

Leather Bag QC Inspection Checklist

9-Point Inspection — IQC / IPQC / FQC / OQC | Based on ISO 2859-1, ISO 5402-1, ISO 11640

PO#: _____ Style#: _____ Date: _____ Inspector: _____

Shift: _____ Lot Size: _____ AQL Sample: _____

C = Critical M = Major m = Minor | Tolerances: Critical 0 / Major 2.5 / Minor 4.0

Step 1: Golden Sample & Limits

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Physical golden sample present and brand-approved on site	C		_____
☐ Feel front panel grain — matches sample texture	M		_____
☐ Listen to main zipper — smooth, no grit	M		_____
☐ Squeeze bottom gusset — structural firmness confirmed	M		_____
☐ Defect glossary defined by component name (not color alone)	m		_____
☐ Tolerances set: Critical 0 / Major 2.5 / Minor 4.0	m		_____

Step 2: Inspect, Grade & Cut Leather Panels

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Hides graded under 6500K lighting	C		_____
☐ Grade A assigned to exterior front panels	C		_____
☐ Grade D hides rejected entirely	C		_____
☐ Brand marks, scars, tick bites, wrinkles, flay cuts flagged	M		_____
☐ Loose grain / baggy belly zones quarantined	C		_____
☐ Mirrored side panels — grain & stretch match physically verified	M		_____
☐ Yield rate recorded: (Usable Area / Total Hide Area) × 100	m		_____

Step 3: Sensory & Surface Inspection

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Thickness measured across 5 points — within tech pack tolerance	M		_____
☐ Color, gloss, backing match approved swatch	M		_____
☐ Dry white cotton rub test (ISO 11640) — no color transfer	C		_____
☐ Flex test (ISO 5402-1) — no wrinkling, no whitening	C		_____
☐ Flashlight angled parallel to grain — no cloudy haze (chrome spew)	C		_____
☐ 6500K lamp — tilt panel, check color-lot mismatch / scratches / glue marks	M		_____
☐ Smell check — no sharp solvent or mildew odor	C		_____
☐ Flexed grain bounces back without looseness	M		_____

Step 4: Hardware — Incoming IQC & Finished Bag Cycle Test

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Zipper brand, plating color, logo match tech pack	M		_____
☐ Main zipper — cycle 5× back and forth, smooth glide, no grinding	C		_____
☐ Front pocket snap — decisive magnetic click	M		_____
☐ Bare finger test — D-rings, side clasps: zero sharp burrs	C		_____
☐ Strap buckle & bottom rivets — twist test, no looseness	C		_____
☐ Logo plate — alignment, no oxidation, no plating rub-off	M		_____
☐ REACH test reports collected for all outsourced trims	C		_____
☐ Lining shade, thread shade, reinforcement board, adhesive batch match	m		_____

Step 5: Skive, Seams & Edge Paint

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Skive depth measured with caliper — matches tech pack (folded edges, gussets, turn-backs)	C		
☐ No over-skiving, exposed fiber, cut-through, uneven fold width	C		
☐ Reinforcement boards / tapes inserted per tech pack	C		
☐ Folded edge lies flat — no bulging	M		
☐ SPI count verified — matches target	M		
☐ Seam straightness — no skipped stitches, wandering lines, tension puckering	C		
☐ Thread shade match — no "grin" between panels	m		
☐ Pull test — bottom gusset & handle anchor, zero exposed thread	C		
☐ Broken-needle control — zero tolerance, fragment traceability log	C		
☐ Edge paint — coat smoothness, uniformity, no corner overspill	M		
☐ Edge flex-and-wipe test (90° bend) — no cracking, peeling, tackiness	C		

Step 6: Dimensions & Symmetry

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Bag placed upright on flat surface — no leaning, no tipping	C		
☐ Height, width, depth, handle drop — within tech pack tolerance	M		
☐ Strap centerlines, pocket placement, logo position verified	M		
☐ Left vs. right gusset — absolute symmetry confirmed	M		

Step 7: Handle & Strap Load Test

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Dead weight applied — matches product class / ASTM D2208 threshold	C		
☐ Bag suspended by shoulder strap & top handles — full duration	C		
☐ Post-load check — D-ring anchors: no seam opening	C		
☐ Post-load check — no rivet pull-out, anchor distortion, leather tearing	C		

Step 8: AQL Sampling Check

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Sample size pulled per ISO 2859-1 table	—		
☐ Each sample — physically touch, open, flex, smell	—		
☐ Critical defects count (broken needles, mold, chemical): ____ / 0 allowed	C		
☐ Major defects count (cracked edge, loose grain, stitch fault, oxidation): ____ / ≤2.5%	M		
☐ Minor defects count (thread ends, hidden glue marks): ____ / ≤4.0%	m		
☐ Defect tally below agreed threshold — lot release decision	—		

Step 9: Packaging & Logistics Risk Control

CHECKPOINT	SEV.	PASS / FAIL	REMARKS
☐ Leather surface — completely dry before packing	C		
☐ Tissue stuffing / air support inserted — silhouette firm	M		
☐ Silica gel + humidity card inside main compartment	C		
☐ Dust bag → outer polybag — correctly sealed	M		
☐ Master carton — compression test: not soft, damp, or collapsed	C		
☐ Pallet condition, shipping marks, release paperwork verified	m		

Quick Reference: 3 Common Factory Defects

DEFECT	ROOT CAUSE	IMMEDIATE ACTION	
Edge Paint Cracks	Rushed cure time / dirty substrate	Flex-and-wipe test before bulk restart; verify skive thickness & humidity	☐
Chrome Spew / Loose Grain	Overbuilt tannery finish on cheap hides	Quarantine lot; re-inspect under 6500K; compare flex to golden sample	☐
Hardware Oxidation / Mildew	Warehouse humidity exceeded safe limits	Isolate affected units; replace packing; fresh silica desiccants; pause loading	☐

FINAL DECISION: ☐ APPROVE ☐ REWORK ☐ HOLD / QUARANTINE ☐ REJECT

IQC Inspector:

Line QC:

Finishing Supervisor:

Final QA / 3rd Party:

Date:

CAPA Triggered? ☐ Yes ☐ No

CAPA Ref#: