



Sl.No	Process Stage/Area	Critical parameters relating the job	Responsibility	Inspection Plan	Specification & Tolerance	Acceptance Criteria
1.	Clicking	<ul style="list-style-type: none"> - Operating the clicking machine - Adjustment of the pressure regulator - Identify patterns - Leather clicking with minimum wastage 	Clicking Operator " " "	Periodic Check " " 100% against the approved sample	The patterns should be as per the requirement +/- 2mm with the samples	Machines should be able to click the leather smoothly " " Samples should pass the inspection
2.	Printing	<ul style="list-style-type: none"> - Identify appropriate screen - Printing of gloves (at appropriate place) as per approved sample 	Printer "	Visual - 100 % to be checked against the approved sample	Torn screen should not be used No smudging / inappropriate printing	"
3.	Heat Embossing	<ul style="list-style-type: none"> - Identifying appropriate emboss / die - Embossing of gloves (at appropriate place) as per approved sample 	" "	Visual check Visual - 100 % to be checked against the approved sample	No burning sign should appear on the gloves	
4.	Stitching	<ul style="list-style-type: none"> - To identify the cut components - To select the appropriate stitching machine and able to run independently - Should be able to stitch the cut components with the help of consumables (binding tape, elastic, lining, velcro, etc) - Needle size - 16 / DP-1/DP-5 	Tailors " "	Visual " "	The stitch should be 1.5 - 4.5 mm inside the edge. There should be about 8-10 stitches per inch for general 5-8 stitches per inch for Binding jobs & 3-6 stitches per inch in case of zig zag machine	All should pass
5.	Turning	<ul style="list-style-type: none"> - Should be able to remove excess leather from the stitched gloves - Should be able to turn the stitched gloves against the turning pole & bundling in pairs 	Operator	20% sample to be selected at random from a lot and selected for even and strong stitching	"	If 5 out of 20 samples selected is found to be defective go for 100% inspection



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6.	Ironing	<ul style="list-style-type: none"> - Should be able to select, fix and operate the Irons according to the size of the gloves - Should be able to set the regulator (Auto cut Out) of the irons - Should be able to iron the gloves on the iron - No ironing for gloves with fur/linen 	Operator	<ul style="list-style-type: none"> - Visual - The appropriateness of the Irons, the temperature of the irons should be checked periodically (say every hour) -100% of the gloves to be checked during the process of ironing for the rigid stitch 	<p>Ironing for 5 -6 seconds. Temperature of the irons should be within 120 - 140 degree celsius</p> <p>The gloves should remain intact after ironing</p>	<p>As per specification</p> <p>All should pass</p>
7.	Preservation	<ul style="list-style-type: none"> - Stacking the gloves on the racks evenly in the dehumidification chamber - Allowing gloves to be in the dehumidification chamber for the specified period 	Operator	<ul style="list-style-type: none"> - Time of preservation to be checked - RH of the chamber to be measure twice a day 	<ul style="list-style-type: none"> - RH of the dehumidification chamber to be maintained around 40% (+/- 5 %) - 1 hr 	As per specification
8.	Final Inspection	<ul style="list-style-type: none"> - Style - Size - Thickness - Holes - Apparent Discolouration - Visible colour variation between the pair - Rigid stitching - Crumpled gloves 	Checkers	100 % - visual Gauges to be used for measuring thickness	As per specification	All should pass
9.	Packing	<ul style="list-style-type: none"> - Bundling of finished gloves as per Q/plan - Placing bundles in polythene bags/packets - Information sheet inside the packet - Heat Sealing of the packets - Quality checked sticker on the packets - Placing the required number of packets inside the cartons as per Q/plan. - Putting shipping mark on the cartons as per Q/plan 	Packers	100 % - visual under direct supervision		All should pass