>LOTE</b> 1	<b>ROLO FORNECEDOR</b> 1	<b>PESO LÍQUIDO KG</b>	
<b>FABRICADO NO(A):</b> CHINA		<b>METRAGEM (M)</b> 88.00	
<b>IMPORTADOR</b> EXCIM IMPORT E EXPORT		<b>CNPJ</b> 02384871000181	
			
<small>OBS. EM CASO DE RECLAMAÇÃO ANEXE ESSA ETIQUETA, V. 1.3</small>			
0002000001			
			

【 Fabric information label 】



【 Colored Lot number label 】

4. Position of labels: Fabric information label (1 pc, Size: according to the Portal system) and Colored Lot number labels (1 pc, Suggested size: Diameter around 3 cm) must be placed at extremity of the roll, outside of poly-bag.



5. Packing list detail should be uploaded in the web-site.
6. Focus China office will help and guide suppliers to get login, password and instructions how to use the new label system
7. Glue/sticking must be strong enough in order to avoid label falling during container loading / sea travel / container unloading and logistic handling.
8. Hand written, even partially, will not be accepted by Focus Têxtil. All necessary data should be indicated by stamp.
9. Focus Têxtil requires not to write anywhere by any means in the fabric, tags or wrapping as follows:
- Factory / Supplier name
  - Anything in English language
  - Chinese or Korean letters

**2<sup>nd</sup> OPTION: PREVIOUS LABEL STYLE**

Our suppliers should make and print fabric information label, Care label and Color lot label as below guidance.

**【Fabric information label】**

**IMPORTADOR:EXCIM**  
**IMPORTAÇÃO EXPORTAÇÃO SA**  
**CNPJ: 02.384.871/0001-81**

**COMPOSIÇÃO:** (Percentage/fiber content)

QUANT. GROSS (KG): (means gross quantity for knitted goods in kilos)  
 QUANT. NET (KG): (means net quantity for knitted goods in kilos)  
 QUANT. (M): (means quantity for woven goods in meters)  
 COR NR: (color # of color way)    COR NOME: (color name)  
 DES. NR: (design# of color way)

**LARG. TOTAL(M):** (Article total width in meters)  
ORD. NR: (means order #)    PESO (G/M<sup>2</sup>): (Article weight in g/m<sup>2</sup>)  
 ART. NR: (means article #)    LOT NR: (means lot #)  
 ROL. NR: (means roll #)

**FABRICADO NO(A):** (means country of origin)  
QUANT. PONTOS: (means points quantity found for the roll) - OPTIONAL  
 PONTOS / 100 M<sup>2</sup>: (means conversion into points qty / 100m<sup>2</sup>) - OPTIONAL

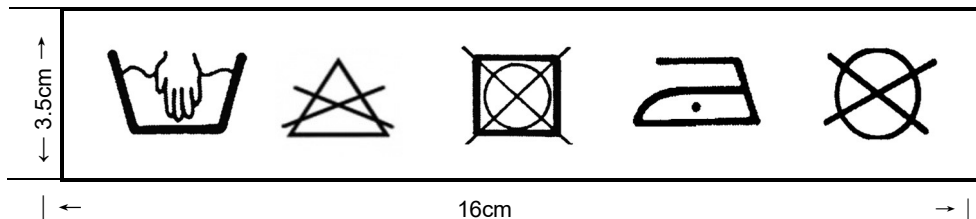
**【Note】**

- ※All fields indicated in LARGE DARK highlight should size no shorter than 5mm after printing.
- ※Composition should be indicated by Portuguese

<b>Composition translation chart</b>	
<b>ENGLISH</b>	<b>PORTUGUESE</b>
POLYESTER	POLIESTER
NYLON	POLIAMIDA
COTTON	ALGODÃO
LINEN	LINHO
VISCOSE	VISCOSE
RAYON	RAYON VISCOSE
PAC/ ACRYLIC	ACRILICO
SPANDEX / PUE	ELASTANO
METALIC	METALICO
WOOL	LÃ

- ※ Order number and Color name should be printed as CA document indication.
- ※ 1pc must be placed at one side of each roll, outside the polybag.

**【Care label】**



**【Note】**

- ※ Supplier should find and make the care symbols according to **corresponding article quality sample test approval mail comments.**
- ※ One piece must be placed at one side of each roll, inside of poly-bag. (Pls see below table 1.)

**【Colored Lot number label】**

※ Same requirement as 1<sup>st</sup> option introduces.

**【Additional Note】** Pls follow the same points 7, 8, 9 in 1<sup>st</sup> option label requirement.

**【 Table 1】**



Fabric information label position

Care label position

## How To Roll And Pack?

### 1<sup>st</sup> step: Prepare paper tube.



- ※ Tube length cannot be shorter than fabric width. But don't exceed 2cm per end of roll.
- ※ Tube Inner diameter: 3.5cm, thickness: 0.4cm, Pls see above picture A.
- ※ Tube is required to be strong in order to avoid smashing, breaking during container loading/sea travel/logistic handling.

### 2<sup>nd</sup> step: Rolling

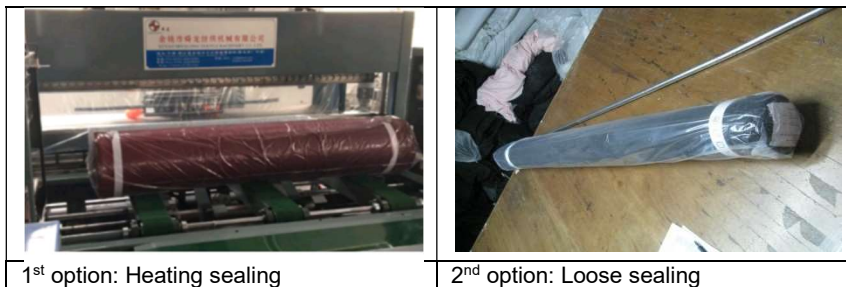
- ※ Fabric face inside rolling. Roll touch must be soft and cold.
- ※ One white paper tape should be bind at both sides of roll in order to tight the roll.
- ※ Transparent gummy tapes cannot be used on the fabric face and back side directly.
- ※ Each roll piece length: should be followed corresponding PI **color assortment document** indicated. Pls see below picture We will give this document to suppliers before bulk produce.

5	ROYAL	C - JULY 11TH 2018	P11AC0164500099-CHARMEUSE COMMERCE ROYAL	20.000	
				<b>TOTAL</b>	<b>220.000 M</b>
<small>PIECE LENGTH OF M ( ) / PIECE LENGTH OF M ( ) ACCORDING QUALITY MANUAL - BULK ORDER SHOULD BE LOADED IN THE CONTEINER IN COLOUR GROUPS (ROLLS OF SAME COLOR)</small>					

Find here

### 3<sup>rd</sup> step: Packing

- ※ We only accept the plastic bag packing, and heating sealing or loose sealing with self-tied or gummy tapes.



- ※ Plastic bag should be strong in order to avoid damages during container loading / sea travel / logistic handling.
- ※ Plastic bag thickness: 0,08mm, sheerness of minimum: 70%.
- ※ P.P. bag, clothing bag is not allowed.
- ※ Vacuum packing and Carton packing is only used for special item, should be confirmed with Focus quality department.



\*\*\* THE END \*\*\*