



The Embroidered & Printed Clothing Company Quality Control Procedures

1. Overview

At The Embroidered & Printed Clothing Company quality control is embedded throughout the production process rather than applied at the end.

Each stage includes defined checks to ensure consistency, accuracy, and repeatability across all orders.

This approach ensures quality is controlled at source, not inspected in at the end of production.

2. Pre Production Controls

Artwork & Specification Review

- All artwork is checked internally for:
 - ✓ Resolution and suitability for the decoration method
 - ✓ Correct sizing and positioning
 - ✓ Colour accuracy and Pantone references
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Proof Approval Process

- A digital proof is supplied to the client for approval prior to any production taking place
 - The proof includes:
 - ✓ Artwork layout
 - ✓ Print size and positioning
 - ✓ Colour references (including Pantone where applicable)
 - For embroidery and DTG, a photo of the actual stitched/printed sample is supplied alongside the proof and must be approved prior to production
 - Production will not begin until approval of the proof has been received
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Proof as Production Specification

- The approved proof forms the single, final production specification
 - All production is carried out strictly in line with the approved proof
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Colour Management

- Colour is controlled using method specific systems:
 - ✓ DM4 automated ink mixing machine (screen print) This ensures high accuracy and repeatability for Pantone colours across repeat orders and multiple production runs.
 - ✓ Madeira thread matching (embroidery)
 - ✓ Calibrated print profiles (DTG)
- All processes are designed to ensure maximum consistency across repeat orders



Production Setup

- Jobs are set up directly from the approved proof
 - All production details are verified prior to printing or embroidering
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3. Setup & Method & Specific Quality Checks

3.1 Screen Print

Screen Preparation

- Mesh count, tension, and coating checked prior to imaging
- Screens produced using laser CTS (Computer to Screen) technology to ensure:
 - ✓ Maximum detail and edge definition
 - ✓ Consistent stencil quality
 - ✓ Accurate reproduction of fine detail

Press Setup

- Registration aligned and verified
 - Ink matched to Pantone specification
 - Under base, flash, and print settings tested for correct opacity and finish
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3.2 Embroidery

Digitising

- Artwork digitised to ensure:
 - ✓ Correct stitch type and direction
 - ✓ Appropriate stitch density
 - ✓ Clean reproduction of fine detail

Machine Setup

- Correct backing, hooping, and stabilisation selected
- Thread tension calibrated prior to production

Test SewOut

- Initial sample checked for:
 - ✓ Stitch quality
 - ✓ Design accuracy
 - ✓ Placement and alignment
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3.3 DTG (Direct to Garment)

Artwork Preparation

- Files prepared to ensure:
 - ✓ Correct resolution
 - ✓ Suitable colour profile
 - ✓ Accurate gradient and detail handling



Pre Treatment

- Applied where required to ensure:
 - ✓ Ink adhesion
 - ✓ Print durability
 - ✓ Colour vibrancy

Printer Setup

- Machines calibrated regularly for:
 - ✓ Colour consistency
 - ✓ Reliable output
- Print heads checked to prevent:
 - ✓ Banding
 - ✓ Inconsistency

Test Print

- Initial sample checked for:
 - ✓ Colour accuracy
 - ✓ Detail reproduction
 - ✓ Placement
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4. In Production Quality Control

- Production setup is checked and signed off by the operator prior to full runs
- Continuous operator monitoring throughout production
- Supervisor checks carried out at defined intervals
- Immediate correction of any variation

Monitoring Includes:

- Screen print:
 - ✓ Registration accuracy
 - ✓ Colour consistency
 - ✓ Ink coverage and finish
 - Embroidery:
 - ✓ Stitch consistency
 - ✓ Thread tension
 - ✓ Fabric puckering
 - DTG:
 - ✓ Ink density
 - ✓ Print clarity
 - ✓ Banding or adhesion issues
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AI Assisted Monitoring (In Development)

- We are currently developing an AI based inspection system to:
 - ✓ Photograph garments during screen printing production
 - ✓ Compare output against approved standards
 - ✓ Flag any variation in print quality, colour, or positioning in real time



5. Post Production Inspection

- Random sampling from each batch
 - Checks include:
 - ✓ Quality and consistency
 - ✓ Colour accuracy (Pantone matched where applicable)
 - ✓ Placement and alignment
 - ✓ Garment condition
 - Defective items are removed and reworked prior to dispatch
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6. Packing & Dispatch Controls

- Quantities verified against approved order specification
- Size breakdowns and garment variants confirmed

Visual Record (Client Transparency)

- A photo of every design is taken at dispatch
 - Images are uploaded to the client portal, allowing clients to:
 - ✓ Confirm final print quality
 - ✓ Review completed designs
 - ✓ Maintain a record of each production run
 - Delivery notes checked and tracking uploaded
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7. Traceability & Records

- You can see all order history and live information on the client portal
 - Full traceability includes:
 - ✓ Artwork approvals
 - ✓ Colour references and specifications
 - ✓ Production records
 - ✓ Photos of your jobs and delivery data
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8. Continuous Improvement

- Ongoing monitoring of defect rates and reprints
 - Process improvements implemented to reduce repeat issues
 - Continued investment in:
 - ✓ DM4 automated ink mixing
 - ✓ Laser CTS technology
 - ✓ AI inspection systems
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9. Staff Training

- Operators are trained across all decoration methods
 - Focus on quality standards, setup, and fault identification
 - Regular upskilling to maintain consistent output
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10. Artwork Approval & Client Responsibility

- Production is based strictly on the approved proof
 - Clients are responsible for confirming all details when approving, including:
 - ✓ Artwork content
 - ✓ Spelling and design elements
 - ✓ Sizing and placement
 - ✓ Colour references
 - We cannot be held responsible for errors contained within approved artwork
 - Changes after approval may require reproofing, incur additional costs, and impact lead times
 - They may also only be possible if the production run has not started
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11. Photo Sign Off (Detailed / Critical Jobs)

- For highly detailed or complex jobs, a photo sign off may be provided at press stage
 - Approvals must be returned promptly as production is ready to proceed
 - Delays may impact scheduling and lead times
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12. Production Tolerances

- Print & embroidery positioning: typically plus or minus 5 to 10mm
- Colour variation: minor variation may occur depending on process and material
- Garment sizing and construction: subject to manufacturer tolerances

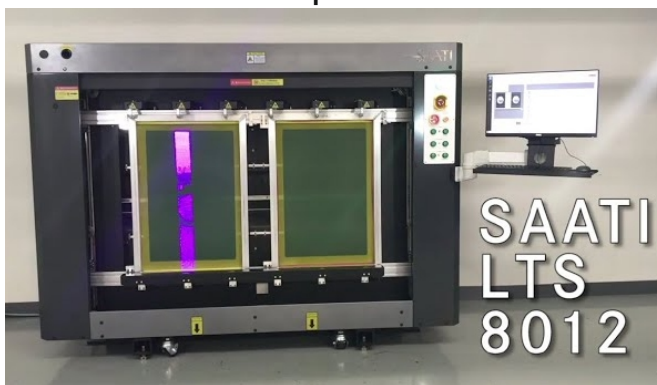
These tolerances are standard within the garment decoration industry and do not constitute defects



Summary

We operate a structured, multi stage quality control system across screen print, embroidery and DTG. Through controlled processes, trained staff, and ongoing investment in technology we ensure consistent, high quality output with full transparency via our client portal.

Our laser developer

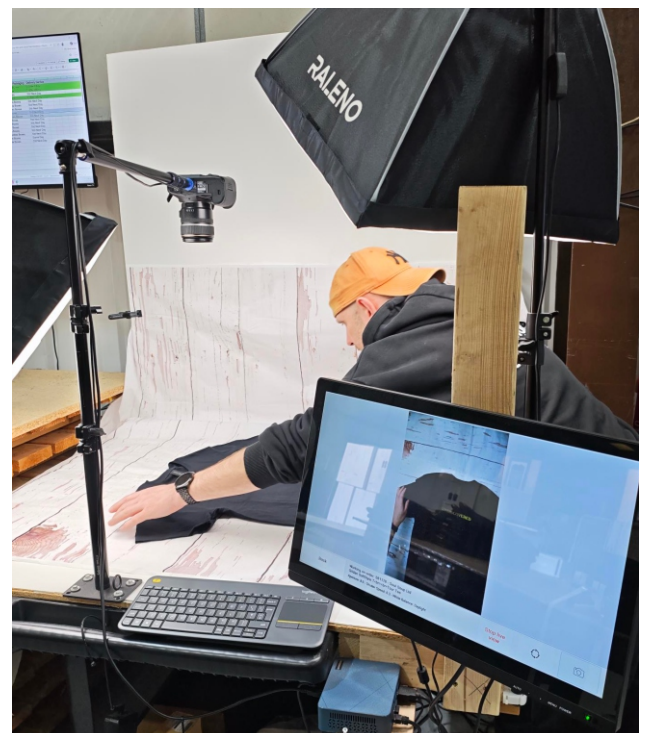


Print detail with wax or film

Print detail with laser developer



Our DM4 Pantone ink mixer



All items are photographed for you to view on the portal