

GENERAL INFORMATION

Client Name	ABC		
Supplier Name	ZXY		
Factory Name	ZXY		
Inspection Location	xxxxx, xxxxx, Gampaha, Sri Lanka.		
Inspection Date	17 th March 2023		
P/O Number	N/A	P/O Quantity	1161 Units
Sampling Plan	ISO 2859: Single , Normal	Sample Level	General Level II
AQL	Critical: Not Allowed Major : 2.5 , Minor : 4.0	Sample Size	32 Units
Item Number	Refer Quantity Chart		
Product Description	Girls Bicycles		



INSPECTION SUMMARY

OVERALL CONCLUSION	Due to those Remarks final result will be PENDING				
Category	Conform	Not Conform	Pending	N/A	Remarks
1. Quantity	x				Remarks: 1.1
2. Workmanship			x		
3. Style, Color & Documentation			x		Remarks: 3.1 – 3.4
4. Data Measurement & On-Site Test			x		Remarks: 4.1 – 4.3
5. Shipping Marks & Packaging			x		Remarks: 5.1 – 5.3
6. Other Specifications / Requirements				N/A	
APPROVED BY IQMS SUPERVISOR:					

REMARKS

1.	Quantity	
1.1	Upon arrival to factory, actual packed quantity was observed as per the packing list to be 1161 units in 1161 cartons, against the supplier provided P.O quantity of 1161 units. Note: Some finished goods are, packed the separate warehouse outside the inspection location. Therefore, sample (available 600 units with three modules) and quantities to be checked, items were packed in the same inspection location warehouse only.	
2.	Workmanship	Nil
3.	Style, Color & Documentation	
3.1	For all three models: No approved / reference samples were available from the client for product conformity check. Therefore, actual findings have been recorded in the report for reference.	
3.2	Color reference, designs, placement was available from client. Therefore, actual findings have been recorded in the report, for details refer to attached photos.	

3.3	For all three models, 100% of the inspected pieces were observed compared with Panton, of the inspected pieces were observed with a slight variation of some modules (Model : 20' xxxx – Girl & 24' Velo Ville). Therefore, actual findings have been recorded in the report (refer Product View photos) for reference.
3.4	For all three models reference spec (provided by the supplier) observed with the material inspection checklist did not mention the material model/brand specification. Therefore, actual findings have been recorded.

4.	Data Measurement & On-Site Test
4.1	For all items: Product measurement and weight specifications were not available from client or supplier; hence actual findings have been recorded. For details, refer to data measurement sheet below
4.2	For all items: Carton size and weight print details were not available form client, therefore actual findings have been recorded in report for client reference.
4.3	The ride performance test and brake resistance check are only conducted on the 24' Velo Ville model. The other two models are not tested due to their smaller size.

5.	Shipping Marks & Packaging
5.1	For all items: Packing instructions details was not available form client; therefore, actual findings have been recorded in report for client reference. For details refer to below attached photo.
5.2	For All three models, 100% of the inspected cartons were observed with model specification label and "Operateur bicycode". Hence actual findings have been recorded. For details refer to below-attached photos.
5.3	Assembly with (Box) necessary protective items with the model - Saddle, Basket, Front/ Rear reflector lights, Seat Post, Pedal set, 2 Allen keys and multi spanner set, & Manual.

INSPECTION DETAILS

1. QUANTITY		Conform						
P/O Number	Item Number	P/O Qty	Shipment Qty		Packed Quantity		Sample Size	
		Unit / Pcs	Unit / Pcs	Carton	Unit / Pcs	Carton	Unit / Pcs	Carton
N/A	16" xxxx Girl	394	394	394	394	394	11	11
	20" xxxx Girl	399	399	399	399	399	12	12
	24' Velo Ville	368	368	368	368	368	9	9
Total		1161	1161	1161	1161	1161	32	32

Total 32 cartons were randomly selected for sampling. During inspection time observed cartons numbering are not available.

Inspection Standard: ANSI/ASQZ1.4 (MIL-STD-105E)		Defects		
Workmanship AQL		Critical	Major	Minor
Item:				
Sampling plan: Single , Normal	AQL	0	2.5	4.0
General Level II	Max. Allowed	0	2	3
Sampling Size: 32 units	Defects Found	0	3	3
Inspection Standard: ANSI/ASQZ1.4 (MIL-STD-105E)		Defects		
Dimensional & Measurement AQL		Critical	Major	Minor
Item:				
Sampling plan: Single , Normal	AQL	0	2.5	4.0
Special Level 1	Max. Allowed	0	1	1
Sampling Size: 13 Units	Defects Found	0	0	0
Inspection Standard: ANSI/ASQZ1.4 (MIL-STD-105E)		Defects		
Special Functional & On -Site Test AQL		Critical	Major	Minor
Item:				
Sampling plan: Single , Normal	AQL	0	2.5	4.0

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Special Level 1	Max. Allowed	0	1	1
Sampling Size: 8 Units	Defects Found	0	0	0

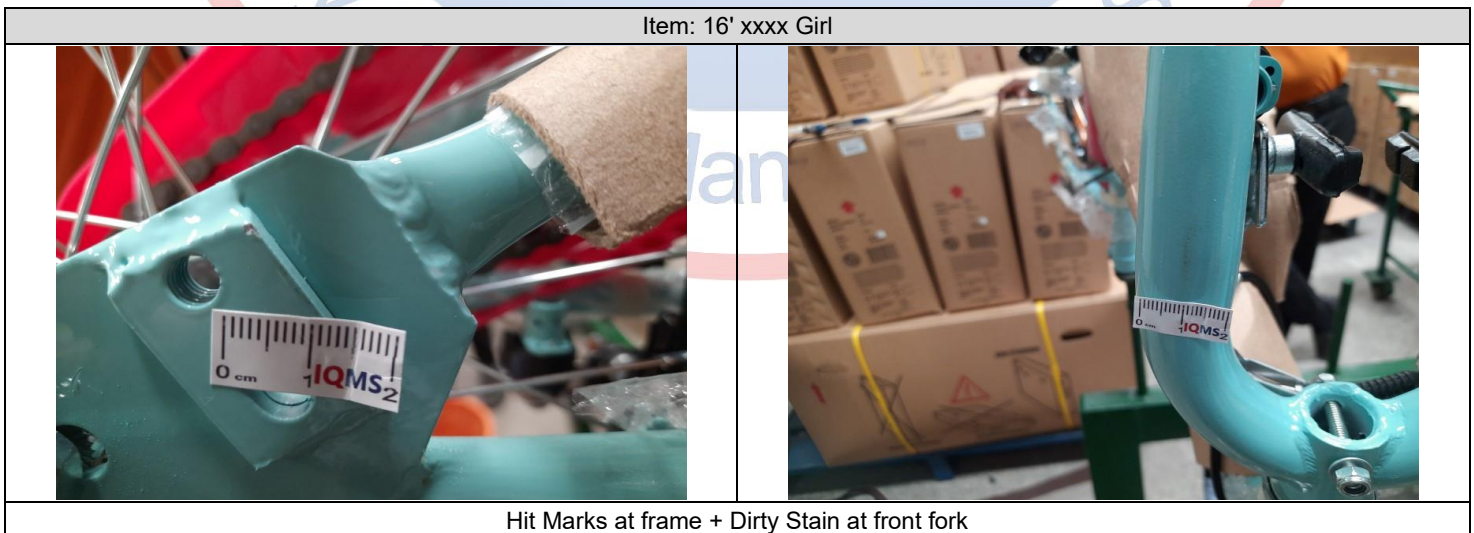
2. WORKMANSHIP		Conform / Not Conform / Pending	
Checkpoint / Test	Inspection Level	Inspection Method	Result
Product Visual & Workmanship Check	General Level II	• Product physical conditions, appearance & cleanliness	Pending
Remarks:			

Defects Description	Critical	Major	Minor
Item: 16' xxxx Girl			
Hit Marks at frame + Dirty Stain at front fork	-	-	1
Solvent popping at frame + Scratch mark at rim + Dirty Stain at Bottom Tube	-	-	1
Item: 20' xxxx Girl			
Hit mark at Middle Tube + Scratch mark at Chain Cover	-	1	-
Hit mark at Middle Tube	-	1	-
Item: 24' Velo Ville			
Grip Damage + Paint damage at Carrier	-	1	-
Dirty Stain at back Fender (Removable) + Scratch mark at Stem	-	-	1
Total Found	0	3	3
Max. Allowed	0	2	3
Sample Size	32 Units	32 Units	32 Units

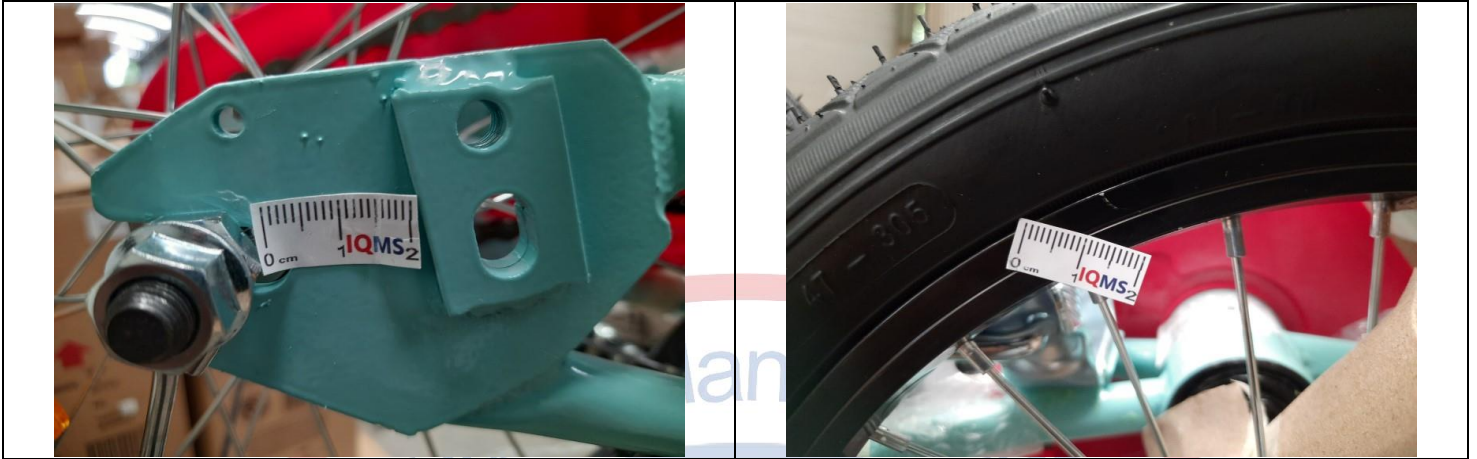
Special Attention Point: Other than individual defects any batch defects found,
Nil

The Following field test included in workmanship check:
Labeling Check
Pairing Check

Reference Photos of Defects Found

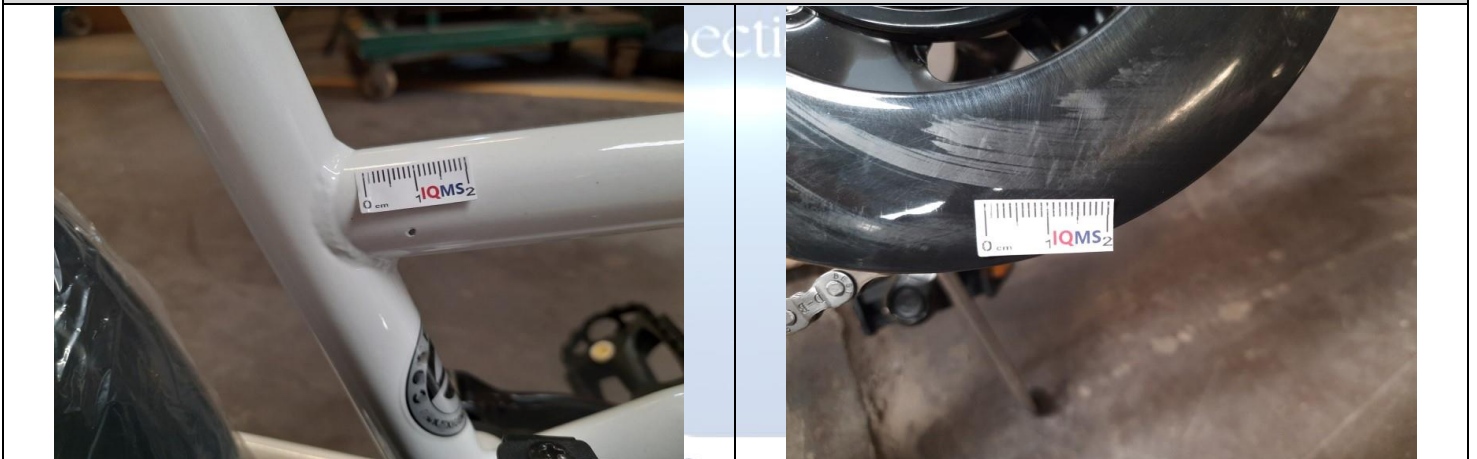


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Solvent popping at frame + Scratch mark at rim + Dirty Stain at Bottom Tube

Item: 20' xxxx Girl



Hit mark at Middle Tube + Scratch mark at Chain Cover



N/A

Hit mark at Middle Tube

Item: 24' Velo Ville



Grip Damage + Paint damage at Carrier



Dirty Stain at back Fender (Removable) + Scratch mark at Stem

3. STYLE , COLOR & DOCUMENTATION		Conform / Not Conform / Pending	
Checkpoint / Test	Inspection Level	Inspection Method	Result
Check the Conformity of the Product Compared to the approved Sample & Technical File of the Client.	Special Level 1	• Same style/materials with approved sample & technical file of the Client	Pending
Remarks:			
3.2	Color reference, designs, placement was available from client. Therefore, actual findings have been recorded in the report, for details refer to attached photos.		

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Discription	Conform	Not Conform	Pending
The inspected samples were consistent with	-	-	-
Product Specification	x		
Submitted sample	-		x
Color lot check	x		
Digital photo	x		
Client Comment	-	-	-
Nil			
 	-	-	✓
16' xxxx Girl			
 	-	-	✓
20' xxxx Girl			
 	-	-	✓
24' Velo Ville			

4. DATA MEASUREMENTS & ON -SITE TEST

4.1. DATA MEASUREMENTS

		Conform / Not Conform / Pending	
Checkpoint / Test	Inspection Level	Inspection Method	Result

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Check the product measurement	Special Level 1	• Measurement shall match product specification of the client.	Pending
Remarks:			
4.3	The ride performance test and brake resistance check are only conducted on the 24' Velo Ville model. The other two models are not tested due to their smaller size.		

Item No:	Brake resistance check					
	Specification			Actual - Dry		
24' Velo Ville	Condition			Both	Rear only	
	Dry	25	Both			1.52
		16	Rear only	3.05	1.67	2.43
	Wet	25	Both	2.13	1.72	2.87
		16	Rear only	4.57		

Size Measurement Chart					
S/N	Measurement Point	Spec (mm)	16' xxxx Girl	20' xxxx Girl	24' Velo Ville
1	Handlebar Length	-	480	580	640
2	Stem Length	-	50	50	90
3	Seat Position	-	500	500	650
4	Seat tube Length	-	180	200	250
5	Wheel Size	-	390 (16 x 1.75)	490 (SRI- 59)	590 (SRI- 75)
6	Wheelbase Length	-	780	860	100
7	Chain Stay Length	-	320	360	410
8	Kickstand Length	-	200	220	275

4.2. ON – SITE TEST		Conform / Not Conform / Pending		
Checkpoint / Test	Inspection Level	Inspection Method	Result	
Check the product functional and performance level	Special Level 1	• All the functional and performance check shall match product specification of the client and	Conform	
Remarks:				

Item Check	Specification / Remarks	Sample Size	Conform	Not Conform	Pending
4.1	Gross weight and quantity	3	✓		
4.2	Torque Checks on Nuts and Bolt	3	✓		
4.3	Derailleurs and shifters	3	✓		
4.4	Tire Pressure Check	3	✓		

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4.5	Noise and abnormal sound check	Stand some meter away from the bicycle, rotate the wheel and check for any abnormal sound	3	✓		
4.6	Fatigue test	Handbrake- Squeeze the hand brakes 50 times with a force of 445 newton Pedals - Spin each pedal in one full rotation 50 times Kickstand - Raise and lower the kickstand 50 times	3	✓		
4.7	Rub test on labels	Perform this test on a larger labels. You'll need two clothes one soaked in water and the other in alcohol. Rub the logo's with each cloth for 15 sec.	3	✓		
4.8	Coating Cross Hatch Test	Reported Actual (photo)	3	✓		
4.9	Braking system Assembly check	Use adhesive tape and a sharp blade for this test. Choose a blemish-free area on the bike and use the blade to make 11 horizontal and 11 vertical in a lattice pattern. Each line should be 20 mm long and the cuts should penetrate the coating	3	✓		
4.10	Brake block and brake pad assembly security check	Pay special attention to the cable pinch bolts that secure the brake cable to the lever arm	3	✓		
4.11	Braking distance test	Models: 24' Velo Ville only	3	✓		
4.12	Paint coating thickness	Reported Actual (photo)	3	✓		
4.13	Welded joints		3	✓		
4.14	Assembly Dimensions	Reported Actual	3	✓		
4.15	Carton box quality	Bursting strength / thickness layer and other details	3	✓		
4.16	Barcode Labels		3	✓		
4.17	User manual		3	✓		
4.18	Check toolkit components		3	✓		
4.19	Alignment of Fork	Check the alignment of Fork straight or not	3	✓		
4.20	Handle Alignment	Check the Handlebar should be properly aligned	3	✓		
4.21	Pedals	Pedals Quality and also check thread on pedals	3	✓		
4.22	Freewheel and Crankset	Check the Quality of Freewheel and Crankset includes their alignment (bent or proper) and their teeth.	3	✓		
4.23	Gear Cable (Brake and Derailleur Connecting cable)		3	✓		
4.24	Chain Quality	Brown PPO	3	✓		
4.25	Fender	Quality of Mudguards	3	✓		
4.26	Wheel (Spoke, Rim and Hub)	Check Front and Rear Hub, Spoke and Rim	3	✓		
4.27	Reflectors / Light	Quality of Reflectors	3	✓		
4.28	Frame	General Checking of Frame Quality	3	✓		
4.29	Stem	Check the Quality of Stem	3	✓		
4.30	BB set	Check Bottom Bracket for Quality	3	✓		



4.31	Chain should be Lubricated		3	✓		
4.32	Tyres and Tubes	Check the Quality of the tyres and tubes	3	✓		

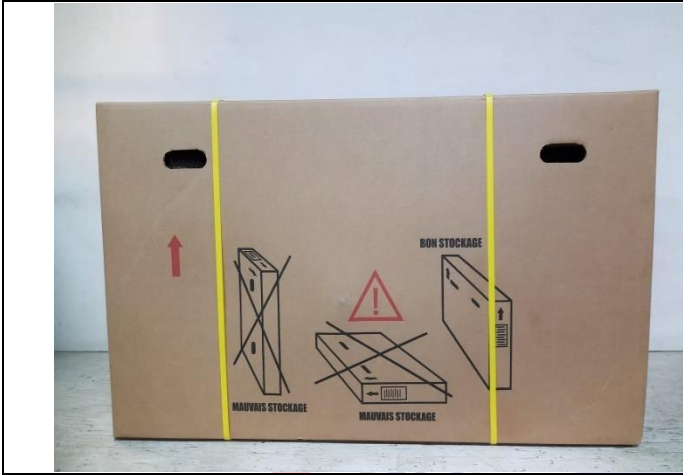
Carton Dimension & Weight				
Item:	Carton Size Measurements – in (cm)		Carton Weight – in (Kg)	
	Specification / (Marked on carton) (Length x Width x Hight)	Result	Specification (Marked on carton)	Result
16' xxxx Girl	N/A	97 x 21 x 48	N/A	11.73
20' xxxx Girl		105 x 20 x 62		15.69
24' Velo Ville		127 x 20 x 73		19.15

5. SHIPPING MARKS & PACKAGING			Conform / Not Conform / Pending	
Checkpoint / Test		Inspection Level	Inspection Method	Result
5.1	Packing Visual Check	Special Level 2	<ul style="list-style-type: none"> Packing method and conditions Retail package artworks Correct content within the package Quantity of items & accessories within the package Presence of correct version of printed literature within the package 	Pending
5.2	Shipping Marks	Special Level 2	<ul style="list-style-type: none"> Conform with client specifications Shipping marks / labels and their position 	Pending
5.3	Barcode Visual Check	Special Level 2	<ul style="list-style-type: none"> All the barcodes need to be clean Barcode type as requested Positions as per client requirements 	Conform

Remarks:	
5.1	For all items: Packing instructions details was not available form client; therefore, actual findings have been recorded in report for client reference. For details refer to below attached photo.
5.2	For All three models, 100% of the inspected cartons were observed with model specification label and “Operateur bicycode”. Hence actual findings have been recorded. For details refer to below-attached photos.
5.3	Assembly with (Box) necessary protective items with the model - Saddle, Basket, Front/ Rear reflector lights, Seat Post, Pedal set, 2 Allen keys and multi spanner set, & Manual.

Shipping Marks Photos

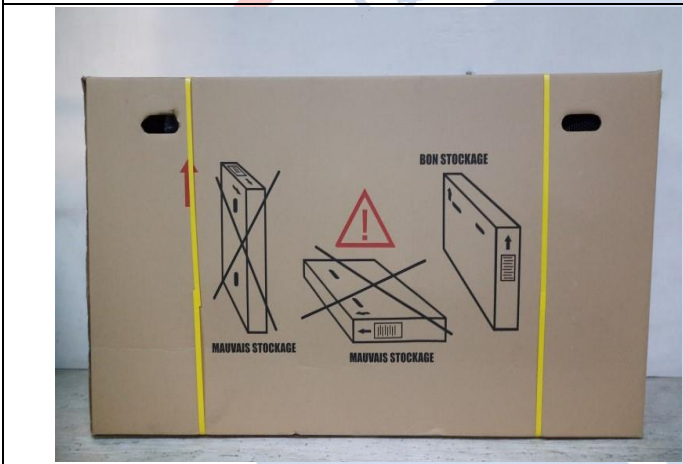
	
Item: 16" xxxx Girl	Item: 16" xxxx Girl



Item: 20" xxx Girl



Item: 20" xxx Girl



Item: 24' Velo Ville



Item: 24' Velo Ville

Packing Photos



Item: 16" xxx Girl



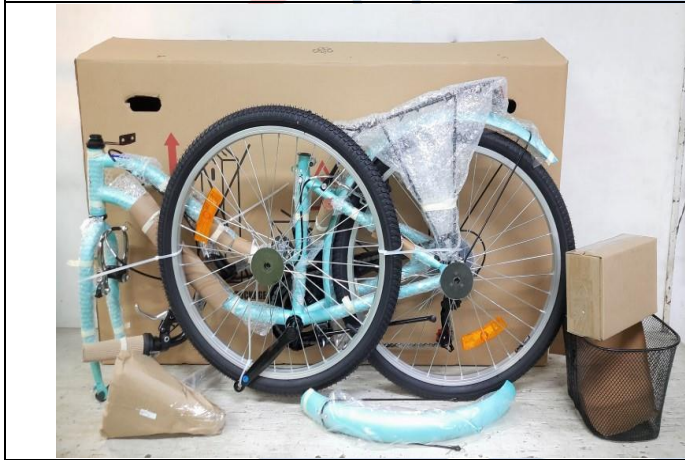
Item: 16" xxx Girl



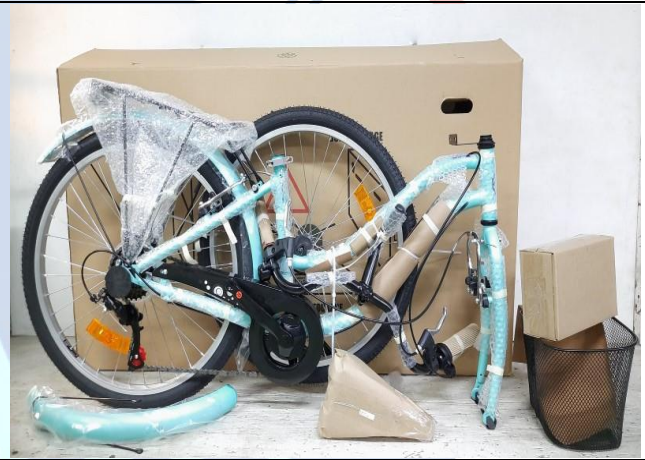
Item: 20" xxx Girl



Item: 20" xxx Girl



Item: 24' Velo Ville



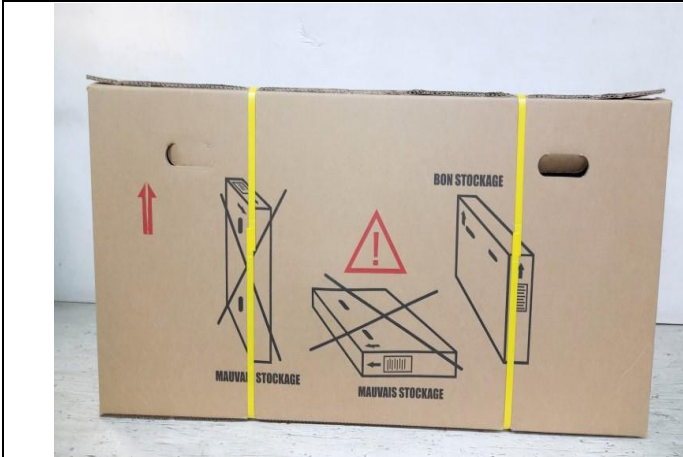
Item: 24' Velo Ville

Packing Description:	Carton plies	5
<ul style="list-style-type: none"> - 01 unit packed into a master carton with safety rapping. - 01 Accessories Box into a one unit. - Each export carton was sealed with staple pin and rapping. 		

REFERENCE NOTES	
1.	Our inspector required the factory to repair all defective samples before shipment.
2.	Draft report has been provided to the factory and defective points have been explained as well.
3.	The inspected cartons were not sealed because the factory did not repack them immediately after inspection.

7. INSPECTION RELATED PHOTOS

01. Photo of Packing & Shipping Marks View
01. Item: 16" xxx Girl



Carton Front View



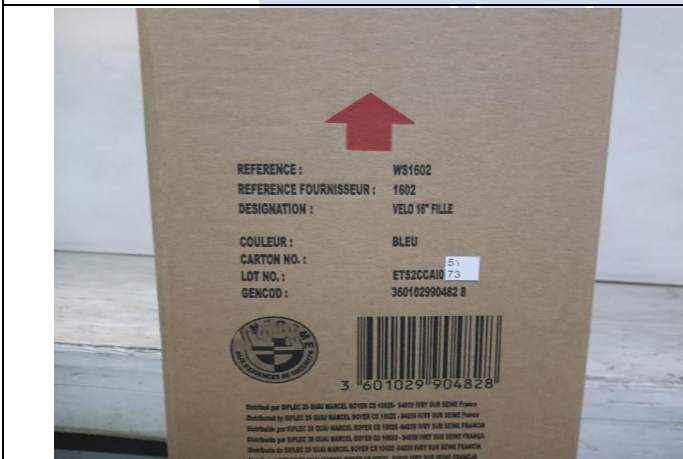
Carton side View - 1



Carton side View - 2



Carton Label View



Carton Shipping Mark View



Carton Top View



Carton Open View



Packing View



Packing View



Accessories Box View



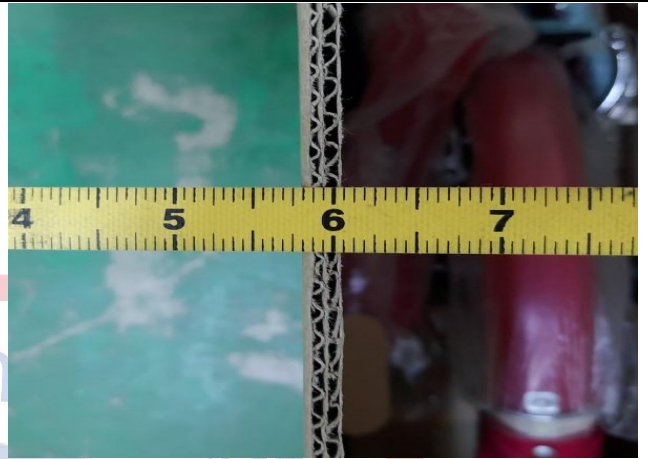
Carton Dimension Check



Carton Dimension Check



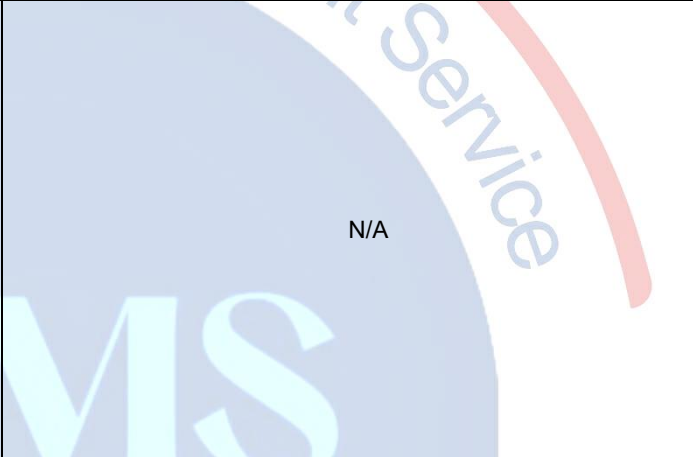
Carton Dimension Check



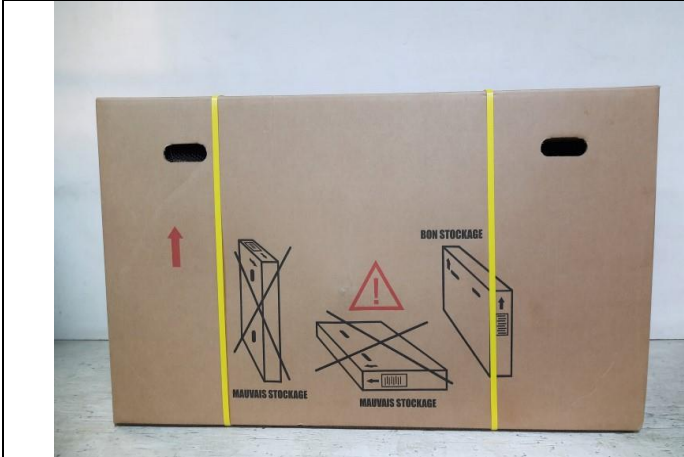
Carton Ply Check - All Models are same 5 Ply



Carton weight Check



02. 20' XXXX Girl



Carton Front View



Carton side View - 1



Carton side View - 2



Carton Label View



Carton Shipping Mark View



Carton Top View



Carton Open View



Packing View



Packing View



Accessories Box View



Carton Dimension Check



Carton Dimension Check

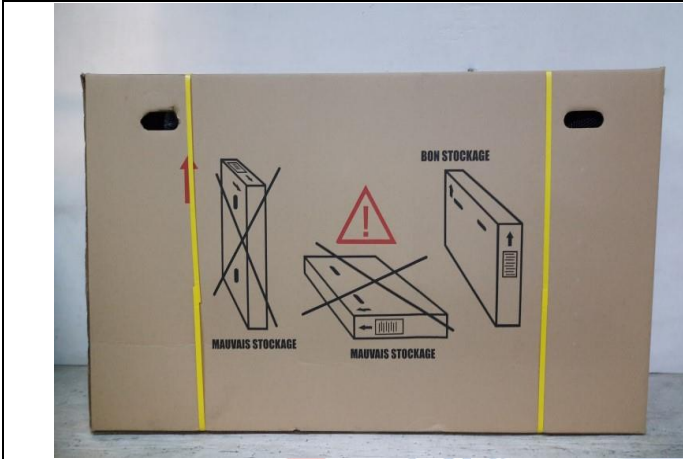


Carton Dimension Check



Carton weight Check

03. 24" Velo Ville



Carton Front View



Carton side View - 1



Carton side View - 2



Carton Label View



Carton Shipping Mark View



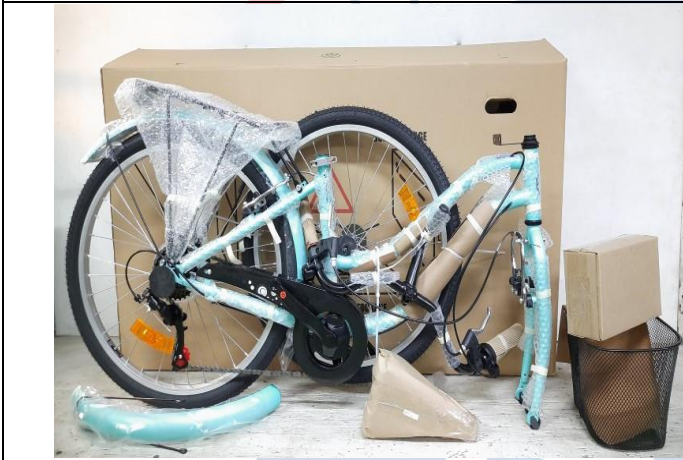
Carton Top View



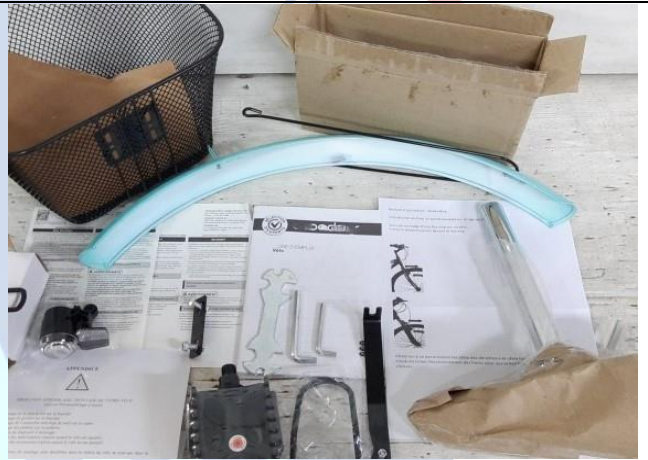
Carton Open View



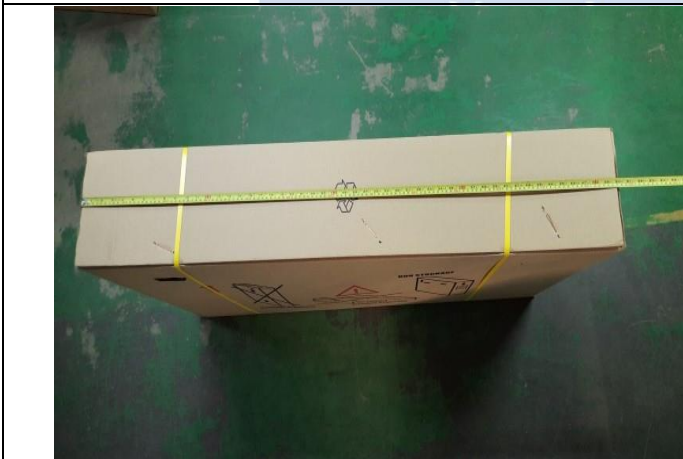
Packing View



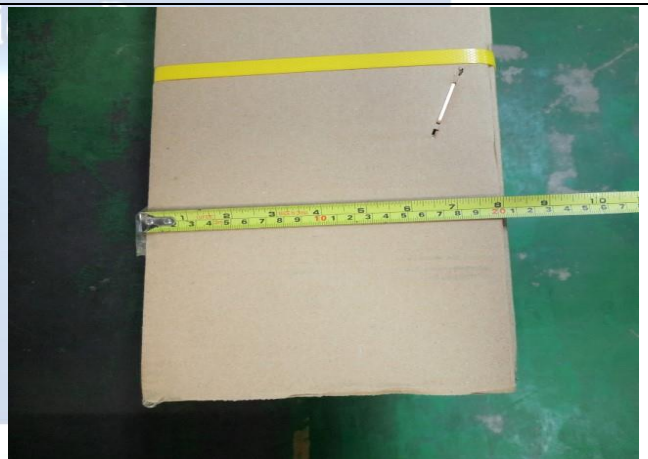
Packing View



Accessories Box View



Carton Dimension Check



Carton Dimension Check



Carton Dimension Check



Carton weight Check

02. Photo of Product View

01 16" xxx Girl



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product Label View



Product View



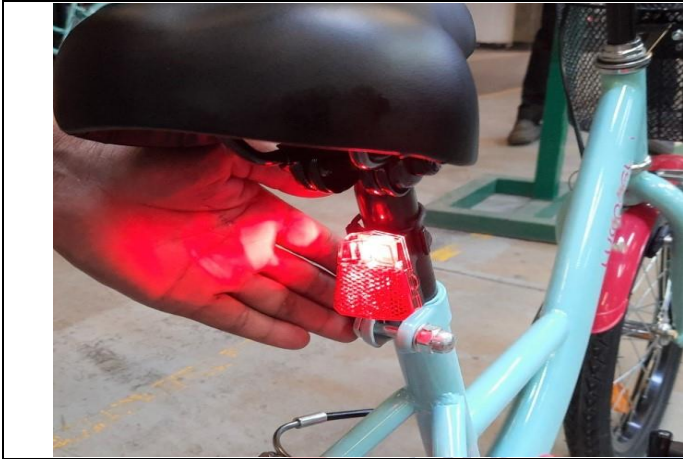
Product View



Product View



Product View



Product View



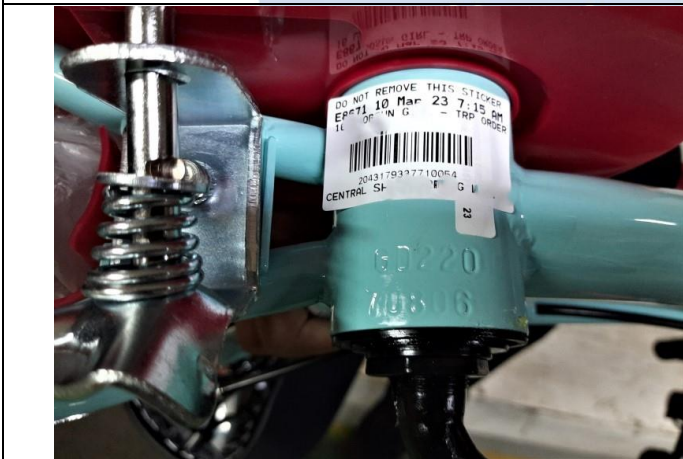
Product View



Product View



Product View



Serial number + Supplier Barcode



Product Lot Label



Product View



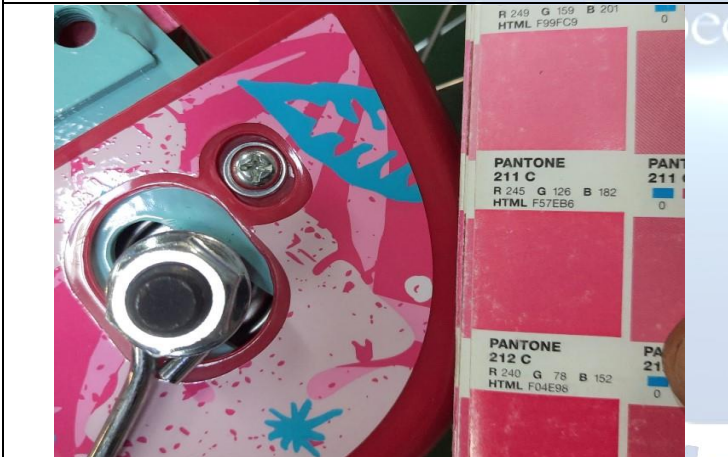
Color matching Check



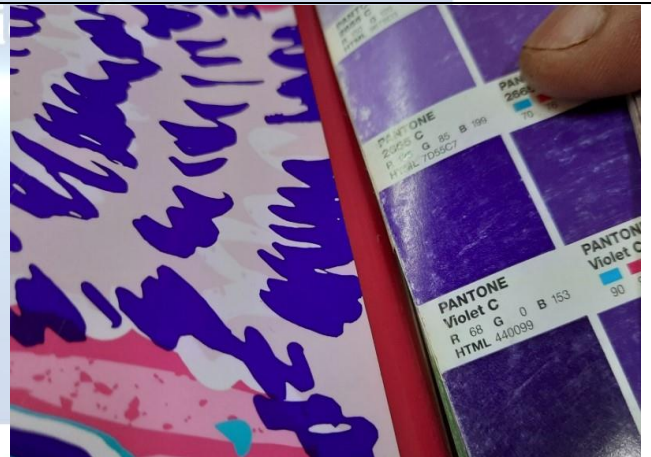
Color matching Check



Color matching Check



Color matching Check



Color matching Check



Color matching Check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check

02 20" xxx Girl



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



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Logo View



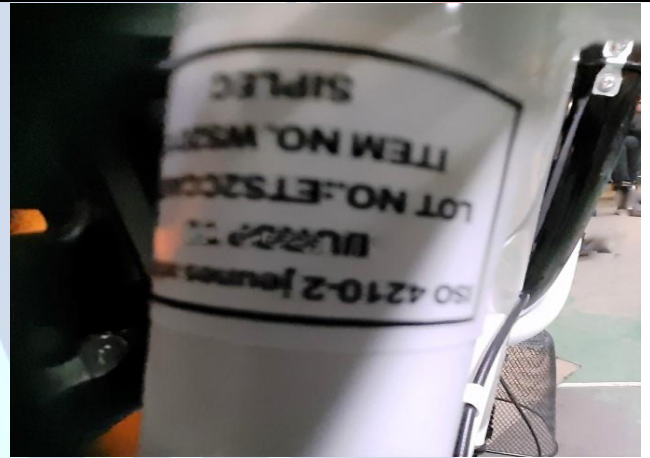
Product Code Label



Product View



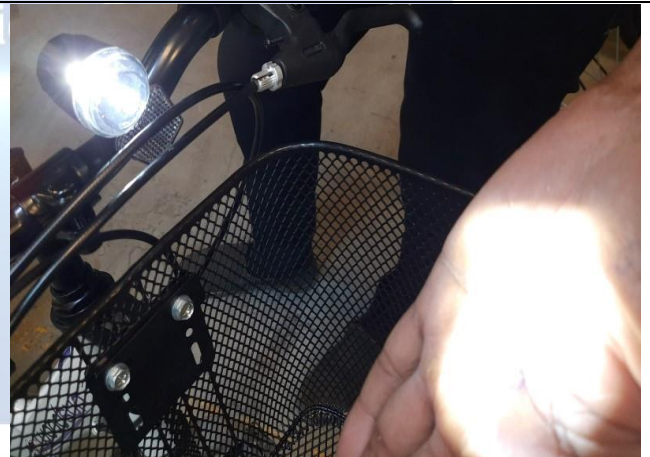
Serial number + Supplier Barcode



Product Lot Label



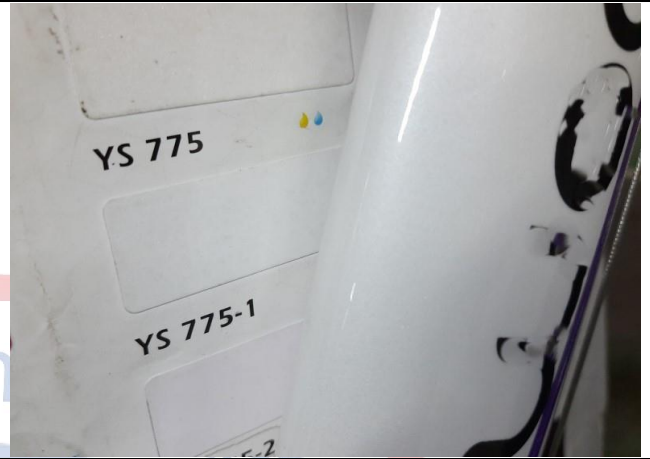
Product Label View



Product View



Product View



Color matching Check



Color matching Check



Color matching Check



Color matching Check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check

N/A

03 24' Velo Ville



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



Product View



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Product Code Label



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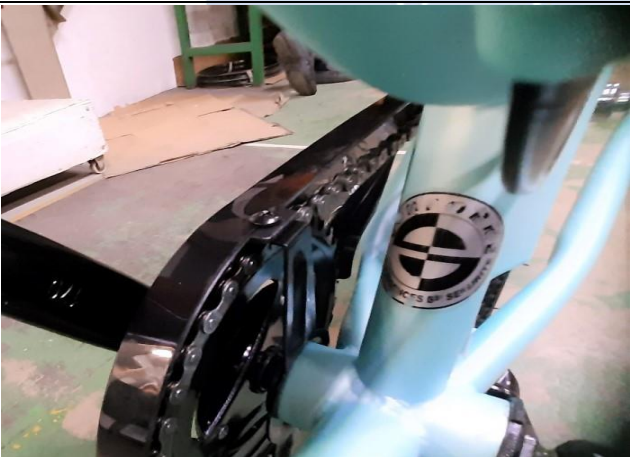
Product View



Product View



Product View



Product Label View



Serial number + Supplier Barcode



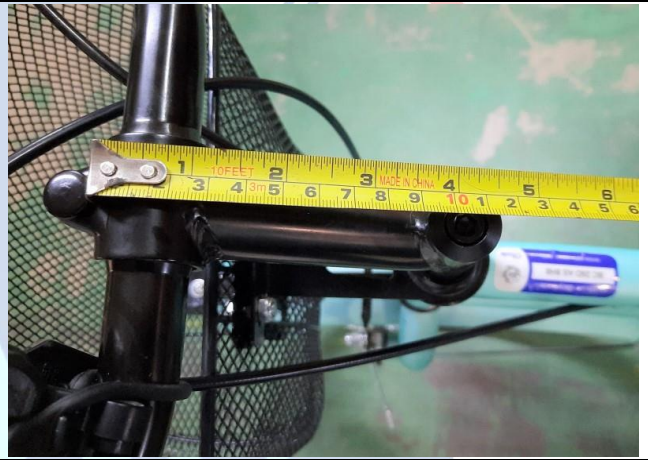
Serial number + Supplier Barcode



Logo View



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



Dimension check



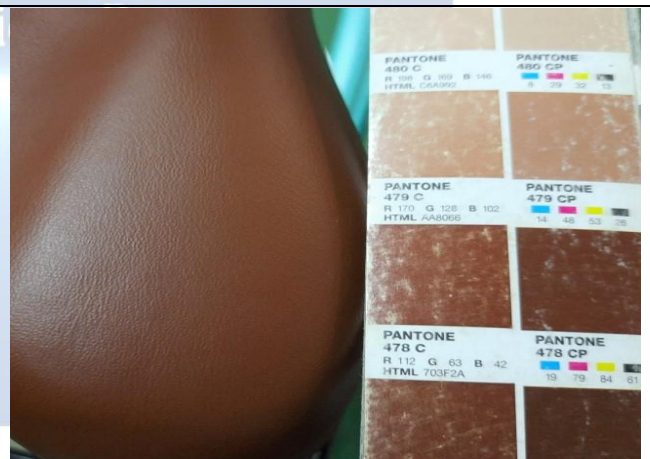
Dimension check



Dimension check



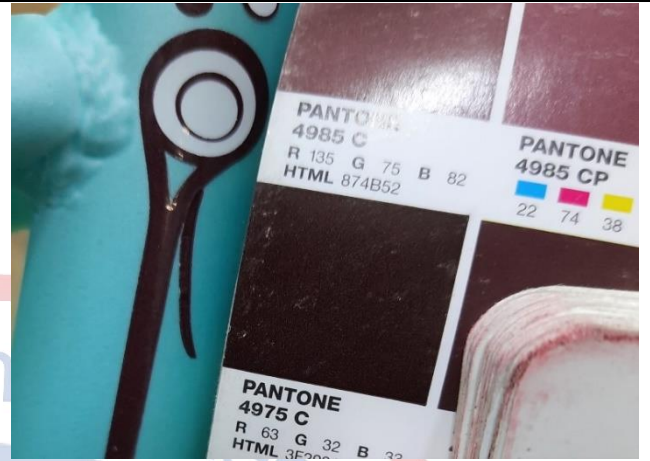
Color matching Check



Color matching Check



Color matching Check



Color matching Check

04. Photo of On - Site Test







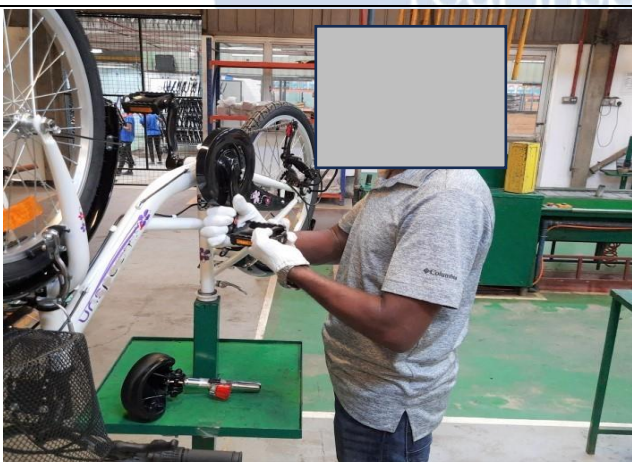
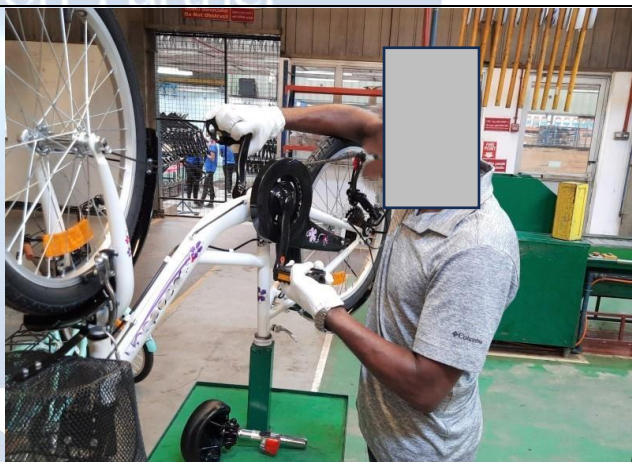
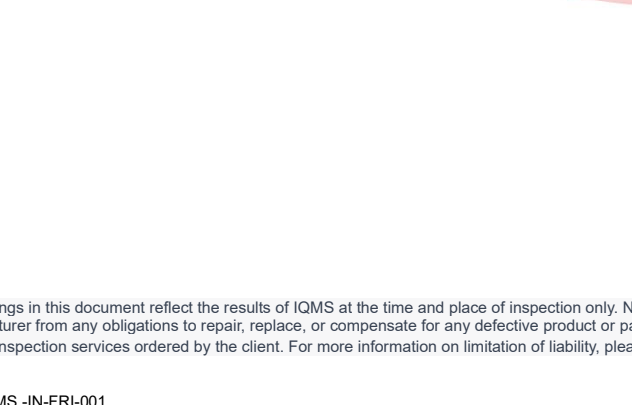
DFT Test



DFT Test



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<p style="text-align: center;">Rub Test</p> 	<p style="text-align: center;">Rub Test</p> 
<p style="text-align: center;">Handle alignment Check</p> 	<p style="text-align: center;">Handle alignment Check</p> 
<p style="text-align: center;">Hand Brakes Test</p> 	<p style="text-align: center;">Hand Brakes Test</p> 
<p style="text-align: center;">Pedals Check</p> 	<p style="text-align: center;">Crank Bolts Check</p> 

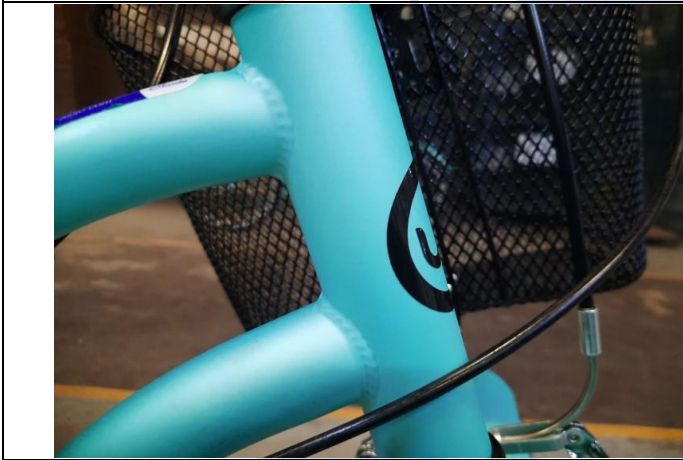
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Pedals Thread Check



Welded Joint Check



Welded Joint Check



Kickstand test



Kickstand test



Air Pressure Check



Derailleurs and Shifters Check



Derailleurs and Shifters Check



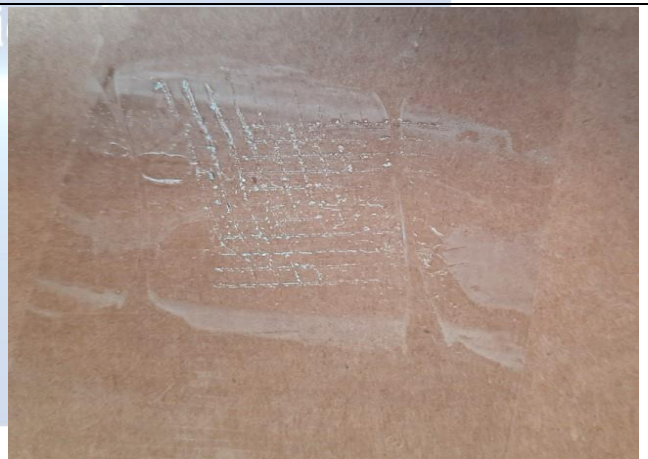
Tires and Tubes Check



Tires and Tubes Check



Cross Hatch Test



Cross Hatch Test



Nuts and Stem Check



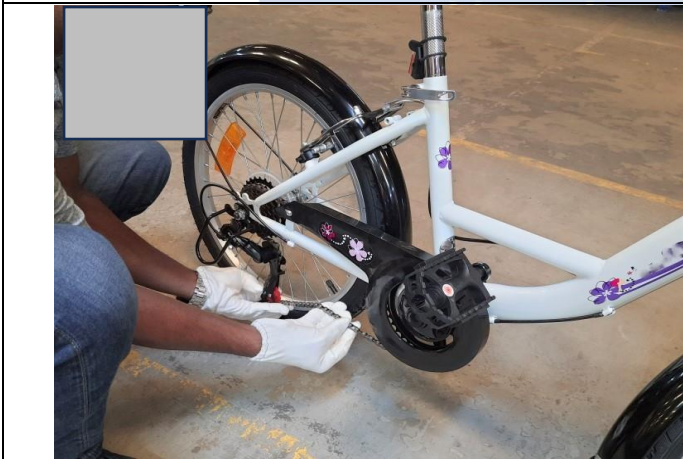
Nuts and Stem Check



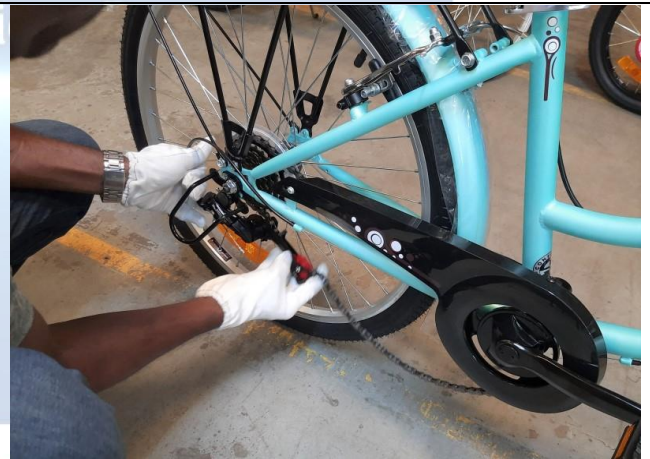
Fork alignment Check



Fork alignment Check



Chan lubricate & Quality Check



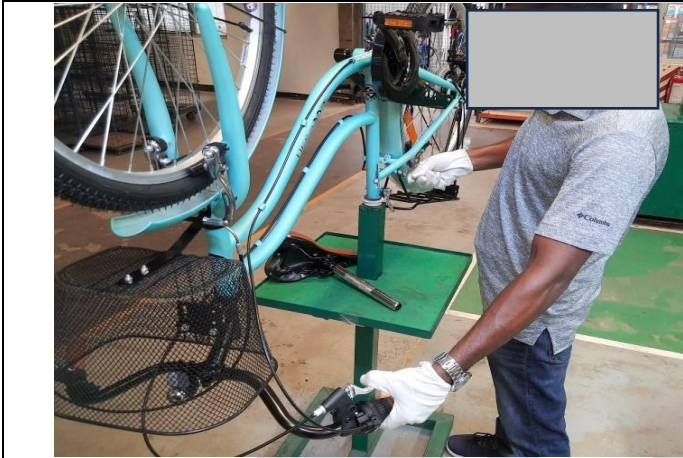
Chan lubricate & Quality Check



Cable Pinch and bolts Check



Cable Pinch and bolts Check



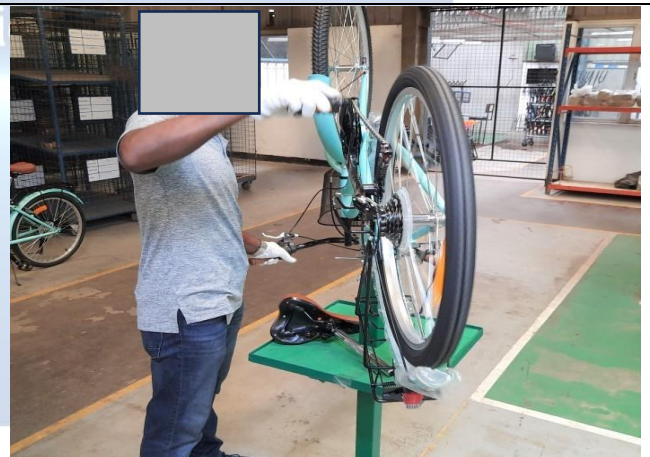
Brakes Check



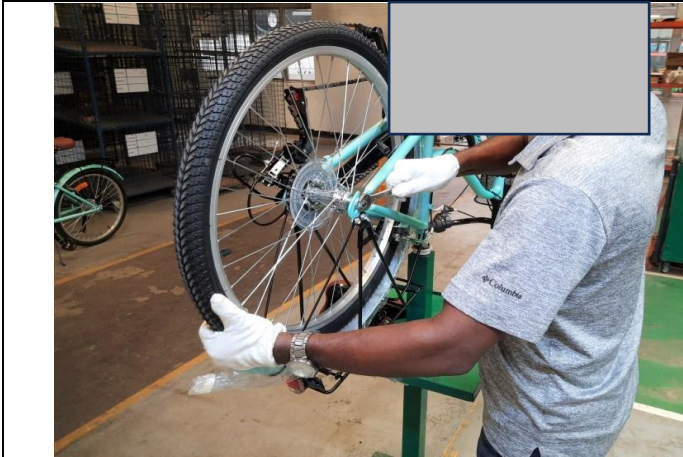
Brakes Check



Rear Derailer Bolts check



Spin check - Gear shifting



Rear Wheel nuts check



Front Wheel nuts check



Noise and Abnormal sound Check



Noise and Abnormal sound Check



Braking Distance Check



Braking Distance Check



Braking Distance Check



Ride performance test



Ride performance test



Ride performance test

05. Photo of General View



Factory name board View



Factory Front View



Warehouse



Cartons Stacking View



Cartons Stacking View



Inspection Product Models View

Your Inspection Partner

INSPECTOR:

IQ10001

AUDITOR:

IQA20003

***** END OF REPORT *****

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