

SOP FOR YARN INSPECTION

- We randomly select 20 cartons from running production and stock pictures are taken.
- Shipping marks are to be checked whether neutral or regular as per buyer specifications
Picture are taken for shipping marks.
- Gross weight & net weight of each carton is to be checked.
- All cartons are opened and 2 cone from each carton is send to the lab for testing. All 20 cones are weighed on small scale and their tail end and appearance is to be checked and pictures are taken.
- Plant is checked for its working & housekeeping from blow room to packing. Machinery pictures lab pictures are taken during visit.
- After that all 20 cones are tested as per ISO (Uster Standards) Lab testing includes below tests:
 - A) Uster Testing from 20 Cones (for Uster, I.P.I and Hairiness)**
Testing Modes: 20 Tests from each cone, So mean of 100 tests
 - B) Yarn Strength Testing from 10 Cones**
For Utr 10 Cones /20 tests each on drafting speed of 5000 mm/Min.
For Utj 10 Cones/2000 single tests on drafting speed of 400 mm/Min.
 - C) C.S.P**
 - D) T.M & T.P.I**
 - E) Count Wrapping from 20 readings from 20 cones .**
 - F) Classimat from 100 Kms of yarn following readings are taken**
Short Thick (A1+B1+C1+D1)
Short Thick (A3+B3+C2+D2)
Long Thick (E+F+G)
Short Thin (H1)
Long Thin (H2+I1+I2)
 - G) Appearance Board from randomly selected cones.**
- Results are compared with their regular results and shipment is allowed in case no major variation found.
- Container loading pictures if stuffed.
- Knitting trails are taken wherever necessary for randomly selected lots and Greige fabric is dyed in two shades one dark and another and evaluated as per 4 point system.
- Complete summary of inspections in details and send to customer in two parts one for physical inspections and another for testing done.