

Pre-shipment Inspection Report

Report #: PSI20230921&22-R2309133838

General Information:	
Client name	XXX
Product name	Alum Box
Item	HP-1,HP-2,HP-3,HP-4,HP-5,HP-6,HP-7,HP-8
PO#	22003978
Ordered quantity(Lot size)	266pcs
Inspection Date	September 21&22, 2023
Arrival time	9:30 AM (21th)
Departure time	16:40 PM (22th)
Supplier name	XXX
Factory name	XXX
Inspection location	XXX



Inspection Summary					
Inspection Sections	Conform?	Remarks			
1. Product quantity check	Pending	Remark 1.1			
2. Workmanship appearance/ Function inspection	Beyond AQL		Cr	Ma	Mi
		Found	0	11	7
		Max Allowed	0	2	2
		Sample Size	30	30	30
		Most serious defects found: Remark2.1&2.2			
3. Test checking/Special check points	Pending	Remark 3.1-3.3			
4. Packing/Packaging	Pending	Remark 4.1-4.3			
5. Shipping marks/Label/Marking	Pending	Remark 5.1			
6. Product conformity/Measurement	Pending	Remark 6.1			

Conclusion	FAIL (Client has the final decision to Reject or Approve)
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AQI Remarks	
1	Quantity Check
1.1.	When the inspector arrived at the factory, the factory had already completed a batch of products (226 pieces) and had not yet packaged them into boxes.
2	Workmanship
2.1.	Selected 30pcs samples for inspection, found 11pcs major defects and 7pcs minor defects.

2.2.	The main defects include edge scratches and black particles on the side. When the product is standing 1 meter on the side, the problem of black particle defects on the side is not obvious.
2.3.	All product issues discovered on site have been notified to the factory, and for some surface paint issues, the factory has already repaired them on site (please refer to some repair department pictures).
3	Testing and special check points
3.1.	Supplier cannot provide the document of COC, COA, COT.
3.2.	Supplier cannot provide the report of salt spray test.
3.3.	Supplier cannot provide the report of silicon structure adhesive.
3.4.	The factory provided samples for coating adhesion 3M testing of the paint, and there were no abnormalities after testing.
4.	Packing Check
4.1.	Only when the inspector arrives at the factory, the products have all completed the installation and reinforcement of the sound insulation film. The factory uses tape to stick all the edges together.
4.2.	Add corner protectors on the four corners of the product to prevent damage to the edges.
4.3.	The absence of package transport tests in the factory can lead to the risk of damage to the products during shipping.
5.	Shipping marks inspection/Marking/Label
5.1	Factory just start to do the last process of installing the anti-drum, so factory do not start packing.
6	Product conformity inspection
6.1	The approval sample was not available for reference on site, pls see the photos for that actually found.

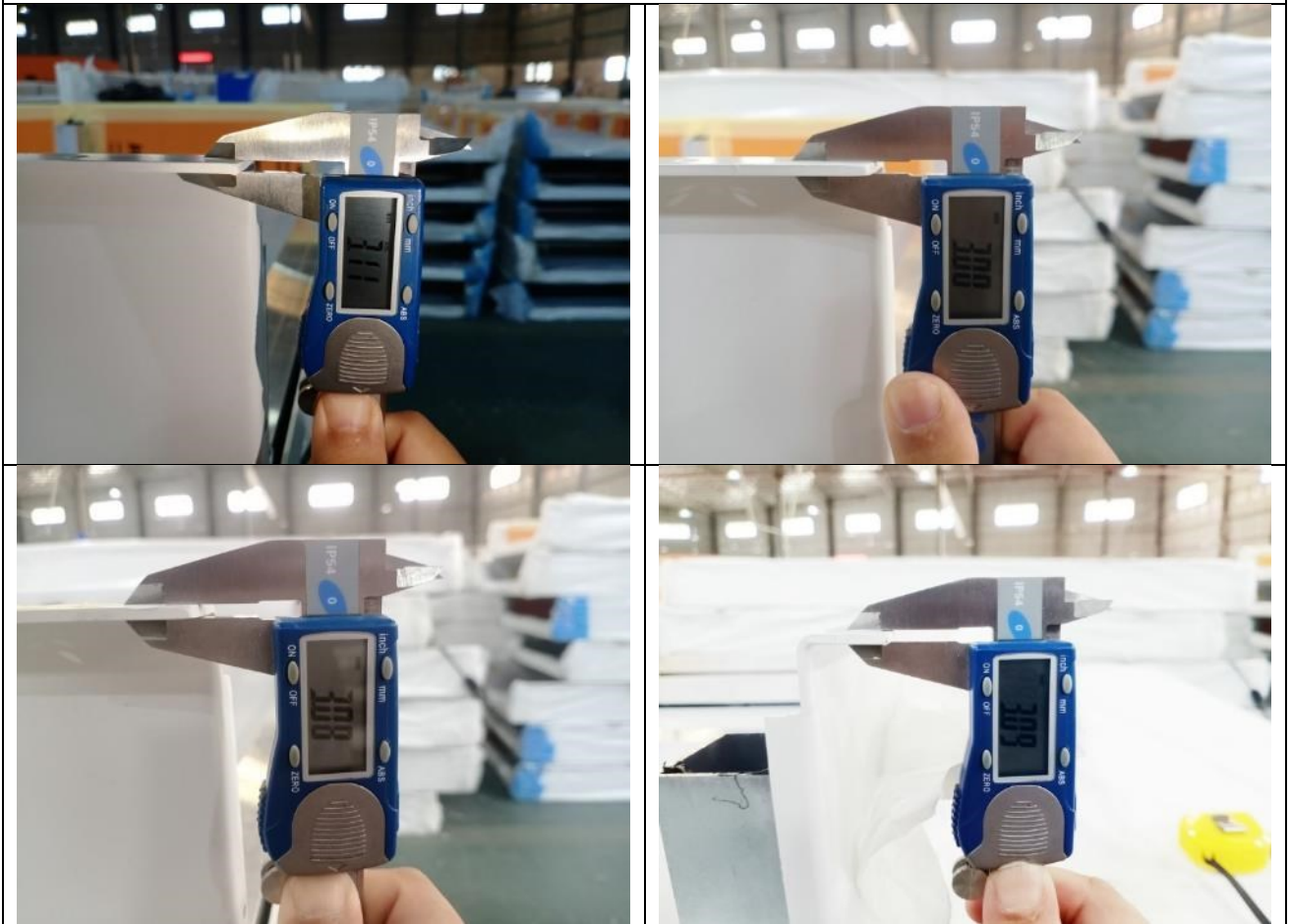
Pictures of remarks

1. Remark 1.1 When the inspector arrived at the factory, the factory had already completed a batch of products (226pieces) and had not yet packaged them into boxes.





1. The material of which the boxes are made of is – aluminum alloy 5052H32 3 mm. thickness

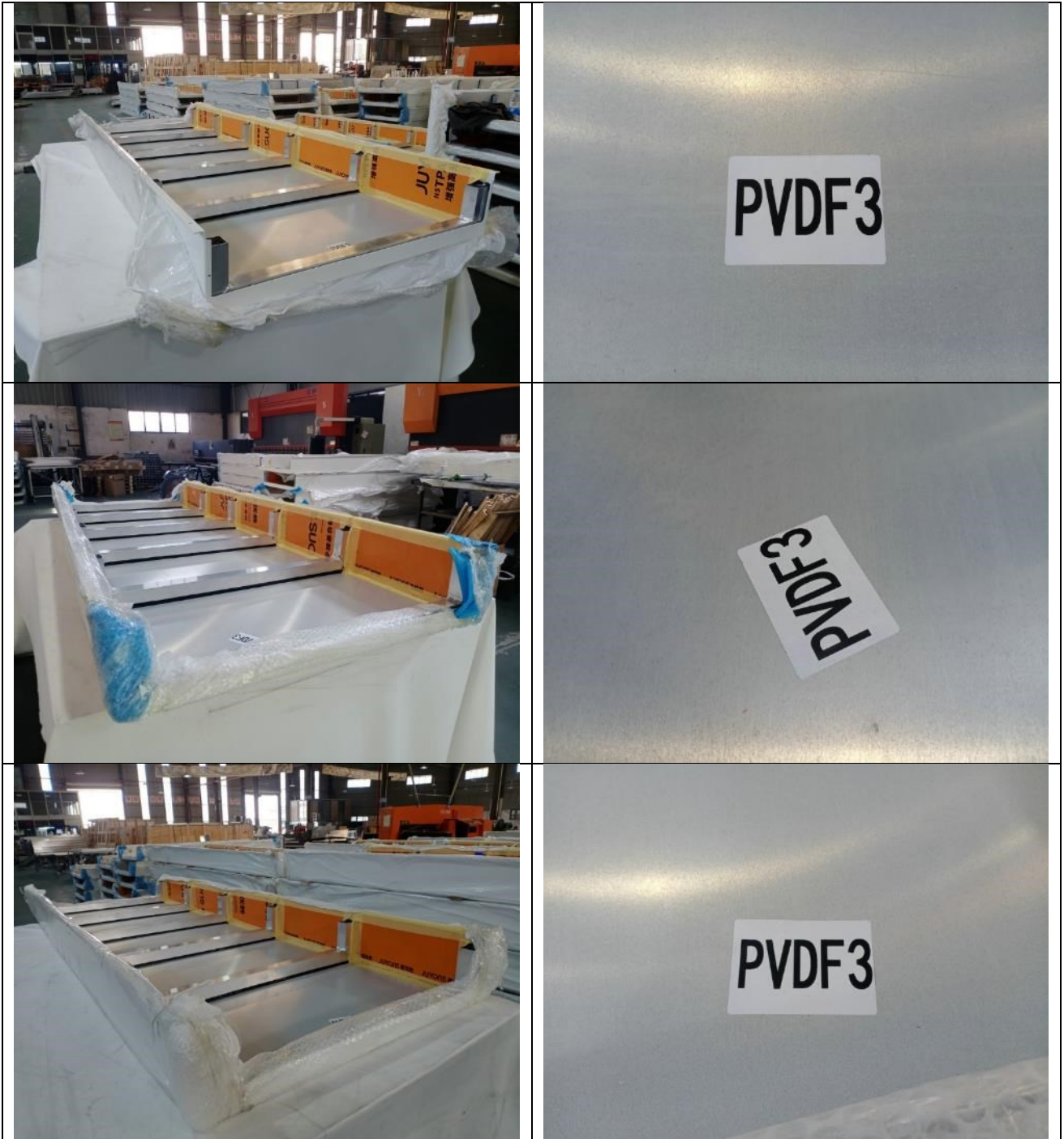


2. The coloring will be applied in 3 coats (PVDF3) 40>32 μ m thickness



3. PVDF3 seal is printed inside the box





4.As per the client requirement, The finish of the inner part of the boxes should be passivation10µm thickness, but factory missing this process.

5. Only when the inspector arrives at the factory, the products have all completed the installation and reinforcement of the sound insulation film. The factory uses tape to stick all the edges together.





6. Clear water passage of the square shaped profiles, 5x5mm

All installations are completed and cannot be measured on site.

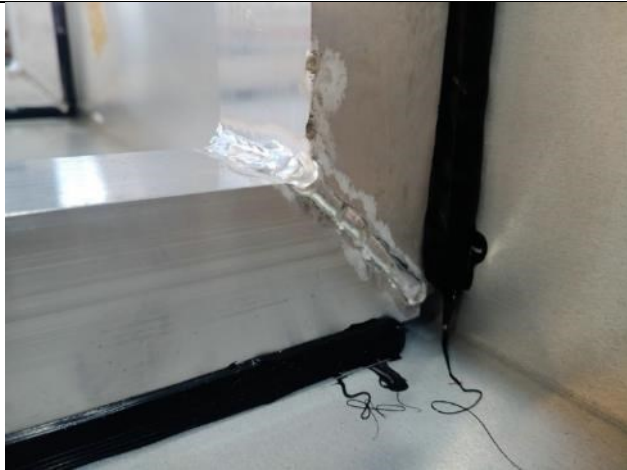


7. Welding thickness test, 4mm ~5mm

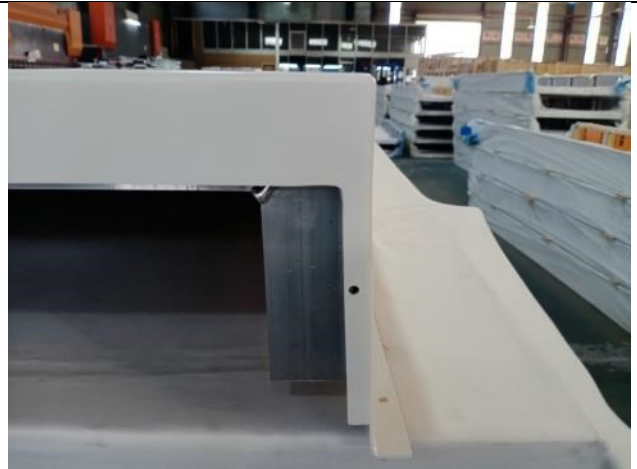
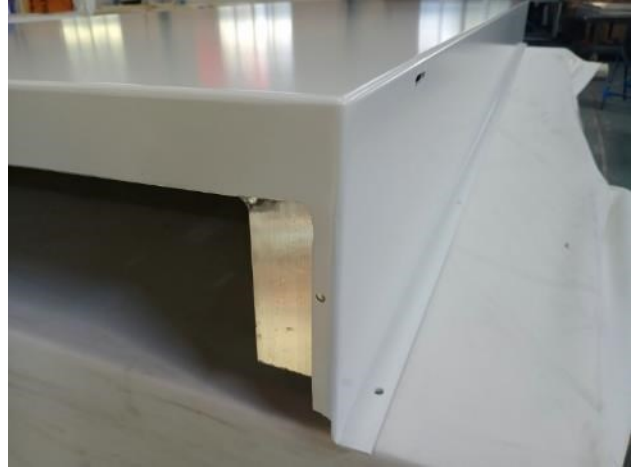
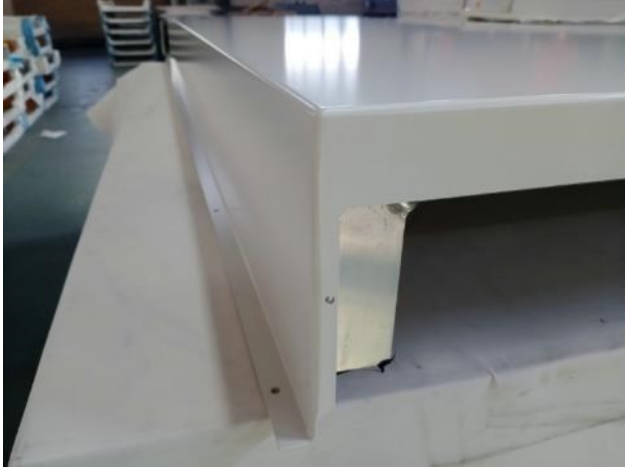




8. The reinforcement in the middle were welding from 3 sides, the welding was done with gap



9.Edge of the box

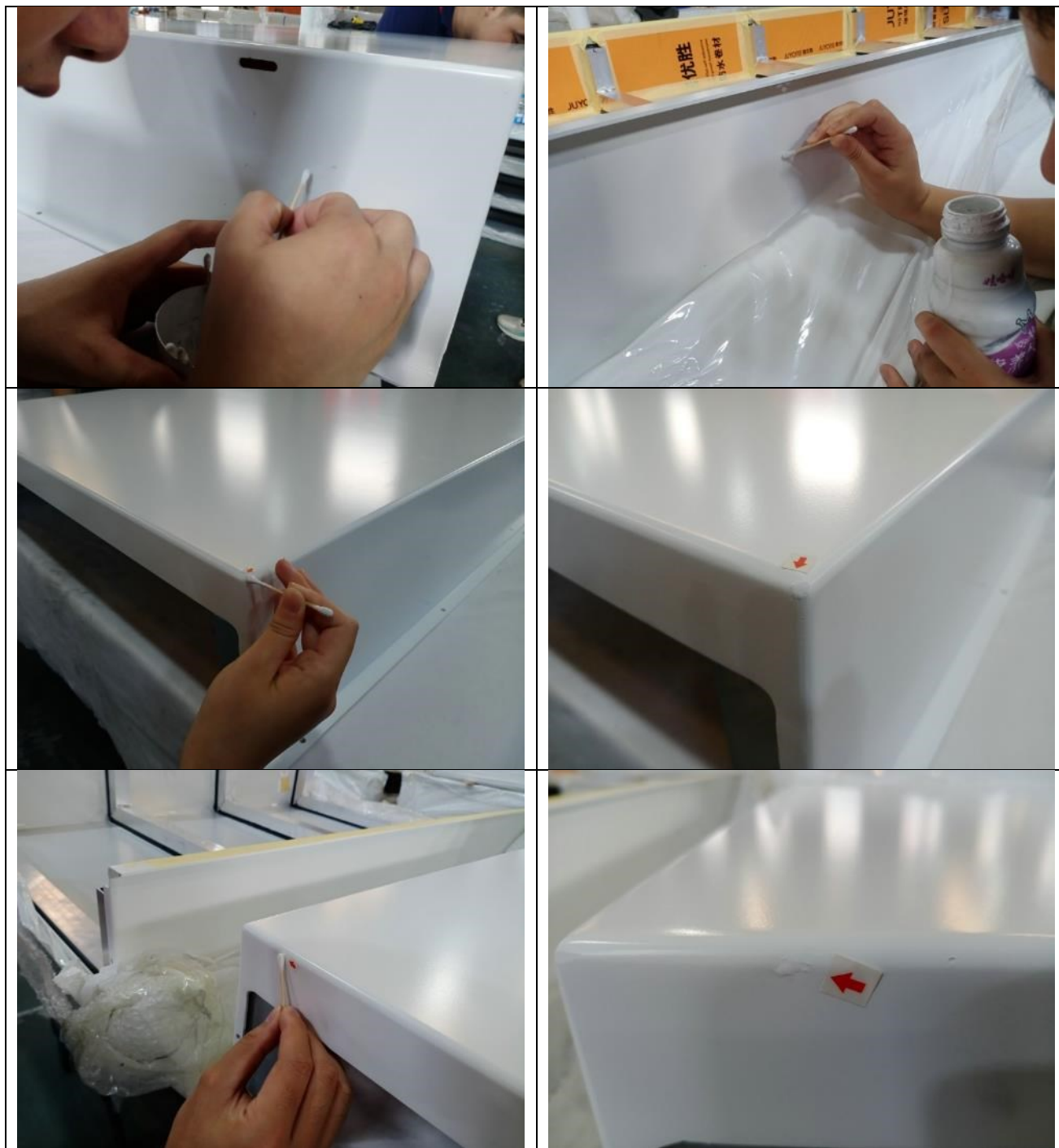


10. Add corner protectors on the four corners of the product to prevent damage to the edges.



11. All product issues discovered on site have been notified to the factory, and for some surface paint issues, the factory has already repaired them on site (please refer to some repair department pictures).





Client's requirements	Comments
1. Material thickness 3 mm	Pass
2. SPC measurement Color coating thickness 40>32 μ m	Pass
3.PVDF3 stamp imprint on the inner part of the boxes	Missing PVDF3 label inside the HP-6 product box
4.Color coating defects – defects that are visible from 1 m away from the box will be considered as major and defects found that cannot be seen from 1 m will be considered as minor. – boxes with major defects will be rejected and need to be fixed prior to shipment.	Failed (Remark2.1&2.2)

5. Clear water passage of the square shaped profiles (drainage)	Pass
6. Visual check of the exterior side of the box to make sure that the welding marks are not visible.	Pass
7. Check that square reinforcements profiles are welded on 3 out of 4 sides.	Pass
8. Structural bonding bite size for reinforcements bite size 8X6 mm	Pending (Unable to measure on site)

Manufacturer Signature	/	AQI Inspector	David	AQI Report Approver	Helen Zhang
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Inspection Method Applied:

Inspection type	Pre-Shipment Inspection					
Inspection Standard	ANSI/ASQ Z1.4 (ISO2859-1)					
Sampling plan	Single, normal					
Inspection level	G – II					
AQL:	Cri.	0	Maj.:	2.5	Min.:	2.5
Sample size inspected	30pcs					
Total number of AVAILABLE cartons:	0					
Quantity for selected cartons	N/A					
Carton # of the selected cartons	N/A					

1. Product Quantity Inspection:

Item No.	Color	Ordered Qty.(Pcs)	Available Qty.(Pcs)	Packed Cartons	Unpacked Cartons	Not finished QTY	Sample Size	
							Pieces	Cartons
HP-1	White	96	96	0	96	0	10	N/A
HP-2	White	72	72	0	72	0	5	N/A
HP-3	White	15	15	0	15	0	2	N/A
HP-4	White	12	12	0	12	0	2	N/A
HP-5	White	23	23	0	23	0	3	N/A
HP-6	White	12	12	0	12	0	2	N/A
HP-7	White	12	12	0	12	0	2	N/A
HP-8	White	24	24	0	24	0	4	N/A
Total		266	266	0	266	0	30	N/A

2. Workmanship Appearance / Function inspection

#	Description	Cri.	Maj.	Min.	Remarks
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HP-1	Black particles on the surface	0	0	3	
	Damaged edges and corners with paint	0	3	0	
HP-2	Damaged edges and corners with paint	0	1	0	
	Damaged edges and corners with paint	0	0	1	
	Spray defects	0	0	2	
HP-6	Some drainage outlets inside are blocked	0	2	0	
	Missing PVDF3 label inside	0	1	0	
HP-7	Damaged edges and corners with paint	0	2	0	
	Multiple scratches on the surface of the topcoat (not visible at 1 meter of the product)	0	0	1	
HP-8	Damaged edges and corners with paint	0	2	0	
Total Defects		0	11	7	Beyond AQL
Maximum allowed Defects		0	2	2	
Sample size		30	30	30	
Pictures of defects					
Item: HP-1					
					
Black particles on the surface-Min		Black particles on the surface-Min			
					
Black particles on the surface-Min		Damaged edges and corners with paint-Maj			

	
Damaged edges and corners with paint-Maj	Damaged edges and corners with paint-Maj
Item:HP-2	
	
Damaged edges and corners with paint-Maj	Spray defects-Min
	
Spray defects-Min	Damaged edges and corners with paint-Min
Item:HP-6	

	
Some drainage outlets inside are blocked-Maj	Some drainage outlets inside are blocked-Maj
	N/a
Missing PVDF3 label inside -Maj	N/a
Item:HP-7	
	
Damaged edges and corners with paint-Maj	Damaged edges and corners with paint-Maj

	
Multiple scratches on the surface of the topcoat (not visible at 1 meter of the product)-Min	
Item:HP-8	
	
Damaged edges and corners with paint-Maj	Damaged edges and corners with paint-Maj

3. Reliability Tests/Special Check Points				
#	Testing Description	Sample Size	Result	Remark
3.1.	Barcode scanning test	S-2	N/A	
	Barcode should be read easily and correctly			
3.2.	Rub test for logo/fabric	S-2	N/A	
	Dry and wet Rub 20times			
3.3.	3M tape testing on coating	S-2	Pass	
	Logo not peel off or fade after testing.			
3.4.	Application check	1 pc/item	N/A	
	Perform real operation on the product			
3.5.	Smell check	All samples	Pass	
	No strong or irritative smell is allowed on the product.			
3.6.	Stability test	S-2	N/A	
	Place unit on a 10° inclined at most unfavorable position, No tip over			
3.7.	Color comparison check	S-2	N/A	
	Check with client's Spec or Pantone, No color deviation			
3.8.	Wobble test	All samples	N/A	
	Place units onto a flat surface, No wobble			

3.9.	Assembly check	S-1	N/A	
	Assemble the unit according to the description. (e.g. user manual or instruction sheet or any packing)			

4. Packing/Packaging Inspection

#	Check Points	Result	Remarks		
4.1.	Packing Method	N/A	Remark 4.1		
4.2.	Packing Quantity	N/A	Remark 4.1		
4.3.	Metal staples on carton	N/A			
4.4.	Polybag with warning clause/Polybag with Air holes	N/A	Sealing	Warning text	Punch holes
			☐ Yes	☐ Yes	☐ Yes
			☒ No	☒ No	☒ None
4.5.	Desiccant	N/A			
4.6.	Tissue paper	N/A			
4.7.	Carton filling has no over-packed, no gap, no crash are allowed	N/A			
4.8.	No found mixed sizes cartons	N/A			
4.9.	If the packaging check conform to client's documents	N/A			
4.10.	Carton size/weight	N/A			

Item#	Qty (Pcs)		Carton size(cm)		Carton weight(Kg)	
	Inner box	Outer carton	Spec	Actual	Spec	Actual
N/A	N/A	N/A	N/A	N/A	N/A	N/A

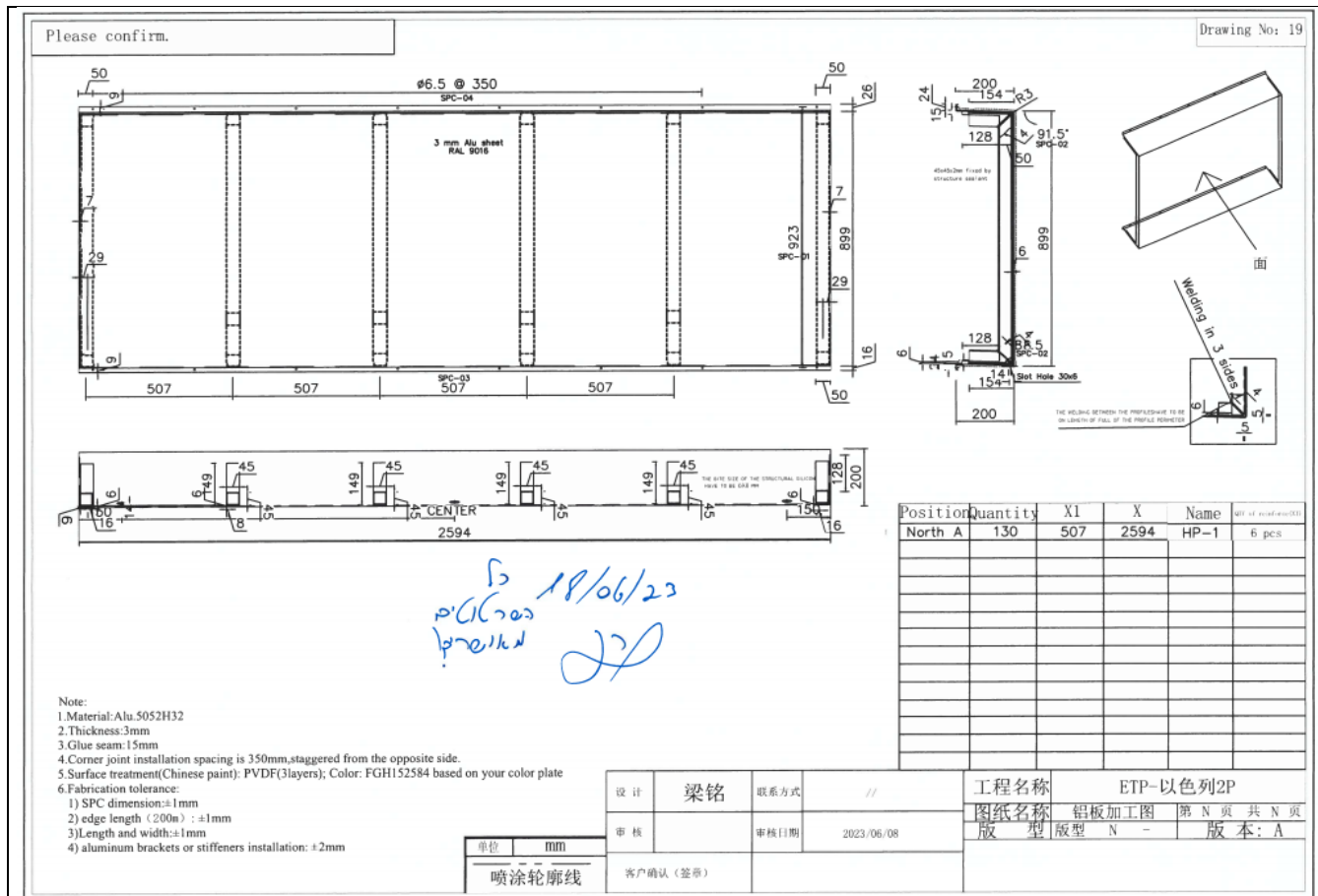
5. Shipping Marks /Label/Marking Inspection

#	Check points	Result	Remarks
5.1	Shipping mark	N/A	Remark 5.1
5.2	Barcode Verification	N/A	Barcode on Shipping package: N/A Barcode on Retail packaging / Product: N/A
5.3	Care/composition label	N/A	
5.4	Country origin label	Pass	
5.5	Poly bag printing / label	N/A	
5.6	Inner box printing / label	N/A	
5.7	Other label or marking	N/A	

6. Product Conformity / Measurement Inspection:

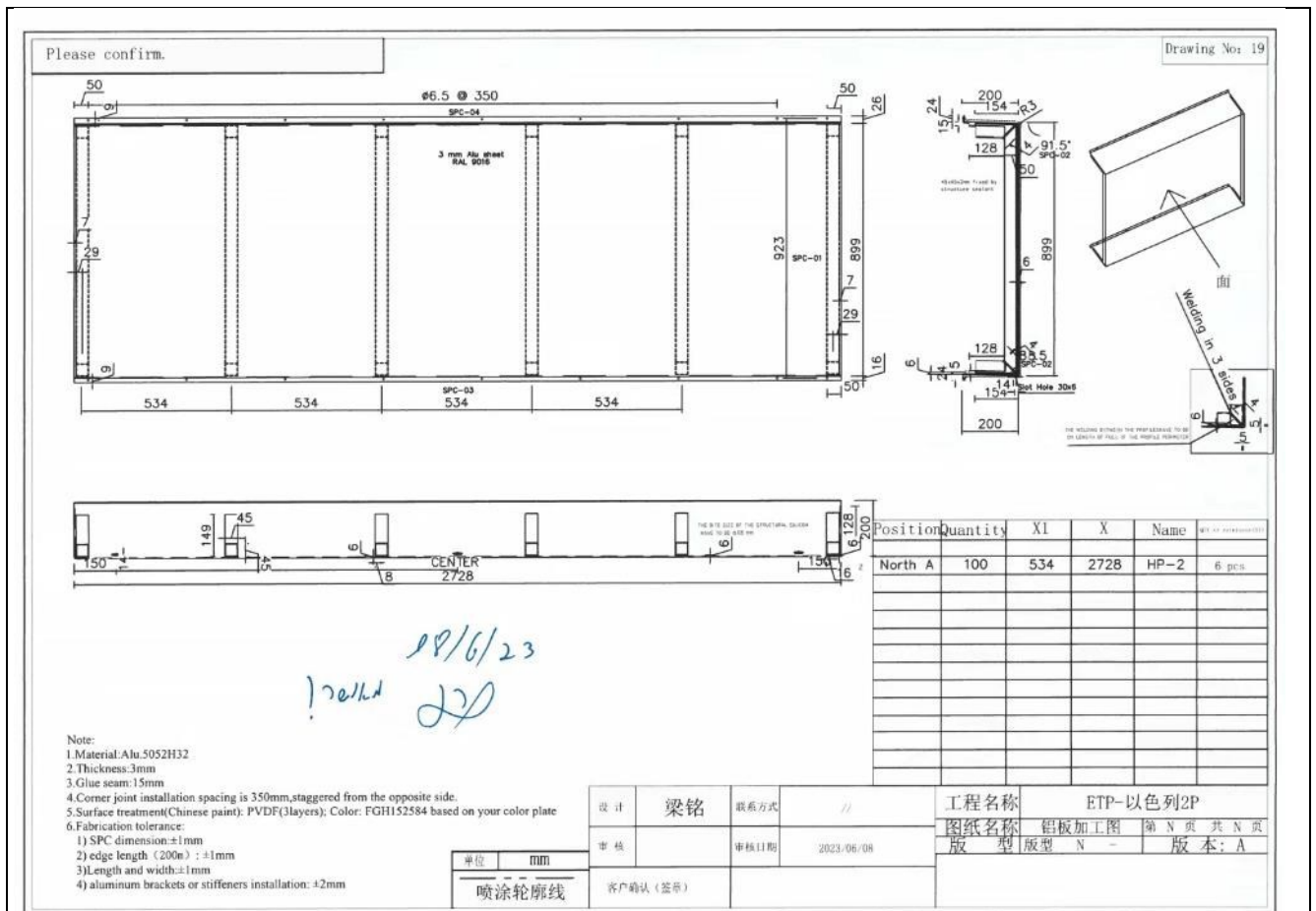
#	Check Points	Result	Remarks
6.1	Product Overview	N/A	
	Requirement:		
6.2	Sample Comparison	Pending	Remark 6.1
	Requirement:		

6.3	Product size/Weight	Pending	Refer to below chart
	Requirement:		
6.4	Other size or measurement	Pass	
	Requirement:		



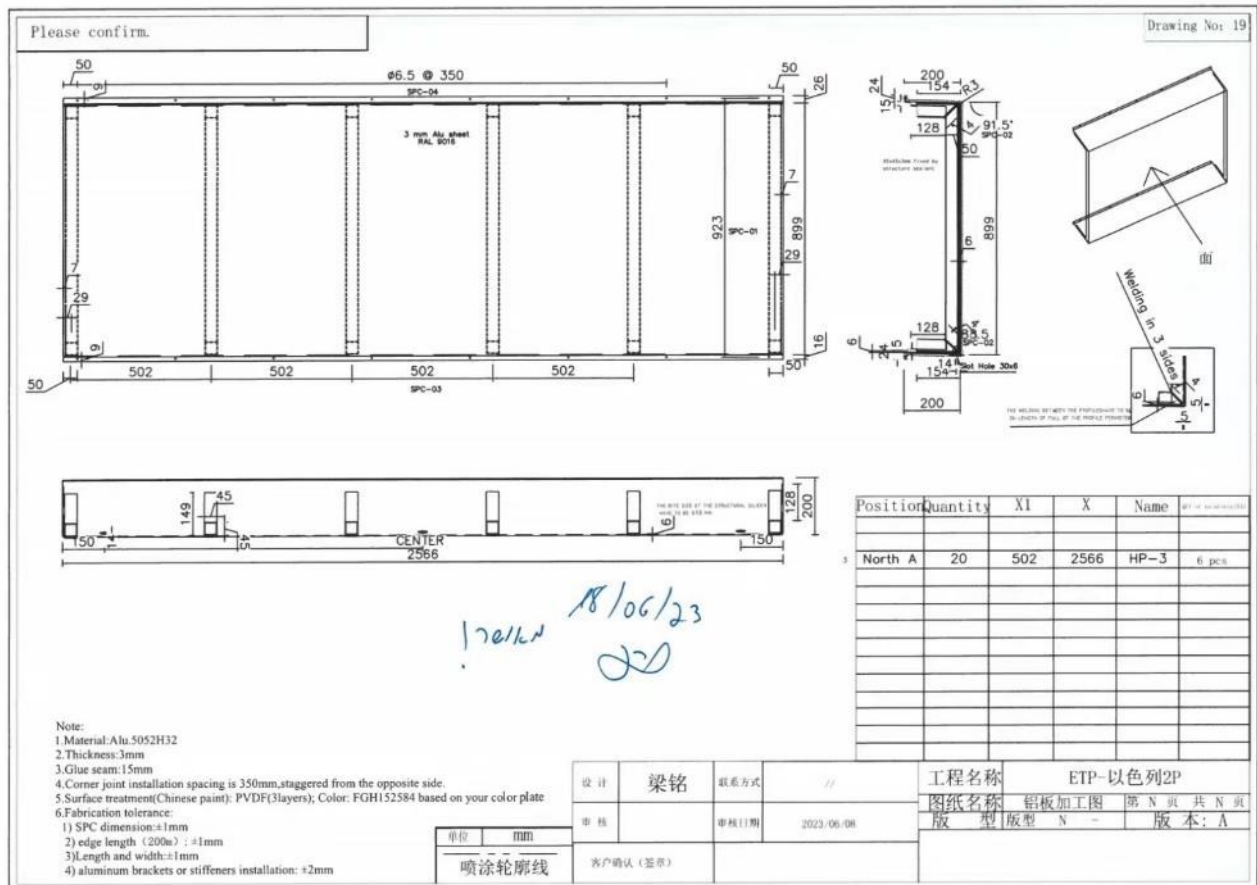
Item	Point	Spec (mm)TOL	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6	Sample 7	Sample 8	Sample 9	Sample 10
HP-1	SPC-1	923 ± 1	923	922	923	922.5	923	923	922	922	923	923
	SPC-2	91.5° ± 0.5	91.48°	91.54°	91.39°	91.45°	91.48°	91.48°	91.54°	91.54°	91.45°	91.39°
	SPC-2	88.5° ± 0.5	89.03°	88.45°	88.3°	88.25°	88.36°	88.48°	88.54°	88.46°	88.36°	89.03°
	SPC-3	507 ± 2	508	507	508	508	507.5	508	507	507	508	507
	SCP-4	350 ± 1	350	350	350	350	350	350	350	350	350	350
	Edge length	200 ± 1	200	200	200	199	200	199	199	200	199	200
	Box length	2594 ± 1	2593	2594	2594	2593	2594	2593	2593	2593	2594	2594
	Box width	899 ± 1	898	899	898	898	898.5	898	899	899	898	898

Client's requirement:



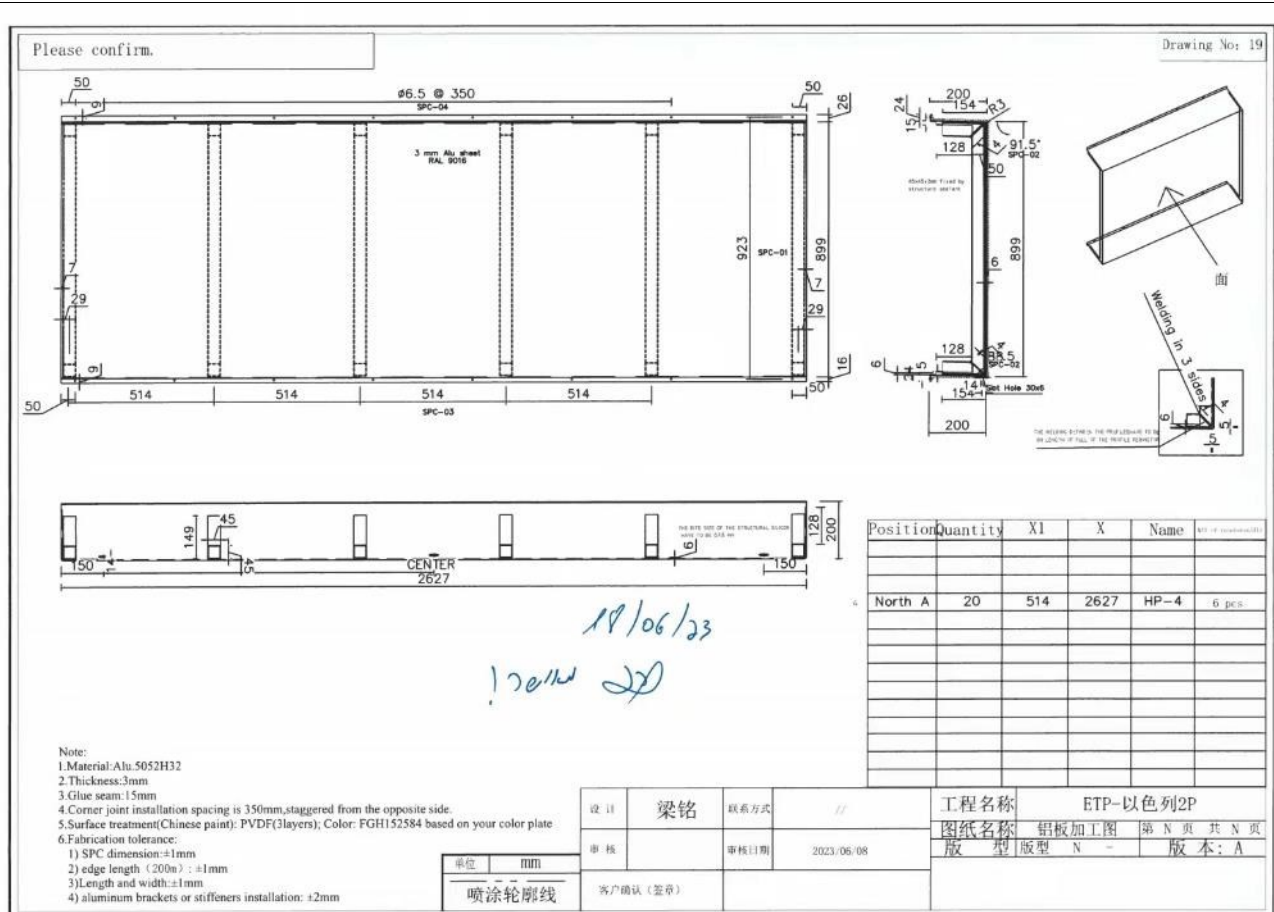
Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6
HP-2	SPC-1	923	+/-1	922	922	923	922.5	922.5	/
	SPC-2	91.5°	+/-0.5	91.39°	91.45°	91.39°	91.48°	91.54°	/
	SPC-2	88.5°	+/-0.5	88.48°	88.54°	88.36°	88.27°	88.48°	/
	SPC-3	534	+/-2	533	534	533	534	534	/
	SPC-4	350	+/-1	350	350	350	350	350	/
	Edge length	200	+/-1	200	200	200	199	200	/
	Box length	2728	+/-1	2727	2727	2728	2727.5	2728	/
	Box width	899	+/-1	898	898	899	898	899	/

Client's requirement:



Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3
HP-3	SPC-1	923	+/-1	923	922	/
	SPC-2	91.5°	+/-0.5	91.03°	91.39°	/
	SPC-2	88.5°	+/-0.5	88.3°	88.45°	/
	SPC-3	502	+/-2	502	501	/
	SPC-4	350	+/-1	350	350	/
	Edge length	200	+/-1	200	200	/
	Box length	2566	+/-1	2565	2566	/
	Box width	899	+/-1	898	899	/

Client's requirement:

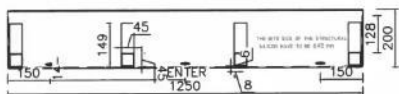
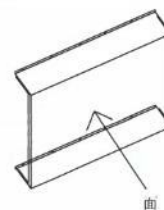
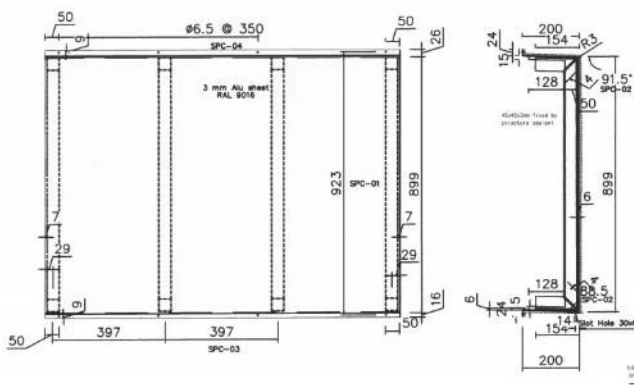


Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3
HP-4	SPC-1	923	+/-1	924	923	/
	SPC-2	91.5°	+/-0.5	91.54°	91.48°	/
	SPC-2	88.5°	+/-0.5	88.54°	88.36°	/
	SPC-3	514	+/-2	513	514	/
	SPC-4	350	+/-1	350	350	/
	Edge length	200	+/-1	200	200	/
	Box length	2627	+/-1	2627	2626	/
	Box width	899	+/-1	898	899	/

Client's requirement:

Please confirm.

Drawing No: 19



18/06/23

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Note:

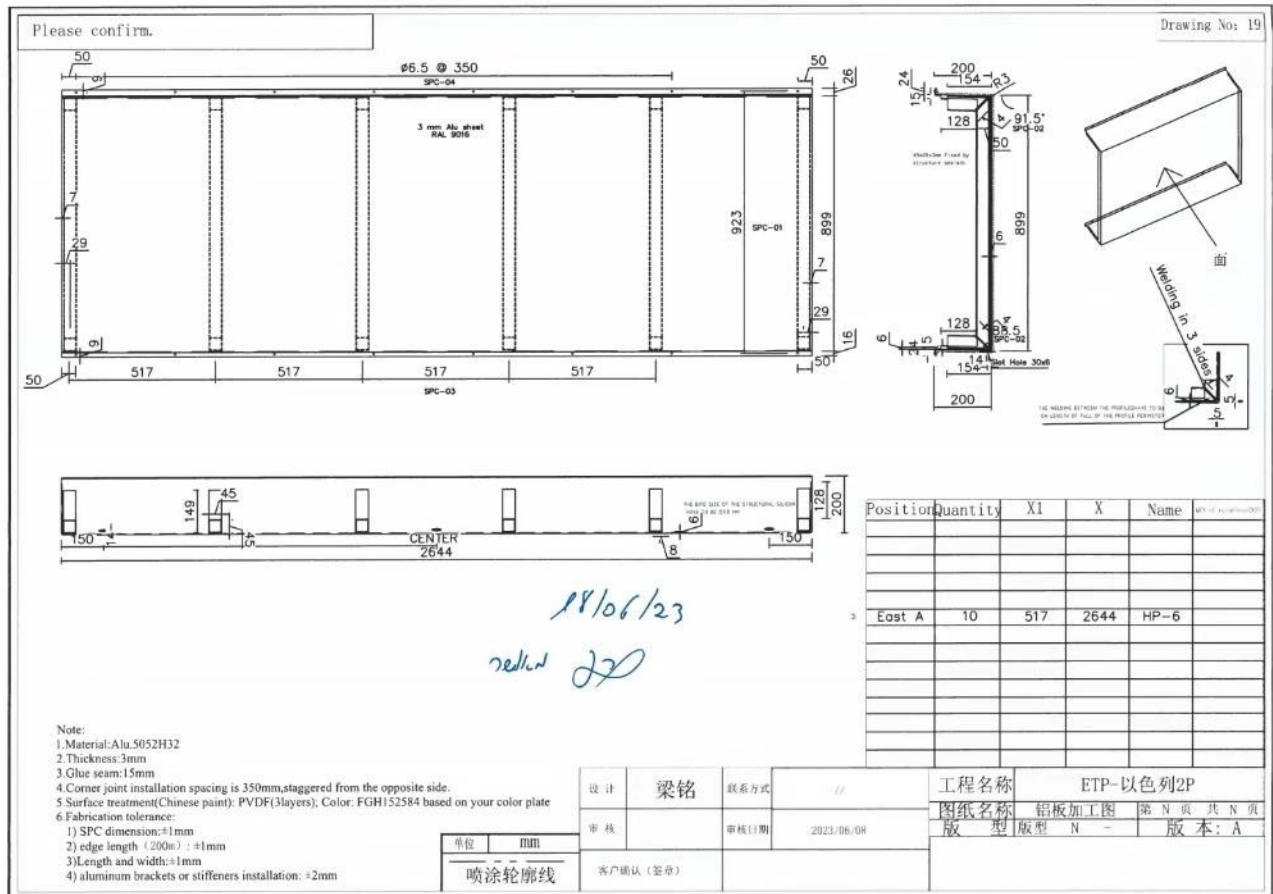
1. Material: AU. S052H3;
2. Thickness: 3mm
3. Glue seam: 15mm
4. Corner joint installation spacing is 350mm, staggered from the opposite side.
5. Surface treatment (Chinese paint): PVDF (3layers). Color: FGH15-2584 based on your color plate
6. Fabrication tolerance:
1) SPC dimension: ± 1 mm
2) edge length (200): ± 1 mm
3) length and width: ± 1 mm
4) aluminum brackets or stiffeners installation: ± 2 mm

设计	梁铭	联系方式	///
审核		审核日期	2023/06/08
客户确认（签章）			

工程名称	ETP-以色列2P		
图纸名称	铝板加工图	第 N 页	共 N 页
版 型	版型 N -	版 本: A	

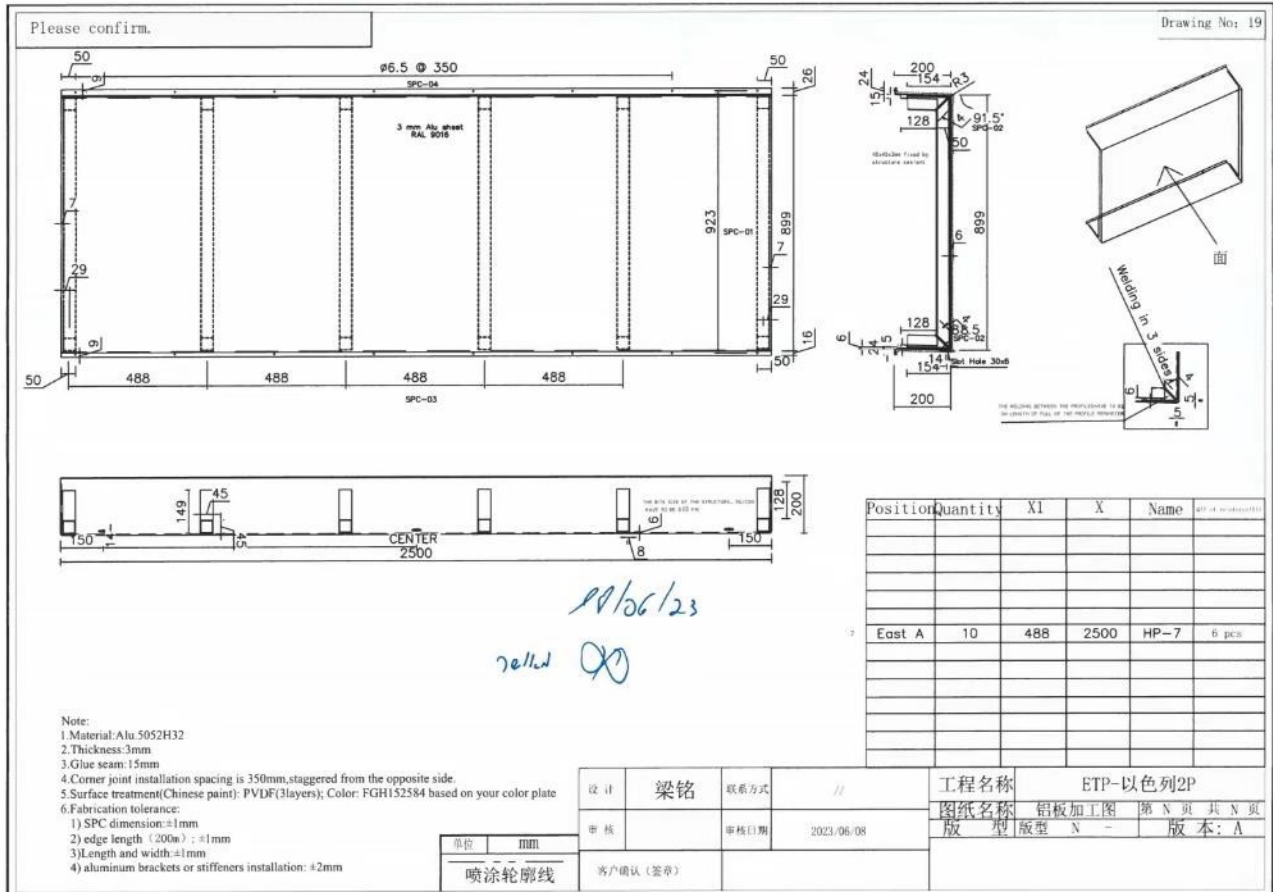
HP-5

Client's requirement:



Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3
HP-6	SPC-1	923	+/-1	923.5	924	/
	SPC-2	91.5°	+/-0.5	91.45°	91.39°	/
	SPC-2	88.5°	+/-0.5	88.27°	88.36°	/
	SPC-3	517	+/-2	516.5	517	/
	SPC-4	350	+/-1	350	350	/
	Edge length	200	+/-1	200	200	/
	Box length	2644	+/-1	2642.5	2644	/
	Box width	899	+/-1	898	87.5	/

Client's requirement:



Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3
HP-7	SPC-1	923	+/-1	922	922	/
	SPC-2	91.5°	+/-0.5	91.48°	91.45°	/
	SPC-2	88.5°	+/-0.5	88.36°	88.48°	/
	SPC-3	488	+/-2	488	487	/
	SPC-4	350	+/-1	350	350	/
	Edge length	200	+/-1	200	200	/
	Box length	2500	+/-1	2499	2500	/
	Box width	899	+/-1	898	899	/

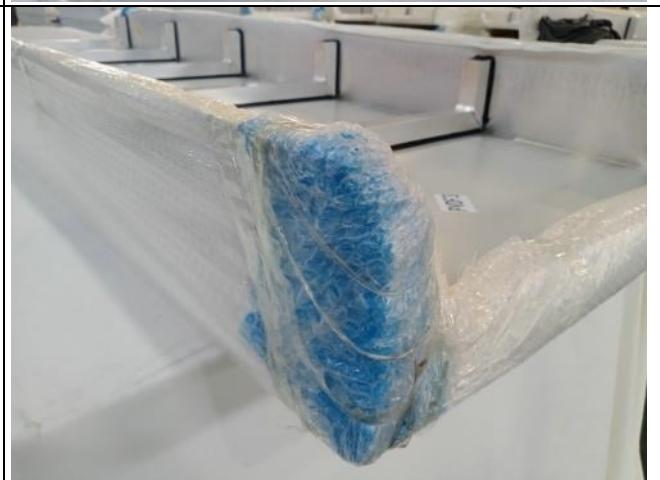
Client's requirement:

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Item	Point	Spec (mm)TOL		Sample 1	Sample 2	Sample 3	Sample 4
HP-8	SPC-1	923	+/-1	923	922	922	923
	SPC-2	91.5°	+/-0.5	91.48°	91.54°	92°	91.39°
	SPC-2	88.5°	+/-0.5	88.36°	88.48°	88.27°	88.36°
	SPC-3	384	+/-2	384	383	384	384
	SPC-4	350	+/-1	350	350	350	350
	Edge length	200	+/-1	200	199	199	898
	Box length	1209	+/-1	1209	1208	1209	1209
	Box width	899	+/-1	898	899	898	898

Pictures for packing, shipping marks and product checking

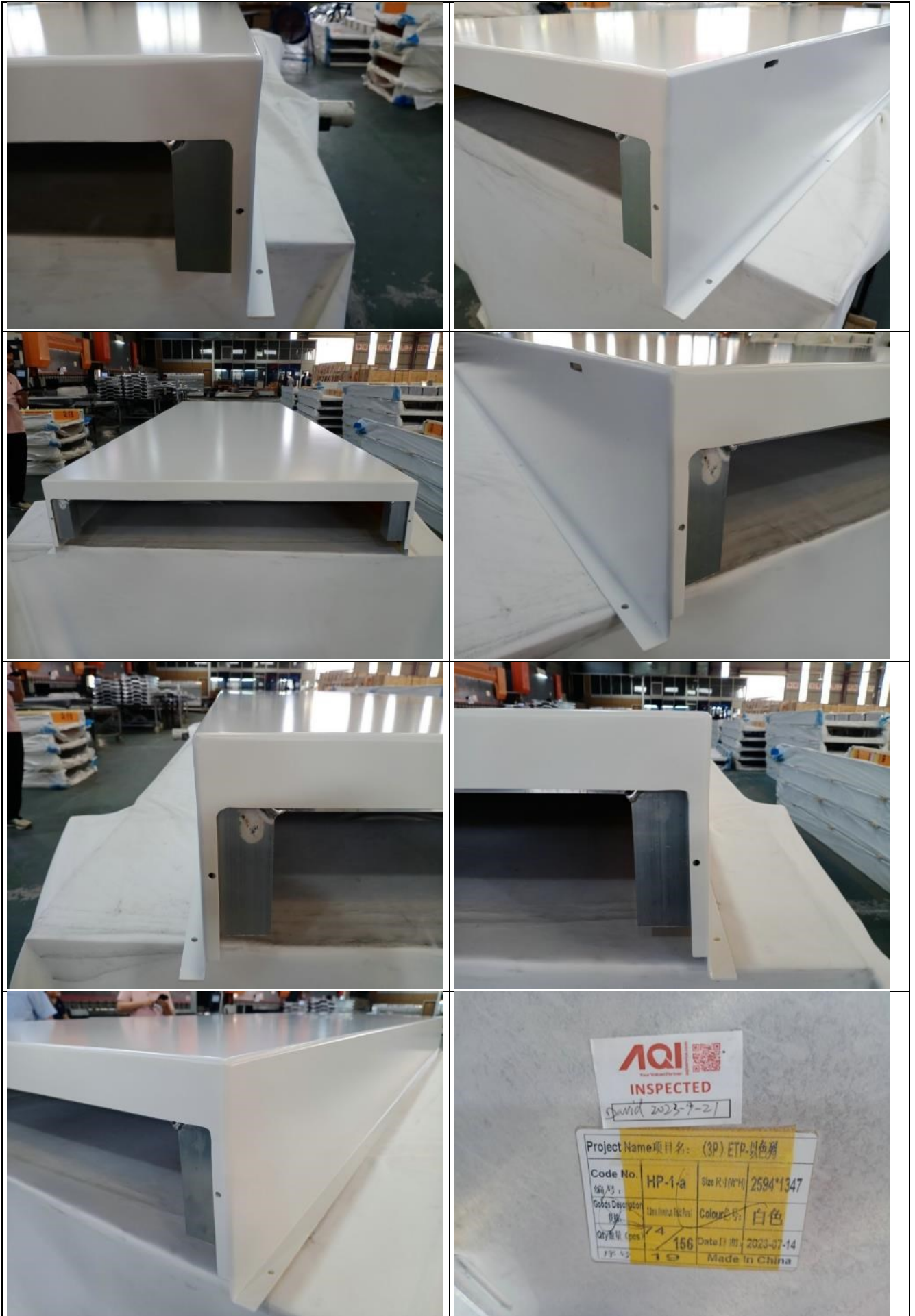
Item:HP-1

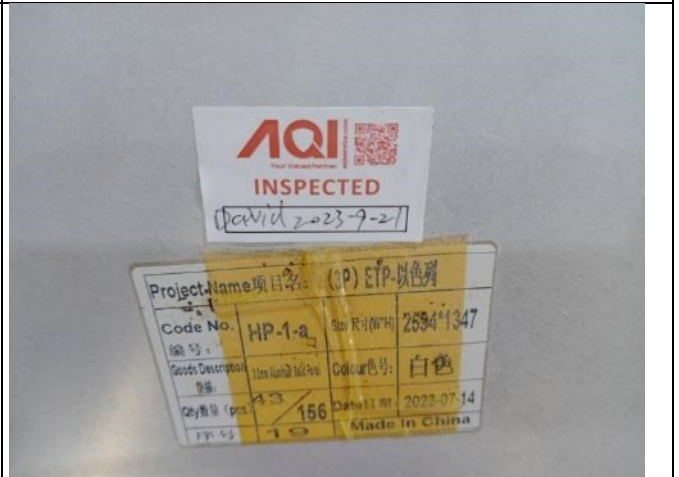




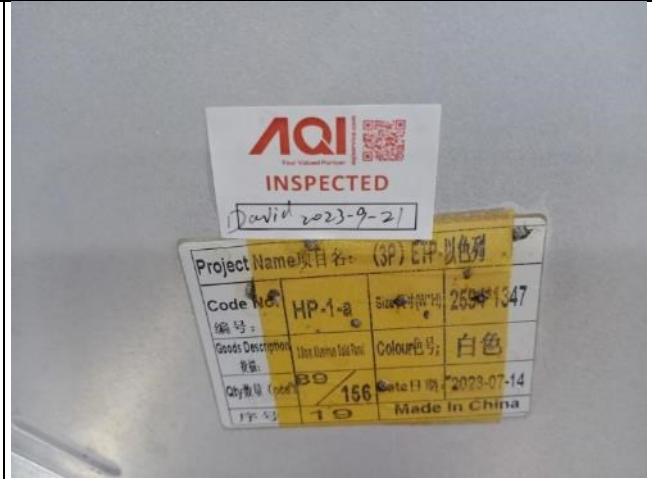






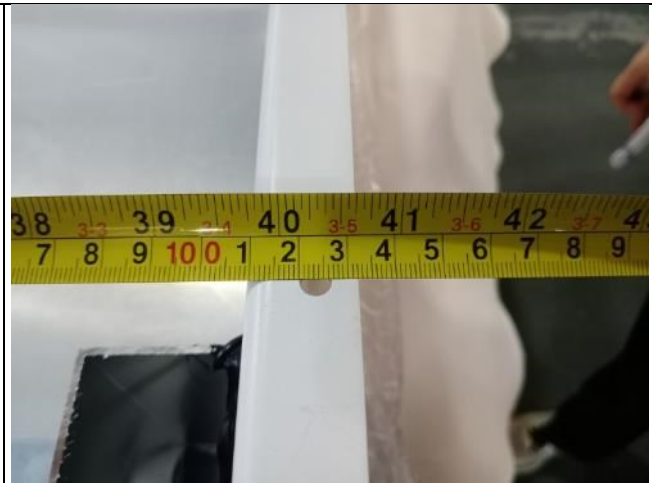
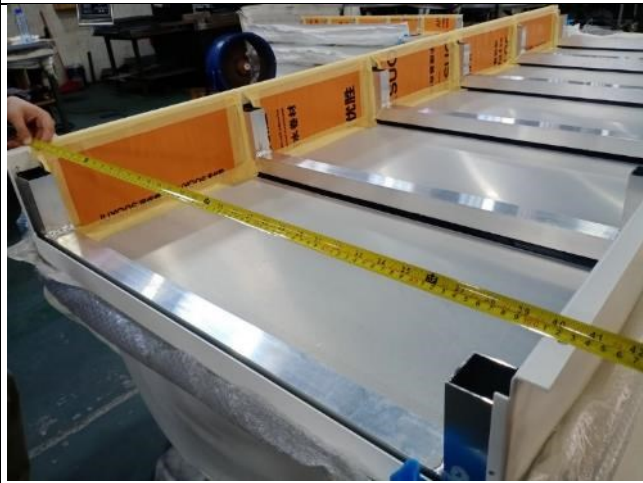






Spec check

SPC1: $1023 - 100 = 923\text{mm}$



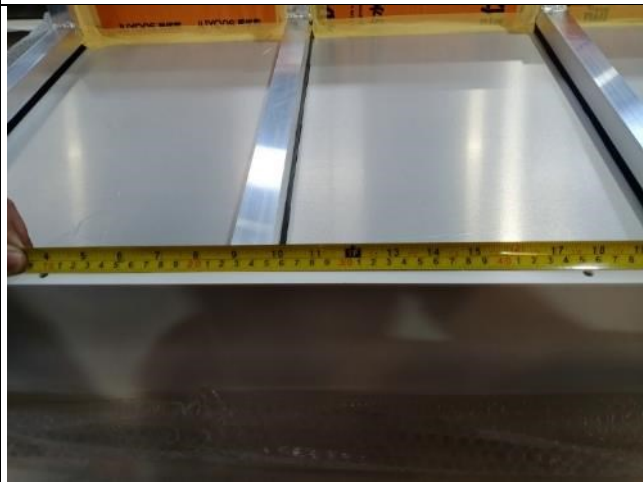
SPC 2: 89.03° , 91.48°



SPC 3: (reinforcement width) 508mm



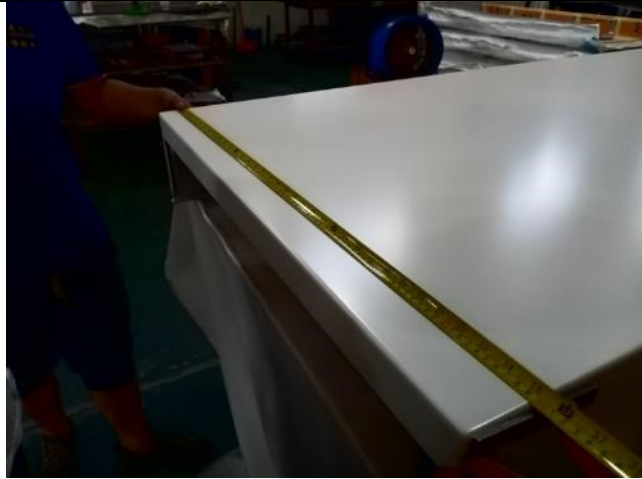
SPC 4: 450 - 10(Holes width) =350 mm



Box length: 2593mm



Box width: 898 mm



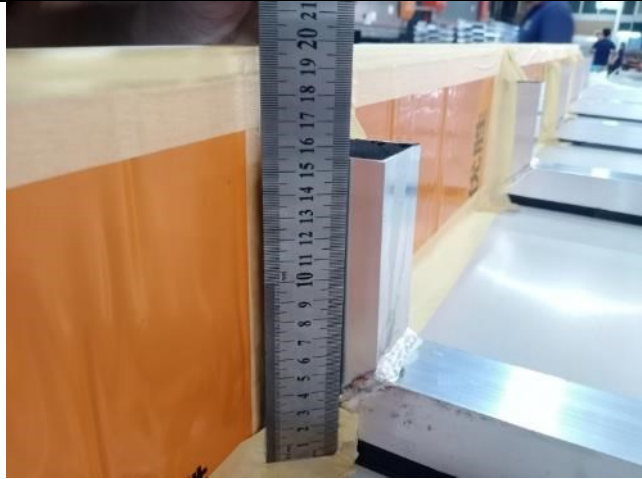
Edge length: 200mm



Hole width: 6.47mm



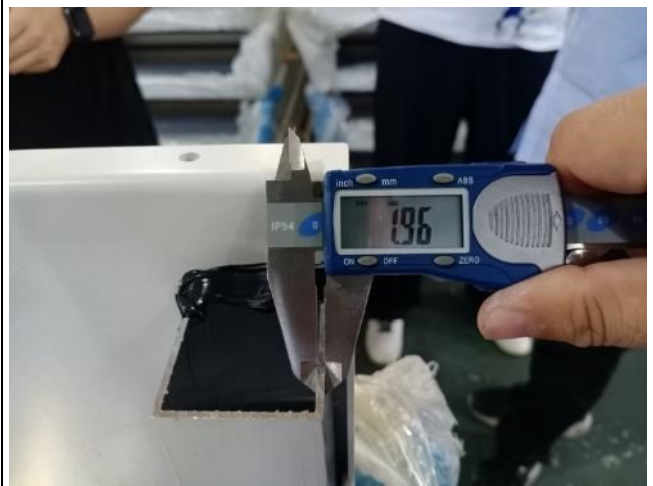
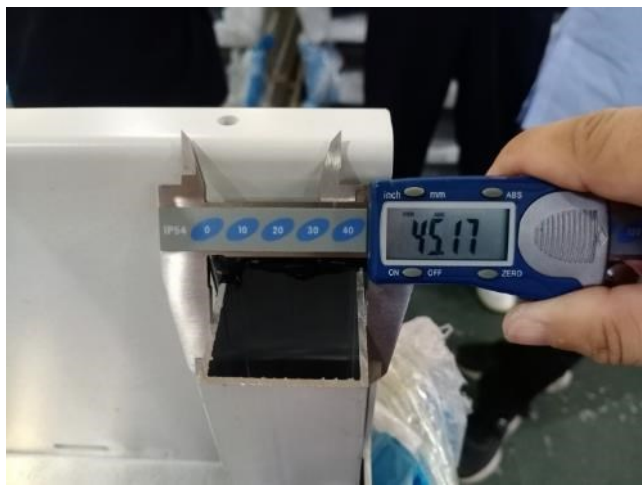
Reinforcement height:(glue tape height) = 155 mm



Reinforcement width: 45.17 mm



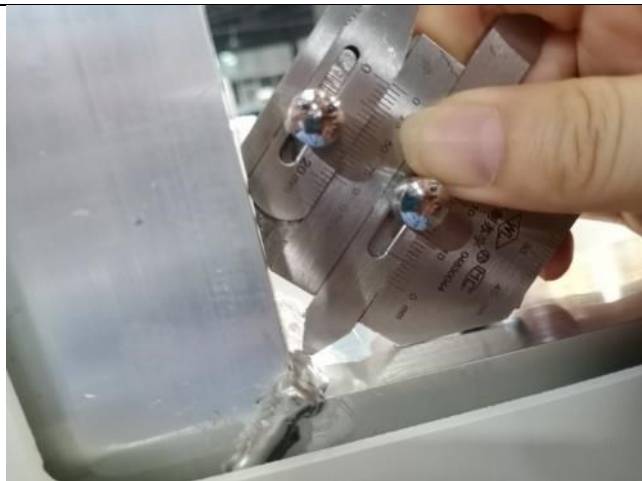
Reinforcement Thickness: 1.96mm



Reinforcement interface size: 5mm * 5mm

All installations are completed and cannot be measured on site.

Thickness of reinforcement welding point: 4mm-5mm

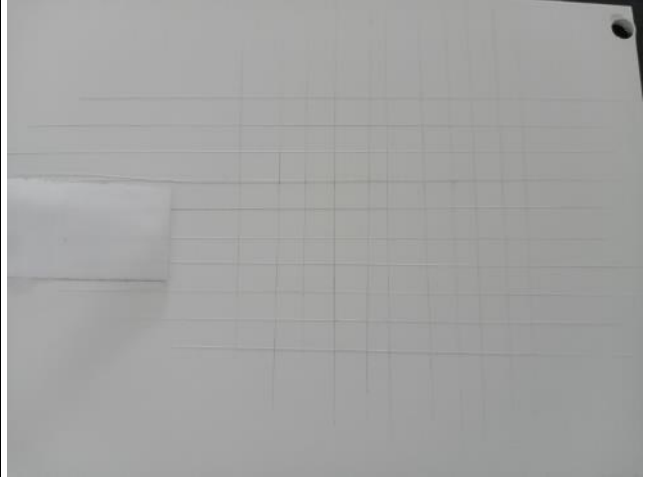
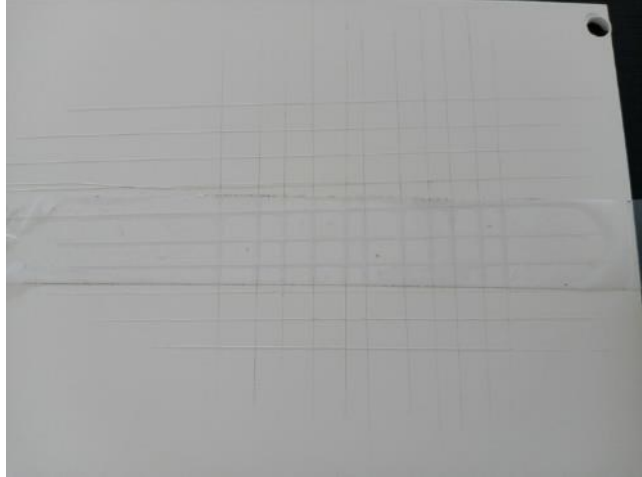




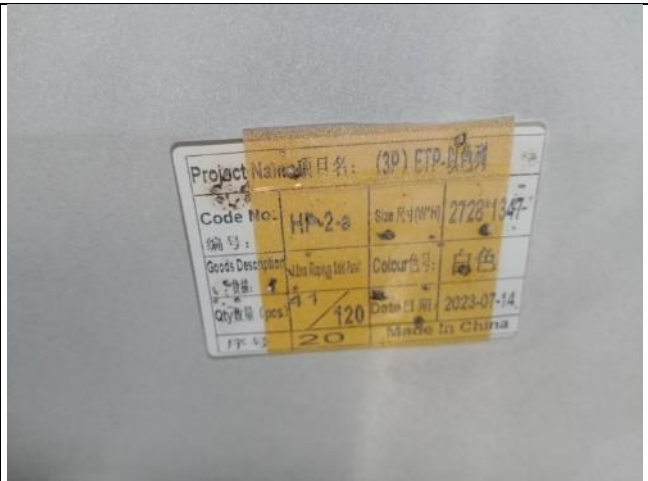
Color coating thickness: average $253.9 / 5 = 50.78 \mu\text{m}$



3M tape testing

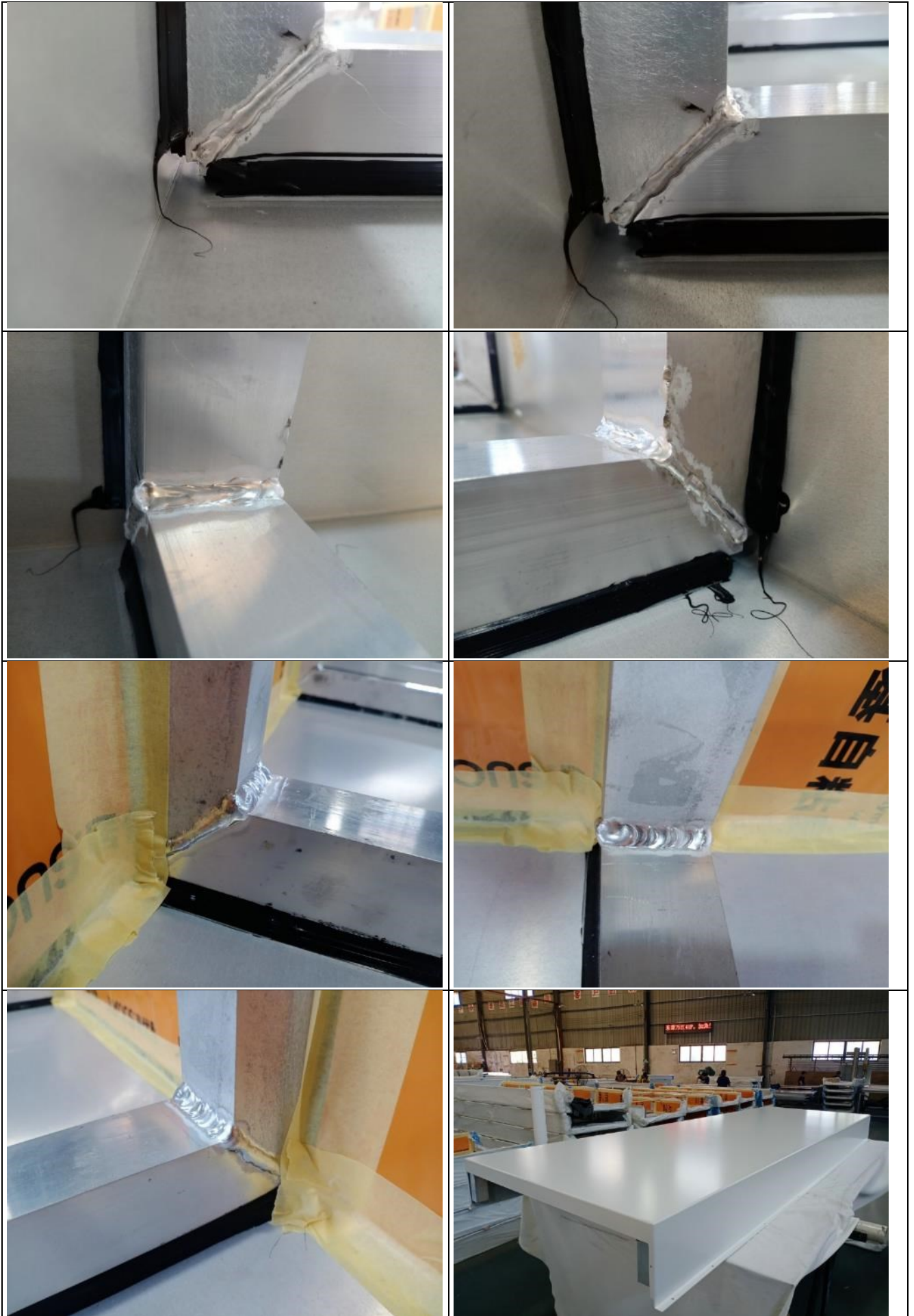


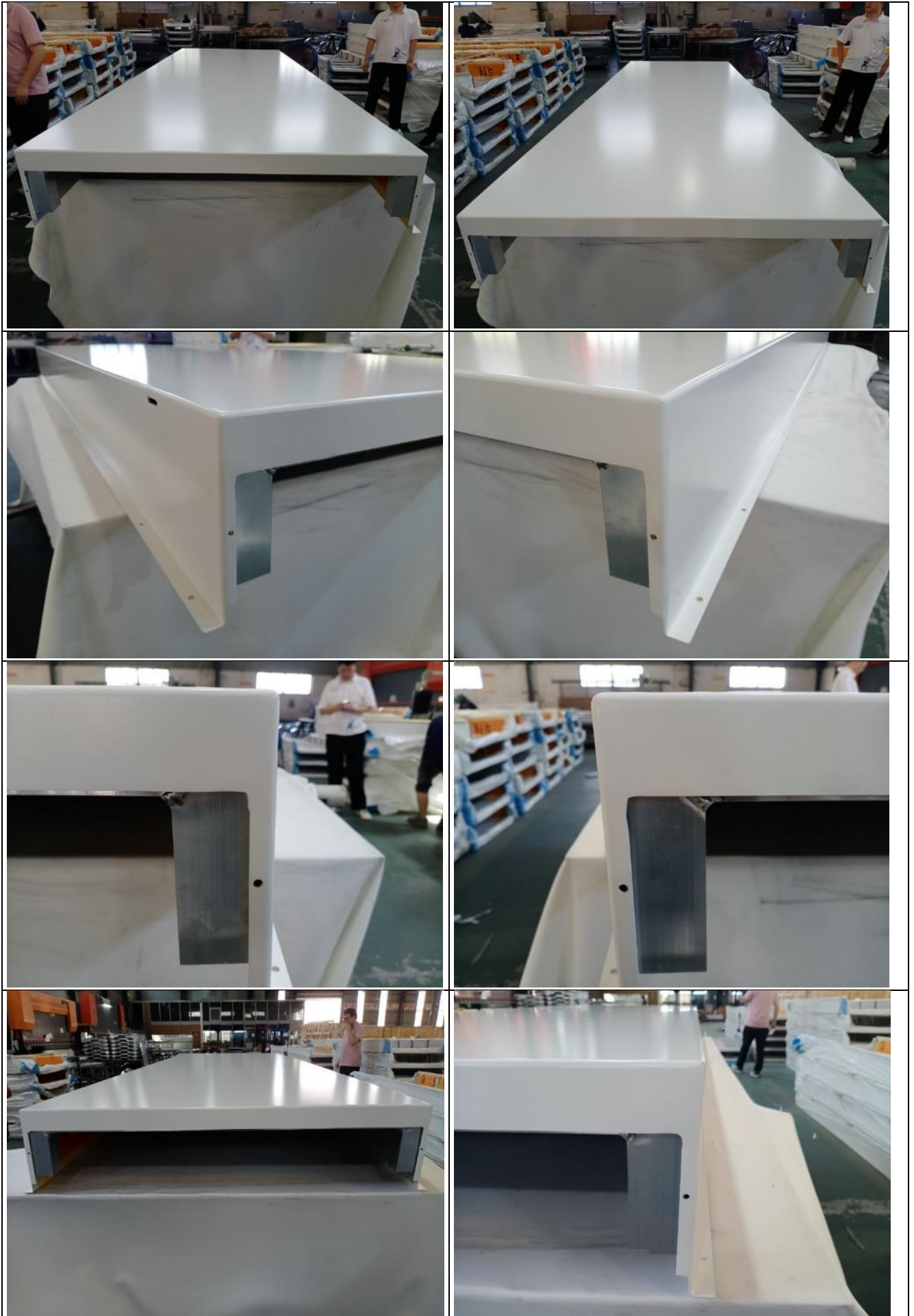
Item: HP-2

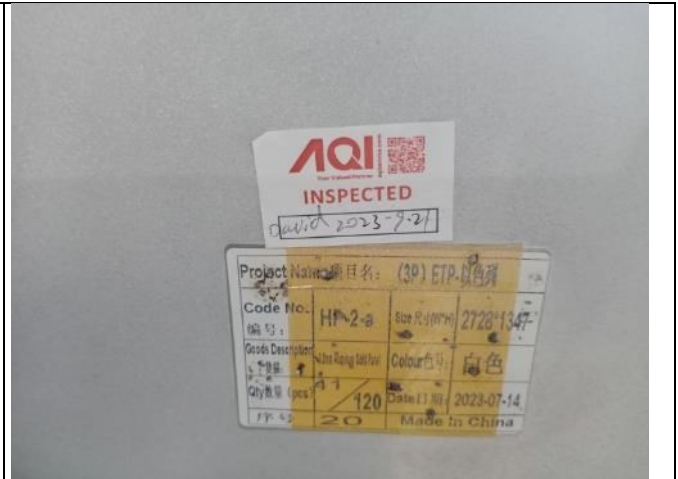
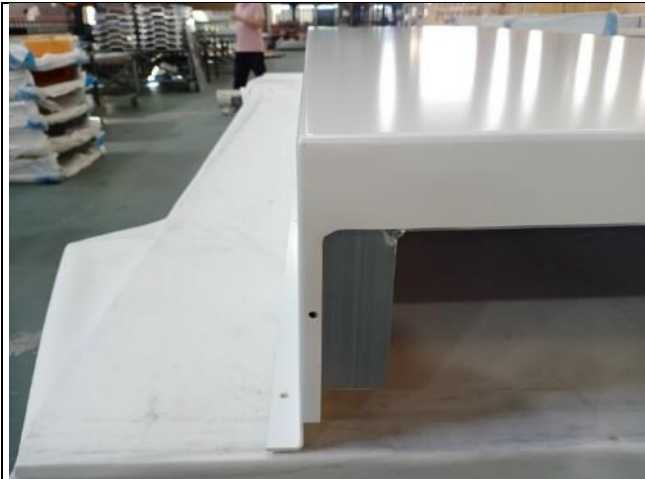


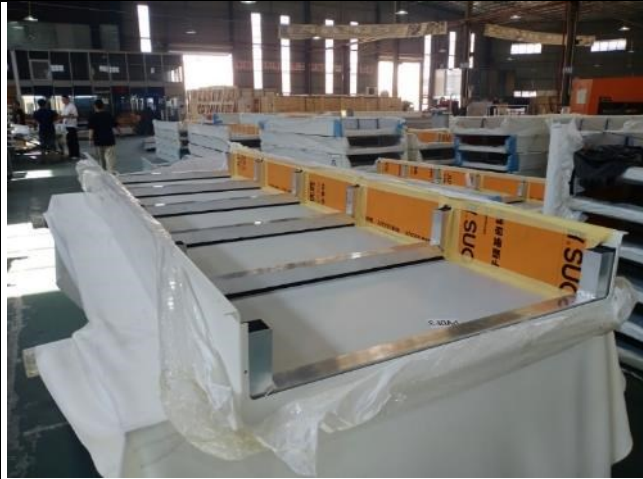










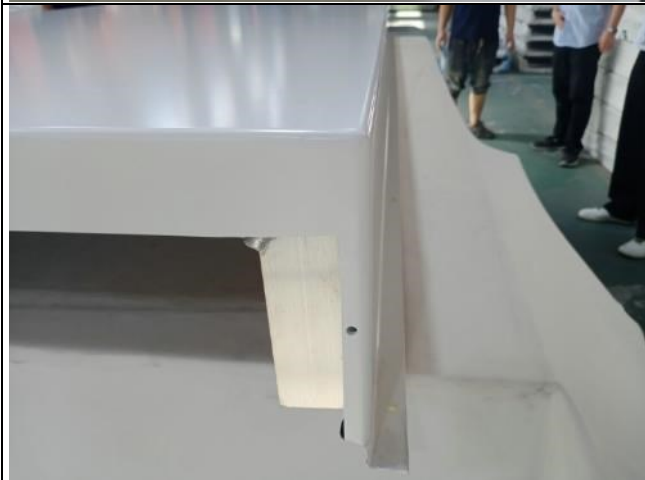
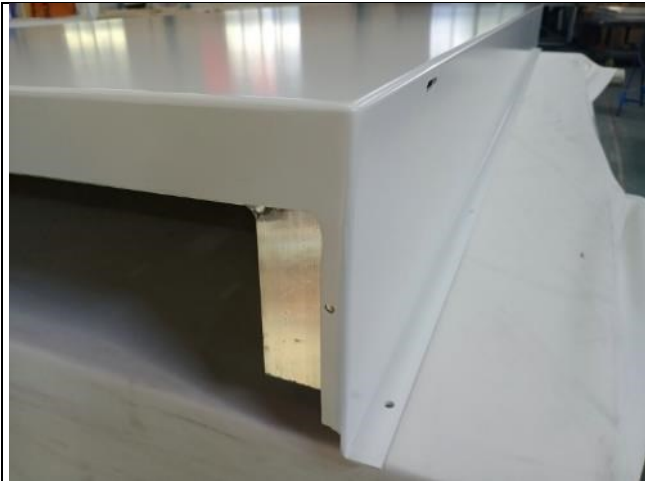


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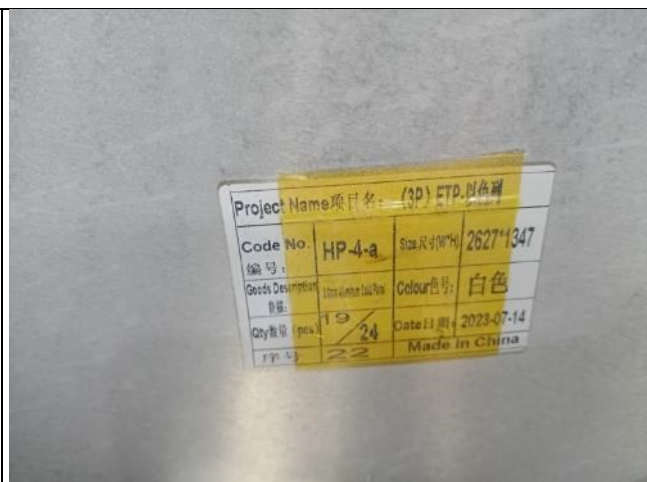


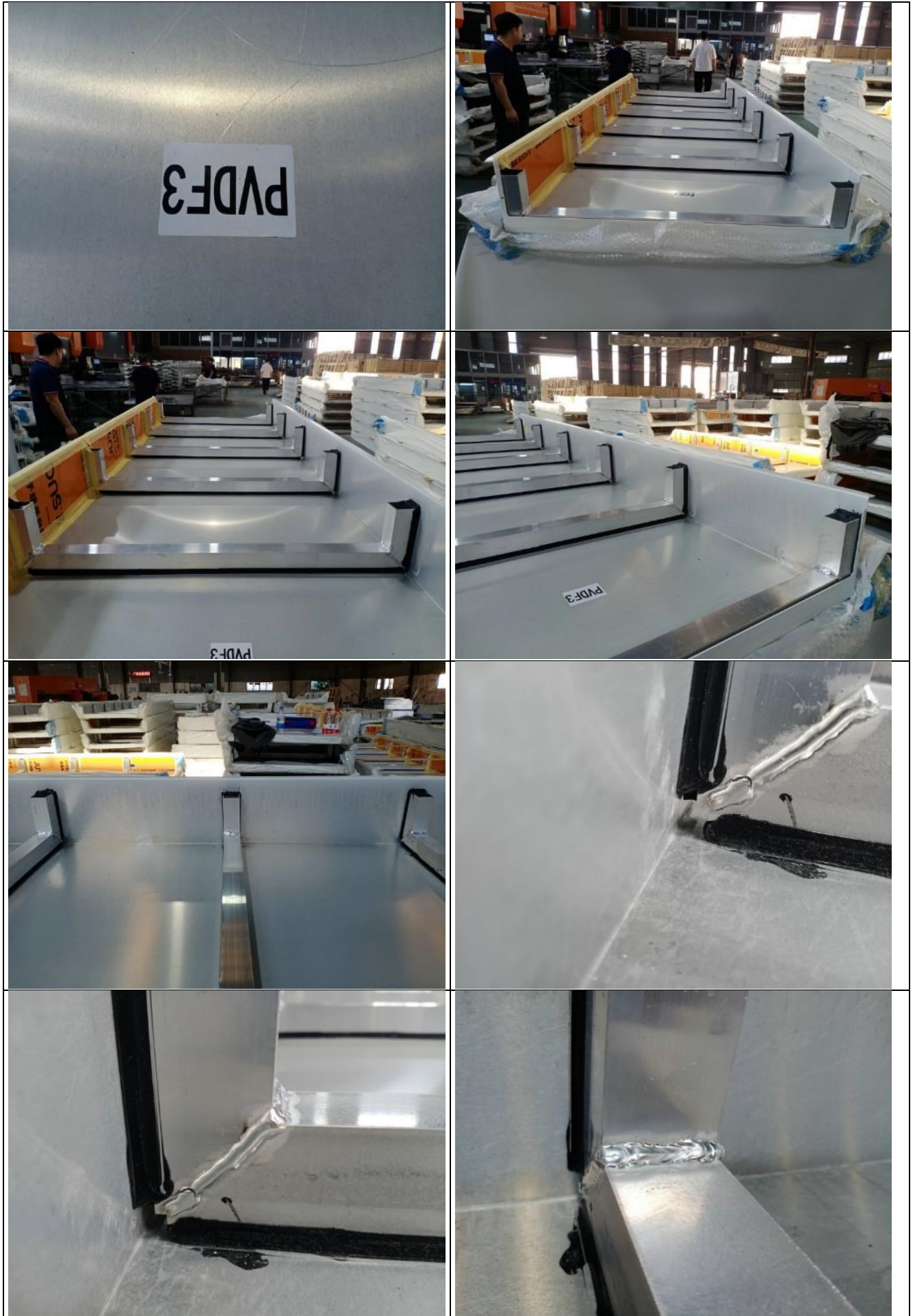






Item: HP-4





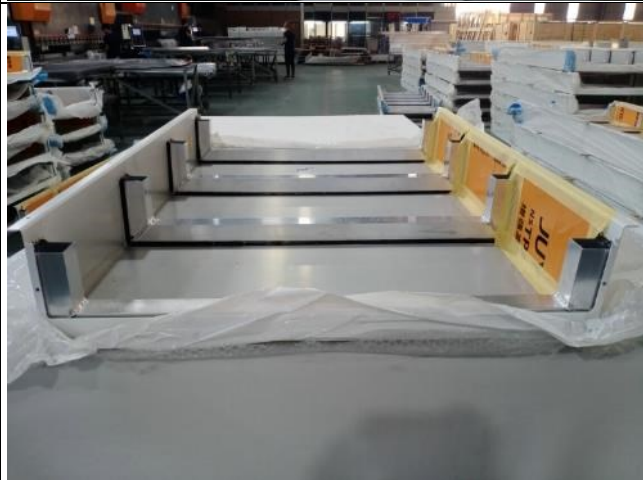
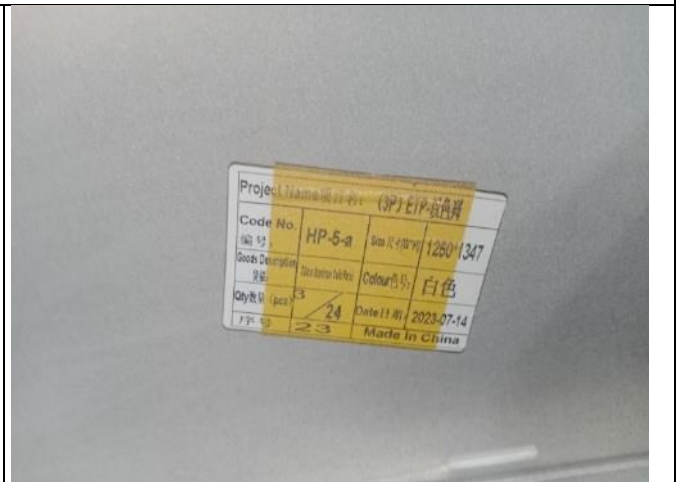


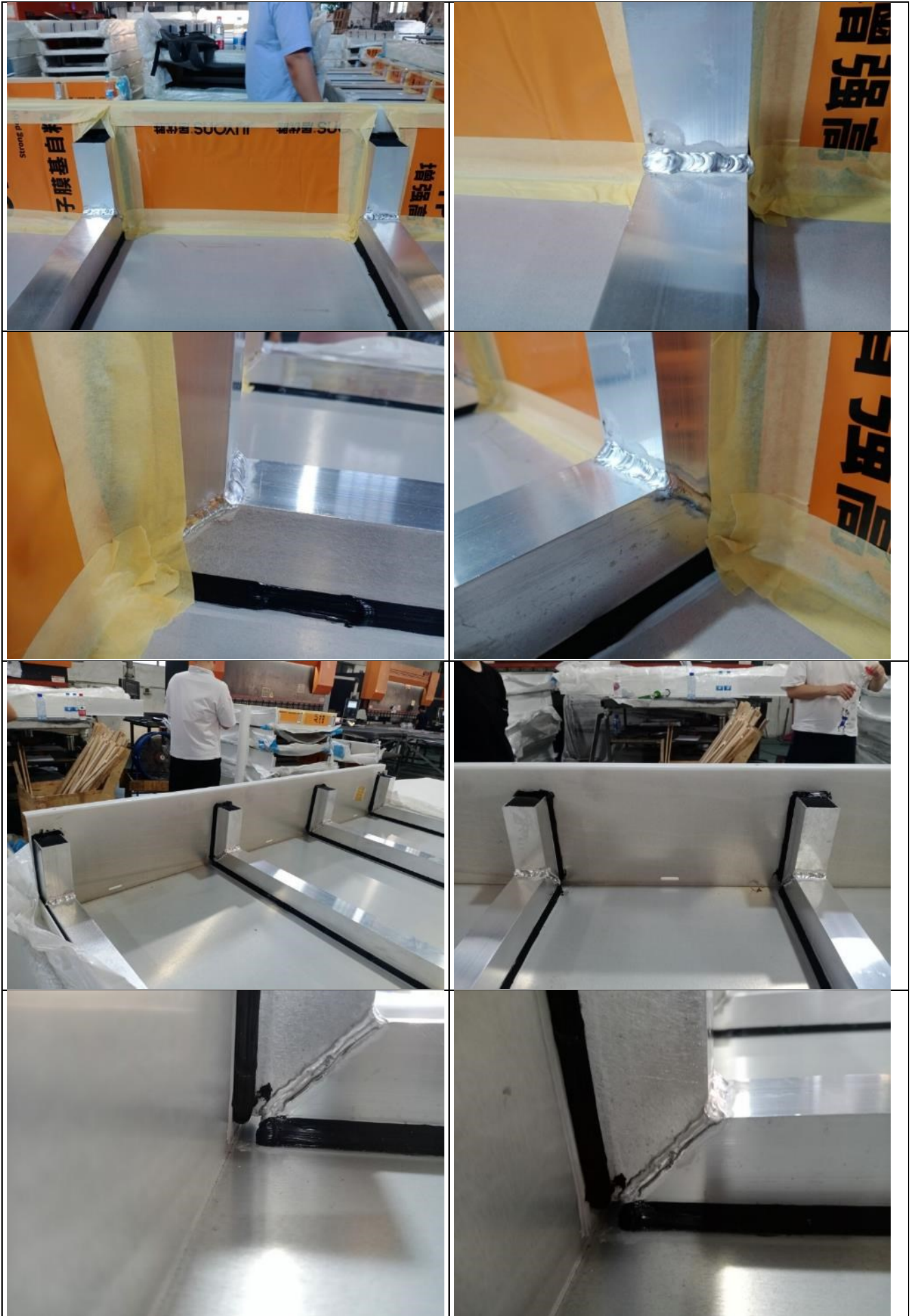


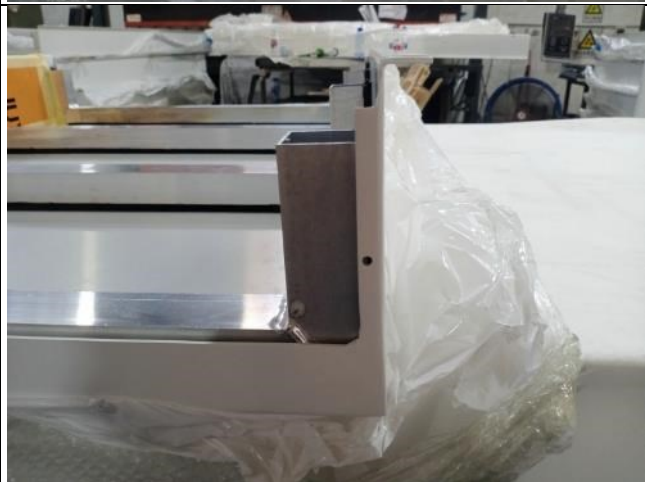


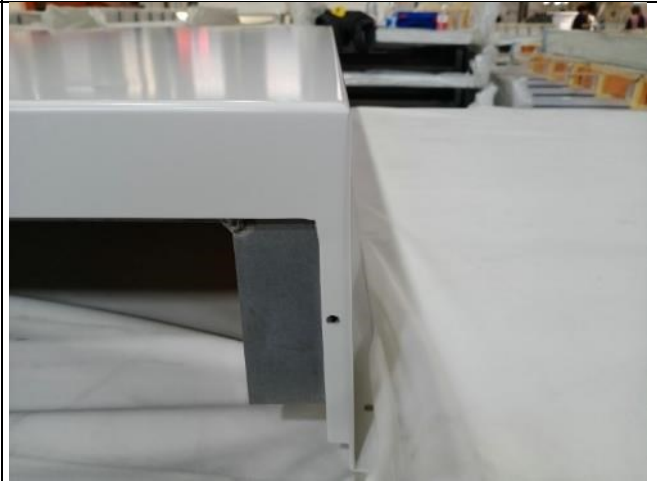
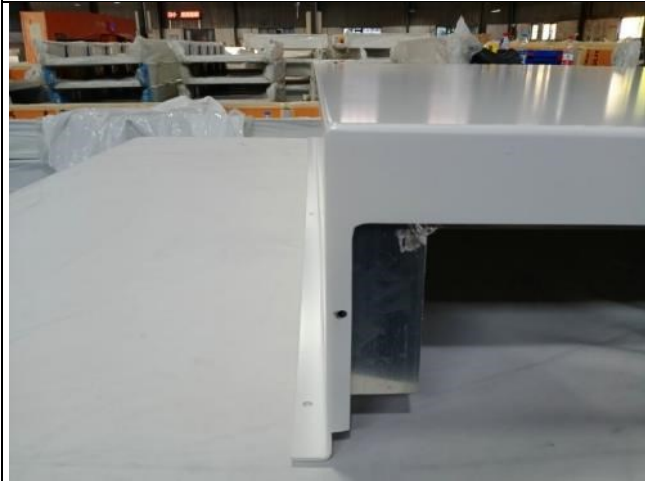
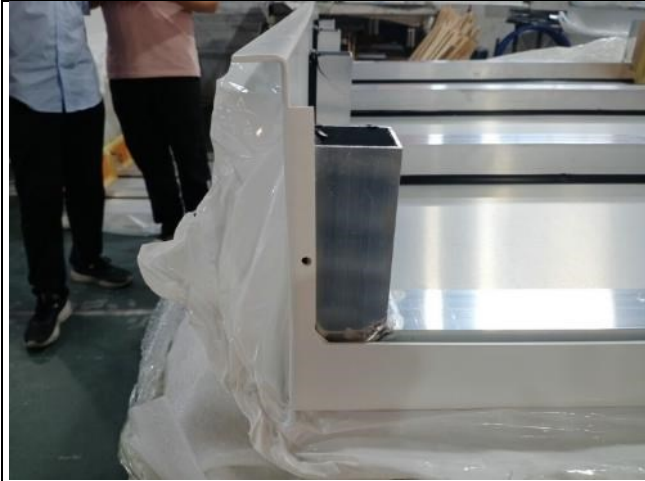


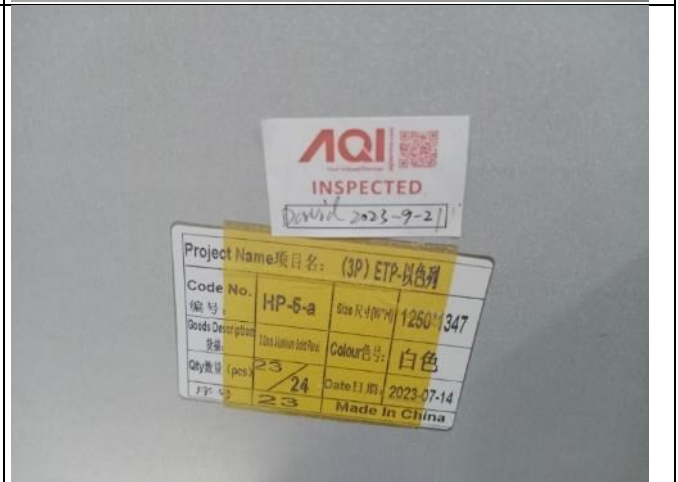
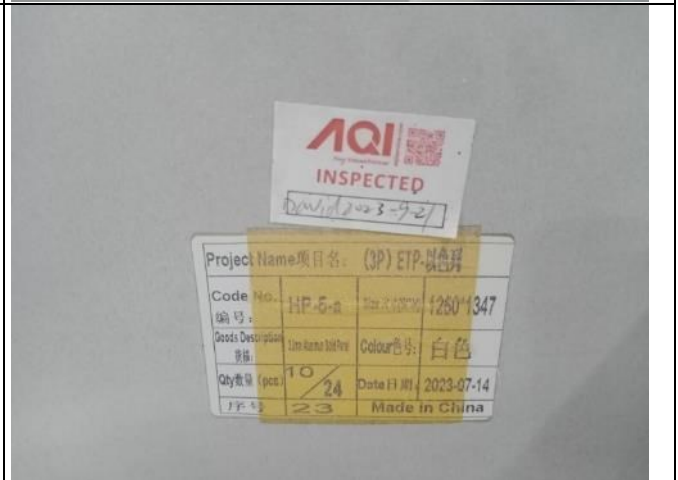
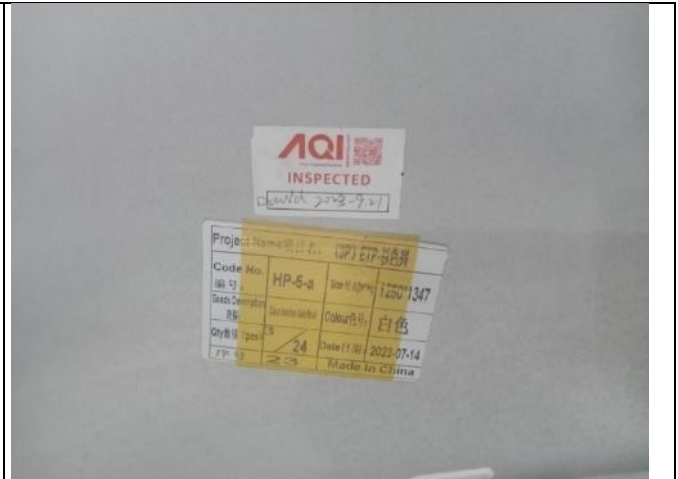
Item: HP-5



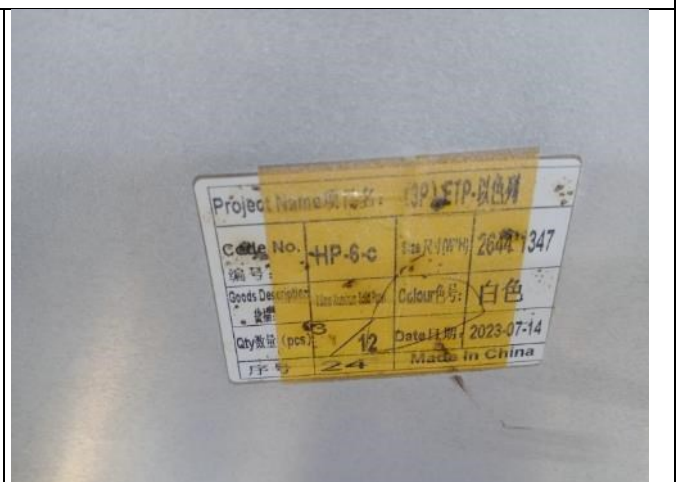








Item: HP-6





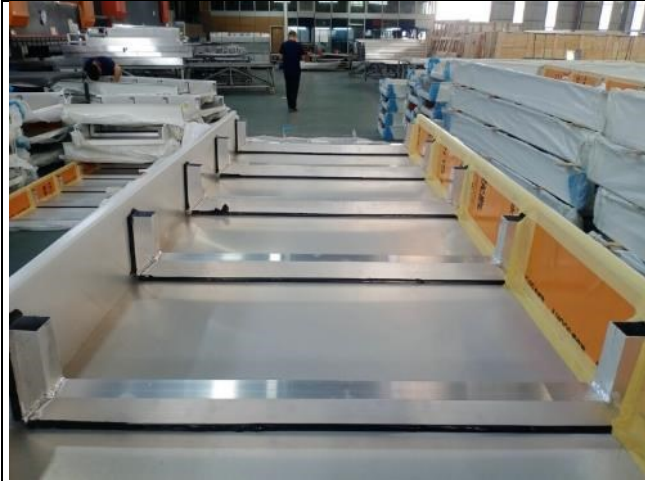


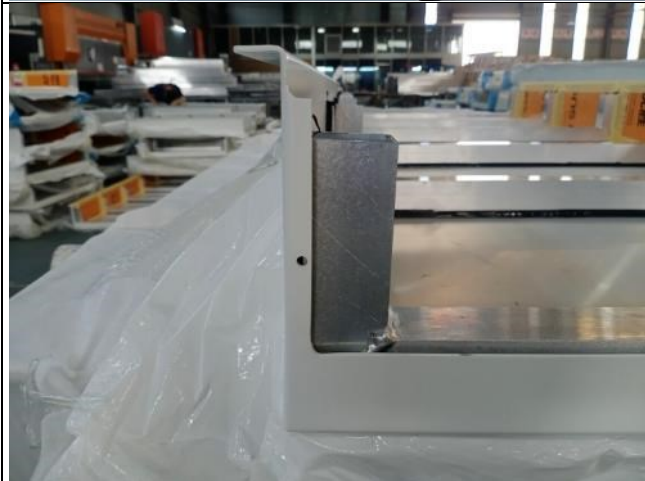


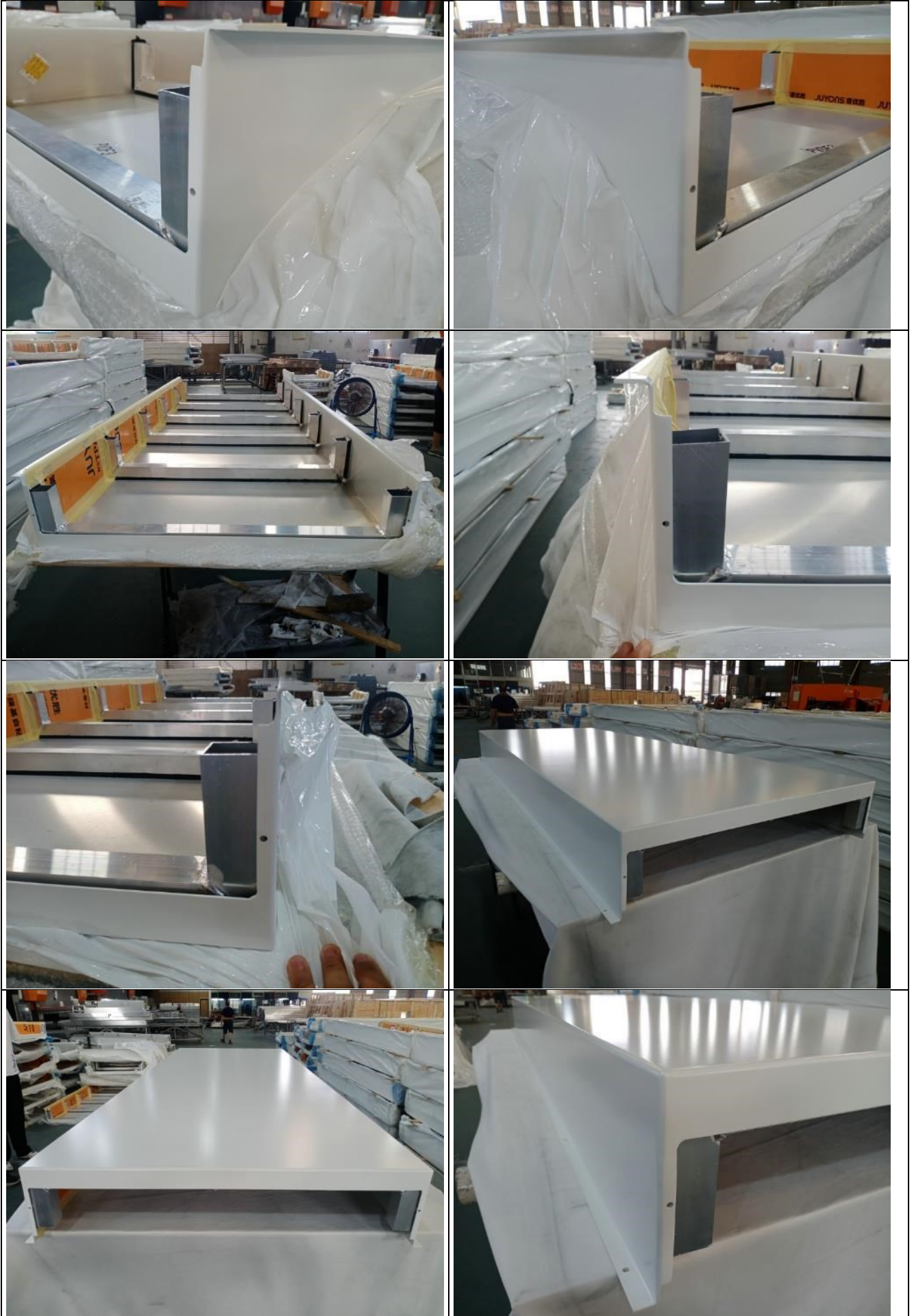


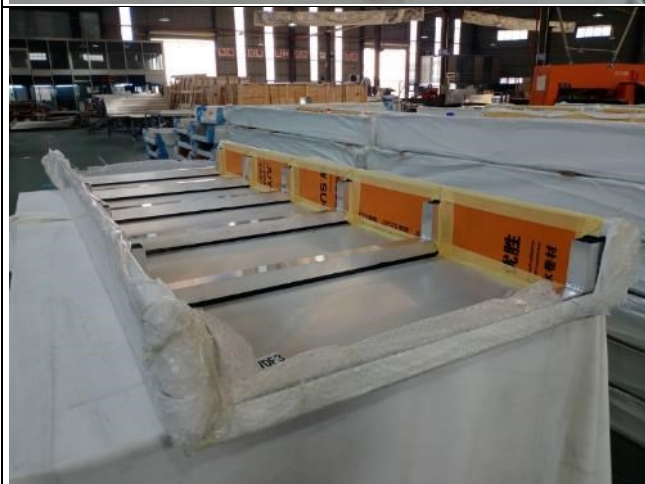
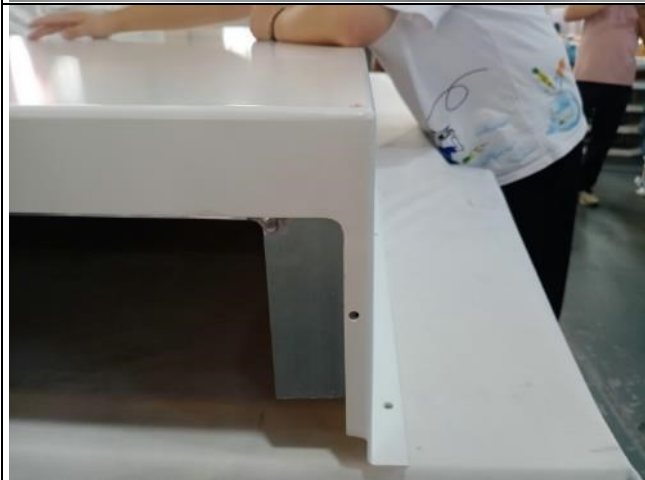
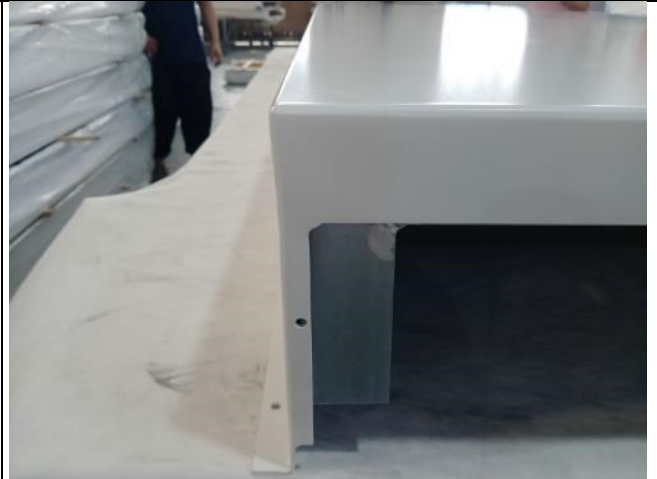
Item: HP-7









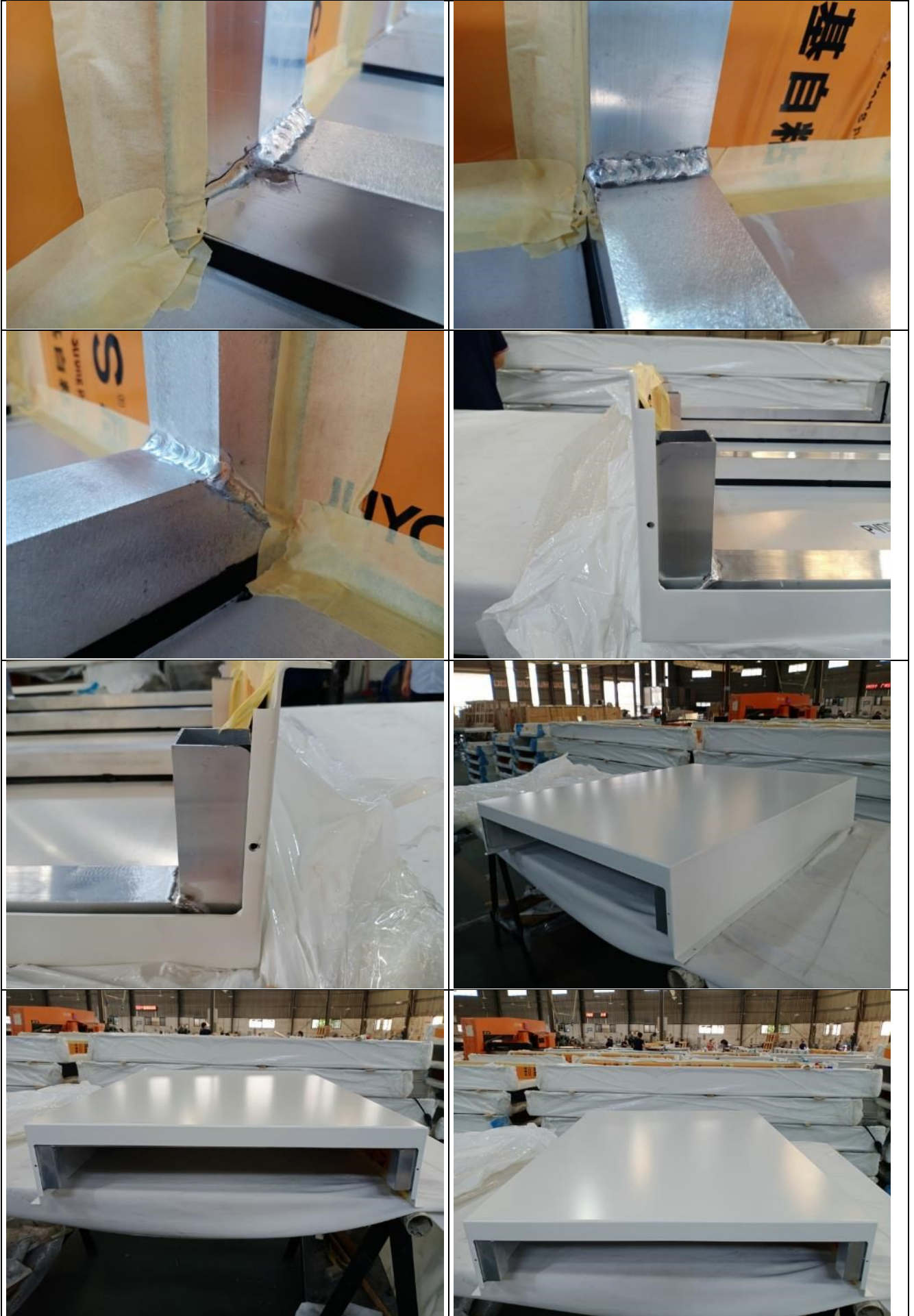


Item: HP-8













7. Factory General Outlook		
Is the factory/workshop location Same as booked by client?	Factory/Workshop cooperation	Factory/Workshop organization
Yes	Average	Average
Warehouse Cleanliness	Inspection Room Lighting Conditions	Inspection Room Conditions Cleanliness
Average	Bright	Clean
Factory Gate	Production Line	Warehouse



Warehouse



Warehouse



Warehouse



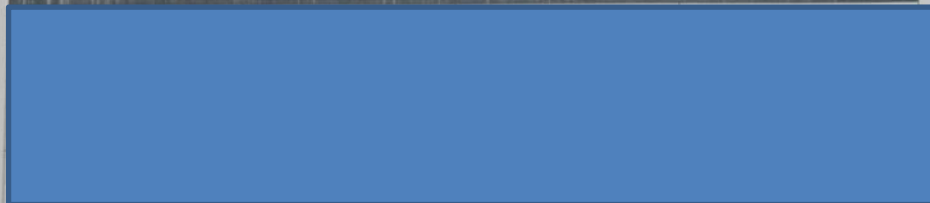
8. Draft Report



Draft Report

DOCUMENT #: AQI-DOC-Draft REPORT

General Information:



Inspection type	PSI	AQL Level	Cri. 0 Maj.: 2.5 Min.: 2.5
Sample size inspected	30pcs	Qty. for selected cartons	N/A

Defective list	Critical	Major	Minor
Spray defects	0	0	2
Black particles on the surface	0	0	3
Damaged edges and corners with paint	0	8	0
Damaged edges and corners with paint	0	0	1
Multiple scratches on the surface of the topcoat (not visible at 1 meter of the product)	0	0	1
Some drainage outlets inside the HP-6 box are blocked	0	2	0
Missing PVDF3 label inside the HP-6 product box	0	1	0
	Total Defectives	0	11
	Maximum allowed:	0	2
	Sample Size	30	30

Conclusion:

Failed

AQI Remark :

1. When the inspector arrived at the factory, the factory had already completed a batch of products (226 pieces) and had not yet packaged them into boxes.
2. The approval sample was not available for reference on site.
3. Supplier cannot provide the document of COC, COA, COT
4. Selected 30pcs samples for inspection, found 11pcs major defects and 7pcs minor defects.
5. No special cutting tool and accurate weight scale to check the GSM at the factory.
6. All product issues discovered on site have been notified to the factory, and for some surface paint issues, the factory has already repaired them on site (please refer to some repair department pictures).

Manufacturer Signature	<i>Edwin</i>	AQI Inspector	David
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Remark: All defects already fixed

IMPORTANT NOTES

THE ABOVE RESULT(S) REFLECT(S) AQI QUALITY INSPECTION FINDINGS AT THE TIME AND PLACE OF INSPECTION. THIS REPORT DOES NOT RELEASE THE BUYER OR SELLER FROM CONTRACTUAL RESPONSIBILITIES, NOR DOES IT PREJUDICE THE BUYER'S RIGHT OF CLAIM TOWARD THE SELLER/SUPPLIER FOR COMPENSATION FOR ANY APPARENT AND/OR HIDDEN DEFECTS NOT

DETECTED DURING INSPECTION OR OCCURRING ANYTIME THEREAFTER.

End of the Report