



The chart below lists acceptable industry manufacturing tolerances vs. defects.

CONSTRUCTION

Area	Acceptable	Defective	Information
Dust/Lint	Very small amount of dust or lint that is easily removed by shaking or tape	Dust or lint that does not remove very easily	
Fiber Stains	Less than 1/4" long (barely detectable at arms length)	Greater than 1/4" long (and visible at arms length)	Fiber stains are discolored cotton fibers
Holes	Less than .020" dia (undetectable at arms length), thread not broken	> .020" and/or a completely broken thread	
Oil/Stains	Less than .020" dia (undetectable at arms length)	Greater than .020" dia (detectable at arms length)	Light sewing oil is easily removed by washing
Seam	Slight wrinkles at hems/collars are normal	Fabric folded over & sewn onto itself	
Yarn "Runs"	Length < 1/8", & does not affect integrity of garment	Length > 1/8"	Yarn runs are areas where the thread is thinner than normal (visible at arms length)

EMBROIDERY

Area	Acceptable	Defective	Information
Color Match	Exact match to Maderia or Isacord thread number	> (1) thread color off	
Fills	Very small amount of base fabric visible (but not at arms length)	Base fabric visible below stitches at arms length	
Hoop Marks	Slight impression of hoop mark acceptable, barely visible at arms length	Clearly visible at arms length	
Mis-Sew	Small mis-sewing barely detectable at arms length	Clearly visible at arms length	
Trims	< .05" thread showing	> .05" thread showing	

PRINTING

Area	Acceptable	Defective	Information
Color Match	Within (1) Pantone number	> (1) Pantone number difference	
Edge Definition	Slight blurring (undetectable at four feet)	Blurring detectable at four feet	
Image Size	± 5% of specification	Greater than 5% of specification	
Opacity	Ink covers fabric completely	Ink is "thin" & allows fabric color to show through	Loose fabric yarns may rise above ink surface; this is OK
Pinholes	Less than .002" dia & intermittent (undetectable at arms length)	Greater than .002" dia (detectable at arms length)	
Placement	± 1/2"	Varies more than 1/2"	
Registration	± .005" (undetectable at arms length)	More than ± .005 (visible at arms length)	