Medical Scrub Factory Audit Checklist

Medical Scrub Manufacturing Quality Control — LantaoWork.com

Purpose

This 4-step checklist turns the *30-Day Factory Audit Plan* into a printable field sheet. Complete it during a live factory visit — watch the actual line, do not accept stock video or marketing photos. Sign and date page 2 after you verify each control.

> **When to use this:** Before approving a bulk medical scrub order, after you have shortlisted a manufacturer. Pair it with the manufacturer's signed spec sheet and raw lab reports.

Step 1 — Verify Assembly-Line Controls

- [ ] **Incoming fabric checks:** Audit raw material rolls under a D65 lightbox for exact shade matching.
- [ ] **Cutting control:** Watch operators cut high-stretch panels on the bias to prevent warp distortion.
- [ ] **In-line seam audits:** Inspect stress points every 50 garments using ISO 2859-1 (AQL 2.5).
- [ ] **Wash tests:** Confirm shrinkage rates using commercial industrial washing machines, not domestic units.
- [ ] **Needle detection:** Workers log every broken needle digitally — a broken needle is an AQL 0.0 critical failure.
- [ ] **Final AQL release:** Review the signed Quality Assurance report before authorizing shipment.

> **Red Flags:** Factory shows stock video instead of the live line. No digital needle log. No signed AQL report. Shade mismatch visible between bundles.

Step 2 — Analyze Raw Lab Data

Require an original comparative report against market-standard fabric at 10, 25, and 50 industrial wash equivalents. Reject "pass" results without numeric values.

METRIC	TARGET FOR MEDICAL SCRUBS
Wash-cycle durability	No heavy pilling at 50 cycles
Colorfastness	Pass ISO 105-C06 at 50 industrial washes
Shrinkage	≤1.5% warp reduction
Seam integrity	≥22 lbs burst strength
Finish retention	Antimicrobial block retained after laundering

- [ ] **Lab is ISO 17025-accredited** and the report shows the accreditation number.
- [ ] **Report is current** — within the last 12 months for the exact fabric you are ordering.

> **Red Flags:** CoA shows only "pass" with no numbers. Lab report older than 12 months. No accreditation number. Test fabric does not match your ordered GSM.

Step 3 — Fix Floor Machine Settings

- [ ] **Machines:** Juki DDL-8700 or equivalent single-needle industrial units on high-stress seams.
- [ ] **Needles:** Size 75/11 ballpoint so the needle never cuts spandex yarns.
- [ ] **Speed:** Motor at ≤3,500 stitches per minute.
- [ ] **Stitch density:** Exactly 11 SPI using core-spun polyester thread; tension checkpoints every 50 garments.
- [ ] **Embroidery stations:** Heavy cut-away stabilizer backing on high-stretch fabrics.

> **Red Flags:** Rigid lockstitch used on stress points. Operator cannot explain tension setup. Visible puckering on stretch panels.

Step 4 — Finalize Your Specifications

- [ ] **Signed spec sheet:** Exact GSM, blend, and lab results documented before funding prototypes.
- [ ] **Sample-to-bulk approvals:** Lab dips under D65 light, fit revision, and pre-production sample all approved in writing.
- [ ] **Compliance documents:** OEKO-TEX Standard 100 report and batch-specific traceability (GRS transaction certificates if recycled).
- [ ] **MOQ, lead times, landed costs:** Itemized by style, color, and fabric under written Incoterms (FOB or DDP).

> **Red Flags:** "We're working on certification" with no timeline. Quote lacks documented assumptions. No batch-level traceability report.

Final Verdict

☐ APPROVE	☐ PROCEED WITH CAUTION	☐ REJECT
All controls verified + signed reports	1-2 minor items to fix before bulk	Any red flag or missing AQL 0.0 control

Auditor name: _____ Date: _____

> **Final Check:** Every claim must survive a written contract. If a vendor won't put a control in writing, it does not exist. Verbal promises do not survive staff turnover.