

V-TRUST INSIGHTS

June 2019



HOW TO AVOID MOLD

How to Avoid Mold

Be alert of the mold if your products are produced in coastal cities of China! From April to October is the monsoon season, especially June! Not only wooden products, but also cardboard, paper box, genuine suede, imitation suede microfiber, PU/Starch/Wax coating with organic material backing and synthetic or textile items are easy to get mold.

Mold occurs for various reasons, the unique characteristics of the material, pre and post manufacturing treatments, storage, shipping time and route, weather conditions and type of mold protection chosen are all factors.

There are many different preventative practices in use. The best strategy to minimize the risk of mold damage is to control the humidity at all levels of the supply chain, from the material receiving until products loading & shipping. Establishing process and enforcing housekeeping rule is critical for success.

1. Prevention of Mold – Material Receiving

- ▶ Keep unloading area dry and clean
- ▶ Unload only in dry conditions or under protective cover
- ▶ Unload goods on dry and clean plastic pallets
- ▶ Check the incoming goods for visible moisture and make sure all material have no sign of mildew before production
- ▶ Measure moisture content of critical materials, reject the material with high risk of moisture

2. Prevention of Mold – Material Storage & Product Storage

- ▶ Store materials, finished products, semi-finished products and waste materials separately
- ▶ Store goods with high natural moisture content separately
- ▶ Keep relative humidity level in storage areas below 60%:
 - Install adequate, functioning dehumidifiers, fans for good air circulation and ventilation in the material and finished goods warehouse and maintain <60% humidity the whole day. Don't turn off at night, make sure the number and size of dehumidifiers is appropriate for the warehouse.
 - It is highly recommended not to use water cooling screen system for cooling and ventilation of finishing and packaging areas
- ▶ Keep old materials in separate place, not to be mixed with new material. Follow FIFO (first in, first out basis) for materials management.
- ▶ All packed cartons must be put on plastic pallets at a minimum of 12cm above the floor and at least 50~100cm from the windows
- ▶ Storage rooms should have proper roofs for protection during rainy weather, and the roofs and walls should not leak.
- ▶ For long term storage: need to carry out additional check by AQL plan to see any signs of mold every other week.

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V-Trust Team

Team-building



Together as a team, our new inspectors joined our headquarters staff on a tree-planting activity day in the outskirts of Guangzhou. These activities have given us a common purpose and the assurance of doing something good and giving something back to the world. Over 50 trees were planted by the river on that day!

Exhibition

This spring, V-Trust took part in more than 10 tradeshow in Asia including Mainland China, Hong Kong, and Vietnam. We shared many valuable tips with our visitors and got to know more about their main concerns when it comes to the quality of their products.



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3. Prevention of Mold – Production Phase

- ▶ **Prevention measures for wooden products:**
 - Dry the wooden material in the dryer equipment to keep the moisture content of raw material at appropriate content: regular drying method, high frequency drying or microwave drying method.
 - Regular drying method is to extract the moisture from the surface layer of wood, high frequency drying or microwave drying is a solid method to keep the even moisture content inside the whole wood, from the surface layer to the core, the wooden moisture content would be more stable.
 - Add the proper anti-mold agent into the lacquer before painted to the surface of wood.
 - Avoid using excessive glue inside the product.
- ▶ **Prevention measures for paper packaging box:**
 - Use the moisture meter to check the humidity of semi-products/finished products, should be no more than 12%, or it would be high risk of mold.
 - Add the anti-mold agent (for example:1~2% ASD-SX anti-mold agent) into the animal glue to cut down the nutrition of mold.
- ▶ **Prevention measures for textile products**
 - Leather and fabric materials should be kept in controlled environment with less than 40% relative humidity reading.
 - Washing process: Make sure the garment is washed cleanly, reduce the residual detergent as less as possible.
 - Drying process: Thoroughly dry all garment washed products while checking drying status of thicker seam and attachment parts.
 - Written controls must be in place at laundries to ensure drying cycle times and temperatures are accurately controlled and that control devices are monitored and calibrated.
 - Dryers and extractors must be well maintained and properly cleaned and rinsed between operations.
 - Ironing process: Do not apply water on iron shoes after heat setting.
 - Use steam irons with vacuum tables. Dry steam is required during final pressing.
 - Leave the garment on vacuum table for 5 seconds after pressing to remove the steam.
 - Add steam drying device to iron ducts to reduce steaming. The steam ducts of each pressing machine are connected and expel steam out of the building.
 - Garments (specially for the cotton or wool material) must be given 4 hours to dry and cool down after pressing and cleaning before poly bag packing in the drying room.
 - For any product made of suede (faux or real), leather or PU, recommend to use desiccant paper over the individual product or in the fold of the garment.
 - For the high moisture absorptive products (product with cotton or wool material as stuffing, e.g. quilt), the vacuum packing could be isolated air would be required.
- ▶ **Prevention measures for shoes**
 - Add the anti-mold agent to lamination glue or latex before the upper lamination process and all lamination materials should be cut within two days.
 - Install a cooling fan in the upper lamination machine to prevent uppers from absorbing moisture after lamination.
 - Cutting pieces stored in breathable plastic bags prior to stitching, the stitching required to commence 1-2 days after cutting.
 - The stitched uppers should run through a dryer before being placed into breathable plastic bags prior to lasting.
 - QC technician uses the moisture meter to check the semi-finished and finished product's humidity content.
 - All shoes, boxes, lids, put through a hot air drying tunnel as the last step of production just before closing the boxes.
 - Install properly functioning UV lights at the end of each production line, all semi-finished products or finished products should be subjected to appropriate heat and UV treatment to ensure they are completely dry before being stored.
- ▶ **Keep production areas dry, clean and ventilated**
 - Clean the production and packing area floor, conveyors & packing surface daily with bleach water or Formalin, then wipe dry with clean cloths.
 - Spray the floor and wall corners with bleach water or Formalin Monthly.
 - Install production areas with adequate, functioning fans for good air circulation and ventilation.
- ▶ **Keep equipment and support materials dry and clean**
- ▶ **Separate the wet processing areas**
- ▶ **Avoid unnecessary storage at production areas**
- ▶ **Use the moisture meter to check the semi-finished product and finished products**

4. Prevention of Mold – Packing Phase

- ▶ Wash hands with soap & water to remove grease & oil before returning to the line
- ▶ Make sure the packaging material : box / carton are dry and clean before packing
- ▶ Pack only fully dried products, make sure the products are completely dry before packed into box
- ▶ Add the desiccant (for example : silica gel)into the polybag / box / carton to absorb the moisture

5. Prevention of Mold – Loading and Shipping

- ▶ **Key measures to protect the products from mold damage during loading and shipping:**
 - Keep loading area dry and clean
 - Load only in dry condition or under protective cover: Care must be taken during the loading of the shipment to container particularly in wet weather conditions. Loading area should be properly and adequately covering the loading vehicles to avoid water getting into the cartons and vehicle.
 - Inspect container or trucks regarding visible damage, dirty, moisture and odor, make sure that the export container has no leaks in the roof and the floor is dry.
 - Measure the moisture content of wooden floors for container, should not exceed 20%
 - Ensure all containers have a sufficient quantity of calcium chloride-based shipping container desiccant such as Drypole or SUPER DRY. For the correct quantities, the guidelines are:
 - 3 bags of 1.5KG are recommended for 20 FT container.
 - 6 bags of 1.5KG are recommended for 40 FT container
 - Put the cartons on pallets inside container



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Regulation Updates



RoHS 3.0 (EU 2015/863)

RoHS 3.0 (EU Directive 2015/863), which takes effect July 22, 2019, adds Category 11 (catch-all) products and adds four new restricted substances - all phthalates. The four phthalates are mainly used as insulation plasticizers, and are on the REACH list of SVHC (Substances of Very High Concern). The expanded list for RoHS 3.0 is thus as follows:
Cadmium (0.01 %)
Lead (0.1 %)
Mercury (0.1 %)
Hexavalent chromium (0.1 %)
Polybrominated biphenyls (PBB) (0.1 %)
Polybrominated diphenyl ethers (PBDE) (0.1 %)
Bis(2-ethylhexyl) phthalate (DEHP) (0.1 %)
Butyl benzyl phthalate (BBP) (0.1 %)
Dibutyl phthalate (DBP) (0.1 %)
Diisobutyl phthalate (DIBP) (0.1 %)

Extention exemption: Of note is that medical devices have a two-year extension to meet RoHS 3.0 compliance:

"The restriction of DEHP, BBP, DBP and DIBP shall apply to medical devices, including in vitro medical devices, and monitoring and control instruments, including industrial monitoring and control instruments, from 22 July 2021."

Category 11 products include all other electronic and electrical equipment not covered under the other categories. Included are 2-wheeled vehicles, electronic nicotine delivery systems (ENDS) such as e-cigarettes, cannabis vaporizers and vape pens. Also included are electrical cables that are less than 250V working voltage.

Insights



10 Most Common Defects Every Buyer Should Know About LED

LED LIGHTING | Sourcing lighting products from Asia allows you to find innovative products for a reasonable cost, but even though more tempting import opportunities open in China, as well as India and Vietnam, the Quality issues would remain your #1 concern when production is outsourced.Forewarned is forearmed! We have prepared a short list of the 10 common defects in lighting products that were found on the inspection sites of suppliers in China, India and Vietnam.

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Upcoming Fairs

China (Guangzhou) International Building Decoration Fair



08-11 July 2019
Guangzhou, China