

VENDOR MANUAL

2017-2018 VERSION 2.0

SECTION 4 – Fabric Quality & Inspections

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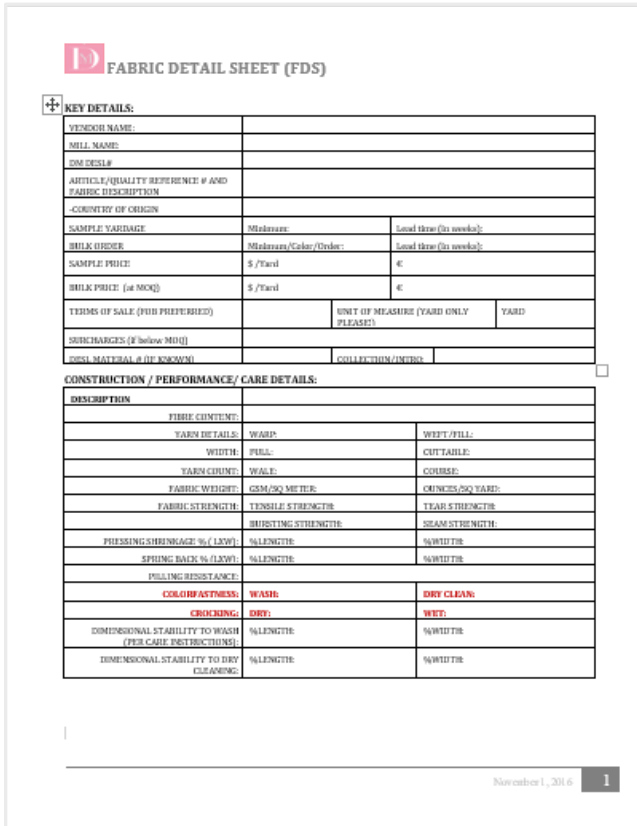
SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

It is the requirement of DM Mill/Vendors to ensure that only first quality piece goods are utilized. To that extent, there are standards that must be obtained prior to production fabric release from the Mill. Approvals for Fabric Quality, Color and Stability must be secured. This section will provide you with the information to successfully navigate the production requirements for textiles.

Fabric Detail Sheet

The Fabric Detail Sheet (FDS) is the standard from which Destination Maternity Initiates bulk orders and is the first item requested from suppliers. All information entered on the FDS must be representative of the anticipated or historical performance of production fabric. Technical information required, such as Physical performance, Fabric Properties and Shrinkage must be provided direct from either DM Certified Mills or DM Certified Testing Lab Reports. The FDS is the benchmark for garment care. All failed production yardage will be the responsibility of the Mill to correct. All FDS sheets must be completed fully prior to any order given. FDS will be valid for one year provided quality/finish does not change. The FDS is accessible in the [Forms Link](#) on the Vendor Manual Dashboard, ***Vendors must download FDS from the Forms Link, on the Vendor Manual Dashboard, SECTION 4 FORMS**



FABRIC DETAIL SHEET (FDS)

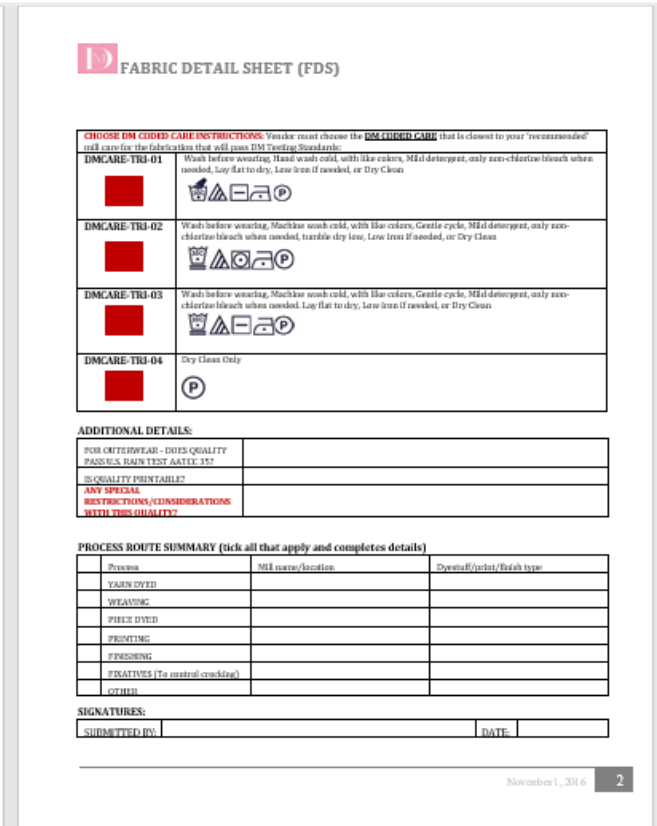
KEY DETAILS:

VENDOR NAME:		
MILL NAME:		
DM DESIG:		
ARTICLE/QUALITY REFERENCE # AND FABRIC DESCRIPTION:		
COUNTRY OF ORIGIN:		
SAMPLE YARDAGE:	Meters	Yards (In weeks)
BULK ORDER:	Meters/Color/Order:	Yards (In weeks)
SAMPLE PRICE:	\$ /Yard	€
BULK PRICE (44 NOG):	\$ /Yard	€
TERMS OF SALE (PUB PREFERRED):	UNIT OF MEASURE (YARD ONLY PLEASE):	YARD
RECHARGES (if below MIN):		
FORM MATERIAL # (if known):		

CONSTRUCTION / PERFORMANCE/ CARE DETAILS:

DESCRIPTION:		
FIBRE CONTENT:		
YARN DETAILS:	WEAVE:	SHEFT/PILL:
WIDTH:	PURL:	CUTTABLE:
YARN COUNT:	WALE:	COURSE:
FABRIC WEIGHT:	GSM/SQ METRE:	OUNCES/SQ YARD:
FABRIC STRENGTH:	TENSILE STRENGTH:	TEAR STRENGTH:
	RIPISTING STRENGTH:	SEAM STRENGTH:
PRESSING SHRINKAGE % (LXW):	%LENGTH:	%WIDTH:
SPRING BACK % (LXW):	%LENGTH:	%WIDTH:
PULLING RESISTANCE:		
COLOR FASTNESS:	WASH:	DRY CLEAN:
CRACKING:	DRY:	WET:
DIMENSIONAL STABILITY TO WASH (PER CARE INSTRUCTIONS):	%LENGTH:	%WIDTH:
DIMENSIONAL STABILITY TO DRY CLEANING:	%LENGTH:	%WIDTH:

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FABRIC DETAIL SHEET (FDS)

CHOOSE DM CERTIFIED CARE INSTRUCTIONS: You do not choose the **DM CERTIFIED CARE** that is closest to your "recommended" end user for the fabrication that will issue DM Testing Standards:

DMCARE-TRI-01	Wash before wearing. Hand wash cold, with like colors. Mild detergent, only non-chlorine bleach when needed. Lay flat to dry. Low Iron if needed, or Dry Clean	
DMCARE-TRI-02	Wash before wearing. Machine wash cold, with like colors. Gentle cycle. Mild detergent, only non-chlorine bleach when needed. tumble dry low. Low Iron if needed, or Dry Clean	
DMCARE-TRI-03	Wash before wearing. Machine wash cold, with like colors. Gentle cycle. Mild detergent, only non-chlorine bleach when needed. Lay flat to dry. Low Iron if needed, or Dry Clean	
DMCARE-TRI-04	Dry Clean Only	

ADDITIONAL DETAILS:

FOR OUTERWEAR - DYES QUALITY PASS/US BAIN TEST AATCC 157:	
IS QUALITY PRINTABLE?:	
ANY SPECIAL INSTRUCTIONS/CONSIDERATIONS WITH DURABILITY?:	

PROCESS ROUTE SUMMARY (tick all that apply and completes details)

Process	Mill name/location	Dye/soft/finish/Block type
YARN DYED		
WEAVING		
PIECE DYED		
PRINTING		
FINISHING		
FINISHES (To control cracking)		
OTHER		

SIGNATURES:

SUBMITTED BY:		DATE:	
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*For Sweaters Vendors must use the YDS (Yarn Detail Sheet) accessible [from the Forms Link, on the Vendor Manual Dashboard, SECTION 4 FORM](#)

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

Sample Yardage & Print Policy

Vendors/Mills supply sample yardage and garments free of charge and are considered a normal part of doing business with DM. We encourage the utilization of reduced DPI digital prints in lieu of creating screens and their inherent cost for any print requirements. If suppliers generate screens they will be at their cost. We are all hopeful that a style and fabrication make it to retail as this is our only recourse for recovering our development investment.

Standards & Requirements

Physical, chemical and performance requirements are detailed by fabric/product class. If your fabric will not meet any of these requirements, it is necessary to be evaluated prior to production. All production test reports will be held against the standards established by Destination Maternity. ****Please read SECTION 7 Testing-Labeling-Product Compliance.***

Production Fabric Testing

Destination Maternity requires that all production fabrics be tested (1) To maintain a standard of quality and excellence, (2) To verify fabric performance and (3) As part of Federal Trade Commission, U.S. Customs/CPSC regulations on fiber content and flammability.

Certified Testing Lab

Fabric must be tested at Destination Maternity's Certified Laboratory:



INTERTEK lab has extensive global lab locations and is the only laboratory from which DM will accept testing. All lab locations are versed on Destination Maternity Testing Standards and complete procedures.

It is critical to understand the Destination Maternity Global Testing Program guidance to ensure test results are expedited. This program accommodates all DM Vendors including Mill Vendors and is appropriate for purchase orders of various sizes for ALL BRANDS.

Under the DM testing guidance, the following must be adhered to:

- Mill vendors must only submit to the lab using DM Testing Forms
- Mill must set up payment terms with the lab PRIOR to the start of fabric testing.

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

- Only production fabric should be submitted for testing. DM will not accept test conducted on pre-production, trial or sample fabric. Fabric must represent bulk quality/finish/weight/color.
- Preliminary testing (excluding colorfastness concerns) in available color is permitted if quality/finish/weight/color is representative of bulk.
- Mill/Supplier should submit fabric for testing after the first bulk lot has completed finishing process, simultaneously submitting 1 yard cutting to Destination Maternity at: **DM RAW MATERIALS SUBMISSIONS.**

***For quality and color approval guidance reference Section 3 Color System.**

***NOTE: Mill Vendors who have a current year 3rd party fabric test report to provide in lieu of new testing, may provide it to the Raw Materials Team if it meets the following criteria:**

- Testing report is from and Accredited Testing Bureau
- Testing is applicable to DM Bulk Production quality/finish/weight contracted by DM.
- Testing includes Fiber Content Verification, Weight, Construction, and Pilling. Test report confirms proof of Care Labeling and applicable tests for colorfastness, dimensional stability, pressing & appearance are included in the test report.
- Test report will not expire before finished product NDC date.
- 3rd Party test report is provided at the same time as the FDS/Fabric submission

Unless otherwise specified ALL testing for DM Apparel is to be performed at Intertek Testing Lab as per the DM Testing Program Guidance. The DM Testing program is managed between the US and HK Intertek offices in conjunction with the Destination Maternity Testing Team located at the DM corporate office. Intertek Program Managers will ensure DM Vendors and all global lab locations are working in unison within the testing program guidance for all testing submitted on DM's behalf. ***Failure to use the DM Certified Testing Lab will result in the total cost of testing to be deducted from the Fabric Cost confirmed on the DM Purchase order.**

Contact Information

Intertek Contact information & DM Test Request Form is accessible *from the [Forms Link](#), on the Vendor Manual Dashboard, SECTION 7 FORMS*

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

Vendors should review:

- Intertek Global Lab Locations
- Destination Maternity Test Request form (TRF) * This is the only testing form that may be submitted to the lab for testing on behalf of Destination Maternity. *Submission using any other form is not permitted and will result in testing going on hold.
- Section 7 Testing-Labeling-Product Compliance and all forms/documents associated with this section

Sample Collection Center

Mills manufacturing DM fabric in the USA must use **Intertek Korea Lab** in lieu of testing at the Intertek Lab located in USA (Illinois) as cost of testing in the USA would be price prohibitive. The ITS Sample Collection Center in Los Angeles, CA will accommodate all DM Vendors and they will expedite fabric/garments to the Korea Lab on behalf of DM Vendors:

- **Vendors in the LA area can call ITS for a sample Pick-Up.**
- **Vendors outside the LA area can mail samples directly to the ITS Sample Collection Center in Los Angeles, CA.**

*Sending Details are outlined in the Global Testing Program 2017 Document accessible in the [***Forms Link on the Vendor Manual Dashboard, SECTION 7 FORMS***](#)

To contact the Destination Maternity Testing Team directly: [**testingteam@destinationmaternity.com**](mailto:testingteam@destinationmaternity.com)

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Piece Goods Inspection Requirements

Mill Inspections

All Mills are required to perform **100% Inspection** at their facilities to ensure quality of goods prior to shipping. This is a **CRITICAL RESPONSIBILITY** of the supplier to enable factories to proceed into production efficiently.

- Accept/Reject Procedures; Mill should not ship any roll or shipment with defect points that exceed DM evaluation Guidelines. The mill will determine how to best meet DM Standards
- Reporting: Inspections are intended to determine shipment quality and to capture information for quality performance evaluation of nominated mills. One inspection report should be completed for each style/color inspection and a copy of an inspection report to the garment factory prior or without shipment.
- Inspection reports should include the following information:
 - Inspection Date
 - Shipped Date
 - Quarter/Year
 - Mill
 - DM Style Number
 - Batch Number
 - DM Color code/Color name
 - Inspection Points
 - Inspection Results
 - Yardages
 - Weights
 - Width...etc.
 - Documentation in English language (minimum)
 - Records should be kept minimum 2 years and available to DM upon request

The Factory will do random inspection upon receipt to confirm Mill's results. It will be the responsibility of the Factory/Vendor to assure first quality and to maintain the Mill Inspection provided with Fabric Shipment along with Random Inspection Records. Records should be available to Destination Maternity upon request.

Destination Maternity reserves the right to reject or cancel any order that does not meet the agreed and established testing and inspection requirements. Please advise DM Textile (Fabric) & Product Development (PD) teams if there are any problems that arise in the process, so as to expedite orders as efficiently as possible.

Thank you for your cooperation in this process as we continue to work to improve our product and our partnership together.

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

Requirements for Inspection

To ensure only grade-A quality piece goods to our factories, all Mills are required to perform 100% internal inspection on-site or at an approved inspection center prior to shipping. This inspection should be performed after all finishing processes are completed, using Destination Maternity report form to score and evaluated by roll and lot, and summarized on the **DM MILL PIECE GOODS INSPECTION FORM**. This Form will enable the Factory to utilize the same form to verify Mills Inspection.

Once completed this form must be sent to the Vendor Partner to identify the conditions of the shipment. This will include all compensation yardage shipped so that factories are aware of allowances. ***Inspection reports must be submitted to Vendors for approval five days prior to fabric shipping date.**

The **DM MILL PIECE GOODS INSPECTION REPORT FORM** and a completed 'example' is accessible in the [***Forms Link on the Vendor Manual Dashboard, SECTION 4 FORMS***](#)

Use of this standard form ensures clarity when discrepancies are noted by the factory and ensures easier communication with Textiles (Fabric) / Product Development (PD) teams for questions. Please note, DM does not allow any piece goods to ship without inspection and approval. It is the responsibility of the vendor partner / factory to maintain the inspection records on behalf of DM for future reference.

The FOUR POINT SYSTEM (Reference ASTM D-5-430-93)

The Four Point System method should be used to grade all rolls. DM has established a maximum of 20 points per 100 linear yards as standard for passing grade for all DM Brands. Any roll or shipment found to contain more than 20 points per 100 linear yards will be subject to rejection. Average points between 12 and 20 points per 100 linear yards require +2% extra yards on the specific shipment by color to compensate for cutting losses. Any roll or shipment found to contain more than allowed points per 100 linear yards will be subject to rejection. The goods will then need to be replaced by the Mill without effecting delivery date. If such rejection will affect production delivery date the Vendor/Mill will be fully responsible to maintain required delivery at their expense.

Under the 4-point system, all defects will be scored as follows:

- 1 Point - For defects not exceeding 3"
- 2 Points - For defects exceeding 3" but not exceeding 6"
- 3 Points - For defects exceeding 6" but not exceeding 9"
- 4 Points - For defects exceeding 9"
- 4 Points - All holes are penalized 4 points

ALL MAJOR DEFECTS IN A ROLL SHOULD BE MARKED ON THE SELVAGE (MILL MARK) IN A WAY THAT CAN BE CLEARLY SEEN ON THE CUTTING TABLE TO ENABLE DEFECTS TO BE IDENTIFIED DURING SPREADING.

****A maximum of four points can be assigned to one yard of fabric and each 4-point penalty requires one yard of extra fabric to compensate for cutting loss.***

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Piece Goods Inspection Requirements

The Destination Maternity 100% inspection Report identifies and records the following specific defects:

- Broken ends/ Picks
- Coarse ends / Picks
- Knots / Slubs
- Hole / Broken selvedge
- Others as detailed
- White dots/ Color dots
- Oil stains / Color stains / Water marks
- Filling bar / Dye streaks
- Off-Register pattern
- Thin bar / Thick yarn
- Foreign yarn
- Creases
- Hooked yarn / Abrasion

Special Requirements for Stretch: For all fabric containing stretch content in the warp and bi-stretch direction, Suppliers and Mills will be requested to ship +1% extra yard on the booked order to cover for relax shrinkage during garment production (Factory's must unroll fabric toe be relaxed at least 36-48 hours prior to cutting).

Face: The face of the piece goods should be on the inside of roll and should be clearly marked in writing or with a stickler on each roll. During inspection process, if the rolls are opened, they must be returned to the original state so that the face will be consistently on the INSIDE of the roll.

Width: Only rolls where the usable fabric width (width inside selvages or pin holes) is over the minimum width purchased, but not more than one inch above the purchase width, will be considered first quality.

Selvages: The fabric must lay flat on the cutting table. Fabric with tight or loose selvages causing ripples or puckers will not be considered first quality and will be subject to a cutting allowance or return if found to be unusable.

Wrinkles: Piece goods containing wrinkles or creases will be considered second quality and may be subject to rejection depending on severity. Special finishing procedures may be necessary to control wrinkling of the piece goods.

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Piece Goods Inspection Requirements

Fabric Hand Feel, Pattern and Color: Must meet the established DM standard.

Shading: DM will not accept any piece goods that have side to side, side to center, or end to end shading within the roll as first quality. Goods that are found to have shading within will be subject to rejection.

Shading within the piece goods should be rated 5.0 on the grey scale.

If any piece goods are shipped with such shading problem, the Fabric Mill is fully responsible for all extra costs that may occur during garment production such as:

- ❑ Cost of 100% Factory Inspection to determine extent of shading
- ❑ Using special layout marker (to prevent shaded defect garments)
- ❑ Using narrow marker (to reduce fabric width to prevent shaded garment)
- ❑ Cost of making extra / revised markers (copies)
- ❑ Replacing extra yards to compensate for cutting loss

In the event of shaded fabric, Garment Factory may need to allow longer production time, effecting original garment shipping date. **Any delays are the responsibility of Fabric Mill.**

Roll to Roll Shading: All roll to roll shading within the same lot number should be graded as 5.0 on the grey scale. Any roll(s) found with less than this rating should be re-grouped into a new lot number and shade group (100% inspection).

Color Group Shading Standard:

CRITERIA	REQUIREMENT ON THE GREY SCALE
Standard	5.0
To be in the same shade group	5.0 - 4.5
To create a new shade group	4.0

****To Create additional shade groups, the color tone must be within the same color cast***

Shade Lots: The amount of shade lots within a shipment must be as minimal as possible.

Vendor/Partner/Factories will monitor cuttings from each lot per shipment to ensure shades read within a commercially acceptable tolerance. Cuttings must be kept with inspection records for future reference by DM.

- ❑ **ALL ROLLS MUST INDICATE SHADE LOT** on outside and be **SHIPPED** together indicating details of roll #'s and shade on shipping form.

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Piece Goods Inspection Requirements

Bowing, Skewing / Bias – including plaids: A Maximum of ½” Bowing and 1” skewing or Bias is allowed on fabric with width up to 48”. On fabric with greater than 48” in width, a maximum of ¾” Bowing and 1 ¼” Skewing or Bias is acceptable. In the event skewing or bias does exist, it should not show any wavy characteristics that would adversely affect cutting. No hooked fabric will be accepted.

Possible Considerations for Rejection Roll Length

- No roll with less than 25 yards will be accepted as first quality. Except under special consideration (lace warp lengths for example) this must be identified on purchase order.
- No roll containing more than one splice should be accepted as first quality.

For Defect Allowance: All extra yardage given to compensate for cutting loss should be listed on the packing list and reflected on the invoice as a discrepancy, i.e. **“FREE YARDAGE GIVEN TO COMPENSATE FOR CUTTING LOSS”**. This documentation will facilitate our Factory/Vendor logging of extra good shipped.

Minor Defect: A defect that would not cause the product to be termed a second either because of severity or location. When inspection piece goods prior to cutting, it is necessary to rate questionable defects as major, since the inspector will not know where the defect may occur on the item.

Major Defect: A defect that, if noticeable on the finished product would cause the item to be a second. (A “second” is a garment with a noticeable defect that affects the salability or serviceability of the item).

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Garment Factories Piece Goods Inspection Procedures

Destination Maternity requests that all garment factories perform random inspection on all piece goods immediately upon receipt. The purpose of forwarding the approved inspection reports will enable the factories to verify the mills internal reports and proceed immediately into production. It is in the interest of all parties to disclose, approve and resolve all quality issues prior to production. DM encourages the respectable resolution to any discrepancies as equal partners in our production process.

In all communication between mills, factories, and DM regarding defects, factory must clearly state lot numbers, number of rolls, and amount of yardage affected. Vendors must use the **DM SUMMARY PIECE GOODS INSPECTION REPORT FORM** for all DM fabric inspections. This form and a completed 'example' is accessible in the [**Forms Link on the Vendor Manual Dashboard, SECTION 4 FORMS.**](#)

The following defects may be found in addition to the prior listings and must be identified accordingly:

DEFECT	EXPLANATION	SEVERITY
Burl Mark	When a slub or extra piece of yarn is woven into the fabric, it is often removed by a "Burling Tool". This will usually leave an open place in the fabric	Major
Drawbacks	Gradually caused by an excessive loom tension.	Major
Soiled Filling or End	Dirty, oily looking spots on the warp or filling yarn or on packaging (dyed yarn).	Major
Spot Marks	When the loom is stopped, the yarn elongates under tension. When the loom starts again, the slack is woven into the fabric.	Major/Minor
Thin Place	Often caused by the filling yarn breaking and the loom continuing to run until the operator notices the problem.	Major
Reed Mark	Often caused by the warp yarn breaking and the Loom continuing to run until the operator notices the problem.	Major
Water Spots	Usually caused by wet fabric being allowed to remain too long before drying; the color migrates leaving blotchy spots.	Major
Sanforize Pucker	Results from uneven wetting out on sanforize, usually cause by defective spray heads. Fabric will appear wavy or puckering when spread on cutting table. Difficult to detect while on inspection machine with fabric under roller tension.	Major

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Garment Factories Piece Goods Inspection Procedures

Missing Yarn	Caused by one end of the yarn missing from the feeder and machine continuing to run.	Major
Mixed Yarn	Results from wrong size fiber yarn placed on the Warp. Fabric could appear as thick ended or as a different color its fibers have different affinity for.	Major

KNIT DEFECTS

DEFECT	EXPLANATION	SEVERITY
Barre	Occurs in circular knits. Caused by mixing yarns on the machine. Fabric will appear to have horizontal streaks.	Major
Bird Eyes	Caused by unintentional tucking from malfunctioning needle. Usually appears as two distorted stitches, side by side.	Major
Broken Color Pattern	Usually caused by colored yarn out of place on frame.	Major
Drop Stitches	Results from malfunctioning needle or jack. Will appear as holes or missing stitches.	Major
End Out	Occurs in the warp knit. Results from the knitting machine continuing to run with missing end.	Usually Major
Hole	Caused by broken needle.	Major
Missing Yarn	Occurs in circular knits. Caused by one end of the yarn missing from the machine continuing to run.	Major
Needle Line	Caused by bent needle forming distorted stitches. Usually appears as vertical line.	Major/Minor
Mixed Yarn	Occurs in the warp knit. Results from wrong fiber yarn (or wrong size yarn) placed on warp. Fabric could appear as thick ended or as a different color its fiber have a different affinity for dye.	Major
Press-Off	Results when some of all of the needles on a circular knitting machine fail to function and fabric either falls off the machine or design is completely disrupted or destroyed. Many knitting needles are broken and have to be replaced when bad press-off occurs. Bad press-off usually starts a new role of fabric.	Major

SECTION 4 - FABRIC QUALITY & INSPECTIONS

Fabric Team Contact Information

	<i>NAME</i>	<i>CONTACT INFORMATION</i>
<i>Chuck Pickett</i>	<i>Director Creative Services, Production</i>	Main 856-291-9700 ext. 79834 <u>cpickett@destinationmaternity.com</u>
<i>Melissa Loder</i>	<i>Fabric/OPM Manager, Production</i>	ext. 79745 <u>mloder@destinationmaternity.com</u>
<i>Rebecca Barnes</i>	<i>Fabric Coordinator</i>	ext. 79759 <u>rbarnes@destinationmaternity.com</u>
<i>Kiyon Horbury</i>	<i>Raw Materials Expeditor</i>	ext. 79758 <u>khorbury@destinationmaternity.com</u>

All shipment notification e-mails should be sent to:

→ rawmaterialssubmit@destinationmaternity.com

All physical fabric submits should be sent to the attention of:

→ **DM RAW MATERIALS SUBMISSIONS.**

To contact the Testing Team directly regarding testing /certified testing lab please contact:

→ testingteam@destinationmaternity.com