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Document Number	JS	Quality Specification Document	Approval	Acknowledgement	Completed
Version		Engineering Quality Inspection Criteria			
Revision date	2023.02.20				

I. Purpose

It stipulates the basic quality requirements that should be met by the processing of bags in our factory. Scope

Applicable to the company's school bags, backpacks, hiking bags, computer bags, briefcases, travelling bags and other series of products. Third, the standard requirements

※ The importance of quality items: CR (serious), MA (major), MI (minor)

No.	Item	Standard Requirements	Test method	Judgement
1	Cutting machine	The material should not be drawn out/slipped due to the bluntness of the cutter mould.	Visual inspection	MA
		The size/shape should be the same as the grid and the pattern should be the same as the sample.	Grid / Sample	MA
		Cut fabrics should be organised in a timely manner, correctly tied and must be protected from soiling/corner folding.	Visual inspection	MA
2	Threading	Thread colour and thickness must not be used incorrectly and the thread gauge must match the colour card.	Colour card	CR
		There should be no beads, skipped stitches or throws in the thread.	Sight	MA
3	Gauge	7~8 stitches/inch.	Steel ruler measurement	MA
		Inner lining 6.5~7 stitches/inch, inner false 6.5 stitches/inch (depending on the situation).	Measurement of steel ruler	MI
		Buried pocket 6.5~7 stitches/inch.	Measurement of steel ruler	MA
		Inside wrapped edge 6.5-7 stitches/inch, outside wrapped edge 7.5-8 stitches/inch.	Steel ruler measurement	MA
		Concealed line of backstrap 6.5-7 stitches/inch.	Steel ruler measurement	MA
		False line 7 stitches/inch.	Steel ruler measurement	MI
4	Stop margins	Side net wrap 8 stitches/inch.	Steel ruler measurement	MA
		Face line margins 0.75 cents, side line margins 1~1.5 cents, car joint false line margins 0.75 cents, buried bags	Measurement by steel ruler	MA
5	Heavy thread	Margin 2~2.5 points, buried bag margin 2.5~3 points, wrapping margin 1~1.5 points.	Steel ruler measurement	
6	Zip	The surface line heavy line ≤ 4 pins, such as car surface line without the bottom line will be pulled back to the original position of the surface line, can not be connected to the line, heavy	Visual	MA
		When rethreading, there must not be two lines that do not overlap.		
		The zip specification model/line colour should be consistent with the colour card and standard plate.	Visual	CR
		One zip to be orientated correctly when pulling, two zips to be indistinguishable.	Visual	MA
		The teeth are aligned, the line is clear and straight, and the margins are the same size.	Visual inspection	MA
		The width of the zip fabric should be the same, the corners should be rounded, elasticity should be moderate, and there should be no waves.	Visual inspection	MI
7	Buried Zip	The lining fabric should be level with the face line, the left and right chain stickers should be level, should not be too wide or too narrow, and the puller should not hurt the	Sight	MI
		The pulling head should not hurt the material of the chain, and the pulling should be smooth.		
		The chain sticker is smooth and free from any distortion/waves after turning.	Visual inspection	MA
		The zip fabric is symmetrical and has an even stop to ensure a proper stop for the buried bag.	Visual inspection	MA
		The zip should be slightly loose at the turn, so that the slider can slide smoothly, and the corners are free of sharp edges/wrinkles.	Visual	MA
		The stop is 2.5 points.	Steel ruler measurement	MA
8	Zips	The barge surround should first be aligned with the teeth shipping line, the zip must not burst.	Visual	CR
		too long or too short, will lead to buried out of the bag type skewed or wrinkled, so refute the dark line before	Visual	CR
		Therefore, we should try to bury the bag and produce it only when it is suitable.		
		The double lines should be straight and well-proportioned, with a uniform spacing of 1.5 minutes.	Steel ruler measurement	MA
9	Velcro	Trolley bag main enclosure chain stickers, left and right side chain stickers should be level, can not be forced to barge the enclosure, otherwise it will affect the effect of hitting the tie rod.	Visual inspection	MA
		Otherwise, it will affect the effect of hitting the drawbar.		
		Carrying the line along the hook edge / burlap edge, parallel top and bottom / left and right without distortion.	Sight	MI
10	Turning Handle	Consistent stitch length/margin, 1 point stop, 4~5 stitches.	Measurement	MI
		Firm stitches, " 7 " heavy stitches.	Visual inspection	MA
11	Bone Pulling	Handle turning dark threads need to be tried on the cotton first to prevent the stop being too small, which will cause the sponge net to burst or the handles to	Visual	CR
		If the stop is too small, the sponge net will burst or the handle will be too big, which will make it impossible to put on the cotton or it will be unsightly.		
		The shape and feel are consistent with the sample.	Visual	MI
		Bones should be pulled to the edge, not too tight/loose/deformed, and the distance between the edges should be even.	Visualisation	MA
		The height of the folded bones should be the same, the corners should be rounded and smooth, and there should be no creases.	Visual	MA
12	Voltage mark	Both ends of the bone should be cut symmetrically, leaving 1 inch.	Measurement	MI
		Bone wrapping fabric should be tight to the bone core, and the joint should not show the broken bone.	Visual inspection	MA
		The spring bone joint should be made with steel wire.	Visual	CR
		No rotten/broken bones, wrinkling of wrapped aggregate.	Visual inspection	MA

		Correct position after punching/backing sheet is fastened securely, and the patterned paper is attached. No scratches and other damages.	Visual	MA
		The material after being punched must not be wrinkled/pulled/broken/printed.	Visual inspection	MA
		The position of the foot pegs should be within 1 cent, and the position of the logo button should be within 2mm from the pocket.	Measurement by steel ruler	MA
		The distance between the eyelets and the pocket is within 3mm.	Measurement by steel ruler	MA
		If the material is thin, the hardware is loose, the bottom should be added to support the material, and the surface of the hardware should be protected to prevent the logo from being upside down.	Visual inspection	CR
14	Punching Nails	The model/size/colour should be the same as the colour card.	Colour card/board bag	MA
		Pay attention to the strength and direction of hitting, so that the nail is tightly fastened and not damaged.	Sight/feel	MA
		When hitting the nails with the drawbar, the hole diameter should be smaller than the nails to make the effect tight. Prevent loosening after hitting the nail.	Visual	MA
15	Screws	Smooth, non-scratchy surface, no whitening or exposed holes at the edge of the hole.	Visual / Feeling	MI
		The length of the screws is suitable, the direction is correct, and there is no looseness in the installation.	Visual/Hand feeling	MI
16	Shovel skin	No breakage, narrow and straight margins, uniform thickness, length consistent with the sample.	Paper grid / sample board	MA
		Peeling at the head of the cover is less than 3 points, peeling at the ends of the enclosure is less than 3~3.5 points, and the enclosing piece and the front and back body pieces are less than 3~3.5 marks or less.	Steel Ruler Measurement	MA
17	Gluing	Glue part of the wrapping/folding/reverse wrapping, parallel edges should be straight and not skewed, no waves/blisters/reinforcement out of position.	Visual Inspection	MA
		No waves/bubbling/reinforcement out of position.		
		Corner folds should be rounded and smooth, no folding or bursting of corners.	Visual	MA
		No unevenness in the fabric after folding.	Visual inspection	MA
18	Edge oiling	Cutting error of 1mm or less.	Measurement with steel ruler	MA
		The colour of the edge oil should match the colour of the leather, except when the customer specifies a clash of colours.	Visual inspection/production sheet/board bag	MA
		After oiling, there should not be any defects such as bumps, trachoma, bubbles, scratches, over-face and pollution.	Visual inspection	MA
19	Trademarks/Marks	Appropriate thickness of edge oil, no discolouration/breakage due to hot/cold temperature change.	Visual inspection	MA
		Marks and labels are of correct size and specification, with clear fonts, contents and colours consistent with the sample.	Visual / production sheet / board bag	MA
		Woven labels must not be jerky/pilling/faded.	Visual	MA
		Usually starts at the bottom and finishes with 3~4 stitches, 8~9 stitches/inch.	Steel ruler measurement	MI
		Loose ends need to be folded and then turned, with correct and smooth seam positions/lines and even stops.	Visual inspection	MI
20	Shoulder Strap	Protective film should be applied to metal and adhesive labels.	Visual	MI
		The shape of the shoulder piece is free from distortion/wave/popping.	Visual Inspection/Production Sheet/Panel Bag	MA
		Sewing without thread throwing/skipped stitches, with the puller positioned correctly and the margins symmetrically even on both sides.	Visual Inspection/Production Order/Panel Bag	MA
		The stitching of the drawstring is correct and meets the requirements of the sample.	Visual inspection/Production order/Panel bag	MA
21	Lining	The thickness/feel is consistent with the board bag.	Visual/Production Order/Panel Bag	MI
		Inside colour match to pattern/manufacturing order.	Visual/Production Order/Panel Bag	MA
		There must be no rips/texture errors/printing mistakes.	Visual inspection/Production order/Panel bag	MA
22	Reinforcement	Uniform stops, draw length $\leq 3\text{mm}$, no glue over the surface.	Measurement with steel ruler	MA
		The practice and effect of adding reinforcement is the same as that of the board bag.	Visual / Board Bag	MA
		Reinforcement is in the correct stress position and is not skewed.	Visual / Board Bag	MA
23	Front Bagging	Do not use dark coloured material for reinforcement under light coloured material, and the reinforcement colour should not come through to affect the appearance.	Visual inspection/board pocket	MA
		Stitches must be covered or scored on the front panel, and the needle must be started at the centre of the header or bottom.	Sighting	MA
		After bagging, the corners should be parallel and symmetrical from side to side.	Visual Inspection	MA
24	Installation of pockets	The needle should be closed by overlapping the needle holes.	Visual	MA
		Pen insert pockets, CD inserts, inner insert pockets, etc. are correctly sized and installed in the correct location and function.	Visual inspection	MA
		The pockets are square and the alignment is symmetrical. The lining must not be reversed.	Visual inspection	MA
25	Buckle ear webbing	The left and right pockets of the patch pockets should be hit with dates, and the left and right extensions of the insertion pockets to the edges of the bag can be stitched backwards.	Sight	MA
		Positioning and mounting in the correct position/direction.	Visual inspection	MA
26	Threading Cord	Stressed button ear webbing is date or backstitched to ensure firmness.	Visual inspection	CR
		Nylon ropes are of the same colour/specification as the same board.	Visual/Production sheet/board bag	MA
27	Magnetic Buttons	No draws or splices, no loose ends of rope.	Visual	MI
		Colour/shape/size in accordance with the requirements of the board bag and production order.	Visual/Production Order/Bag	MA
		Strong enough magnetic attraction, easy to open and close, no oxidation/rust/fogging/scratch/popping/colour difference.	Visual / Feeling	MA
28	Attaching the cover head	The front panel position is within half a cent from the sample board.	Measurement with steel ruler	MI
		Align needle position for turning, balanced, and free of skew.	Visual inspection	MA
		The alignment is straight, the stop is even, and the backstitch is secure.	Visual inspection	MA
29	Loading Side Bags	Reinforcement where necessary due to material/bag type differences.	Visual	CR
		The direction of the slider must not be mistaken.	Visual/Panel Pocket	MA
		Side pockets are sewn with square corners, even curvature, parallel top and bottom, and symmetrical left and right.	Visual	MI

30	Car Back Strap	The dark line of the backstrap must be controlled at 6.5 to 7 stitches per inch.	Steel ruler measurement	MA
		Bright coloured materials should not be used with mixed coloured threads to avoid exposing the thread colour after cotton threading.	Visual Inspection	MA
		The shape of the pearl cotton is consistent with that of the tape tube, the bow shape is maintained after cotton threading, and the backstrap is smooth and full after threading.	Visual	MA
		No void, no distortion. Before sewing the belt tube, we should try to wear cotton, and only after suitable for mass production.	Visual	MA
		Hook and loop fasteners are used with the correct type, firm connection parts and good functionality.	Visual inspection	MA
		The tops of the straps need to be reinforced to improve the strength of the force.	Visual	CR
31	Threading Buckles	Hand threading of various types of buckles/bow buckles/D buckles/day buckles/pin buckles/chest buttons, etc., should be done in the right direction and on the right side (all holes are on the bottom side). front side (bottom side if there are holes).	Sighting/Board Pocket	MA
32	Turning triangle webbing	If the triangles do not cross in all directions, place the webbing into the triangle material outlet to ensure that the webbing can be turned when the back width is set. to ensure that the webbing can be turned when the back width is set.	Visual	CR
33	Setting the backstrap triangle	The backstrap triangles are symmetrical, and the direction should be clear.	Visual	MA
		stop should not be more than 2 points, to ensure that the buried bag can exceed the position of the false line, the finished product does not The finished product will not show the false line.	Measurement with steel ruler	MA
34	Lining	The lining is turned flat against the fabric, with no discounting.	Visual inspection	MA
		Keep the stop at 2 points to prevent the stop from being too small and leading to loose edges, or too large and leading to false threads.	Measurement	CR
		Regardless of whether there is a cotton layer or not, adjust the line of the needle car to prevent wrinkles, which will affect the effect of burying the bag.	Visual Inspection	MA
35	Burying bags	Burying the bag and wrapping the edge must be carried out separately, burying the bag first and then wrapping the edge, it is strictly prohibited to combine them into one completion.	Visual	CR
		The front and rear widths must not be reversed or put down.	Visual, steel ruler measurement	MA
		Align the teeth with the thread, bury the pocket at 6.5~7 stitches per inch, and keep the stop at 2.5 minutes.	Measurement with steel ruler	MA
		Symmetry around the left and right, no crooked pockets, no false threads exposed.	Visual inspection	MA
		Both sides of the bottom are symmetrical and neat, and the cuts are aligned.	Visual	MI
		There should be no wrinkles, pinholes, loose bones or threads in the buried bag.	Visual Inspection	MI
		Trolley bags should especially control the stopper to prevent bursting or insufficient height of the bag body to affect the effect of the trolley.	Sight	CR
36	Hand Trimming	The trimmed edges are rounded and smooth, with no gaps/thread wadding/solid seams.	Visual	MI
		Trimmed webbing cuts must be hot ironed to prevent loose ends/brown edges.	Visual inspection	CR
37	Wrapping	The edges must be free of empty or missing wraps, without deviation, and the joints must not be in the open position.	Visual inspection, hand feeling	MA
		The edges should be tightly wrapped and straight, with the same size of margins and no bending, creasing or bursting.	Visual	MA
		Corners should be rounded and smooth, no folding/sharp corners. The cut-outs of the edging strips should not be exposed.	Visual	MA
		Pocket hems should be hot ironed to ensure that they are straight and not wrinkled.	Sight	MI
		The rubber bands of the side mesh wraps are kept unstrung when stretched, and the elastic length is matched to the large enclosure material, which shall be set to The stitch length should be adjusted to 8 stitches per inch.	Visual inspection, steel ruler measurement	MA
		For the back width mesh edging, it is necessary to test-fit the mesh bag before mass production to prevent the mesh from stretching and deforming, which will make it impossible to fill the bag.	Visual inspection	MA
		Front pocket/side pocket inner edging with 7 minutes tape, finished edging with 1 inch tape. Needle back The top and bottom of the edging strips are levelled.	Sight	MI
38	Punching dates	Positioning is accurate and must be hit at the point of stress and centred.	Visual	CR
		Must not use the wrong line (according to the requirements of production orders and samples). The front and back should be correct and the line should be beautiful.	Visual/Production Order/Board Bag	MA
		The triangular date should be divided into directions, and the backstrap date should be set positioned and centred, paying attention to the symmetry of left and right.	Visual	MA
		The finished product should be hit within the wrapping line and at the stress points on both sides of the backstrap and the handles.	Visual inspection	MA
		The decorative band is to be struck in the centre.	Sight	MA
39	Tie rods/wheels	Tie rods/wheels specifications are used correctly and mounted securely.	Visually, by hand	MA
		Trolley bar/wheels withstand force, mountaineering bag and other large bag series 40 kg force on a flat concrete floor normal running 500 metres, no breakage/damage. --- 1pc/lot	Endurance test	CR
40	Printed paper cards for packaging	The contents of packaging hangtags / reply cards / instruction manuals / postcards comply with the requirements, without omission of words or typographical errors,	Visual / Sample	MI
		The font/colour is consistent with the sample board.	Visual / Sample	MI
		Hanging position is correct, no omission.	Visual	MI
		Good cleanliness, no glue, silver pen marks, threads, dust, debris and other residues.	Visual inspection	MI