BUYER GUIDE · 2026 EDITION

Premium womenswear manufacturing in Guangzhou

A practical guide to fabric sourcing, complex style development, sample approval and production planning.

HOW TO USE THIS GUIDE

Make the first sample answer the right questions.

A good factory conversation begins before price. It begins with a clear product brief, a workable material direction and agreement on what the sample must prove.

Source with purpose

Match fibre, weight, structure, finish and order quantity to the intended garment.

Develop, do not copy

Translate references into original proportions, construction and details.

Approve in stages

Use documented fit, workmanship and production checkpoints.

CONFIRMED PIPK WORKING TERMS

120 pieces

Standard custom MOQ per style; mixed sizes. Colour and material minimums are confirmed separately.

From RMB 600

Sample fee, depending on style complexity.

7–14 days

Typical standard sample lead time after materials and details are confirmed.

RMB 150–300

Indicative production price range only. Final price follows approved design, fabric, trims, quantity and commercial terms.

NDA available

Design confidentiality can be documented before development.

SCOPE NOTE

This guide supports initial evaluation. It is not a binding quotation, technical specification or inspection standard. Confirm every commercial and technical term against the final style.

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04 China export context

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MARKET CONTEXT

China remains a large clothing export base.

Scale matters to a buyer only when it improves access to specialised materials, processes and production knowledge.

USD 159.1bn

China's 2024 exports of garments and clothing accessories.

China Customs, 2024 full-year merchandise trade table. Rounded from USD 159.1427 billion.

89.1%

Estimated domestic content in China's textile and clothing exports in 2022.

WTO Global Value Chain sector profile, published 2024.

EXPORT VALUE COMPOSITION · 2022 ESTIMATE

89.1%

domestic content

10.9% remainder. Calculated from the WTO's 89.1% domestic-content estimate.

BUYER IMPLICATION

Country-level scale does not replace factory-level verification. Evaluate the people who will source, pattern, sample, produce and inspect your specific style.

Industry context image: Lindsay Maizland via Wikimedia Commons, CC BY-SA 2.0.

Sources: General Administration of Customs of the People's Republic of China, 2024 full-year table; WTO, Global Value Chain Development Report sector profile: Textiles and clothing, 2024.

WHY GUANGZHOU

Development works as a connected sequence.

PIPK's Guangzhou workflow connects fabric and trim sourcing with pattern work, sampling and production follow-up. The advantage is practical: decisions can move between adjacent functions without losing the product brief.

01
Design brief and target market

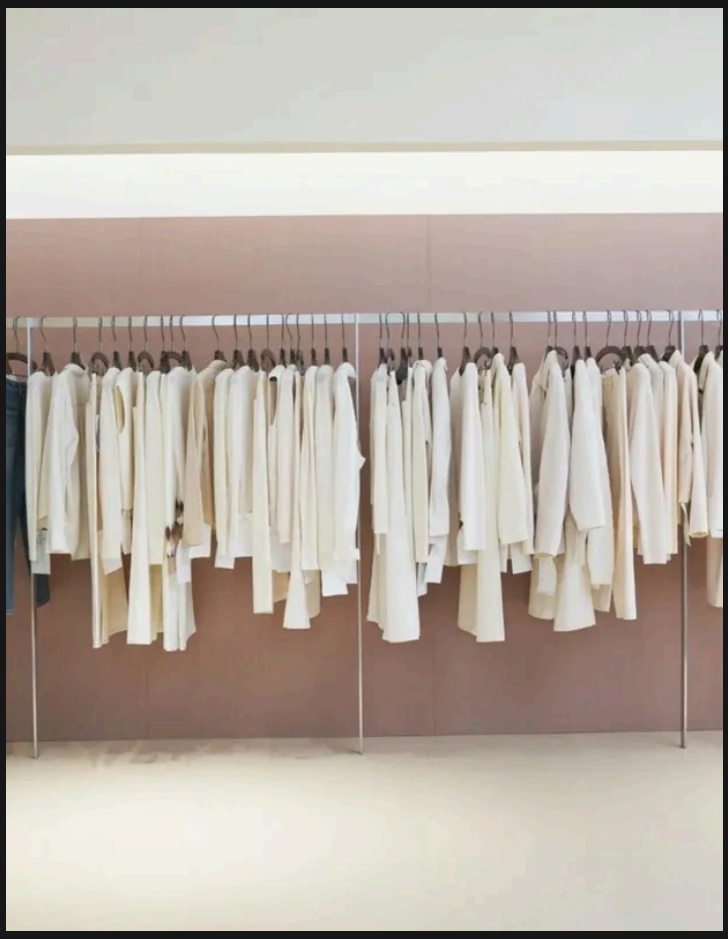
02
Fabric and trim shortlist

03
Pattern and construction plan

04
First sample and fitting

05
Approved production standard

06
Bulk production and QC



PIPK showroom and production workflow in Guangzhou. Images supplied by PIPK.

BEFORE QUOTATION

A quote-ready product brief.

Send enough information to identify the real construction and material questions. A reference photo alone is a starting point, not a specification.

BRIEF ITEM	WHAT TO PROVIDE	WHY IT CHANGES THE QUOTE
Style reference	Front, back and detail views; sketch or tech pack if available.	Clarifies silhouette, panel lines and visible finish.
Target customer	Market, size range, fit expectation and price position.	Guides measurements, material level and construction.
Fabric direction	Fibre, weight, hand feel, colour and performance needs.	Material often drives both unit cost and minimums.
Trim list	Buttons, zips, lining, labels, hangtags and packaging.	Custom components may have separate minimums.
Quantity	Pieces per style, colour and size.	Controls cutting, marker efficiency and sourcing route.
Delivery window	Required ex-factory or delivery date and destination.	Allows a realistic schedule and shipping discussion.
Commercial scope	Requested currency, Incoterm and packaging standard.	Prevents a price range from being mistaken for a final offer.

01

Mark priorities

State which details cannot change and where alternatives are acceptable.

02

Send measurements

Use a measurement chart when fit is important to the brand.

03

Define approval

Name the sample stage that releases the next payment or production step.

More choice is useful only when the shortlist is controlled.

Guangzhou's fabric market network supports rapid comparison across fibre, weight, colour, finish and price, but the search must end in an article-level record.

PIPK commonly works with cotton, linen, wool and silk directions, while additional fabrics and custom developments can be sourced through cooperating fabric suppliers.

START WITH FIVE FILTERS

Fibre composition · finished weight · hand feel · colour standard · target garment and quantity.

- [ ] Ask for usable width, not nominal width alone.
- [ ] Confirm shrinkage and colourfastness requirements.
- [ ] Review bulk availability after sample selection.
- [ ] Keep the approved swatch with the sample record.
- [ ] Approve substitutes in writing.

Haizhu District reported approximately 23,000 shops, nearly 20,000 merchants and enterprises, and more than 100,000 fabric and trim varieties in the Zhongda textile district in 2022. These are district-level context figures, not PIPK inventory.

Image: Yuen Tou Zan / Pexels.

Source: Haizhu District Government, “中大纺织商圈全面复市”, 2022. Market figures are historical context.

ZHONGDA SOURCING ROUTE

A market visit is a search process, not an approval.

The district compresses choice. The factory still has to convert a promising hanger or cutting into a traceable material that can be sampled, costed and reordered.

01	02	03	04	05	06
Garment brief and material function	Market / supplier shortlist	Hanger, cutting and article data	Sample-length purchase	Garment and test review	Bulk lot and cutting release

23,000
shops
District figure reported by Haizhu in 2022.

20,000
merchants / enterprises
Approximate district figure reported in 2022.

100,000+
varieties
Fabric and trim varieties reported in 2022.

Market context and PIPK showroom. A large search pool improves options; it does not replace article identification, testing or bulk-lot approval.

Sources: Haizhu District Government, 2022 market reopening report; Haizhu District Government, 2023 Zhongda textile district planning outline.

FABRIC SPECIFICATION

Turn the swatch into a material contract.

A supplier article name is not enough. The record must describe the version of the material that the garment was approved in.

FIELD	RECORD	BUYER DECISION
Identity	Supplier, article, composition, construction and finish.	Is substitution allowed? Who approves it?
Mass and width	Finished GSM and usable width, with agreed tolerance.	Does the marker and unit cost use usable values?
Colour	Physical standard, light source, lot / shade grouping.	What difference is acceptable and where?
Dimensional change	Test method, wash/dry route, length and width result.	Change pattern, care route or fabric?
Surface	Face side, nap, slubs, print repeat and defect limits.	Which natural features are acceptable?
Performance	Tests relevant to use: colour, pilling, strength, snag or stretch.	Which result releases bulk cutting?
Availability	Sample stock, bulk quantity, fabric MOQ and reorder route.	Is continuity more important than novelty?

A

Physical

Approved swatch or lot cutting, signed and dated.

B

Numeric

Width, weight, shrinkage, test result and tolerance.

C

Commercial

Price basis, quantity, MOQ, lead time and validity.

APPROVAL RULE

A screen image may guide the search. Bulk approval should reference a physical material and recorded article data.

WORKED EXAMPLE · ILLUSTRATIVE

Shrinkage changes both fit and fabric demand.

Assume a trouser panel measures 100.0 cm in the fabric length direction before laundering and 97.5 cm after the agreed cycle.

Dimensional change = (after − before) ÷ before × 100

(97.5 − 100.0) ÷ 100.0 × 100 = −2.5%

A negative result indicates shrinkage. The team must decide whether to change the pattern allowance, the care route, the fabric treatment or the fabric itself.

CONSUMPTION ILLUSTRATION

Marker length per garment	**1.60 m**
Order quantity	**120 pcs**
Net marker demand	**192.0 m**
Illustrative allowance	**8%**
Planning quantity	**207.4 m**

Formula: 1.60 × 120 × 1.08. This is not a PIPK quote or a universal allowance. Actual demand follows usable width, marker, sizes, matching, defects, shrinkage strategy and replacement reserve.

What must stay together in the approval record

INPUT	RECORD	DECISION
Test route	Method, wash temperature, agitation, drying and number of cycles.	Does the result represent the product care instruction?
Measurement	Marked direction, initial distance, final distance and percentage.	Pattern allowance, tolerance or rejection.
Marker	Usable width, size ratio, nap / one-way layout and matching.	Consumption and bulk purchase quantity.
Lot	Article, shade group and tested roll / sample.	Does the approved result apply to the bulk lot?

Technical references: AATCC TM135/TM150 listings for dimensional change; buyer must define the applicable method and acceptance limit.

FABRIC INSPECTION

Shade and defects must be controlled before cutting.

Four different shade questions

Lot to lot	Can separate dye lots appear in one garment or delivery?
Roll to roll	Can rolls be grouped to one approved shade family?
Side to centre	Will panels cut across the width appear different?
Head to tail	Does shade drift along one roll?

CUTTING IMPLICATION

Bundle identification and panel replacement must preserve the approved shade group. A passed fabric roll can still create visible mismatch if shade information is lost during cutting.

Visual inspection agreement

DEFINE BEFORE INSPECTION	WHY
Face side, usable width and inspection lighting	Controls what is visible and what can enter the marker.
Defect grading option and acceptance limit	ASTM D5430 notes that purchaser and seller should use the same agreed point option.
Shade reference and roll grouping	Prevents visual mismatch from being treated as an isolated sewing defect.
Defect map and replacement route	Links fabric findings to marker placement and material reserve.

Technical reference: ASTM D5430-26, Standard Test Methods for Visually Inspecting and Grading Fabrics. Acceptance limits remain buyer/seller agreements.

SOURCING WORKFLOW

From material direction to approved bulk.

01 Brief

Garment, fibre, weight, hand feel, colour and performance.

02 Shortlist

Compare available and made-to-order routes.

03 Swatch

Review appearance, touch and compatibility.

04 Test

Confirm required shrinkage, colour and care checks.

05 Bulk approval

Approve lot or shade before cutting.

Available fabric route

Useful when schedule and order size favour existing stock. Check that enough fabric remains for the full order and possible replacement pieces.

CHECK	DECISION
Stock quantity	Enough for order, testing and cutting allowance?
Shade continuity	One lot or controlled lot variation?
Reorder risk	Can the same article be obtained later?

Custom fabric route

Useful when a colour, composition, finish or pattern is central to the product. Separate fabric minimums and lead times must be checked.

CHECK	DECISION
Mill minimum	Does it fit the garment order plan?
Lab dip / strike-off	Who approves and against which standard?
Bulk test	Which results release cutting?

PRACTICAL CONTROL

Do not approve fabric from screen colour alone. Keep the physical swatch, supplier article number and approval date together.

FABRIC DECISION MATRIX

Natural fibres behave differently in the garment.

FIBRE	USEFUL FOR	BUYER CHECKS	CONSTRUCTION IMPLICATIONS
Cotton	Shirts, dresses, trousers, casual tailoring.	Weight, shrinkage, opacity, crease recovery, wash route.	Pre-shrinkage and seam puckering depend on weave and finish.
Linen	Separates, dresses, relaxed jackets, warm-weather collections.	Slubs, width, shrinkage, colour variation, desired crease character.	Stabilise bias areas and agree whether natural irregularity is acceptable.
Wool	Tailored jackets, coats, trousers and premium separates.	Composition, weight, recovery, pilling, pressing response.	Interfacing, pressing and seam allowance must suit the cloth.
Silk	Blouses, dresses, occasion pieces and refined linings.	Opacity, snag risk, colourfastness, care method, surface marks.	Cutting stability, needle selection and handling require attention.

Weight

Supports or collapses the silhouette.

Drape

Changes movement and perceived volume.

Recovery

Affects elbows, knees and fitted areas.

Surface

Influences cutting, stitching and inspection.

> “Choose the fabric for the finished garment, not for the swatch alone.”

The same fibre name can cover very different constructions and finishes. Request article-specific information and evaluate it on the intended sample.

MATERIAL APPROVAL

Record the standard before production.

CONTROL	APPROVAL RECORD
Composition	Supplier declaration and any required test report.
Colour	Approved swatch, lab dip or strike-off under agreed light.
Weight and width	Finished values and permitted tolerance.
Shrinkage	Test method, result and pattern allowance decision.
Surface quality	Acceptable slubs, nap direction, print alignment or defects.
Care method	Wash, dry-clean, iron and labelling implications.
Bulk lot	Article, supplier, lot, quantity and approval date.

Fabric preparation before cutting. Image supplied by PIPK.

DO NOT LEAVE THIS IMPLICIT

If fabric shade, hand feel or surface character is commercially important, define the comparison sample and who has approval authority.

A

Approved swatch

Physical reference retained by buyer and supplier.

B

Test record

Required results attached to the style file.

C

Bulk release

Written decision before cutting starts.

REFERENCE PHOTO DEVELOPMENT

Use references to define direction, then develop an original product.

Read the silhouette

Volume, length, shoulder, waist position and balance.

Map construction

Panels, seams, closure, pockets, lining and internal support.

Rebuild the material story

Fibre, weight, drape, texture, colour and trims.

01 Reference review

02 Original change brief

03 Pattern direction

04 Material selection

05 First sample

06 Fit and detail revision

Development work at PIPK. Reference images should be supported by explicit change instructions and ownership checks.

DESIGN-CHANGE MATRIX

Make the new version specific.

DESIGN AREA	REFERENCE OBSERVATION	ORIGINAL DEVELOPMENT DECISION	APPROVAL EVIDENCE
Proportion	Oversized body, cropped length.	Set exact finished length, ease and shoulder width for target size.	Measurement chart and fitting photos.
Construction	Strong shoulder, shaped waist.	Select shoulder pad, interfacing, darts or panel shaping.	Inside-out sample review.
Details	Military pocket and metal trim language.	Redraw pocket, closure and hardware placement.	Detail sketch and trim board.
Material	Premium matte surface.	Choose weight and composition that support the silhouette.	Approved fabric swatch.
Colour	Neutral reference palette.	Set brand colour standard and lining relationship.	Lab dip or physical colour reference.

What a patternmaker needs

Base size, body measurements or block, intended ease, finished garment measurements, construction notes and tolerance priorities.

What a buyer should approve

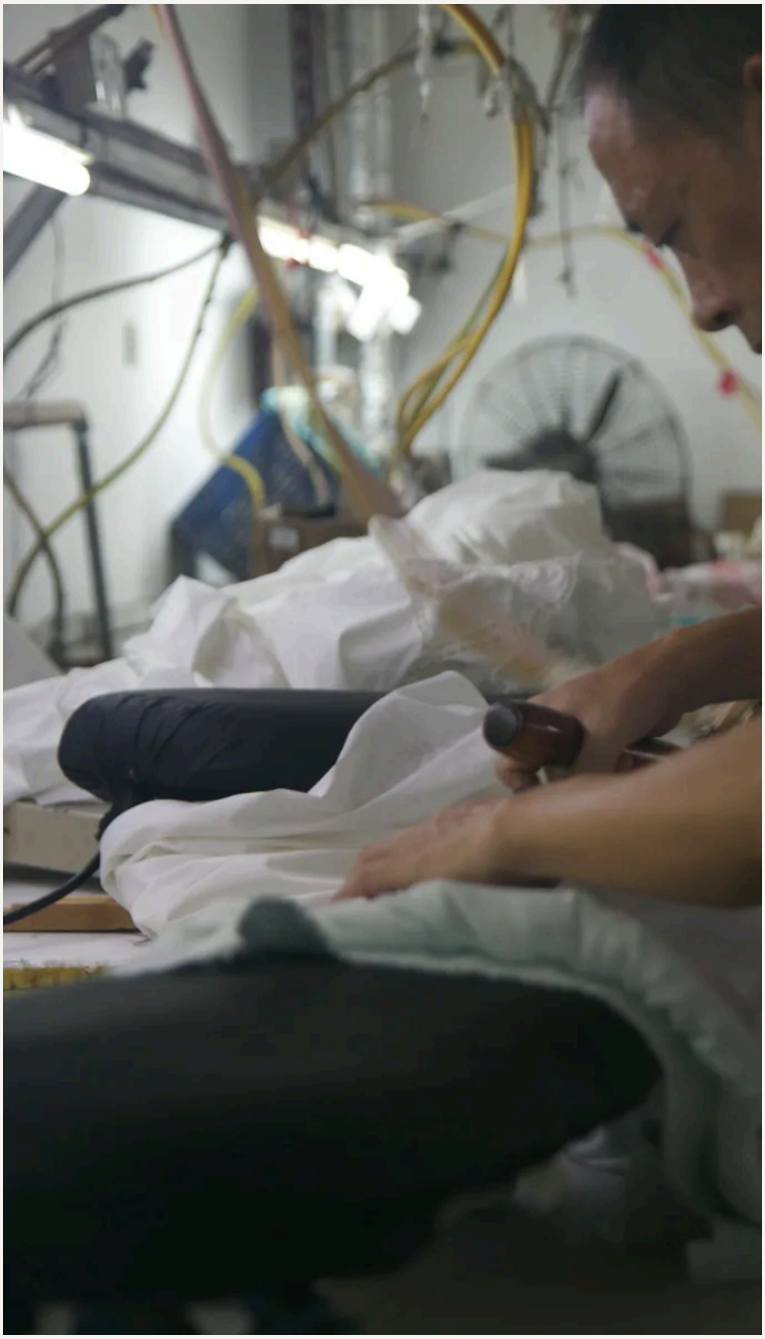
Silhouette, fit, movement, visible details, internal construction, material, trims and measurement deviations.

CONFIDENTIALITY

PIPK can sign an NDA. Buyers should still send only material they own or are authorised to use and clearly identify confidential files.

STRUCTURED WOMENSWEAR

The visible silhouette depends on hidden construction.



Pressing and shaping in production. Image supplied by PIPK.

01

Shoulder

Pad shape, sleeve head, armhole and seam allowance affect height and transition.

02

Front body

Canvas or fusible, dart or panel shaping, lapel roll and closure position create structure.

03

Sleeve

Pitch, cap ease, elbow shape and lining influence movement and appearance.

04

Pressing

Intermediate and final pressing help set shape; the cloth must tolerate the process.

BUYER REVIEW

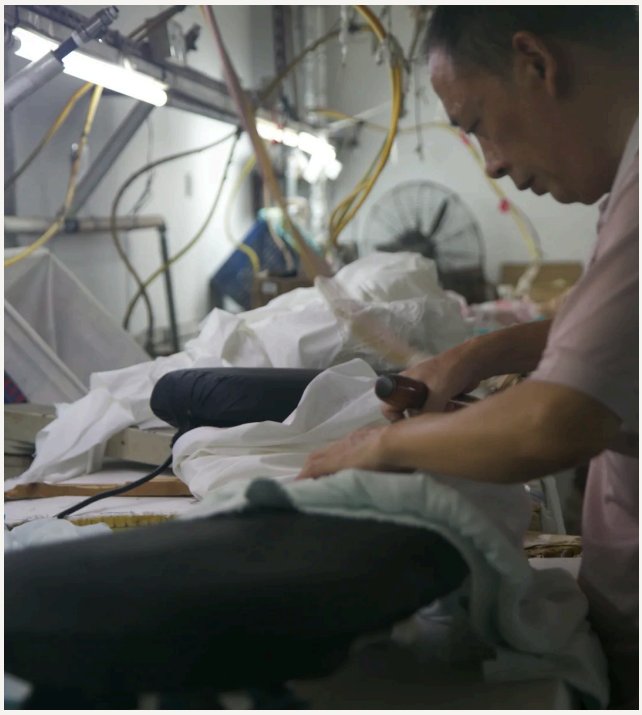
Ask to inspect both the outside silhouette and inside construction of the sample.

INTERLINING COMPATIBILITY

Structure must survive fusing, sewing and care.

A fusible is not selected by stiffness alone. Face fabric, adhesive, support cloth and process conditions must behave as one composite.

INPUT	TRIAL QUESTION
Face fabric	Can it tolerate heat and pressure without shine, strike-through, flattening or colour change?
Interlining	Does weight, stretch direction and recovery support the intended silhouette?
Adhesive	Does it bond without resin strike-back or visible dot impression?
Process	Are temperature, pressure and dwell time set for the selected product?
Cooling	Is the fused panel supported until the bond stabilises?
Care	Does the composite remain flat and stable after the agreed treatment?



Temperature + pressure + time + cooling

All four must be controlled. The correct values are product-specific, not universal.

Trial record

SAMPLE ID	FABRIC / FUSIBLE	MACHINE SETTINGS	IMMEDIATE RESULT	AFTER-CARE RESULT	DECISION
F-01	Article + fusible code	Supplier-recommended starting point	Hand, surface, bond	Flatness, bubbling, shrinkage	Approve / revise
F-02	Alternative support	Recorded trial settings	Hand, surface, bond	Flatness, bubbling, shrinkage	Approve / reject

Technical reference: Freudenberg Performance Materials apparel interlining guidance. Follow the selected product's instructions and validate the face-fabric composite.

SEAM DIAGNOSIS

“Puckering” is a symptom, not one defect cause.

ROOT-CAUSE FAMILY	SIMPLE DIAGNOSTIC CLUE	PROCESS RESPONSE
Thread tension	Pucker relaxes when stitches are carefully cut in a short test section.	Rebalance needle/bobbin tension and machine timing; confirm stitch formation.
Structural jamming	Dense fabric yarns are displaced by needle and thread.	Trial finer needle/thread, lower stitch density or alternative seam/stitch construction.
Component instability	Pucker appears or worsens after washing, finishing or relaxation.	Check dimensional compatibility of fabric, lining, tape, thread and support materials.
Unequal feed	After removing a seam section, one ply is longer than the other.	Correct presser pressure, feed mechanism, handling and machine settings.

The right correction depends on the cause. Increasing pressing may hide a seam temporarily while leaving the original instability unresolved.

- ☐ Keep a sealed seam sample with machine notes.
- ☐ Review appearance before and after the care trial.
- ☐ Check both plies, not only the visible face.
- ☐ Record needle, thread, stitch and feed changes.

Technical reference: Coats Group, “Eliminating Seam Puckering”. Diagnosis shown here is a buyer-facing summary, not a machine-setting specification.

COMPLEXITY ASSESSMENT

Complexity is cumulative.

AREA	LOWER COMPLEXITY	HIGHER COMPLEXITY	DEVELOPMENT RESPONSE
Silhouette	Straight, relaxed, few shaped panels.	Strong shoulder, corsetry, asymmetric or sculpted shape.	More pattern work and fitting evidence.
Fabric	Stable woven with consistent surface.	Slippery, sheer, stretch, nap, sequins or engineered pattern.	Cutting and handling trials.
Construction	Unlined, simple closure and seams.	Fully lined, internal support, bound seams, multiple layers.	Inside-out workmanship approval.
Decoration	Standard machine embroidery or trim.	Dense embroidery, hand beading, mixed hardware or placement work.	Strike-off, placement map and workmanship limit sample.
Fit	Loose fit with broad tolerance.	Close fit, tailored balance or multi-point body shaping.	Fit model and measurement control.

1

Standard

Known fabric, conventional construction, limited special handling.

2

Developed

One or two demanding areas require trials or extra fittings.

3

Complex

Several interacting risks require staged approval and realistic costing.

SPECIAL PROCESSES

Approve decoration as a process, not only as an image.

Machine embroidery.

Hand finishing and detail inspection.

PROCESS	APPROVE BEFORE SAMPLE	APPROVE ON GARMENT	BULK CONTROL
Embroidery	Artwork, size, colour, stitch density, backing.	Placement, distortion, reverse finish.	Placement tolerance and thread continuity.
Hand beading	Motif, bead type, attachment method.	Weight, comfort, drape and snag risk.	Workmanship limit sample and count checks.
Hardware	Finish, dimensions, weight, function.	Placement, reinforcement and movement.	Colour consistency and attachment security.
Decorative stitching	Thread, stitch type, spacing and path.	Puckering and alignment.	Machine setting and first-piece approval.

COST AND RISK DRIVERS

Price follows the approved product.

DRIVER	WHAT CHANGES
Fabric	Article price, width, yield, defects, minimum and testing.
Pattern pieces	Cutting time, matching, sewing operations and handling.
Internal structure	Interfacing, lining, padding, pressing and skilled labour.
Decoration	Artwork, setup, hand time, placement and rejects.
Trims	Custom moulds, plating, colour, minimums and packaging.
Quantity	Marker efficiency, setup allocation and supplier minimums.

PIPK INDICATION

RMB 150–300

Indicative production price range. The final quotation depends on the approved style, fabric, trims, quantity, packaging and commercial terms.

DO NOT COMPARE UNLIKE QUOTES

A low number may exclude lining, labels, packaging, testing, special processes, freight or duties. Request the same scope from every supplier.

Quote comparison table

SUPPLIER	FABRIC BASIS	INCLUDED TRIMS	PACKAGING	INCOTERM	VALIDITY
A	Article / composition / weight	List	Standard / custom	Confirm	Date
B	Article / composition / weight	List	Standard / custom	Confirm	Date
C	Article / composition / weight	List	Standard / custom	Confirm	Date

CLOTHING SAMPLE DEVELOPMENT

A 7–14 day sampling window needs fast decisions.

Day 0

Brief, NDA if needed, target measurements and material direction.

Day 1–3

Feasibility review, fabric/trim route and pattern planning.

Day 3–8

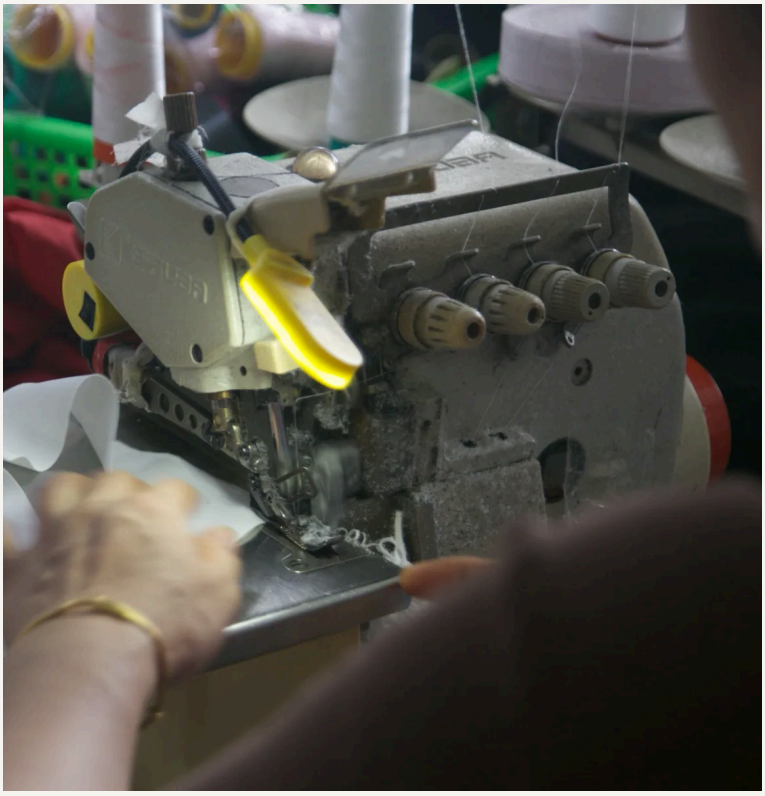
Pattern, cutting, sewing and special-process trial.

Day 7–12

Finishing, measurements and internal review.

Day 7–14

Sample dispatch or buyer review; revision plan follows comments.



Standard sampling is typically 7–14 days after materials and details are confirmed. Complex styles can require more time for sourcing, embroidery, beading, construction trials or fitting.

TIMELINE ASSUMPTION

The 7–14 day range is PIPK's general sampling indication, not a guaranteed schedule for every style. The dated plan begins after the brief, fee and material route are confirmed.

Overlock sewing operation at PIPK. Image supplied by PIPK.

SAMPLE FEE

Budget for learning, not only for one garment.

From RMB 600

Standard sample development; eveningwear development is quoted according to the style. Sample fees can be credited against bulk production as recorded in the quotation. PIPK terms: 26 September 2026.

A first sample can expose gaps in proportion, movement, material behaviour, construction and decoration before bulk production.

COST DRIVER	TYPICAL REASON
Pattern work	Original block, tailored balance or multiple fittings.
Fabric	Premium article, minimum cut or custom colour.
Embroidery	Digitising, strike-off and setup.
Hand beading	Manual placement and attachment time.
Special construction	Corsetry, padding, bonding or internal structure.
Revision scope	New pattern direction versus minor correction.

Comment sheet structure

LOCATION	ISSUE	REQUIRED CHANGE	REFERENCE	PRIORITY
Shoulder	Too wide by 1.5 cm	Reduce finished shoulder; retain sleeve-head shape	Photo + measurement	Must
Front closure	Button sits low	Raise 2 cm and rebalance spacing	Annotated photo	Must
Lining	Pulls at hem	Increase ease and recheck hanging	Inside photo	Must

MOQ PLANNING

Plan quantities by style, colour and size.

PIPK's current standard custom MOQ is 120 pieces per style, with mixed sizes. Colour splits depend on the selected fabric, dye lot, trims and specialist processes. Align the size ratio with your customers and replenishment plan.

Illustrative allocation only: XS 12, S 24, M 36, L 30, XL 18 = 120 pieces. Use the buyer's sales data for the actual ratio.

DECISION	BUYER INPUT
Size curve	Historical sales or target customer measurements.
Colour count	Confirm each proposed colour split against fabric, dye-lot, trim and process minimums.
Channel	Wholesale, retail, online or launch event allocation.
Buffer	Replacement, photography, press and quality reserve.
Reorder	Fabric continuity and realistic replenishment window.

PIPK TERMS: 26 SEPTEMBER 2026

The current standard custom-production MOQ is 120 pieces per style, with mixed sizes. Colour splits, custom fabrics, trims and specialist processes can create separate supplier minimums; confirm the quotation before ordering.

TEST-ORDER PLANNING

Start focused enough to learn.

A small-to-medium launch works best when the first order tests one coherent product proposition rather than too many fabrics, colours and special processes at once.

PLAN	EXAMPLE	OPERATIONAL EFFECT	LEARNING VALUE
Focused	1 style × 1 colour × 120 pcs	One material and one approval route.	Clear fit, price and customer response.
Colour test	1 style × 2 colours × 120 pcs each	Separate colour minimums and shade approvals.	Tests colour demand, but doubles inventory.
Mini capsule	3 styles × 1 colour × 120 pcs each	More patterns, samples and sourcing coordination.	Tests outfit logic and cross-sell.

1

Lead style

Choose the product that best expresses the brand.

2

Known customer

Use a defined fit and size profile.

3

Controlled material

Avoid unnecessary novelty in every component.

4

Review plan

Decide what sales and quality evidence triggers reorder.

COMMERCIAL NOTE

Whether a particular test order is feasible depends on the style, fabric and trim minimums. Confirm it during product assessment.

GARMENT SAMPLE APPROVAL PROCESS

Each sample stage should release a defined decision.

STAGE	PRIMARY QUESTION	BUYER REVIEW	RELEASE DECISION
Prototype	Can the design and construction be made as intended?	Silhouette, construction route, visible details, material behaviour.	Revise concept or move to fitting.
Fit sample	Does the garment fit and move correctly on the target body?	Balance, ease, lengths, movement and measurements.	Approve pattern changes.
Size set	Does the approved base pattern grade correctly across selected sizes?	Key measurements, proportion and fit at the size-range risk points.	Approve grading or correct the grade rule.
Pre-production	Is the complete product ready to become the bulk standard?	Correct fabric, trims, labels, construction, colour and measurements.	Written approval for production.
Top of production	Does early bulk match the approved standard?	Workmanship, measurements, colour, components and packing.	Continue, correct or hold.

One comment, one location, one action

- [ ] Use annotated front, back and detail photos.
- [ ] State the current and required measurement.
- [ ] Separate fit changes from styling preferences.
- [ ] Return one consolidated comment sheet.
- [ ] Record approval version and date.

Garments arranged for review in the PIPK showroom. Image supplied by PIPK.

WORKED EXAMPLE · STRUCTURED CROPPED JACKET

Control changes by version, not by memory.

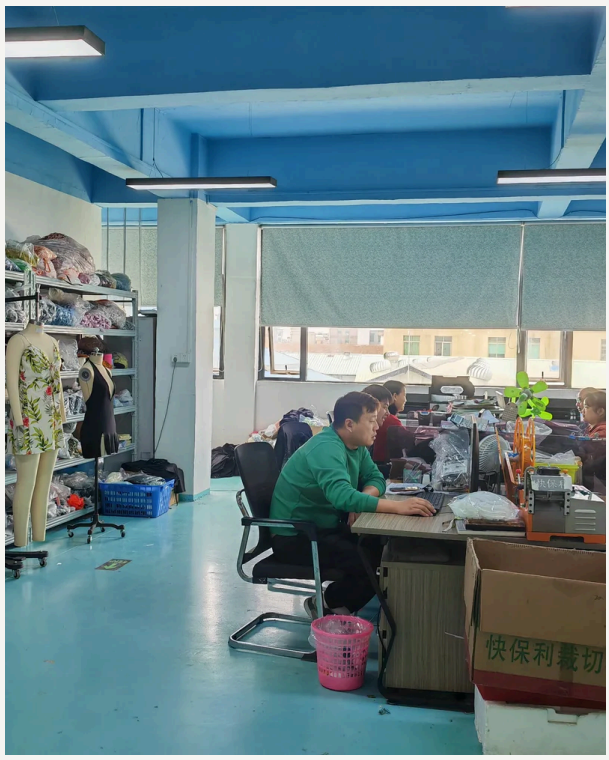
A reference shows the visual direction. The style file records how PIPK and the buyer turn that direction into an original, measurable product.

V0
Reference, brand changes and target measurements

V1
First pattern and construction prototype

V2
Fit revision, material and detail confirmation

PP
Complete production-standard sample



GATE	EXAMPLE EVIDENCE	RELEASE CONDITION
Direction	Cropped length, stronger shoulder, original pocket and closure, target fabric hand.	Buyer confirms what must stay and what must change.
Pattern	Finished measurements, shoulder angle, sleeve pitch, waist shaping and ease.	Annotated fitting and consolidated measurement comments.
Construction	Interlining map, pad and sleeve-head choice, lining ease, pocket reinforcement.	Inside/outside workmanship approval.
Material	Fabric article, colour standard, fusible trial, lining and trim board.	Physical approvals and recorded substitutes.
Production	Approved PP sample, BOM, pattern version, measurement chart and packing.	One signed release record; open issues are closed or accepted.

CHANGE RULE
Every comment needs a version, location, current condition, requested action, evidence and owner. A later message does not silently replace an approved file.

GARMENT QUALITY CONTROL

Build quality into checkpoints.

CHECKPOINT	WHAT TO VERIFY	REFERENCE	ACTION IF OUTSIDE STANDARD
Incoming material	Article, colour, width, visible defects and required tests.	Approved swatch and order record.	Hold, segregate or replace.
Cutting	Marker, direction, matching and bundle identification.	Pattern and cutting instruction.	Correct before sewing.
In-line sewing	Operation, seam quality, alignment and measurement risk points.	Approved sample and workmanship notes.	Correct process and recheck.
Finishing	Pressing, loose threads, stains, trims and appearance.	Finish standard and limit sample.	Repair, clean or reject.
Final inspection	Quantity, workmanship, measurements, labels and packing.	Purchase order and approved PP sample.	Document and resolve before release.

PIPK APPROACH

Confirm quality through the sample first, then use the approved sample and written records as production references. Inspection method and acceptance criteria should be agreed for the order.

AQL selects a sample. It does not define good workmanship.

An acceptance-sampling plan converts lot size, inspection level and buyer-selected AQLs into a sample size and accept/reject numbers.

Lot + inspection level + sampling plan + AQL → decision rule

Use the current agreed standard and edition. ISO 2859-1:2026 replaced the 1999 edition.

Separate the three documents

- ☐ **Product specification:** measurements, materials, construction and packing.
- ☐ **Defect classification:** what is critical, major or minor for this product and market.
- ☐ **Sampling plan:** how many units are inspected and how the lot decision is made.

SEVERITY	BUYER-DEFINED MEANING	GARMENT EXAMPLES TO CLASSIFY BEFORE INSPECTION
Critical	Safety, legal or other unacceptable risk.	Unsafe sharp component, prohibited item or market-specific compliance failure.
Major	Likely to make the garment unusable, unsaleable or materially different from approval.	Wrong fabric/colour, open seam, failed closure, severe shade mismatch, measurement outside agreed limit.
Minor	Does not materially affect use but falls outside the agreed appearance standard.	Small workmanship issue, slight alignment deviation or removable finishing issue, as specifically defined.

IMPORTANT

PIPK does not set one universal AQL in this guide. The buyer and supplier should agree the defect list, severity, inspection level, AQL values, measurement sampling and reinspection route for the order.

Source: ISO 2859-1:2026, Sampling procedures for inspection by attributes — Part 1. Standard text and sampling tables are not reproduced here.

FACTORY EVALUATION

Ask for evidence connected to your product.

EVALUATION AREA	EVIDENCE TO REQUEST	BUYER QUESTION
Product fit	Relevant samples, construction details and process photos.	Have they handled similar materials and complexity?
Development	Pattern, fitting and comment-sheet workflow.	Who owns each technical decision?
Sourcing	Fabric shortlist, article data and substitute approval route.	How are material changes controlled?
Production	Cutting, sewing, finishing and capacity plan for the order.	Where will this style be made and followed up?
Quality	Approved sample, inspection points and issue records.	What stops a defect from repeating?
Confidentiality	NDA and file-access practice.	How are designs and customer information protected?

Primary and technical sources

1. General Administration of Customs of China. 2024 full-year merchandise trade table. Garments and clothing accessories exports: USD 159.142708 billion.
2. World Trade Organization. Global Value Chain Development Report sector profile, Textiles and clothing, 2024. China domestic content estimate: 89.1% for 2022.
3. Haizhu District Government. Zhongda textile district reopening report, 2022: shops, merchants and product-variety context.
4. Haizhu District Government. Zhongda textile district planning outline, 2023.
5. ISO 2859-1:2026. AQL-indexed lot-by-lot acceptance sampling.
6. ASTM D5430-26. Visual inspection and grading of fabrics.
7. AATCC standards directory. Dimensional-change and colour-evaluation methods referenced at method level.
8. Coats Group. Root-cause guide to seam puckering.
9. Freudenberg Performance Materials. Product-specific apparel interlining processing guidance.
10. PIPK working terms supplied by PIPK: MOQ, sample fee, sample lead time, indicative unit-price range, fabric scope and NDA availability.

Research and image method

1. Chinese-language garment-industry publications were reviewed to identify recurring shop-floor questions about sourcing, shade, shrinkage, fusing, sampling, special processes and inspection. Their claims were not treated as standards; the technical sources at left were used for verification.
2. No public-account article text or image is reproduced. This guide synthesises the operating questions for an international buyer.
3. PIPK-owned showroom and factory images are used throughout the guide.
4. Lindsay Maizland / Wikimedia Commons, CC BY-SA 2.0: page 4.
5. Yuen Tou Zan / Pexels: fabric rolls; no person shown.
6. All numerical examples are explicitly labelled illustrative. They are not quotations, inspection limits or guarantees.

Data values are included for context and are not forecasts. All operational recommendations should be adapted to the buyer's product, market and inspection requirements.

NEXT STEP

Send one priority style for a production assessment.

Include the reference or tech pack, target fabric, colour, size range, quantity, market and required delivery window.

- [ ] Front, back and detail views
- [ ] Target measurements or fit reference
- [ ] Fabric and trim direction
- [ ] Quantity by style, colour and size
- [ ] Target market and delivery window

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