RSL Failures

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s.Oliver
**RSL Failures**

**Source of failure:**
- Binder
  - curing temperature and time was incorrect

**Improvement:**
- Re-curing of 2,376 pcs. with correct conditions!

**Correct action:**
- Check technical data sheet & keep the conditions!

**Formaldehyde:**
- 180 mg/kg
- s.Oliver limit: 75 mg/kg
Source of failure: Spray-glue, which was used for fixation of the garment panel on the printing table contains phthalates. 2,059 pcs. were affected.

Correct action: Make sure that all inputs will not cause a fail, and check MSDS of chemicals!
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Source of failure:
Black fabric
→ lining of complete collection!
→ 46,000 pcs.

Improvement:
Replace lining with passed one

Correct action:
Make sure that your raw materials aren’t contaminated!

AZO:
134 mg/kg
s.Oliver limit:
20 mg/kg
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Source of failure: 
Washing process 
→ NPEO is used as emulsifier in washing and cleaning agents 

Quantity: 7,380 pcs.

Correct action: 
Substitute these chemicals in cooperation with your chemical supplier!

APEO: 
9600 mg/kg 
s.Oliver limit: 
1000 mg/kg
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Source of failure:
Belt was contaminated & used for three styles = 30,000 pcs. affected!

Improvement:
re-production and replacement of all belts

Other possibility:
removal and cut the price → less turnover!

Phthalates:
1972 mg/kg
s.Oliver limit:
1000 mg/kg