

Bag Defect Dictionary

Critical · Major · Minor — what each fault is, how it is measured, and how AQL 2.5 counts it

How to use this dictionary

This is one copy for two hands. The inspection floor and the production floor hold it at the same time, so that a word means one thing. A fault is named, given a definition, given a measurement method and given a grade — and nothing is graded by how it looks next to something else.

The grades map onto the sampling plan rather than onto opinion. A critical defect is not counted: the lot is not released on one, whatever the sample size drew. Major defects are counted against the accept number at **AQL 2.5 under ISO 2859-1, General Inspection Level II**. Minor defects are counted separately at a looser level, and are recorded rather than automatically failing the lot. Anything inside the written tolerance on the tech pack is not a defect at all.

Grade	Test it asks	How the plan counts it
Critical	Would the unit injure somebody, or fail a mandatory requirement?	Zero acceptance at any level. The lot is not released on a critical.
Major	Would a retail customer return the unit on sight?	Counted against the accept number at AQL 2.5 for the sample size drawn.
Minor	Would a customer notice it unaided, and does it affect function?	Counted separately at a looser level; recorded rather than failing.
Not a defect	Is it inside the written tolerance on the tech pack?	Recorded and closed. No count against the plan.

Sample size is drawn from the lot size, not chosen. Because the plan is a sample, accept numbers are small: at 500 pieces the lot draws code letter H and 50 units, and at AQL 2.5 that is three accepted majors before the lot fails. That is why a named reference matters more than a good eye — the difference between three and four units is the difference between a release and a re-sort.

Sample size at your lot size

Nobody chooses the sample size; the lot size chooses it. Under **ISO 2859-1 at General Inspection Level II** the lot size sets a code letter, and the code letter sets how many units are drawn. The table below is the part of the standard that matters on inspection day, for the lot sizes a bag programme actually runs.

Lot size (pieces)	Code letter	Units drawn	Accept (Ac)	Reject (Re)
151 - 280	G	32	2	3
281 - 500	H	50	3	4
501 - 1,200	J	80	5	6
1,201 - 3,200	K	125	7	8
3,201 - 10,000	L	200	10	11
10,001 - 35,000	M	315	14	15

Read the last two columns together. At 500 pieces fifty units are drawn and three majors are accepted — the fourth fails the lot. That arithmetic is why this dictionary exists: the gap between three and four is one inspector's judgement about whether a single unit carries a major defect or a minor one, and that judgement should reference a written definition.

What an inspection report has to contain

Entry	Why it belongs there	What a missing entry hides
Lot size and units drawn	Both, because the accept number cannot be checked without them.	A pass recorded against an unknown sample size is not a result.
Code letter and inspection level	Level II is the default; a tighter or looser level changes everything above it.	A lot quietly inspected at a tighter level than agreed.
Defect count by grade	Majors and minors counted separately, against separate numbers.	A lot passed on a combined count that was never the plan.
Every named standard used	The measurement method is part of the result.	A result nobody can reproduce.

Entry	Why it belongs there	What a missing entry hides
Photographs of each defect found	A named fault with no image is a claim.	The difference between a re-sort and a discussion.

Critical — the lot is not released on one

These are not traded off against a count. Any one of them stops the lot.

Defect	Definition	How it is measured	Grade
Bbroken needle fragment in filling	A fragment of a sewing machine needle retained inside wadding, padding or a filling.	Metal detection after filling and again after closing; the unit is quarantined if the detector alarms.	Critical
Sharp point or sharp edge	An accessible point or edge capable of causing injury, including a burr on hardware.	Penetration test against EN 71-1 clause 8.11 / 8.12 where the article is a toy or could be mistaken for one.	Critical
Handle or strap release under load	A load-bearing webbing, handle or strap releasing from the body at or below its rated load.	Static load test to the agreed rating in kilograms, held for the stated minutes, on a seized unit.	Critical
Restricted substance above the limit	A measured value above the limit set by REACH Annex XVII, CA Prop 65, CPSIA or EN 71-3.	Laboratory test against the named standard on a composite sample of the lot.	Critical
Suffocation or choking hazard in packaging	A film thinner than the regulated gauge, a small part detachable in use, or a missing warning.	Film thickness gauge plus small-parts cylinder; warning text read against the destination regulation.	Critical
Incorrect mandatory labelling	Missing or wrong country of origin, fibre composition, care code or traceability marking.	Documentary check against the destination labelling rule; this precedes any visual inspection.	Critical

Major — counted against the accept number at AQL 2.5

The question is always the same: would a retail customer put this back on the shelf having looked at it once?

Defect	Definition	How it is measured	Grade
Seam opening	A sewn seam separating so that the stitch line is visible as a gap.	Ruler or seam gauge; measured at the widest point, opened under a stated manual load.	Major
Liner weld leaking	A welded or RF seam in a waterproof liner letting water through.	Low-pressure water test or air pressure decay on the liner before it is built in.	Major
Shade step against the swatch	A colour difference to the approved swatch visible at arm length.	Grey scale for colour change, ISO 105-A02, under D65 lighting at arm length.	Major
Print misregistration	A print layer outside its stated tolerance relative to the artwork datum.	Measured from the stated datum to the print edge, against the tolerance on the tech pack.	Major
Zip does not run	A slider failing to travel the full chain, or teeth separating behind the slider.	Twenty full open-close cycles by hand; any catch or separation fails the unit.	Major
Foam delamination	A laminated foam or coating separating from its face fabric.	Peel resistance measured against ASTM D2724, or a stated manual peel distance.	Major
Dimension outside tolerance	A finished dimension outside the stated plus and minus range.	Tape measure, laid flat under no load, on the dimension named on the tolerance sheet.	Major
Coating peel or tack	A PU or TPU surface that has lifted, blistered or gone tacky to the touch.	Visual plus thumb-rub; cross-reference ISO 2411 coating adhesion.	Major
Component missing	A named component on the tech pack absent from the finished unit.	Counted against the hardware schedule line by line.	Major
Embroidered logo incomplete	A broken thread, a run, or coverage below the approved sample.	Compared against the approved embroidery sample at arm length.	Major
Hardware corrosion or wrong finish	Rust, plating lift, or a finish not matching the approved sample.	ISO 9227 neutral salt spray where specified; otherwise visual against the sample.	Major
Webbing not sewn through reinforcement	A load strap attached without its bar-tack or box stitch.	Counted stitch examination; any load path without its reinforcement is a major.	Major

Minor — recorded separately, at a looser level

Visible on examination, often corrected on the spot, and not by themselves the reason a lot fails.

Defect	Definition	How it is measured	Grade
Thread end inside the lining	A loose thread end longer than 10 mm left inside the body.	Counted and trimmed; measured with a ruler and closed out on the spot.	Minor
Print registration shift inside tolerance	A shift that is measurable but within the stated tolerance.	Recorded against the tolerance; no count against the accept number.	Minor
Wrinkle or crease at a fold	A set crease in the face fabric away from a sewn line.	Visual at arm length after the unit has been flat packed and reopened.	Minor
Small snag in the face fabric	A pulled thread less than 5 mm that does not break the surface.	Ruler; anything that breaks the surface moves up to a major.	Minor
Label skew within tolerance	A label rotated or offset but still readable and within its tolerance.	Measured against its stated position tolerance.	Minor
Uneven topstitch spacing	A visible variation in stitch spacing with no loss of strength.	Counted stitches over 30 mm against the stated SPI.	Minor
Dust or handling mark on the carton	Soiling on the export carton that does not reach the unit.	Visual; recorded so the pack-out can be corrected for the next lot.	Minor

Not a defect — recorded and closed

Anything inside the tolerance written on the tech pack. Written tolerances are what keep an inspection from becoming an argument.

Defect	Definition	How it is measured	Grade
Dimension inside its tolerance	A measurement inside the plus and minus range on the tolerance sheet.	Recorded and closed. No count against the sampling plan.	Not a defect
Shade within the approved range	A colour inside the grey-scale step agreed at sample approval.	Recorded against the reference pair.	Not a defect
Intended construction feature	Any detail present on the approved golden sample by design.	Compared against the signed golden sample.	Not a defect
Wrinkle from packing, relaxed in 24 h	A crease that falls out once the unit is hung.	Re-examined after the stated time.	Not a defect

Revision and version

Version 1.0. A dictionary goes stale the moment a new material or a new construction enters the range: the issue date below is the date it was agreed, and every revision is renumbered so that an inspector holding page one knows whether page six is the same version.

Version	Issued	What changed	Agreed by
1.0	First issue	Full set across three grades	Quality, production and the buying entity

MOQ: 500 pcs per style and colourway (300 negotiable on a repeat) | Sampling: 6-10 working days; 12-15 where the construction is complex | Bulk production: 35-50 days after sample approval | Inspection: AQL 2.5, ISO 2859-1, General Inspection Level II | Payment: T/T 30/70 Terms: FOB Xiamen (CIF/DDP available)