



Purchase of fibers and yarns

If purchased on the domestic market, Exlan gets actively involved in a careful selection of fibers, done by choosing those best suited for the yarns to be spun. For yarns of heavy counts, Exlan tries to buy the longest and clearest fibers, with the lightest natural shade.



During the spinning process, Exlan goes to the premises of the supplier to verify that they use the correct torsion per meter and the correct yarn count.

If purchased abroad, i.e. imported Exlan requests suppliers to provide their quality control records and certifications and only uses those with approved international recognition and certification.



Once yarn is delivered by either domestic or foreign suppliers and received in house, Exlan does the testing of the yarns as to color crocking, dry, wet and light exposure, as well as to correctness of torsion, count and evenness. In all cases this is confirmed by knitting up swatches which will show how yarn responds to knitting.



Yarn dyeing

Exlan also watches carefully that the dyeing process is done according to the standards developed by their own dyehouse, since Exlan provides their yarn suppliers with their approved dyeing formula and the correct chemicals and dye stuff.

Labelling

Labels are sewn into each product following instructions of each customer.

Prepacking stage

If At this stage all products, whether produced in the cottage industry, in-house or at other sites, all undergo a close Q,.C. based on the following guidelines:

- checking correctness of the general aspect of the garment, fitting it if necessary
- checking the correctness of labeling
- affixing the hangtags following customers' instructions
- folding garments as per customers' instructions
- bagging
- packing

At this stage at random about 10% of cartons are opened and checked if bags were placed correctly in the cartons without endangering the desired look and general condition of the garments. Also a count is done checking its accuracy with the packing list and garments are taken out of polibags, measured and inspected. If more than 10% of the inspected shows defects, another 10% is pulled out and inspected and if again defective, a 100% inspection is performed before releasing shipment

Handknit / handloomed production

Handknit/handloomed production: Its Q.C process takes place both in house and in sites outside of the central plant at the many different locations of the groups throughout the whole country.

70% of Exlan's knitting groups work with the company since its establishment in 1981, thus are knitters well trained in following directives and in meeting standards for export. Exlan ships to the supervisor of each group the yarn, sketches, specifications, layouts of pattern and swatches so that knitters adjust their knitting tension to the product required. They have to produce a preproduction sample which is sent by the supervisor of the group to the central offices of Exlan where the technical staff checks on specs, knitting tension, pattern layout, the sewing, and fitting and the overall aspect of the garment.

Once the preproduction sample is approved, Exlan authorizes the supervisor of the knitting group to start with production. All supervisors have to come with the finished product to the central offices of Exlan on a weekly basis, where they work together with the central office quality staff in inspection of the product, trying to fix whatever needs correction or taking back to the group if major changes/corrections are needed. If the group has difficulties we send a supervisor from the central staff to the location of the group for meeting with the supervisors and knitters for teaching them how to improve or learn to work with the products ordered. Q.C. performed at real time, i.e. immediately without delay is the key to successful product outcome and is emphasized at Exlan at all times.

The supervisors are the key to the Q.C. process. They are carefully selected and their main duties are:

- Upon receipt of the knitting information and the yarns, to process it and to prepare the same one for forwarding it to knitters.
 - To select the appropriate knitters for the product and to provide them with the yarn, the knitting needles and a swatch showing the correct tension and all sketches, layouts and specifications.
 - Teach knitters to do their job and supervise them in their work and help them to overcome their difficulties.
 - Capture new knitters for their group.
 - Travel to the central offices of Exlan in order to meet with the inhouse Q.C. team in order to review results obtained, difficulties encountered and to learn about all finishing details and customer's requirements.
-