

General Inspection Checklist for Footwear

Scope:

A general quality inspection checklist for Footware if clients have not defined their requirement.

Defective Classification

- * **Critical Defect** – Defects which could result in hazardous or unsafe conditions for individuals using or maintaining the product as well as defects contravening legal regulations;
- * **Major Defect** – Function defects reducing the usability or solidity of the product as well as obvious visual defects reducing the sales value of the product.
- * **Minor Defect** – Defects that are unlikely to reduce the use of the product, but nevertheless may influence the sale.

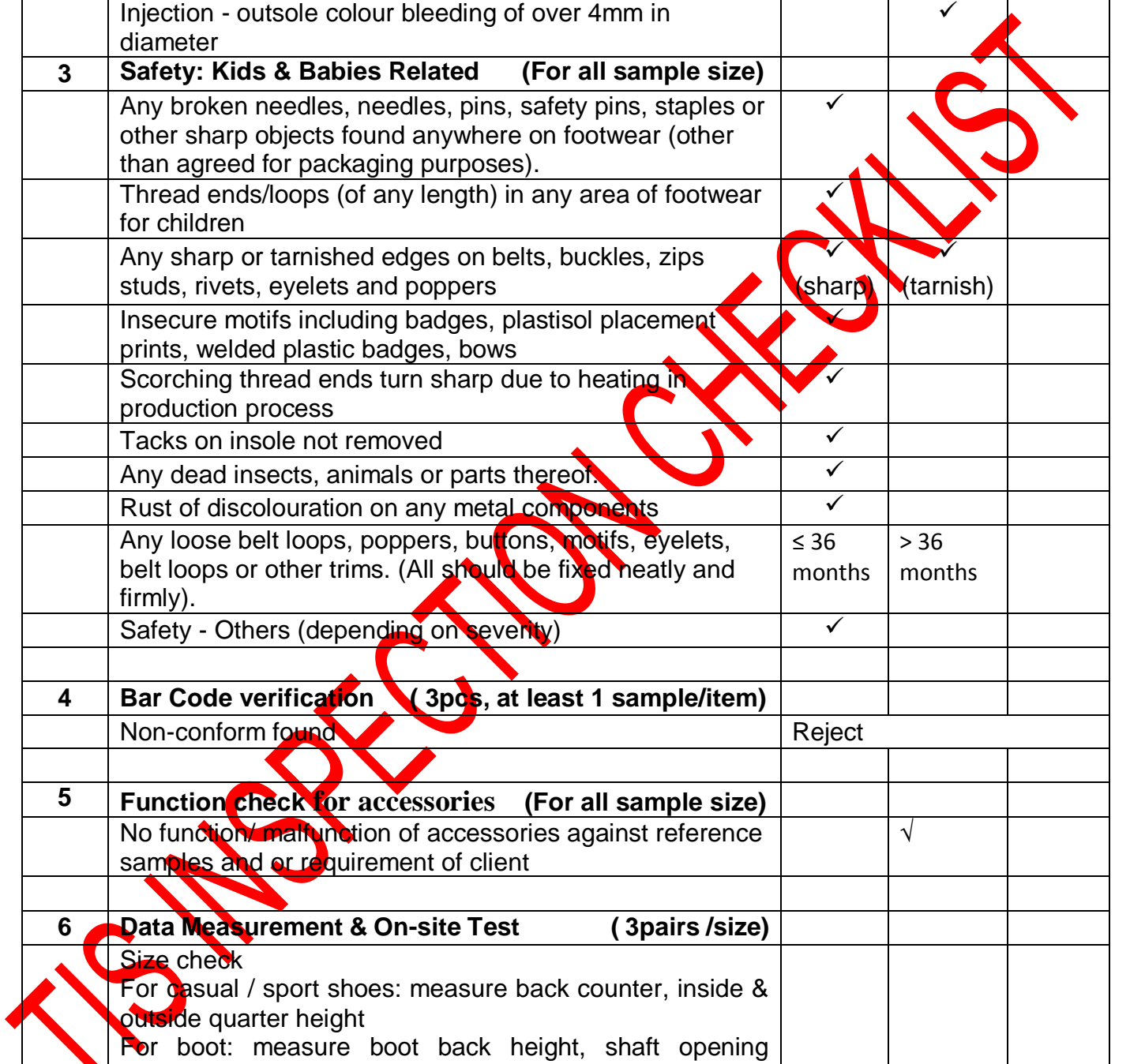
Item Code	Details	Defective classification		
		Critical	Major	Minor
1	Packaging check			
	(For all sample size) Non-conform found	Reject		
2	General appearance / workmanship			
	(For all sample size)			
A	Materials Defects: Fabrics, Material, Components, Accessories & Cutting			
	Incorrect material quality		✓	
	Colour variation from sealed sample		✓	
	Pattern variation from sealed sample		✓	
	Variation in finish or colour within pairs		✓	
	Variation of trims or extras from sealed sample (e.g. laces)		✓	
	Cracked outsole		✓	
	Material tearing		✓	
	Material - other (depending on severity)		✓	✓
	B Construction Defects: Stitching			
Incorrect, thread, stitch density, stitching		✓		
Stitching broken or run-off		✓		
Stitch not straight		✓		
Poor / Loose stitching		✓		
Poor tongue stitching to vamp		✓	✓	



	Stitching - other (depending on severity)		✓	✓
C	Presentation: Appearance (non-safety related)			
	Any non-functioning, poorly attached or missing parts in components		✓	
	Incorrect placement of components		✓	
	Tarnished metals		✓	✓
	Poor Embroidery or prints		✓	✓
	Upper marked with stains, dirt, stitch marking ink or cement		✓	✓
	Any eyelets, studs, caps, loops, buckles, ornamentations not accurately placed or not in correct alignment		✓	✓
	Loose or Untrimmed Thread ends (over 1 cm in length)		✓	
	Appearance - others (depending on severity)		✓	✓
D	Finishing - Lasting			
	Tacks or staples in shoes	✓		
	Sharp edges (e.g. hardened cement, buckles)	✓		
	Insocks not placed evenly or neatly or not securely stuck down		✓	
	Scuffed or damaged upper		✓	
	Top-piece incorrectly positioned		✓	
	Incorrect sole attachment		✓	
	Toe puff too soft		✓	
	Stiffener too soft		✓	
	Pipey or loose leather on vamp		✓	
	Blooming of upper materials		✓	
	Delaminated toe puff or stiffener		✓	
	Toe spring / heel pitch		✓	
	Top-piece loose		✓	✓
	Poor finishing on upper		✓	✓
	Heel covering peeling		✓	✓
	Facings positioned incorrectly		✓	✓
	Uppers wrinkled or counter/toe puff profiling		✓	✓
	Suspect bond		✓	✓
	Toe puff print through		✓	✓
	Uneven or no edge inking		✓	✓
	Flaws or scars on upper leather		✓	✓
	Outsole rocking		✓	✓
	Colour bleeding in upper or lining		✓	✓
	Collapsed shoe shape		✓	✓
	Fronts/foreparts not straight		✓	✓
	Different length fronts/foreparts		✓	✓
	Different heel positions or heel (s) not straight		✓	✓
	Different length fronts/foreparts		✓	✓



	Different heel positions or heel (s) not straight		✓	✓
	Back heights		✓	✓
	Pleating around feather line		✓	✓
	Injection - outsole colour fading on sole surface			✓
	Injection - outsole colour fading on side wall		✓	
	Injection - outsole colour bleeding of over 4mm in diameter		✓	
3	Safety: Kids & Babies Related (For all sample size)			
	Any broken needles, needles, pins, safety pins, staples or other sharp objects found anywhere on footwear (other than agreed for packaging purposes).	✓		
	Thread ends/loops (of any length) in any area of footwear for children	✓		
	Any sharp or tarnished edges on belts, buckles, zips studs, rivets, eyelets and poppers	(sharp)	(tarnish)	
	Insecure motifs including badges, plastisol placement prints, welded plastic badges, bows	✓		
	Scorching thread ends turn sharp due to heating in production process	✓		
	Tacks on insole not removed	✓		
	Any dead insects, animals or parts thereof.	✓		
	Rust or discolouration on any metal components	✓		
	Any loose belt loops, poppers, buttons, motifs, eyelets, belt loops or other trims. (All should be fixed neatly and firmly).	≤ 36 months	> 36 months	
	Safety - Others (depending on severity)	✓		
4	Bar Code verification (3pcs, at least 1 sample/item)			
	Non-conform found	Reject		
5	Function check for accessories (For all sample size)			
	No function/ malfunction of accessories against reference samples and or requirement of client		✓	
6	Data Measurement & On-site Test (3pairs /size)			
A	Size check For casual / sport shoes: measure back counter, inside & outside quarter height For boot: measure boot back height, shaft opening circumference For slipper: measure the insole width (front widest width), thong poi tot center of tip top For sandal with strap: measure strap length, back strap height, inside and outside quarter height			
	The measured data is out of Spec tolerance range	Reject		





B	Weight check			
	The measured data is out of spec tolerance range	Reject		
C	Zipper, Velcro check			
	Open and close 10 times, non-function insecure and not smooth operation	Reject		
D	Rivet, eyelet, studs, hook, spike etc. check			
	Put the lace through it then apply moderate pulling force, non-function insecure and not smooth operation	Reject		
E	Non-marking on outsole check			
	Rub 3 pair outsole on white paper 3 times and report by grey scale grading	Actual findings		
F	Water-proof shoe check			
	static soak test for 2hours, no water penetration after subjecting an un-flexed shoe/boot, checked every 30 mins	Actual findings		
G	Pull test for kids / babies footwear			
	90N pulling force for 10 sec for small components, especial for snap, plastic buttons, studs, poppers, etc. no detached or broken occur	Reject		
6	Carton drop if application (1 carton/item)			
	Critical defect or malfunction or broken carton cannot be shipped;	Reject		
	Wrinkle carton or slightly visual defect on unite such as slightly scratch or deformation which that does not affect the shipment	Record in report		

Note: Check the product from 50cm distance,
 if you can see the defect, then class as a major defect.
 if you can't see the defect, then class as a minor defect.

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