




CHINA FLOOR INSPECTION

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Inspection Report for WO#15KD58004

Product Information

Photos of Product		Pattern No:	
		TW-771-9	
		Inspection Location:	***** City, ***** Province, China
		Inspection Date:	Apr.23, 2015
		P/I No.:	
		15KD58004	
		Articl No.:	
		VLCS12018EICNOX	
		Supplier:	
		***** Plastics Industry Co., Ltd.	
		Order Quantity:	60 boxes 480 pcs
		Reference Sample Available:	Yes
		Inspection Type:	Pre-shipment

Inspection Consequence

Appearance Check:	Passed
Dimension Check 1:	Passed
Dimension Check 2:	Passed
Physical and Chemical Properties Test:	Passed
Final Decision:	Released

Remarks:

Production Status

Percentage of finished & packed products:	100%
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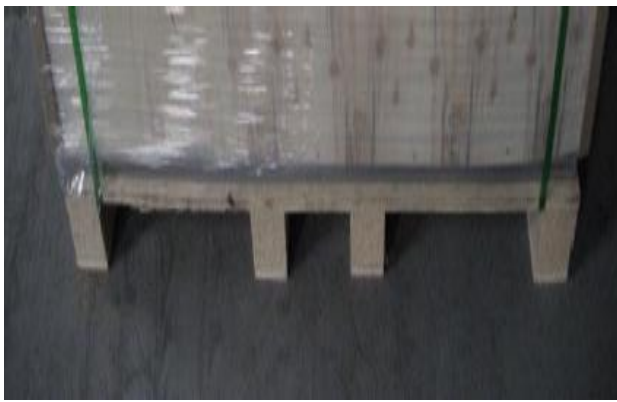
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Percentage of finished & unpacked products:	0%
Percentage of unfinished & unpacked products:	0%
Printed Production Date Status	
Date 1: 2015/04/25	More than 80% cartons
Date 2: others	20%
Total Finished qty.:	100%
Photos of Packaging and product	
	
Goods (Total 10 Pallets)	Pallet
	
Length of pallet (4x7=28boxes/Pallet)	Width of pallet
	
The other side of pallet	Pallet mark



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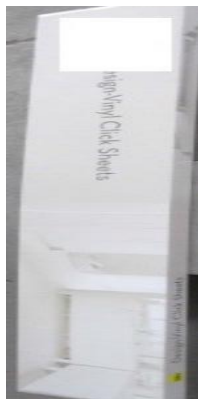
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The pallet



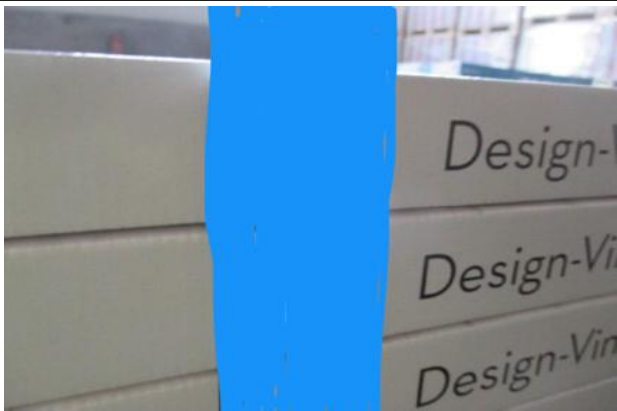
The pallet NO.



Front of box



Long side of box



The other long side of box



End side of Box



The other end side of Box



Cardboard



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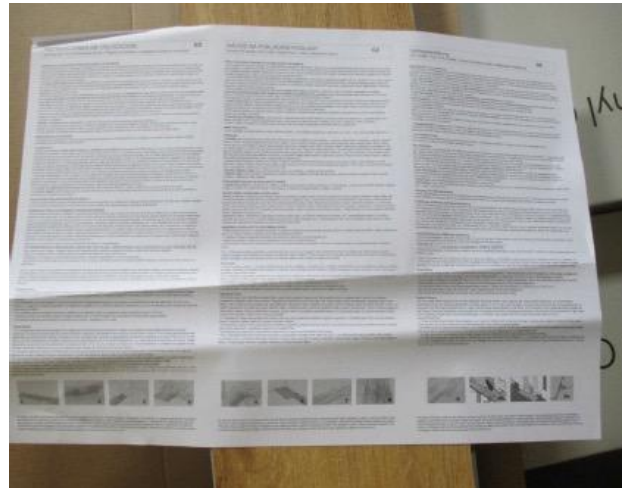
Back of box



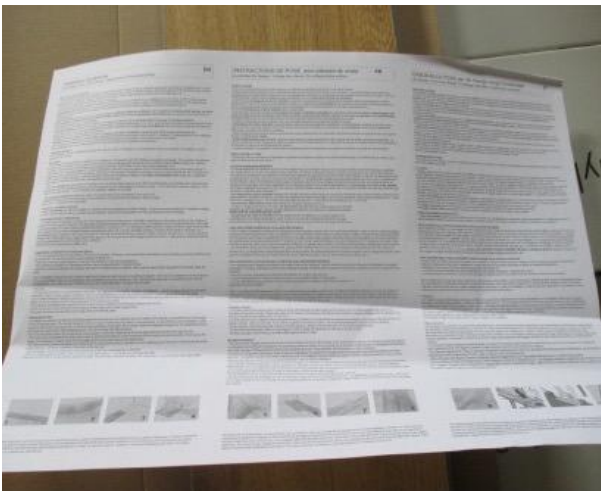
Detail of box (pcs/box)



One instruction paper inside master carton



Front of instruction paper



Back of instruction paper



Product



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The weight of 1 CTN	The weight of 1 P
PVC Color : TW-771-9	Flooring color: Medium
Appearance Check	
Sampling Standard: GB/T 2828.1 Double sampling plan for normal inspection	
Sampling Level: GII AQL: 4.0	
1st Sample Size: 125 pcs Ac: 7 Re: 11	
Total Sample Size 250 pcs Ac: 18 Re: 19	
No.	Defect Description
1	Bulge
Total Defects Found: 1	
MAX. Acceptable: 7	
Result: Passed	
Photo of Appearance Defect	
Bugle	



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Dimension Check 1

1st Sample Size:		5 pcs	Ac:	0	Re:	2	
2nd Sample Size:		5 pcs	Ac:	0	Re:	1	
No.	Specification (mm)	Measures (mm)					Result
		#1	#2	#3	#4	#5	
1	Average Length: 1220±1.0	1220	1220	1220	1220	1220	Passed
2	Average Width: 178±0.2	178.10	178.15	178.05	177.94	177.99	Passed
3	Average Thickness: 6±0.3	6.2	6.0	5.98	5.9	6.05	Passed

Photo of Length Check

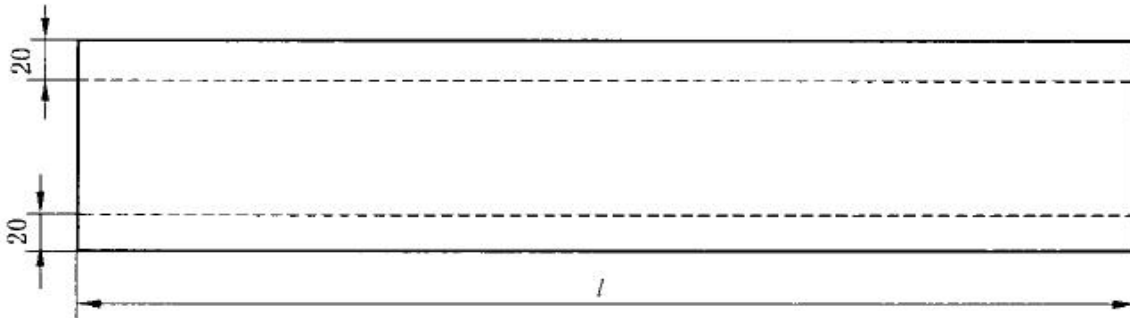


Photo of Width Check



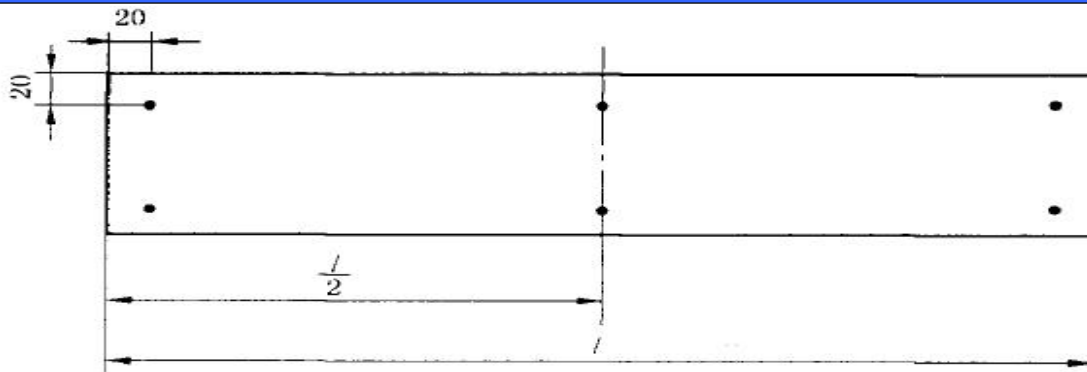


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Photo of Thickness Check



Dimension Check 2

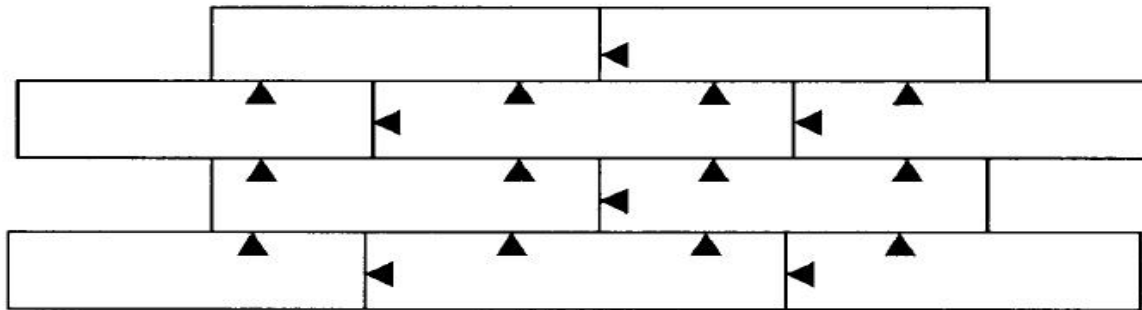
1st Sample Size:		10 pcs	Ac:	0	Re:	2
2nd Sample Size:		10 pcs	Ac:	0	Re:	1
No.	Specification (mm)			1st Dft. Qty.	2nd Dft. Qty.	Result
1	Max Assembly Gap: ≤0.20			0		Passed
2	Max Assembly Altitude Difference: ≤0.15			0		Passed



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Photo of Assembly Gap and Altitude Difference Test



Physical Test 1

1st Sample Size:		5 pcs	Ac:		0	Re:		2
2nd Sample Size:		5 pcs	Ac:		0	Re:		1
No.	Specification (mm)	Measures (mm)					Result	
		#1	#2	#3	#4	#5		
1	Average Gloss: Under10°	5.1	6.1	5.5	6.0	6.5	Passed	

Photo of Gloss Test



Physical Test 2

1st Sample Size:		2 pcs	Ac:	0	Re:	2
2nd Sample Size:		4 pcs	Ac:	0	Re:	1
No.	Specification:			1st Dft. Qty.	2nd Dft. Qty.	Result
A	Antifriction layer thickness: 5 pieces of 50mmX2mm strips were under the microscope to read the minimum wear layer thickness			0		Passed
B	Residual indentation: the sample thickness, and then put in the depression test machine with the load of 150min, 500N and then test the			0		Passed



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	thickness of the pressure			
C	Heating length change rate: Take 3 230mmX230mm into the 80 + 2℃ degrees Celsius temperature blast oven 6h, after taking out the room temperature 24 hours after the contrast test before and after the difference	0		Passed
D	Film wear resistant: $\leq 0.15\text{g}/100\text{r}$ and film is not worn out	0		Passed
E	Color fastness test: according to the GB730 test, according to the GB 250 assessment	0		Passed
F	Interlayer peel strength test: take 6 200mmX50mm upright into ethyl acetate 40min depth is not more than 40mm, by hand stripping immersed in the solvent of the intermediate layer and wear-resisting layer, placed at room temperature for 90 min after the specimen was loaded in the tensile testing machine fixture in the drawing speed of 100 + 10mm / min of wear-resisting layer and middle layer binding properties were tested, six specimens of average value	0		Passed
G	Reduced impact test: GBJ 75, The fifth chapter	0		Passed

Instruction of Sample Making for Physical Test

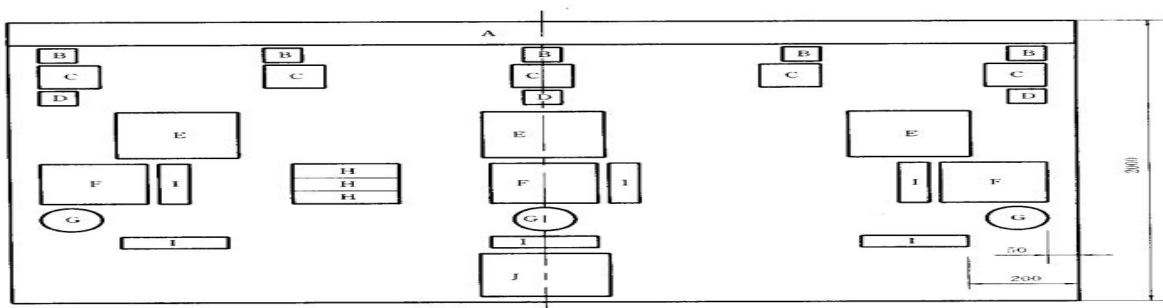


Photo Of Water Proof Test





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Photo Of Residual Indentation Test



Photo Of Heating Length Change Rate Test

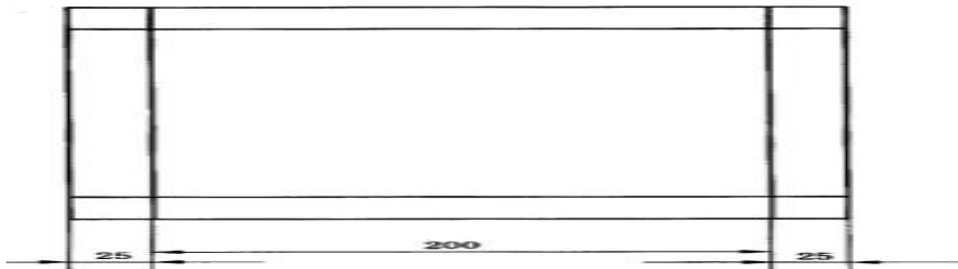


Photo Of Film Wear Resistant Test





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Photo Of Scald Prevention Test



Photo Of Method A Flexibility Test



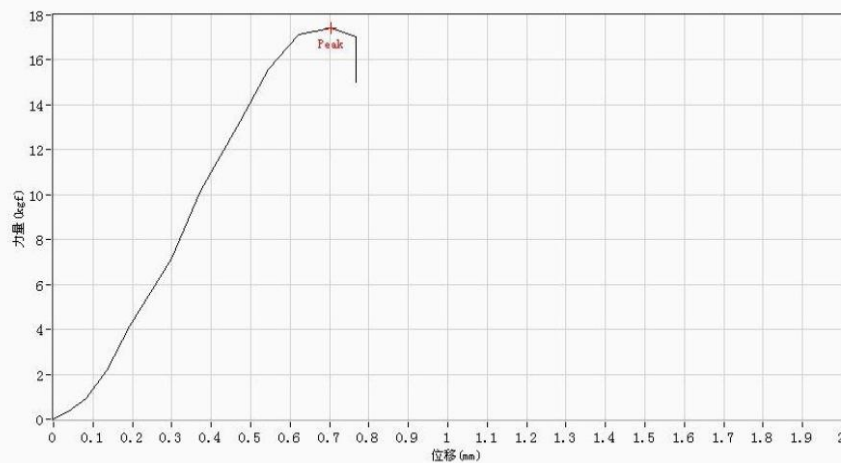


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click report for long side

1. Order No. : 15KD58004
2. Date: 2015-4-23, 10:58:15
3. Testing Lot No. : 0000002
4. Decor No. : TW-771-9
5. Tested By: jueming Qian
6. product: Vinyl plank
7. Testing Speed: 0.500mm/min
8. Testing size:50mm



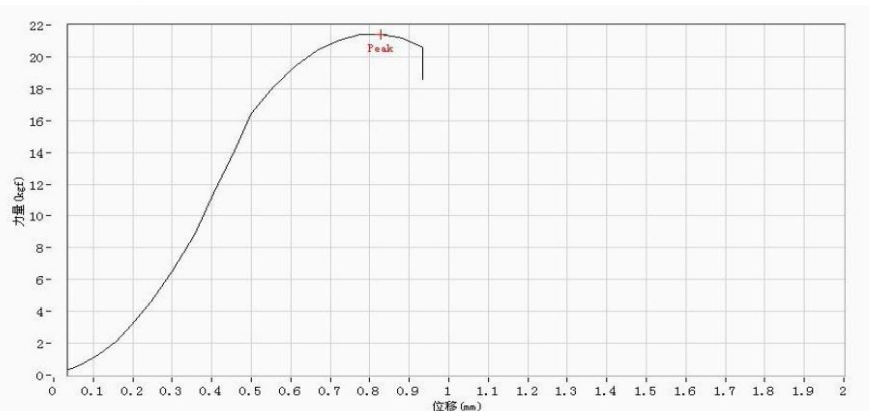
No.	Strength (kgf)	Displacement (mm)
1	17.416	0.703

examine:

tabulation:

click report for short side

1. Order No. : 15KD58004
2. Date: 2015-4-23, 10:43:34
3. Testing Lot No. : 0000002
4. Decor No. : TW-771-9
5. Tested By: jueming Qian
6. product: Vinyl plank
7. Testing Speed: 0.500mm/min
8. Testing size:50mm



No.	Strength (kgf)	Displacement (mm)
1	21.428	0.829

examine:

tabulation:



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Inspection Data

outgoing / incoming quality inspection - checklist for Vinyl-Sheets

Version: March 2015

Notice: For every kind of design a separate form is to fill. Design, colour, gloss and surface is to compare with the retain samples. For packing see the additional packing regulations. For every check make a vertical line into the assigned field or write in figures. General 5 Sheets of every second pallet are to check at least. If not acceptable faults, check 20 related sheets of this pallet or more, if more than 2 pieces of this unacceptable faults, no matter which faults, the supplier have to remove all of them by 100% check of this pallet. **Scale of inspection:** If there is no fault at the pallet (at least 5 sheets are to check) so the next 3 pallets of this design can be omit. If faults within the pallet check every pallet until a pallet is faultless again. **The sheets have to be faultless at the entire size, the sheets will be used up to the edges like delivered, no separate clipping or cutting before processing is necessary.**

supplier/lieferant: <i>11</i>	P / I NO - Order or Invoice No.: <i>14KD8004</i>	Prüfdatum/date of check: <i>2015.4.01</i>	Prüfer/checker: <i>...</i>	Fotos/digital pictures: total quantity overview <input checked="" type="checkbox"/> /no	Details <input checked="" type="checkbox"/> /no
Design / article name or No. (supplier) <i>TW-771-9</i>	nutzschicht stärke/ wear layer thickness <i>2-3 mm</i>	Lieferscheinmenge / packaging quantity ref. delivery notes of this design: <i>4800</i> sheets / <i>6</i> pallets	Istmenge / real quantity of this design: <i>2200</i> sheets / <i>10</i> pallets	Prüfmenge / checked quantity of this design: <i>2200</i> sheets of <i>10</i> pallets	
Design / article name or No. (title) <i>VLCS12018E10 No X</i>	palett (see Document "LF Anlieferungsform Vinyl de-en.pdf")	gut/good <input checked="" type="checkbox"/>	befriedigend/ satisfactory <input checked="" type="checkbox"/>	nicht genügend / fail <input checked="" type="checkbox"/>	
design/pattern/sample (like retain sample; colour, print, structure/amboss etc)	OK/ faultless up to minor faults <i>1/0</i>	noch akzeptabel / faults but even acceptable <i>10</i>	nicht akzeptabel / not acceptable faults <i>0</i>	1219 x 914 mm 1,8 mm 2,0mm 1,8mm 2,0mm 1,8 mm 2,0 mm	
Design/ Muster (wie Rückstellmuster: Farbe, Struktur, Prägung usw.)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>	impurity: 4 pcs bleuish: 6 pcs	
technical surface check (no dents, hole; rawness; unevenness; delamination)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
technische Beschaffenheit (Deilen, Löcher, Wellen, Rauigkeit, Delaminierung)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
surface varnish check (even; smuth; scratchresistent; no smelt)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
Lackoberflächenprüfung (gleichmäßig, glatt, kratzfest, geruchsfrei)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
backing check (minor structure, not glossy; not to dark; low surfaceenergie >=28)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
Rückseiten Prüfung (feine Struktur, nicht glänzend, nicht zu dunkel, niedr. Oberflächenenergie)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
cleaness (no dirt, foreign substances between the sheets)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
Sauberkeit / Schmutz Fremdkörper zwischen den sheets	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
border (unfrayed, not curved, no demolished corners)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
Kanten (Ränder ausgefranst, krumm, abgebrochene Ecken)	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
gloss level Glanzgradvorgabe	on single point auf einzelnen Punkt +/- 2,0 +/- 2,0	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>		
angularity Winkelabweichung	OK / faultless up to minor faults <i>200</i>	noch akzeptabel / faults but even acceptable <i>0</i>	nicht akzeptabel / not acceptable faults <i>0</i>		
length	target dimension: originallänge <i>1220</i> mm (")	shorter than 3mm <i>0</i>	within tolerance of - 3 / +5 mm <i>200</i>	longer than 5mm <i>0</i>	Notice:
width:	target dimension: originalbreite <i>178</i> mm (")	narrower than 2mm <i>0</i>	within tolerance of +/- 2mm <i>200</i>	broader than 2mm <i>0</i>	Notice:
sheet thickness overall:	target dimension: originaldicke <i>5,0</i> mm (")	thinner than tolerance <i>0</i>	within tolerance of -0,1 + 0,2mm <i>200</i>	thicker than tolerance <i>0</i>	Notice:
Notice:				Confirmation (sign, stamp, company): <i>...</i>	

~THE END OF REPORT~