

LeelineToys

MASTER QC PROTOCOL & INSPECTION MANUAL

This document serves as the standard operating procedure for auditing external supplier facilities. It provides actionable checklists and lookup tables to ensure strict compliance with AQL 2.5 standards before mass production is released.

1. ISO 2859-1 Sample Size Lookup Table (General Level II, AQL 2.5)

Total Lot Size (Units)	Code Letter	Sample Size (Units)	Accept (Major 2.5)	Reject (Major 2.5)
500 - 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

2. Master Plush Defect Checklist

Check	Inspection Point	Description & Action	Classification
<input type="checkbox"/>	Pull Test (90N)	Apply 90N tension to eyes, noses, and small attached parts for 10 seconds. Halt line if detached.	Critical (0)
<input type="checkbox"/>	Metal Detection	Pass all finished units through calibrated metal detector to check for broken needles.	Critical (0)
<input type="checkbox"/>	Seam Integrity	Inspect all main seams for opening or weak stitching resulting in exposed stuffing.	Major (2.5)
<input type="checkbox"/>	Shape & Symmetry	Compare structural shape, stuffing distribution, and facial alignment against Golden Sample.	Major (2.5)
<input type="checkbox"/>	Functionality	Test all zippers, velcro closures, or internal sound chips for proper operation.	Major (2.5)
<input type="checkbox"/>	Thread Tails	Check for untrimmed threads longer than 1cm on exterior seams.	Minor (4.0)
<input type="checkbox"/>	Labeling	Verify care tags and CE/CPSIA compliance labels are sewn in straight and legible.	Minor (4.0)

3. Carton Marking & Packaging Checks

Check	Inspection Criteria for External Factory Packing	Result (P/F)
<input type="checkbox"/>	Shipping marks match the PO specifications precisely (Main Mark and Side Mark).	
<input type="checkbox"/>	Carton dimensions and gross weight match the approved packing list for freight calculation.	
<input type="checkbox"/>	Barcode labels (UPC/FNSKU) are scannable and placed correctly on polybags/cartons.	
<input type="checkbox"/>	Inner packaging materials (polybag thickness, suffocation warnings) meet destination market laws.	

4. External Factory Reinspection Protocol

Step	Procedure for Failed Lots
1	Issue Corrective Action Report (CAR): Document all defects from the failed AQL sample. Require the external factory management to sign and acknowledge the failure.
2	Isolate Inventory: Ensure the factory physically separates the failed lot from any staging or shipping areas.
3	Mandate 100% Sorting: The external factory must sort and rework 100% of the lot at their own expense. We do not accept partial sorting.
4	Schedule Re-Audit: Dispatch our QA team to the external facility only after the factory confirms in writing that the 100% rework is complete.
5	Apply Stricter Sample: Execute the reinspection using one sampling level tighter (e.g., move from Level II to Level III) to guarantee statistical confidence.