



Process: Quality Control
 Category: Global
 Document type: Instruction
 Language: English
 IHT: Internal

Title: AQL- Blanket

Document ID: TSLOG-16-85782
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 Effective date: 5/18/2022
 GDP related: No
 Version: 11.0

Definitions:

Critical nonconformity : Any discrepancy which might harm a user or makes it impossible to use the product properly is considered to be critical. Lots with Critical discrepancies is subject to lot refusal.
Major nonconformity : Any discrepancy which makes the use of the product less efficient than expected is considered to be major. Lot with Major discrepancies can be accepted.
Minor nonconformity : Any discrepancy which does not have an influence on the performance of the product is considered to be minor. Lot with Minor discrepancies can be accepted.
Nonconformity: Non-fulfilment of a specified characteristic requirement.
Nonconforming item: Item with one or more nonconformities.
Lot: Definite amount of some product, material or service, collected together
Sample: Set of one or more items taken from a lot and intended to provide information on the lot

Non-Conformities and Corrective Action:

Critical: (AQL 0)

Determination of lot acceptability: to be decided by ICRC' Quality and buyers.
Continual improvement: Improvement plan to be proposed by supplier and validated by the ICRC to eliminate the root cause of occurrence and non detection for the faced non-conformity (ies) for the upcoming purchases. Actions to be implemented by supplier within a defined time frame by default 3 months.
Penalty: 10% penalty of the value of the total PO per each critical non-conformity to be charged to the supplier .

Major: (AQL 4.0)

Determination of lot acceptability: to be decided by ICRC' Quality and buyers.
Continual improvement: Improvement plan to be proposed by supplier and validated by the ICRC to eliminate the root cause of occurrence and non detection for the faced non-conformity (ies) for the upcoming purchases. Actions to be implemented by supplier within a defined time frame by default 3 months.
Penalty: 0.5% penalty of the value of the total PO per each major non-conformity to be charged to the supplier.

Minor: (AQL 6.5)

Determination of lot acceptability: to be decided by ICRC' Quality and buyers.
Continual improvement: Improvement plan to be proposed by supplier and validated by the ICRC to eliminate the root cause of occurrence and non detection for the faced non-conformity (ies) for the upcoming purchases. Actions to be implemented by supplier within a defined time frame by default 3 months.
Penalty: 0.25% penalty of the value of the total PO per each minor non-conformity to be charged to the supplier.

Penalty rules for specific nonconformities:

Thermal resistance for Low Thermal blankets (AQL 4.0)

Discrepancy between requirement and the average result of nonconforming blankets:
 0.15m².K/W >result≥0.14m².K/W: 1% of the value of the PO
 0.14m².K/W >result≥0.10m².K/W: 2% of the value of the PO
 0.10m².K/W >result: 5% of the value of the PO and subject to lot refusal

Thermal resistance for Medium Thermal blankets (AQL 4.0)

Discrepancy between requirement and the average result of nonconforming blankets:
 0.25m².K/W >result≥0.23m².K/W: 1% of the value of the PO
 0.23m².K/W >result≥0.18m².K/W: 2% of the value of the PO
 0.18m².K/W >result: 5% of the value of the PO and subject to lot refusal

Thermal resistance for High Thermal blankets (AQL 4.0)

Discrepancy between requirement and the average result of nonconforming blankets:
 0.40m².K/W >result≥0.36m².K/W: 1% of the value of the PO
 0.36m².K/W >result≥0.29m².K/W: 2% of the value of the PO
 0.29m².K/W >result: 5% of the value of the PO and subject to lot refusal

A corrective action plan must be implemented by the supplier on its processes addressing root causes of occurrence (production) and of non-detection of the nonconformity (QC).
 Penalty is put on hold for 3 months from the date of sharing of the inspection report with supplier, after this period if the nonconformity is not anymore found by inspection the penalty is cancelled, if the nonconformity still exists the penalty applies for the whole POs received during the 3 months.

Additional Information:

The Method of testing is drawn from ISO-2859-1 International Standards (table1: Sample size code letters, and table 2-A: Single sampling plans for normal inspection). The samples will be taken randomly by the buyer from the delivered items and then inspected. The buyer can decide either to inspect the lot at ICRC QC laboratory or to use an inspection company for analysis, or both. Transport to laboratory and analysis cost for lab testing are at expense of ICRC. The seller can contest the results of the Quality Control done at ICRC warehouses by requesting a lab testing. In this case transport to laboratory and analysis cost for lab testing are at expense of the seller. In case the ICRC decides to hold the penalties during the improvement plan, if the faced nonconformity(ies) persist ; penalty for each non-conformity faced during the improvement plan will be applied.



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Nonconformities classification: Critical: C; Major: M; Minor: m

Items	Characteristics	Nonconformities classification	QC type	AQL	QC Inspection at ICRC warehouses and lab testing (Samples of blankets must be from compressed bales)
Bales	Marking on the bales	m	Ok/Nok	6.5	Marking expected: ICRC + BLANKET, SYNTHETIC, 1.5x2m, low thermal resistance - 30 pieces. + PO number. No logo of the supplier allowed. Marking must remain readable and well fixed on the bale after minimum 10 handlings.
	Bales length	m	Measurement	6.5	Minimum: 65cm ; Maximum:85cm.
	Bales width	m	Measurement	6.5	Minimum: 40cm ; Maxi:60cm.
	Bales height	m	Measurement	6.5	Minimum: 55cm ; Maxi:75cm. Height of the bales to be compressed by maximum 60% from free state to final compressed and strapped state.
	Bales strapping	m	Measurement	6.5	Compressed and strapped with 5 straps (2 lengthwise, 3 crosswise)
	Bales quality	m	Ok/Nok	6.5	Bales to be wrapped in a water-tight micro perforated plastic film and covered with a polypropylene or jute woven bag. Items to not be wrapped in single use plastics.
	Content	m	Ok/Nok	6.5	Quantity per bale: 30 pieces.
Blankets synthetic low thermal resistance	Material	C	Ok/Nok	0	Woven/knitted, dry raised both sides, 100% virgin polyester and/or acrylic fibers or polyester/cotton (Content ISO 1833 on dry weight)
	Colours	M	Ok/Nok	4.0	A uniform dark color that is not black (e.g. dark blue, grey, brown). No red or white. Colour should be well fixed and not run with washing.
	Length	m	Measurement	6.5	Minimum: 198cm ; Maximum:206cm. To be taken on flat stabilised sample, without folds.
	Width	m	Measurement	6.5	Minimum: 148.5cm ; Maximum:154.5cm. To be taken on flat stabilised sample, without folds.
	Weight	m	Measurement	6.5	Minimum:200g/m ² ; maximum:400g/m ² . Weight determined by total weight/total surface.
	Thickness	M	Measurement	4.0	3.5 mm minimum. ISO 5084 (1KPa on 2000mm ²)
Blankets synthetic low thermal resistance	Tensile strength	M	Measurement	4.0	250N warp and weft minimum. ISO13934-1
	Tensile strength loss after washing	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO13934-1 and ISO 6330
	Shrinkage maxi.	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO 6330
	Weight loss after washing	M	Measurement	4.0	Maximum 5% after 3 consecutive machine washing at 30°C and one flat drying.
	Thermal resistance ISO 11092	Specific	Measurement	4.0	Rct= 0.15m ² .K/W minimum, rounded to the nearest 0.01, passed on samples picked from compressed bales. Mechanical conditioning: after opening of the bale, the blanket shall be dry tumbled in a dryer (500l minimum capacity) without any other load for 15 minutes at a temperature of less than 30°C. Then, the blanket shall be conditioned for at least 24 hours by flat lying at ambient conditions (20°C and 65% Relative Humidity).
	Resistance to air flow	M	Measurement	4.0	Maximum 1500 L/m ² /s. ISO9237 under 100Pa pressure drop
Blankets synthetic low thermal resistance	Finishing	m	Measurement	6.5	Whipped seam at 10mm from the edge with 10 to 13 stitches/10cm or stitched ribbon or hemmed on 4 sides. The edges finishing should be straight. The corners can be round up to a radius of 100mm maximum.
	Organoleptic test	M	Ok/Nok	4.0	No bad smell, not irritating to the skin, no dust. 4<pH<9. Free from harmful VOC (Volatile Organic Components).
	Fire resistance	C	Ok/Nok	0	Resistance to cigarette - No ignition. ISO12952-1 , Resistance to flame - No ignition. ISO12952-2
	Blanket identification	m	Ok/Nok	6.5	Every blanket should include a tag, stitched in the hem. The tag should include the manufacturer's name, a unique reference batch number and the date of manufacturing. No company logo should be included with the manufacturer's marking.
	Homogeneous quality	M	Ok/Nok	4.0	The blankets should be homogeneous and not presenting fibbers missing.



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Title: AQL- Blanket Synthetic Medium Thermal Resistance

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Items	Characteristics	Nonconformities classification	QC type	AQL	QC Inspection at ICRC warehouses and lab testing (Samples of blankets must be from compressed bales)
Bales	Marking on the bales	m	Ok/Nok	6.5	Marking expected: ICRC + BLANKET, SYNTHETIC, 1.5x2m, medium thermal resistance - 20 pieces. + PO number. No logo of the supplier allowed. Marking must remain readable and well fixed on the bale after minimum 10 handlings.
	Bales length	m	Measurement	6.5	Minimum: 65cm ; Maximum:85cm.
	Bales width	m	Measurement	6.5	Minimum: 40cm ; Maxi:60cm.
	Bales height	m	Measurement	6.5	Minimum: 65cm ; Maxi:85cm. Height of the bales to be compressed by maximum 60% from free state to final compressed and strapped state.
	Bales strapping	m	Measurement	6.5	Compressed and strapped with 5 straps (2 lengthwise, 3 crosswise)
	Bales quality	m	Ok/Nok	6.5	Bales to be wrapped in a water-tight micro perforated plastic film and covered with a polypropylene or jute woven bag. Items to not be wrapped in single use plastics.
	Content	m	Ok/Nok	6.5	Quantity per bale: 20 pieces.
Blankets synthetic medium thermal resistance	Material	C	Ok/Nok	0	Woven/knitted, dry raised both sides, 100% virgin polyester and/or acrylic fibers or polyester/cotton (Content ISO 1833 on dry weight)
	Colours	M	Ok/Nok	4.0	A uniform dark color that is not black (e.g. dark blue, grey, brown). No red or white. Colour should be well fixed and not run with washing.
	Length	m	Measurement	6.5	Minimum: 198cm ; Maximum:206cm. To be taken on flat stabilised sample, without folds.
	Width	m	Measurement	6.5	Minimum: 148.5cm ; Maximum:154.5cm. To be taken on flat stabilised sample, without folds.
	Weight	m	Measurement	6.5	Minimum:400g/m ² ; maximum:700g/m ² . Weight determined by total weight/total surface.
	Thickness	M	Measurement	4.0	6.5 mm minimum. ISO 5084 (1KPa on 2000mm ²)
	Tensile strength	M	Measurement	4.0	250N warp and weft minimum. ISO13934-1
	Tensile strength loss after washing	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO13934-1 and ISO 6330
	Shrinkage maxi.	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO 6330
	Weight loss after washing	M	Measurement	4.0	Maximum 5% after 3 consecutive machine washing at 30°C and one flat drying.
	Thermal resistance ISO 11092	Specific	Measurement	4.0	Rct= 0.25m ² .K/W minimum, rounded to the nearest 0.01, passed on samples picked from compressed bales. Mechanical conditioning: after opening of the bale, the blanket shall be dry tumbled in a dryer (500l minimum capacity) without any other load for 15 minutes at a temperature of less than 30°C. Then, the blanket shall be conditioned for at least 24 hours by flat lying at ambient conditions (20°C and 65% Relative Humidity).
	Resistance to air flow	M	Measurement	4.0	Maximum 1000 L/m ² /s. ISO9237 under 100Pa pressure drop
	Finishing	m	Measurement	6.5	Whipped seam at 10mm from the edge with 10 to 13 stitches/10cm or stitched ribbon or hemmed on 4 sides. The edges finishing should be straight. The corners can be round up to a radius of 100mm maximum.
	Organoleptic test	M	Ok/Nok	4.0	No bad smell, not irritating to the skin, no dust. 4<pH<9. Free from harmful VOC (Volatile Organic Components).
	Fire resistance	C	Ok/Nok	0	Resistance to cigarette - No ignition. ISO12952-1 , Resistance to flame - No ignition. ISO12952-2
Blanket identification	m	Ok/Nok	6.5	Every blanket should include a tag, stitched in the hem. The tag should include the manufacturer's name, a unique reference batch number and the date of manufacturing. No company logo should be included with the manufacturer's marking.	
Homogeneous quality	M	Ok/Nok	4.0	The blankets should be homogeneous and not presenting fibbers missing.	



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Items	Characteristics	Nonconformities classification	QC type	AQL	QC Inspection at ICRC warehouses and lab testing (Samples of blankets must be from compressed bales)
Bales	Marking on the bales	m	Ok/Nok	6.5	Marking expected: ICRC + BLANKET, SYNTHETIC, 1.5x2m, high thermal resistance - 15 pieces. + PO number. No logo of the supplier allowed. Marking must remain readable and well fixed on the bale after minimum 10 handlings.
	Bales length	m	Measurement	6.5	Minimum: 65cm ; Maximum:85cm.
	Bales width	m	Measurement	6.5	Minimum: 40cm ; Maxi:60cm.
	Bales height	m	Measurement	6.5	Minimum: 65cm ; Maxi: 85cm. Height of the bales to be compressed by maximum 60% from free state to final compressed and strapped state.
	Bales strapping	m	Measurement	6.5	Compressed and strapped with 5 straps (2 lengthwise, 3 crosswise)
	Bales quality	m	Ok/Nok	6.5	Bales to be wrapped in a water-tight micro perforated plastic film and covered with a polypropylene or jute woven bag. Items to not be wrapped in single use plastics.
	Content	m	Ok/Nok	6.5	Quantity per bale: 15 pieces.
Blankets synthetic high thermal resistance	Material	C	Ok/Nok	0	Woven/knitted, dry raised both sides, 100% virgin polyester and/or acrylic fibers or polyester/cotton (Content ISO 1833 on dry weight). If any, inner layer can be non-woven/knitted type.
	Colours	M	Ok/Nok	4.0	A uniform dark colour that is not black (e.g. dark blue, grey, brown). No red or white. Colour should be well fixed and not run with washing.
	Length	m	Measurement	6.5	Minimum: 198cm ; Maximum:206cm. To be taken on flat stabilised sample, without folds.
	Width	m	Measurement	6.5	Minimum: 148.5cm ; Maximum:154.5cm. To be taken on flat stabilised sample, without folds.
	Weight	m	Measurement	6.5	Minimum:500g/m ² ; maximum:1000g/m ² . Weight determined by total weight/total surface.
	Thickness	M	Measurement	4.0	9.5 mm minimum. ISO 5084 (1KPa on 2000mm ²)
	Tensile strength	M	Measurement	4.0	250N warp and weft minimum. ISO13934-1
	Tensile strength loss after washing	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO13934-1 and ISO 6330
	Shrinkage maxi.	M	Measurement	4.0	Maximum 5% warp and weft after 3 consecutive machine washing at 30°C and one flat drying. ISO 6330
	Weight loss after washing	M	Measurement	4.0	Maximum 5% after 3 consecutive machine washing at 30°C and one flat drying.
	Thermal resistance ISO 11092	Specific	Measurement	4.0	Rct= 0.40m ² .K/W minimum, rounded to the nearest 0.01, passed on samples picked from compressed bales. Mechanical conditioning: after opening of the bale, the blanket shall be dry tumbled in a dryer (500l minimum capacity) without any other load for 15 minutes at a temperature of less than 30°C. Then, the blanket shall be conditioned for at least 24 hours by flat lying at ambient conditions (20°C and 65% Relative Humidity).
	Resistance to air flow	M	Measurement	4.0	Maximum 1000 L/m ² /s. ISO9237 under 100Pa pressure drop
	Finishing	m	Measurement	6.5	Whipped seam at 10mm from the edge with 10 to 13 stitches/10cm or stitched ribbon or hemmed on 4 sides. The edges finishing should be straight. The corners can be round up to a radius of 100mm maximum.
	Organoleptic test	M	Ok/Nok	4.0	No bad smell, not irritating to the skin, no dust. 4<pH<9. Free from harmful VOC (Volatile Organic Components).
	Fire resistance	C	Ok/Nok	0	Resistance to cigarette - No ignition. ISO12952-1 , Resistance to flame - No ignition. ISO12952-2
Blanket identification	m	Ok/Nok	6.5	Every blanket should include a tag, stitched in the hem. The tag should include the manufacturer's name, a unique reference batch number and the date of manufacturing. No company logo should be included with the manufacturer's marking.	
Homogeneous quality	M	Ok/Nok	4.0	The blankets should be homogeneous and not presenting fibbers missing.	