Supplier Quality Manual – Quality, Testing & Inspection

Oryzon Group SRL (BoostUp) · Annex 2 of the Supply Agreement · Version 1.0 · October 2026

Introduction

This manual sets out how Oryzon Group SRL (“Oryzon”) and its production partners (“the Supplier”) work together to deliver first-quality products, from development to shipment. It applies to all apparel and accessories made for Oryzon and its customers.

This manual is **Annex 2 of the Supply Agreement** between Oryzon and the Supplier and covers quality, testing and inspection only. To avoid repetition, it does not restate what the other documents already cover:

- **Supply Agreement:** orders, prices, delivery, shipping documents, warranty, penalties, confidentiality and designs.
- **Annex 1 (Supplier Policy):** social and environmental rules, audits, REACH and chemical testing, OEKO-TEX, packaging rules (PPWR) and the REACH Commitment Letter.

Where a customer gives specific instructions (tech pack, labels, packaging, testing), those instructions apply in addition to this manual.

The Supplier passes these requirements on to its own material and component suppliers. The forms at the end of this manual can be used for the controls it describes; the Supplier may use its own forms if they record the same information.

Product acceptance flow

1. **Tech pack and price** – Oryzon sends the specs; the Supplier gives the first price.
2. **Proto sample** – checked by the factory first, then sent to Oryzon.
3. **Tests and PPS approval** – the go-ahead to cut bulk.
4. **Bulk production** – full size check at 10 % and in-line quality control.
5. **Final inspection** – AQL 2.5, goods 100 % packed.
6. **Shipment approval** – written approval from Oryzon.

Each step must be approved before the next one starts. A product that fails a step goes back to the Supplier for correction at its own cost.

1. Product development and samples

1.1 Proto samples

Oryzon sends a technical file (tech pack) with design images, materials and a measurement chart. Depending on the collection, Oryzon and the Supplier may work together on the design.

- The first price must be given with the first proto sample, using Oryzon’s cost breakdown format per style.
- Before sending, the Supplier checks each proto sample: measurements, construction and workmanship, colour and labelling. A sample that does not conform is not sent without telling Oryzon.
- A completed measurement chart is sent by e-mail with every proto sample.
- Samples are sent in the sizes requested. Several samples can travel in one master polybag.
- Each sample carries a tag showing at least: Oryzon PO or style number, style name, colour, size, material composition and Supplier name.

1.2 Other samples

Sample	Purpose	Key rules
Size set sample (SSS)	Check measurements and fit across sizes	Only the sizes requested
Pre-production sample (PPS)	Final approval before cutting	Made on the agreed production site, with bulk materials, measurements, construction, all labels, trims and packing. Two pieces to Oryzon, one keep sample at the factory
Salesman / marketing samples	Sales, web shop, events	Sent as requested, under the same conditions as production, with an invoice and packing list
Shipment sample (TOP)	Validate the bulk order before shipment	One piece per style and colour from bulk, unless more are requested
Wear-test sample	Internal wear test	One piece per style from bulk, in the sizes requested

Sample, lab dip and strike-off shipping costs are paid by the Supplier, unless Oryzon agrees otherwise in writing.

1.3 PPS approval

Oryzon answers each PPS with one of three decisions: **approved as submitted**, **approved with comments** (corrections to apply in bulk), or **rejected** (a new PPS is needed). Bulk cutting starts only after PPS approval and final price confirmation. The approved PPS and the factory keep sample are the reference for all inspections.

2. Testing program

Testing makes sure products are durable, safe and compliant with EU law (in particular REACH) and with customer requirements.

2.1 Laboratory

Tests are done by an ISO/IEC 17025 accredited laboratory approved by Oryzon, as required in Annex 1, article 4. The Supplier opens its account with the laboratory before the first submission, pays the tests and sends every report to Oryzon. If a test fails, the Supplier contacts Oryzon **before** starting or continuing production.

2.2 What to test

- **Fabric tests:** as soon as the first bulk fabric lot is finished, send 2 metres of bulk fabric in one colour, plus 2 metres of each additional colour for colourfastness tests.
- **Garment tests:** one garment per production colour that reflects 100 % of bulk, with all trims, made by the actual production factory.
- **Chemical tests:** as required by Annex 1, articles 3 and 4 (not repeated here).
- The required physical tests (colourfastness, pilling, dimensional stability, seam strength, etc.) depend on the product group and are confirmed by Oryzon for each program.

2.3 Exemptions to save time and cost

- **Same fabric quality across several styles:** test colourfastness and pilling on one style only; test each additional colour on one style.
- **Five colours or more in one style:** test one light, one medium and one dark colour for colourfastness.

- **Repeat orders:** a repeat order shipped within 12 months of the first order can be exempt. After 12 months, it is tested as a new program.

2.4 Special requirements

- Garment-dyed, pigment-dyed, washed and denim products are tested in **garment form only**, and appearance after washing is tested on **all colours**.
- Fully lined and activewear styles are tested for **colourfastness to perspiration**.

3. Fabric and production quality control

Only first-quality goods are shipped to Oryzon. Quality control during production is the Supplier's responsibility.

3.1 Fabric inspection (4-point system)

Fabric mills inspect 100 % of the fabric after finishing, by roll and by lot, before it goes to the sewing factory. The Supplier keeps fabric inspection reports showing total lots, total rolls and all defects found.

Defect length	Points
Up to 3" (7.5 cm)	1
3" to 6" (7.5 to 15 cm)	2
6" to 9" (15 to 23 cm), or a hole of 1 × 1 cm	3
Over 9" (23 cm)	4
Hole of 2 × 2 cm	5

Fabric type	Maximum points per 100 square yards
Basic knits (combed cotton, cotton blends, jersey, interlock, rib, mesh)	30
Denim and cotton twill	20
Synthetic fabrics and cotton canvas	15

3.2 Shading

- No side-to-side or end-to-end shading within a roll. Shaded rolls are rejected.
- Roll-to-roll shading within one lot: **grey scale 5** (ISO 105-A02, visual check under D65 light). Rolls below 5 are moved to a new lot.
- Between lots: **grey scale 4/5 minimum**. Keep the number of shade lots per order as low as possible.
- Washed or specially treated products: send any different shades to Oryzon for approval before production.

3.3 Materials and cutting

- Check every fabric lot for colour, weight, hand-feel and quality, and every trim for colour, size, function and quality.
- Number the fabric layers right after cutting so that panels of one garment come from the same layer.
- Bundle cut panels and check them for fabric defects, print and embroidery problems before sewing.

3.4 Full size check at 10 %

When 10 % of the order is produced, the Supplier checks a full size set taken at random from the lines, against the approved PPS and the measurement chart. Results are kept and shared with Oryzon on request.

3.5 In-line inspection

Each factory runs a daily in-line inspection system that covers:

- materials before production;
- sewing lines and semi-finished products during assembly;
- finished products (overall quality, labels, prints and branding);
- a wash test on the first pieces from each line (appearance after washing, print and trim durability, colourfastness).

4. Final inspection

4.1 Before packing

The Supplier trims and visually checks **every piece** before packing.

4.2 Final inspection after packing

- The Supplier confirms the goods-ready date to Oryzon at least **14 days** in advance.
- For each order and each style, the Supplier carries out a statistical final inspection when the goods are **100 % finished and packed**, with the final packing list ready.
- Oryzon or its customer may also send an independent inspector (Supply Agreement, article 3). The Supplier respects the agreed date and gives full access to the goods.
- The inspection report, with photos of every defect found, is sent to Oryzon before shipment. Shipment approval follows the Supply Agreement, article 4.

4.3 Sampling plan: AQL 2.5, general inspection level II

Samples are taken at random, spread over all sizes. Each colour of a style is counted as a separate lot.

Lot size (pieces)	Sample size	Accept (max. major defects)	Reject
2 – 50	5 (all pieces if fewer)	0	1
51 – 150	20	1	2
151 – 280	32	2	3
281 – 500	50	3	4
501 – 1,200	80	5	6
1,201 – 3,200	125	7	8
3,201 – 10,000	200	10	11
10,001 – 35,000	315	14	15

Based on ISO 2859-1 single sampling. In case of doubt, the ISO 2859-1 tables prevail.

4.4 Defect classification

Critical defects – zero tolerance. One critical defect rejects the whole order. The Supplier then checks 100 % of the order (including with a metal detector) and a new inspection is done. Critical defects include:

- needles, pins, broken needle parts, staples, blades, wire or any metal piece in or on the product;
- missing suffocation warning on polybags, or missing conformity labels (e.g. CE marking for protective clothing);
- broken buttons or snaps, sharp edges, or loose cords and trims that are a safety risk;
- mould.

Major defects do not affect safety but make the product different from the approved sample, and could lead to customer returns. They count against the AQL 2.5 plan above. A defect in a hidden area (e.g. inside a garment) may be judged minor.

4.5 What the inspector checks

Check	Requirement
Conformity	Style, materials, trims, artwork and logos match the tech pack and the approved PPS
Measurements	Within the tolerances of the product's spec and grading chart
Colour shading	Grey scale 5 within one piece or set, 4/5 between pieces (ISO 105-A02, D65 light); or ΔE below 1.0 by spectrophotometer
Rubbing test	White cotton cloth, 10 rubs over 10 cm: dry ≥ 4, wet ≥ 3/4 on the staining grey scale (ISO 105-A03), one piece per colour
Fabric weight	Within ± 5 % of the approved sample
Workmanship	Stitches per inch consistent, no puckering, seams secure, no seam slippage on wovens
Zips, buttons, pockets	Run smoothly, securely fixed, balanced left and right; pull test on small parts, snaps and buttons; adjustable parts operated 20 times
Prints and logos	Adhesive tape test: no damage; position, colour, size and spelling correct
Symmetry and pressing	Sleeves, collar, shoulders and placket symmetrical; garments pressed and folded as specified
Hand-feel and treatments	Same as the approved sample
Labels	All labels present, correct and in the right place
Packing	Polybags and cartons as specified; carton drop test (ISTA 1A: 10 drops) with no damage to products
Metal detection	All sampled pieces pass through a needle detector

5. Metal contamination control

No metal object may ever be found in a product shipped to Oryzon.

- Every production site has a working needle detector, and **every finished product** passes through it before packing. A factory without a detector informs Oryzon immediately.
- Only a designated person has access to the needle supply. A new needle is given only in exchange for the used or broken one.
- The Supplier keeps three logs, available to Oryzon on request: used needle disposal log, broken needle log (all parts of a broken needle must be found), and metal detection log.

6. Incoming check at Oryzon

Shipments may be checked at random on arrival at Oryzon, its warehouse or its customer. If a shipment fails, the whole order is inspected 100 %. Oryzon sends the Supplier the results with photos (and samples if needed), and agrees with the Supplier on the action to take. Costs of sorting, repair or replacement are covered by the Supply Agreement, article 6.

7. Labelling

Label designs, materials and placements are given by Oryzon in the tech pack for each customer. Some customers nominate the label supplier; in that case the Supplier orders from that supplier only. In all cases:

- The **fibre composition label** follows EU Regulation 1007/2011 (correct fibre names and percentages, in the languages requested), together with care symbols and country of origin.
- Brand labels, size labels, hangtags and any anti-counterfeit labels are placed exactly as shown in the tech pack.
- Protective clothing carries its conformity labels (e.g. CE marking) exactly as approved.
- Labels with customer logos follow the confidentiality and design rules of the Supply Agreement, article 7.

8. Packaging

8.1 Folding

- Tops: sleeves folded backwards and the garment folded in two. Jackets: as specified per style.
- Trousers: folded in two, with the size visible.
- Tissue paper on plackets with buttons, on zip pullers and on wide or 3D prints, to avoid marks and damage.

8.2 Polybags

The Supplier proposes the polybag for approval during development. Polybags must:

- meet the packaging rules of Annex 1, article 3.5 (PPWR), and be free of BHT;
- fit the folded product, close with an adhesive flap and have ventilation holes;
- carry a printed suffocation warning in the languages required by Oryzon.

Compostable, recycled or reusable alternatives are welcome and are proposed to Oryzon for approval.

8.3 Cartons

- Strong export cartons sized to the content (see also Annex 1, article 3.5).
- One style and one colour per carton where possible; mixed cartons only if Oryzon agrees.
- Carton marks and barcode stickers as specified by Oryzon, showing at least: PO number, style, colour, size breakdown, quantity, carton number (x of y), gross and net weight, and dimensions.
- The packing list matches the carton marks exactly. Shipping documents are listed in the Supply Agreement, article 4.

9. Compliance documents

Compliance documents (social audit, OEKO-TEX certificates or test reports, REACH Commitment Letter with each shipment, factory information) are required by Annex 1 and are not repeated here. The Supplier also completes and signs any customer-specific quality documents that Oryzon passes on.

10. Records

The Supplier keeps for at least 5 years, and shows to Oryzon on request: fabric inspection reports, size check results, in-line and final inspection reports, needle and metal detection logs, test reports, and the keep sample of each style. Traceability records are covered by Annex 1, article 4.

Quality control forms

Form 1 – Final inspection report (AQL 2.5, level II)

See section 4 of this manual. Send this report with photos to Oryzon before shipment.

Item	Answer
Supplier / factory	
Oryzon PO number	
Style / article and colour	
Order quantity / quantity presented	
Inspection date and inspector	
Cartons opened (carton numbers)	
Sample size / accept / reject (section 4.3)	

Check (section 4.5)	Pass / Fail	Comment
Conformity to tech pack and approved PPS		
Measurements (see Form 2)		
Colour shading		
Rubbing test (dry / wet)		
Fabric weight		
Workmanship		
Zips, buttons, pockets, pull test		
Prints and logos (adhesive test)		
Symmetry and pressing		
Hand-feel and treatments		
Labels		

Check (section 4.5)	Pass / Fail	Comment
Packing and carton drop test		
Metal detection		

Defect found	Critical	Major	Minor
Total			

Result: PASS / FAIL	Photos attached: YES / NO
Inspector – name and signature	Factory QC manager – name and signature

Form 2 – Measurement check (full size set at 10 % and final inspection)

Style: _____ Colour: _____ Date: _____ Checked by: _____

Point of measure	Spec (cm)	Tol. ± (cm)	Size:	Size:	Size:	Size:	Size:

Mark every measurement out of tolerance in red and report it to Oryzon.

Form 3 – Fabric inspection report (4-point system)

See section 3.1 of this manual. Points per 100 square yards = total points × 3,600 ÷ (inspected length in yards × fabric width in inches).

Fabric / supplier: _____ Lot: _____ Colour: _____ Date: _____

Roll no.	Length (yd)	Width (in)	1 pt	2 pts	3 pts	4 pts	Total pts	Pts / 100 sq yd	Shade (grey scale)	Pass / Fail

Form 4 – Needle control log

See section 5 of this manual. One log per production line; a new needle is issued only against the used or broken one.

Date	Line / operator	Needle type	Old needle returned (complete / broken)	All broken parts found (Y/N)	New needle issued (Y/N)	Controller signature

Form 5 – Metal detection log

See section 5 of this manual. Check the detector with its test card at the start of each shift.

Date / shift	Detector test card OK (Y/N)	PO / style	Quantity checked	Pieces rejected	Action taken	Operator signature