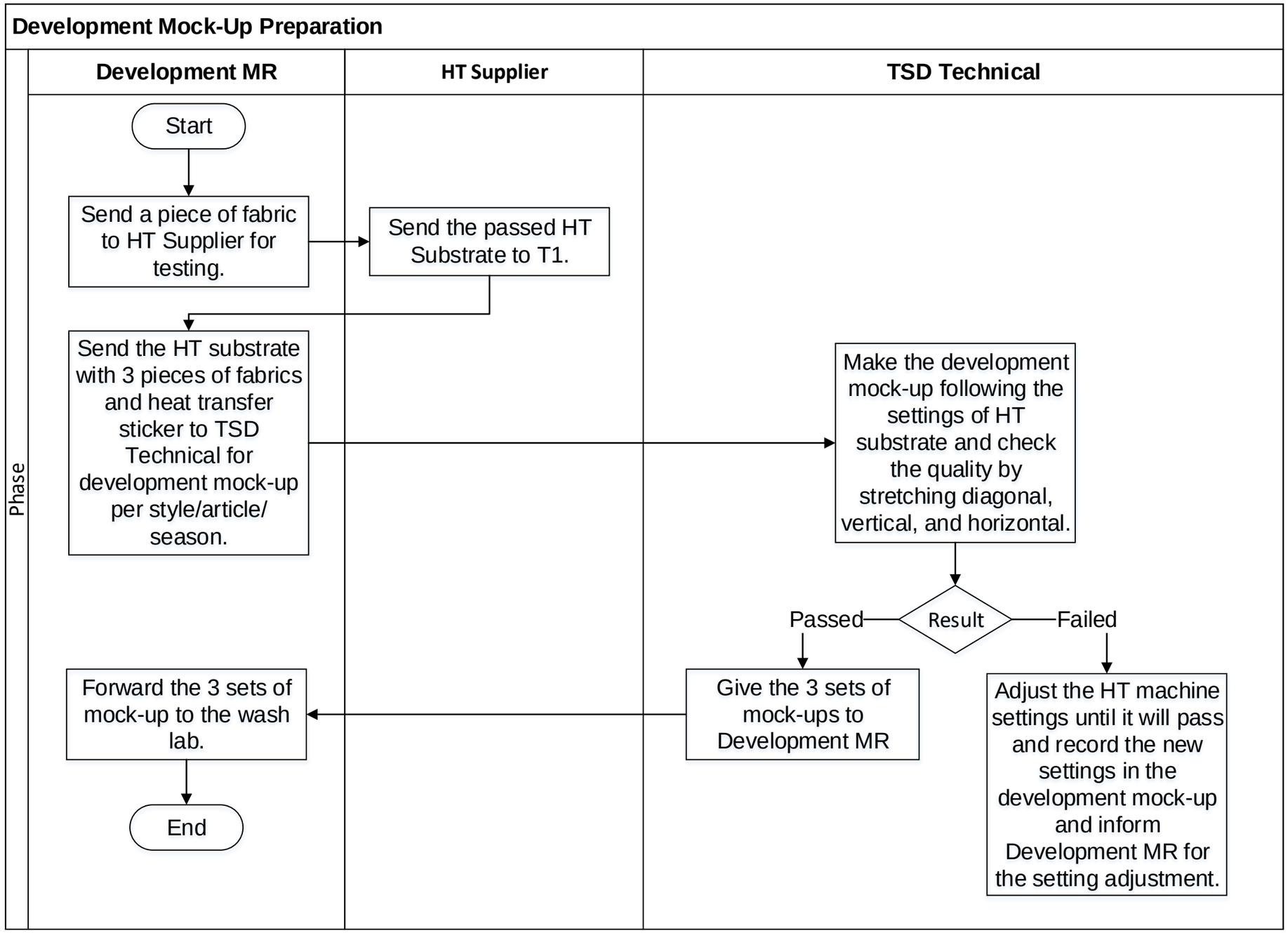
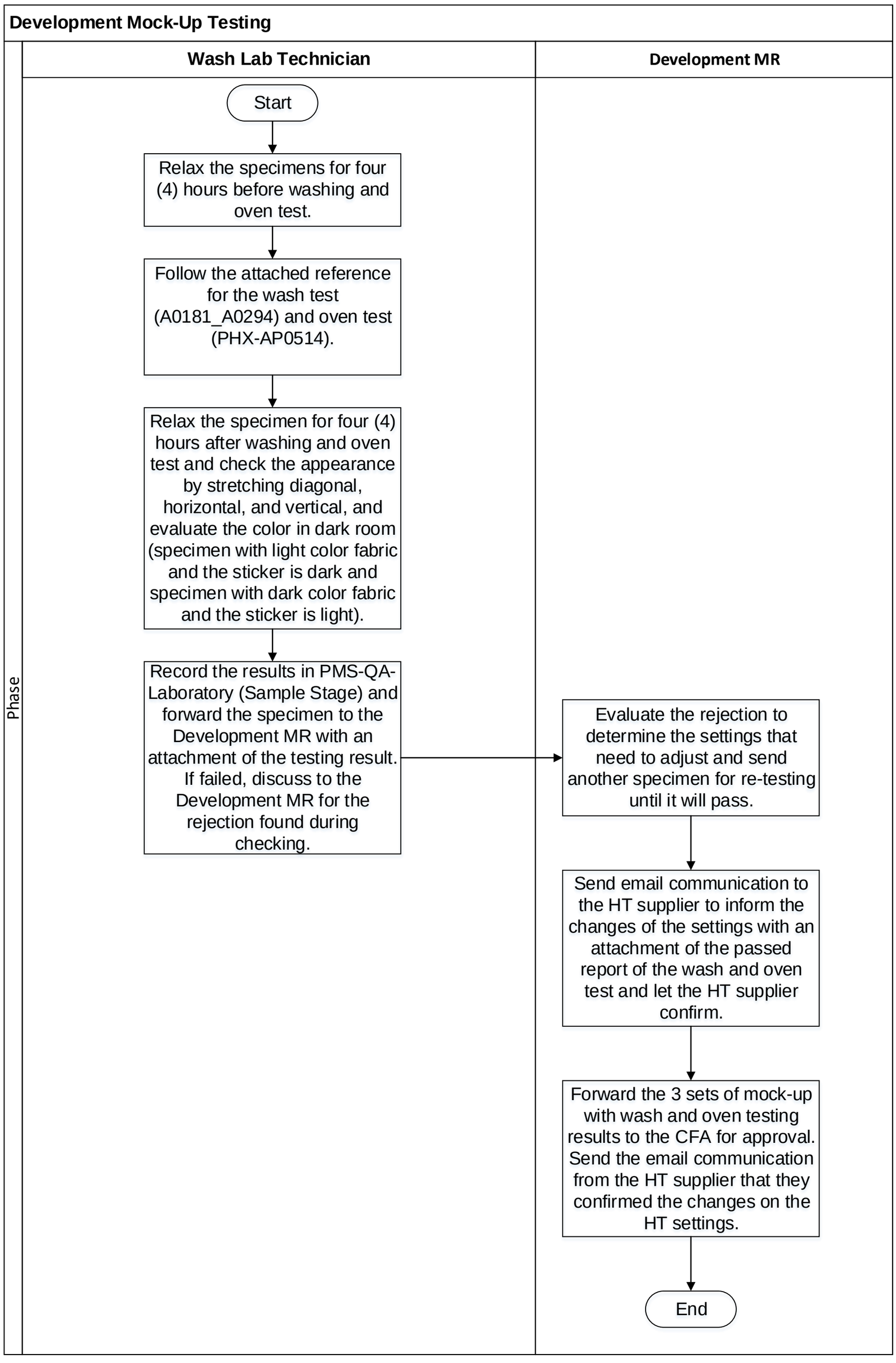
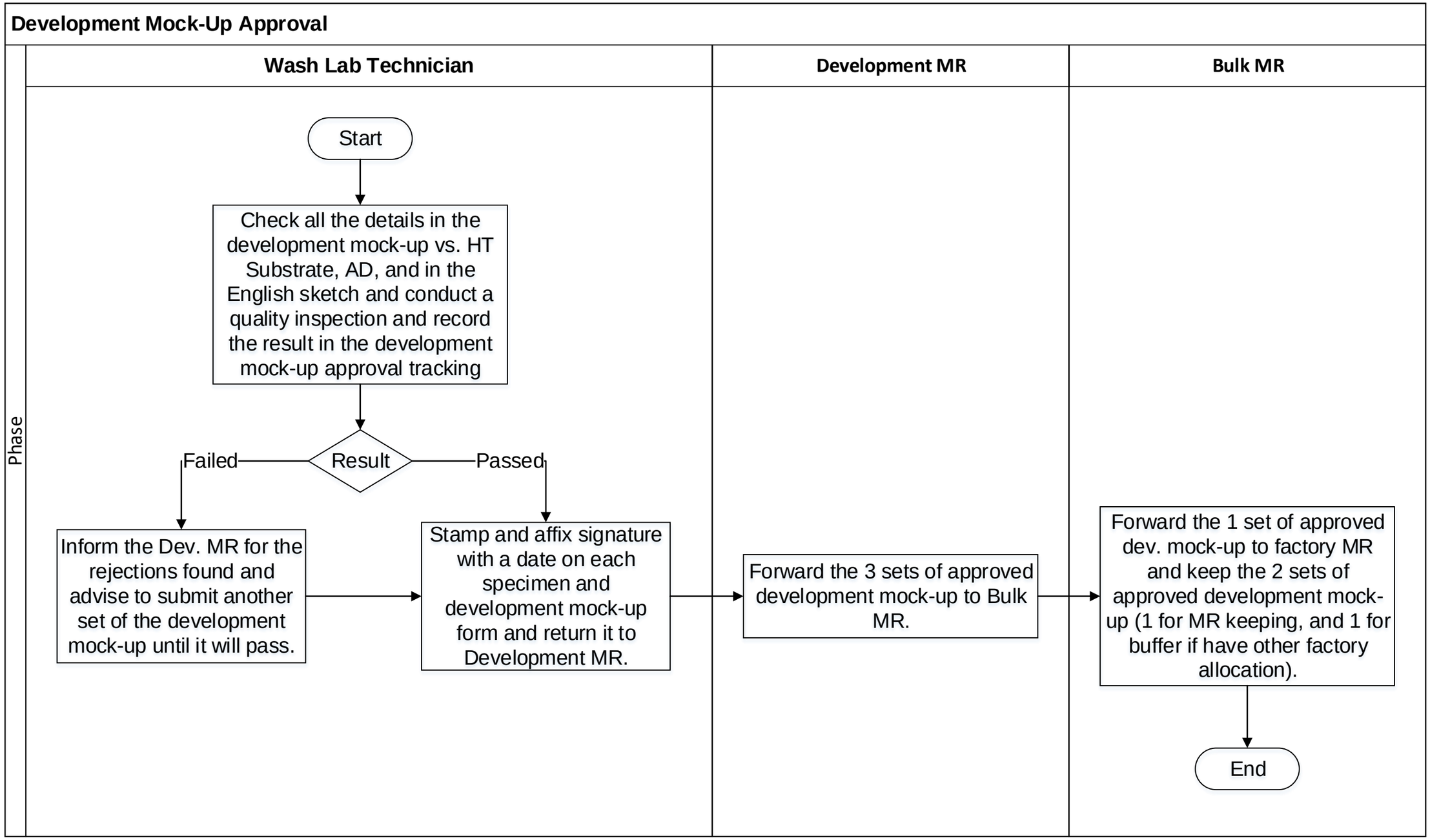
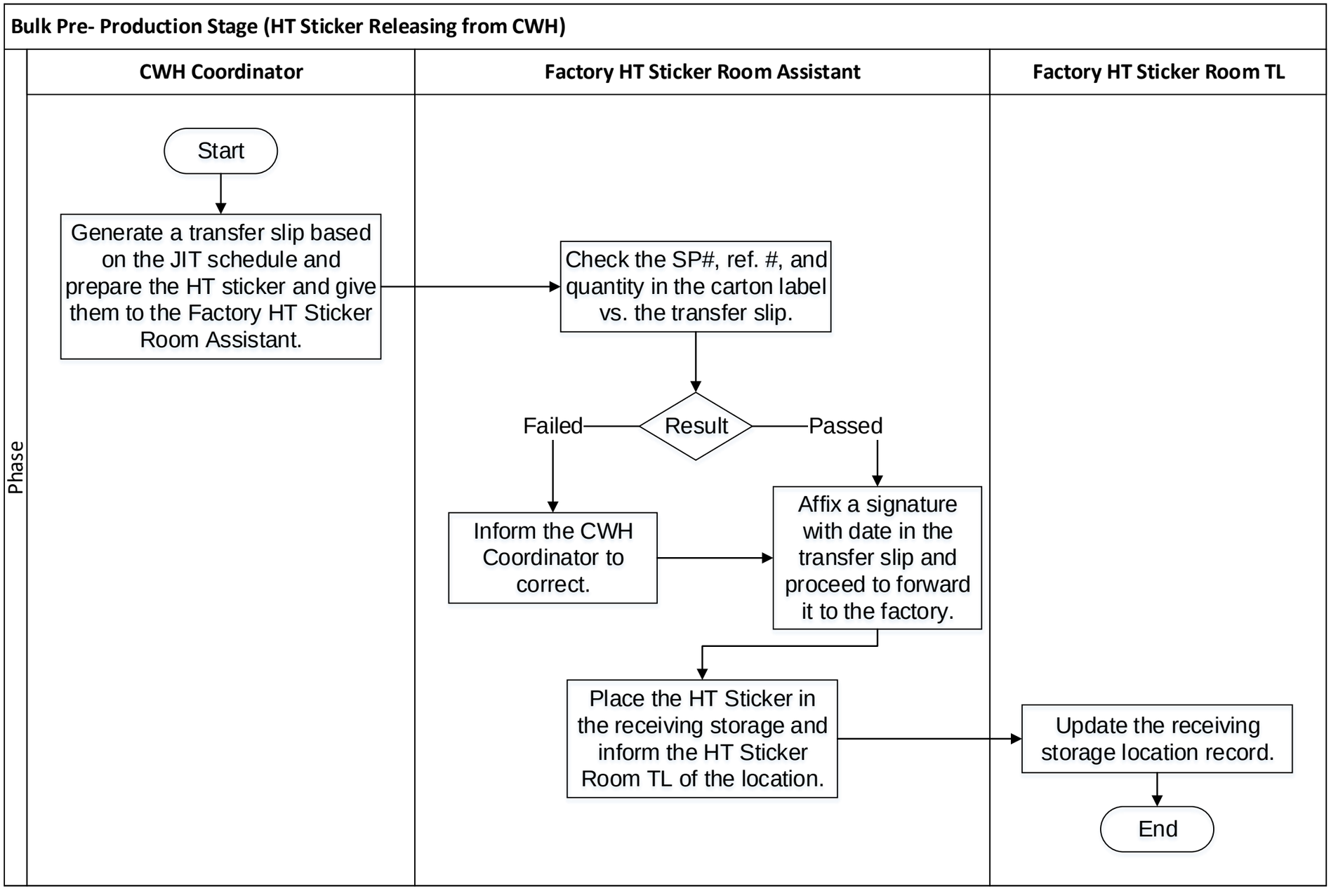
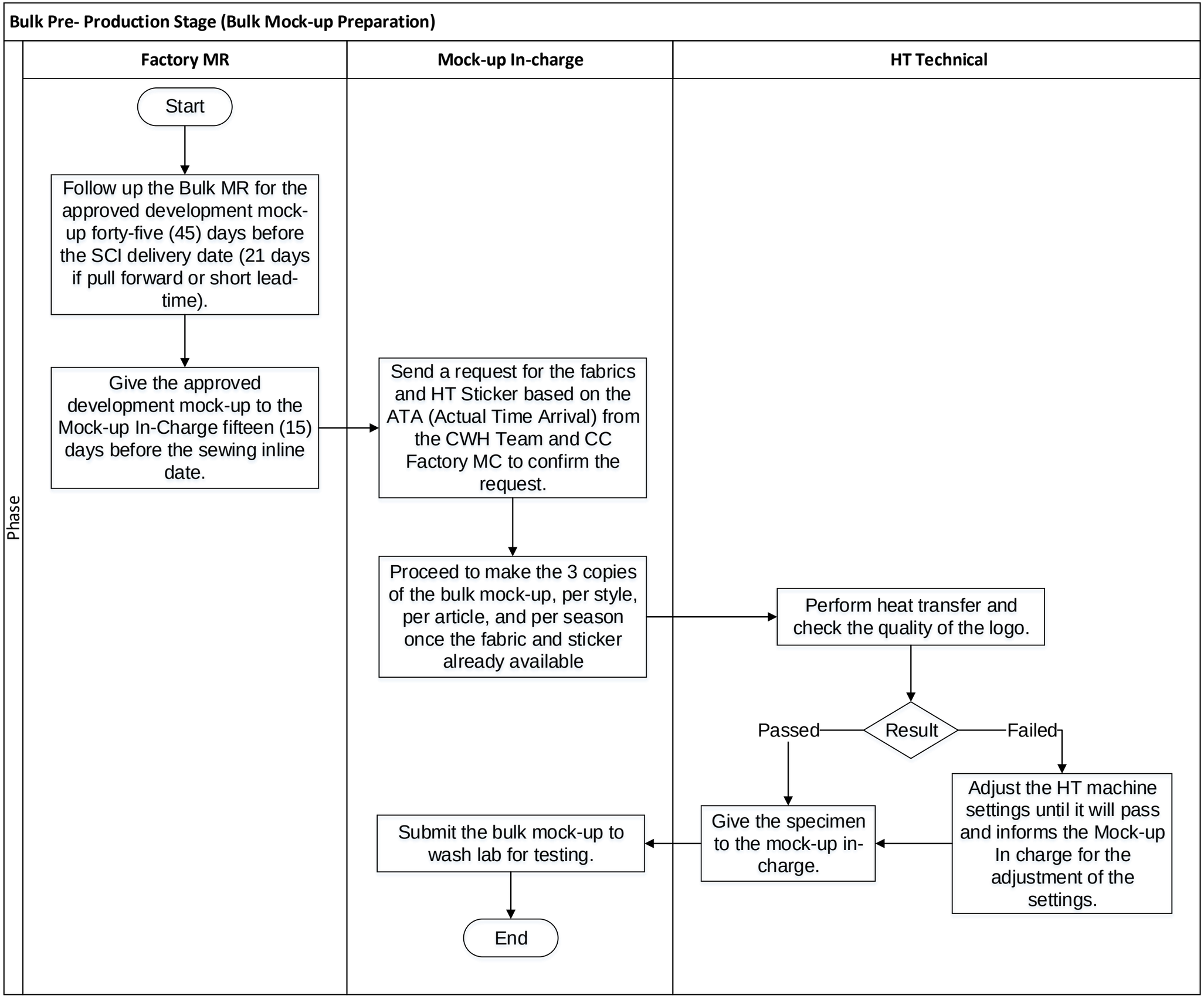
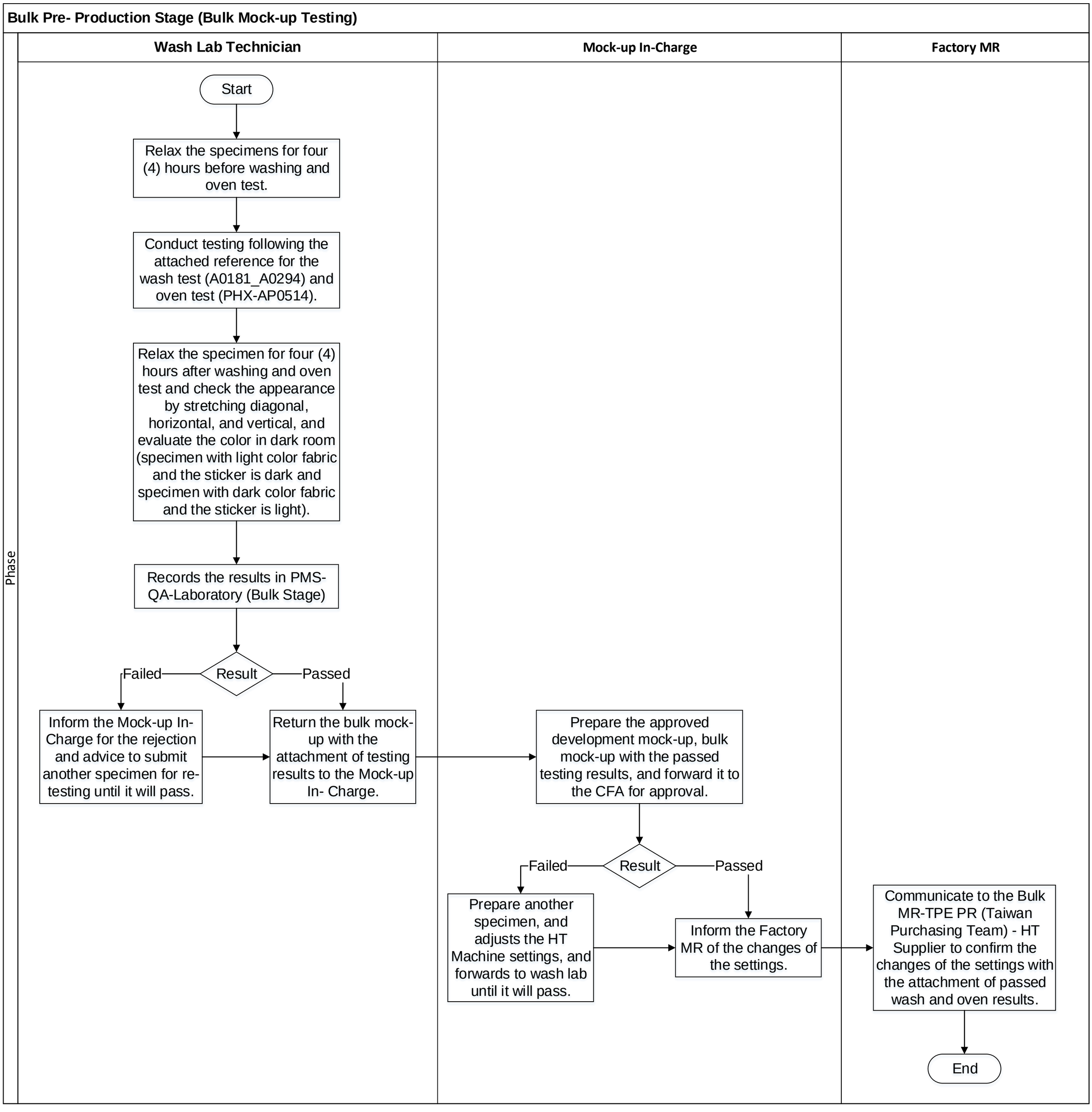

Development Mock-Up Preparation
Phase
Development MR
HT Supplier
TSD Technical
Start
Send a piece of fabric to HT Supplier for testing.
Send the passed HT Substrate to T1.
Send the HT substrate with 3 pieces of fabrics and heat transfer sticker to TSD Technical for development mock-up per style/article/ season.
Make the development mock-up following the settings of HT substrate and check the quality by stretching diagonal, vertical, and horizontal.
Result
Passed
Failed
Give the 3 sets of mock-ups to Development MR
Adjust the HT machine settings until it will pass and record the new settings in the development mock-up and inform Development MR for the setting adjustment.
Forward the 3 sets of mock-up to the wash lab.
End

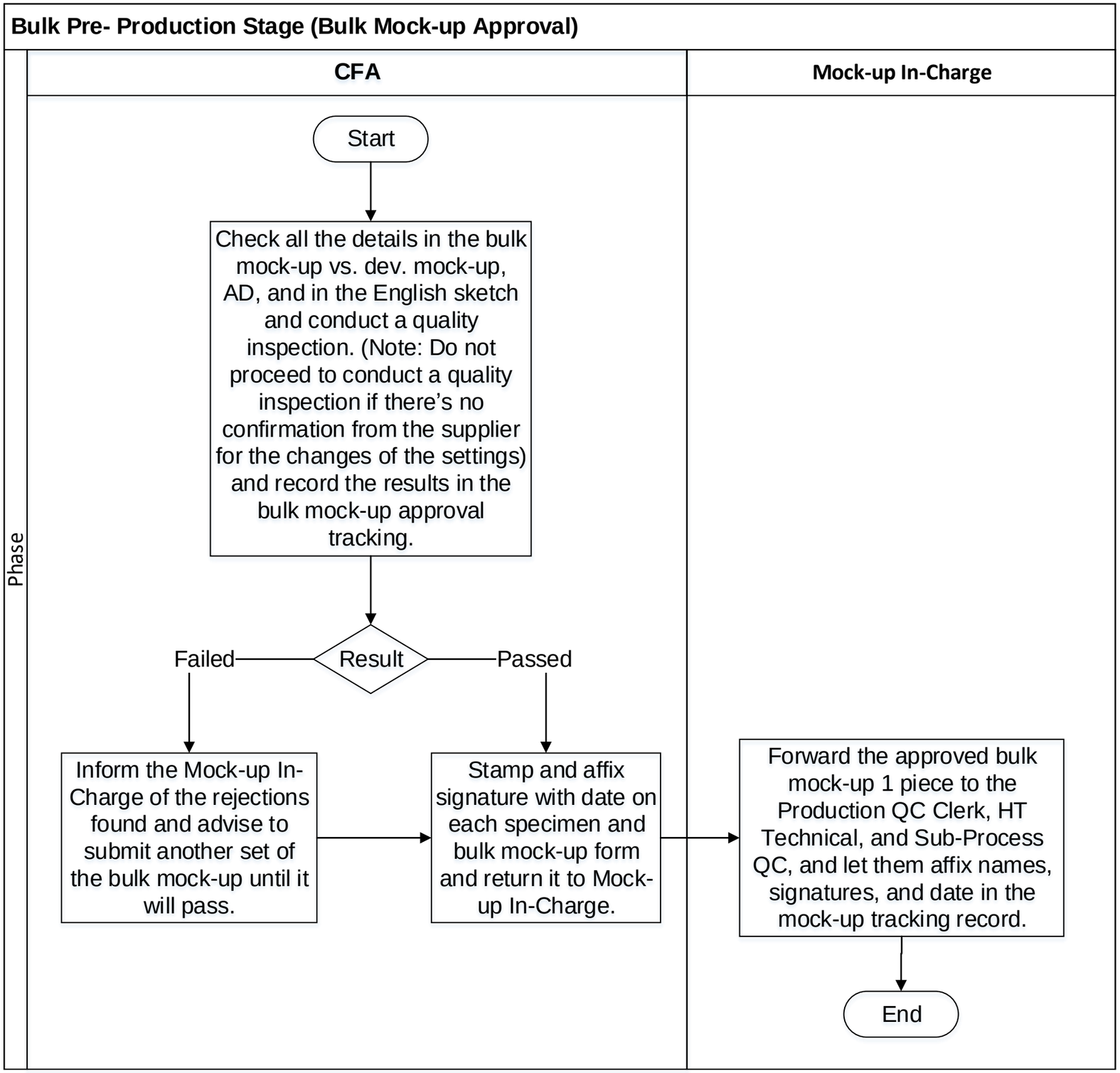

Development Mock-Up Testing
Wash Lab Technician
Development MR
Phase
Start
Relax the specimens for four (4) hours before washing and oven test.
Follow the attached reference for the wash test (A0181_A0294) and oven test (PHX-AP0514).
Relax the specimen for four (4) hours after washing and oven test and check the appearance by stretching diagonal, horizontal, and vertical, and evaluate the color in dark room (specimen with light color fabric and the sticker is dark and specimen with dark color fabric and the sticker is light).
Record the results in PMS-QA-Laboratory (Sample Stage) and forward the specimen to the Development MR with an attachment of the testing result. If failed, discuss to the Development MR for the rejection found during checking.
Evaluate the rejection to determine the settings that need to adjust and send another specimen for re-testing until it will pass.
Send email communication to the HT supplier to inform the changes of the settings with an attachment of the passed report of the wash and oven test and let the HT supplier confirm.
Forward the 3 sets of mock-up with wash and oven testing results to the CFA for approval. Send the email communication from the HT supplier that they confirmed the changes on the HT settings.
End

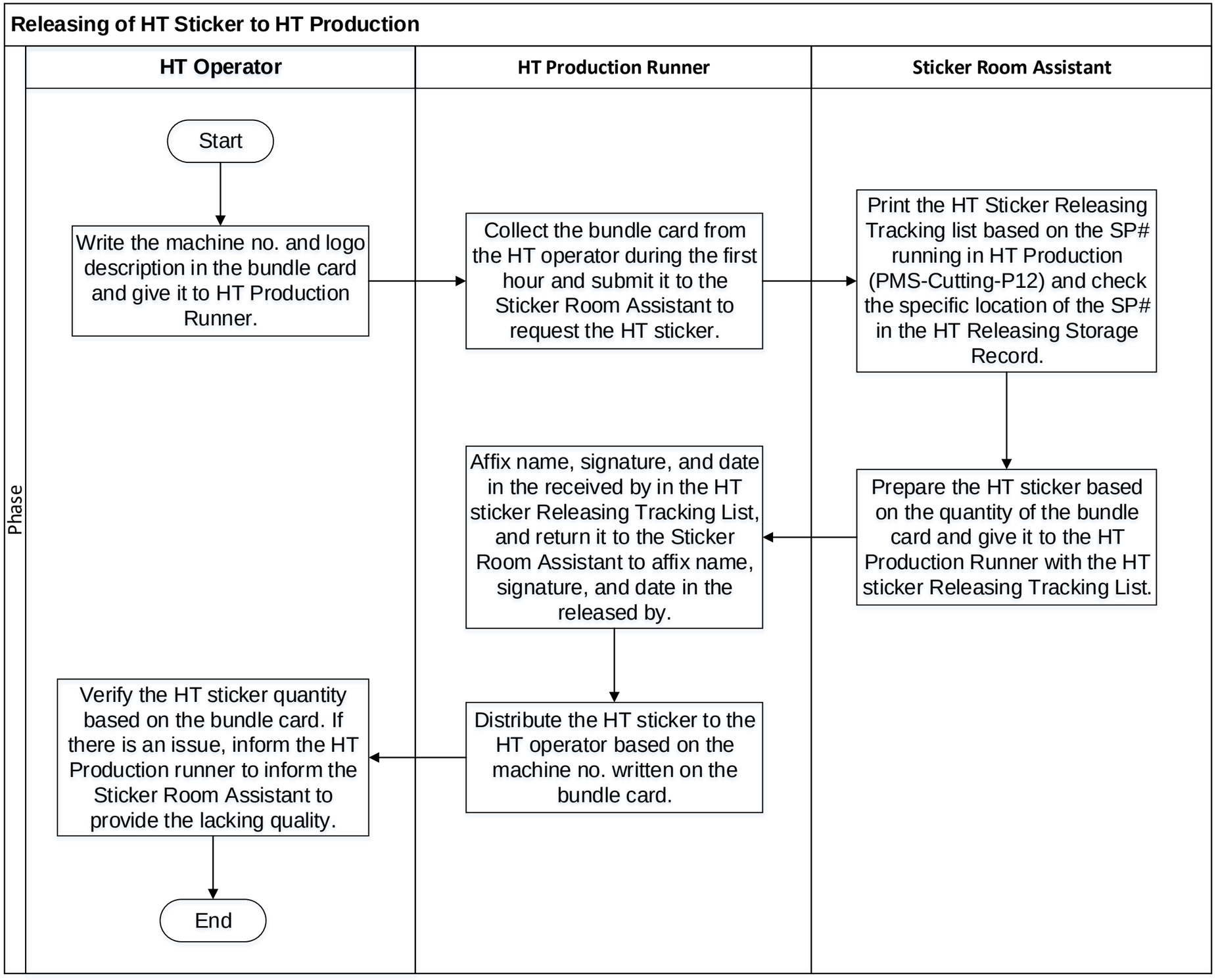

Development Mock-Up Approval
Phase
Wash Lab Technician
Development MR
Bulk MR
Start
Check all the details in the development mock-up vs. HT Substrate, AD, and in the English sketch and conduct a quality inspection and record the result in the development mock-up approval tracking
Result
Failed
Passed
Inform the Dev. MR for the rejections found and advise to submit another set of the development mock-up until it will pass.
Stamp and affix signature with a date on each specimen and development mock-up form and return it to Development MR.
Forward the 3 sets of approved development mock-up to Bulk MR.
Forward the 1 set of approved dev. mock-up to factory MR and keep the 2 sets of approved development mock-up (1 for MR keeping, and 1 for buffer if have other factory allocation).
End


Bulk Pre- Production Stage (HT Sticker Releasing from CWH)
Phase
CWH Coordinator
Factory HT Sticker Room Assistant
Factory HT Sticker Room TL
Start
Generate a transfer slip based on the JIT schedule and prepare the HT sticker and give them to the Factory HT Sticker Room Assistant.
Check the SP#, ref. #, and quantity in the carton label vs. the transfer slip.
Result
Failed
Passed
Inform the CWH Coordinator to correct.
Affix a signature with date in the transfer slip and proceed to forward it to the factory.
Place the HT Sticker in the receiving storage and inform the HT Sticker Room TL of the location.
Update the receiving storage location record.
End


Bulk Pre- Production Stage (Bulk Mock-up Preparation)
Phase
Factory MR
Mock-up In-charge
HT Technical
Start
Follow up the Bulk MR for the approved development mock-up forty-five (45) days before the SCI delivery date (21 days if pull forward or short lead-time).
Give the approved development mock-up to the Mock-up In-Charge fifteen (15) days before the sewing inline date.
Send a request for the fabrics and HT Sticker based on the ATA (Actual Time Arrival) from the CWH Team and CC Factory MC to confirm the request.
Proceed to make the 3 copies of the bulk mock-up, per style, per article, and per season once the fabric and sticker already available
Perform heat transfer and check the quality of the logo.
Result
Passed
Failed
Adjust the HT machine settings until it will pass and informs the Mock-up In charge for the adjustment of the settings.
Give the specimen to the mock-up in-charge.
Submit the bulk mock-up to wash lab for testing.
End


Bulk Pre- Production Stage (Bulk Mock-up Testing)
Phase
Wash Lab Technician
Mock-up In-Charge
Factory MR
Start
Relax the specimens for four (4) hours before washing and oven test.
Conduct testing following the attached reference for the wash test (A0181_A0294) and oven test (PHX-AP0514).
Relax the specimen for four (4) hours after washing and oven test and check the appearance by stretching diagonal, horizontal, and vertical, and evaluate the color in dark room (specimen with light color fabric and the sticker is dark and specimen with dark color fabric and the sticker is light).
Records the results in PMS-QA-Laboratory (Bulk Stage)
Result
Failed
Passed
Inform the Mock-up In-Charge for the rejection and advice to submit another specimen for re-testing until it will pass.
Return the bulk mock-up with the attachment of testing results to the Mock-up In- Charge.
Prepare the approved development mock-up, bulk mock-up with the passed testing results, and forward it to the CFA for approval.
Result
Failed
Passed
Prepare another specimen, and adjusts the HT Machine settings, and forwards to wash lab until it will pass.
Inform the Factory MR of the changes of the settings.
Communicate to the Bulk MR-TPE PR (Taiwan Purchasing Team) - HT Supplier to confirm the changes of the settings with the attachment of passed wash and oven results.
End


Bulk Pre- Production Stage (Bulk Mock-up Approval)
Phase
CFA
Mock-up In-Charge
Start
Check all the details in the bulk mock-up vs. dev. mock-up, AD, and in the English sketch and conduct a quality inspection. (Note: Do not proceed to conduct a quality inspection if there's no confirmation from the supplier for the changes of the settings) and record the results in the bulk mock-up approval tracking.
Result
Failed
Passed
Inform the Mock-up In-Charge of the rejections found and advise to submit another set of the bulk mock-up until it will pass.
Stamp and affix signature with date on each specimen and bulk mock-up form and return it to Mock-up In-Charge.
Forward the approved bulk mock-up 1 piece to the Production QC Clerk, HT Technical, and Sub-Process QC, and let them affix names, signatures, and date in the mock-up tracking record.
End


Releasing of HT Sticker to HT Production
Phase
HT Operator
HT Production Runner
Sticker Room Assistant
Start
Write the machine no. and logo description in the bundle card and give it to HT Production Runner.
Collect the bundle card from the HT operator during the first hour and submit it to the Sticker Room Assistant to request the HT sticker.
Print the HT Sticker Releasing Tracking list based on the SP# running in HT Production (PMS-Cutting-P12) and check the specific location of the SP# in the HT Releasing Storage Record.
Prepare the HT sticker based on the quantity of the bundle card and give it to the HT Production Runner with the HT sticker Releasing Tracking List.
Affix name, signature, and date in the received by in the HT sticker Releasing Tracking List, and return it to the Sticker Room Assistant to affix name, signature, and date in the released by.
Distribute the HT sticker to the HT operator based on the machine no. written on the bundle card.
Verify the HT sticker quantity based on the bundle card. If there is an issue, inform the HT Production runner to inform the Sticker Room Assistant to provide the lacking quality.
End