

LITTLE WORLD STUDIOS

ZARA

PVC Collectible Figure Factory Specification & Pre-Production Control Plan

Document	Value
Brand / World	Little World Studios / Safari Adventures
Character	Zara - hippopotamus character
Product format	Freestanding PVC collectible figure
Nominal size class	6-8 cm collection
Specification status	V1.0 - RFQ and first prototype
Issue date	29 July 2026
Owner	Little World Studios
Source reference	littleworldstudios.com/collectible-figures/safari-adventures/zara

CONTROLLED DOCUMENT

This document defines the commercial and quality requirements for quotation and sample development. Final tooling may begin only after written approval of the 3D sculpt, dimensions, colour standards, decoration map, packaging artwork and signed golden sample.

CONFIDENTIAL - FOR APPROVED MANUFACTURING PARTNERS ONLY

1. Product Definition

DESIGN INTENT

A premium, child-friendly interpretation of Zara that remains faithful to the approved Safari Adventures artwork. The figure must read clearly as Zara at shelf distance, stand securely, feel smooth and substantial, and match the visual language of the full 42-character collection.

1.1 Product architecture

Item	Requirement	Control status
SKU / item code	LWS-PVC-SA-ZARA-01 (working code)	Confirm before PO
Figure type	Single freestanding character; no display base unless later approved	Required
Target age grading	3+ years (subject to final market risk assessment and test plan)	Provisional
Nominal finished height	70 mm target; acceptable design envelope 60-80 mm	CAD confirmation
Target width / depth	Proportionally derived from approved sculpt; factory to declare exact maximum dimensions	CAD confirmation
Target net weight	75-110 g, subject to wall thickness and centre-of-gravity study	Sample confirmation
Pose	Stable, friendly, collection-consistent pose; must stand unaided on a flat surface	Artwork/CAD approval
Part count	Prefer one-piece or permanently bonded construction; minimise seams	DFM proposal
Collection compatibility	Scale, eye line, finish and perceived volume to align with other 6-8 cm figures	Line review

1.2 Critical-to-quality features

CTQ	Acceptance requirement
Character likeness	Head/body proportions, muzzle, ears, eyes, nostrils, expression and silhouette must match approved Zara master artwork.
Facial alignment	Eyes and facial decoration visually level and symmetrical; no wandering gaze or mismatched highlights.
Stability	Figure remains upright on a smooth horizontal surface and after light manual disturbance; no visible rocking.
Surface quality	No sharp edges, burrs, sink marks, flow lines, severe parting lines, dents, contamination or glossy patching.
Colour consistency	All moulded and painted colours match signed colour chips / golden sample under D65 lighting.
Safety	No accessible sharp point/edge; no detachable small parts after applicable use-and-abuse testing for final age grade.

2. Visual Reference & Dimensional Control

The factory shall prepare orthographic front, rear, left, right and top views from the approved 3D sculpt. The web character image is a likeness reference only; it is not production CAD.

FRONT VIEW	REAR VIEW	LEFT VIEW
Insert approved orthographic render or CAD view	Insert approved orthographic render or CAD view	Insert approved orthographic render or CAD view
RIGHT VIEW	TOP VIEW	BOTTOM / DATE CODE
Insert approved orthographic render or CAD view	Insert approved orthographic render or CAD view	Insert approved orthographic render or CAD view

2.1 Measurement schedule

Ref.	Measurement	Nominal	Tolerance / requirement
A	Overall height	70.0 mm proposed	+/- 0.8 mm after golden sample lock
B	Maximum width	Factory to propose	+/- 0.8 mm
C	Maximum depth	Factory to propose	+/- 0.8 mm
D	Foot/contact span	CAD-defined	Sufficient for stability; no rocking
E	Minimum external radius	2.0 mm preferred	No sharp accessible edge or point
F	Decoration registration	CAD/print jig-defined	+/- 0.5 mm; face +/- 0.3 mm preferred
G	Parting-line witness	At approved hidden route	<= 0.20 mm raised witness after finishing
H	Bond-line gap	If multi-part	<= 0.20 mm, consistent and clean

FACTORY ACTION

Return a dimensioned 2D drawing and rotatable 3D file (STEP or equivalent) showing part splits, shut-offs, draft angles, gate location, ejector positions, decoration masks, centre of gravity and declared finished weight.

3. Materials, Colour & Decoration

3.1 Bill of materials

Component	Preferred specification	Prohibited / restricted	Evidence required
Main body	Phthalate-compliant soft PVC or factory-recommended equivalent suitable for detailed collectible figures; consistent durometer	Recycled unknown-origin PVC; lead, cadmium, restricted phthalates or substances above applicable limits	Material declaration, SDS/TDS, lot traceability
Permanent inserts	Only if essential; fully encapsulated and corrosion resistant	Loose metal, magnets, accessible fasteners	Construction drawing and risk assessment
Adhesive	Toy-safe permanent adhesive compatible with substrate; minimal controlled application	Brittle or solvent-migrating adhesive; exposed residue	SDS and bond validation
Paint / ink	Toy-grade, abrasion-resistant coating system compatible with PVC and approved for intended markets	Heavy metals, restricted solvents or migration above limits	Ink/paint declaration and test evidence
Packaging	FSC-certified board preferred; recyclable mono-material approach where possible	Unnecessary PVC blister where a safer/recyclable format works	Board grade and packaging BOM

3.2 Colour standard schedule

Zone	Description	Pantone / master	Finish	Approval
C01	Primary body colour	TBD from approved Zara artwork	Low satin / soft-touch visual	Spray-out chip + sample
C02	Muzzle / secondary body	TBD	Low satin	Spray-out chip + sample
C03	Inner ears / cheek accent	TBD	Low satin	Spray-out chip + sample
C04	Eyes - white	Approved master chip	Satin	Face master
C05	Pupils / lashes / outline	Approved deep neutral	Satin	Face master
C06	Nostrils / mouth detail	TBD	Satin	Face master
C07+	Clothing/accessory colours, if present	TBD after artwork lock	As approved	Decoration map

Colour is approved by physical signed chip and golden sample, not by monitor appearance. Production target: visual match under D65 and TL84; instrumental tolerance Delta E00 <= 2.0 for large flat colour zones where measurement is technically valid.

3.3 Decoration rules

Method	Requirement
Selection	Factory to propose pad print, spray mask, hand spray or combination that delivers crisp, repeatable facial detail.
Registration	No overlap into adjacent moulded zones unless artwork requires it. Facial features receive the tightest registration control.
Opacity	Even coverage with no substrate show-through, pinholes, overspray, feathering, pooling or colour contamination.
Durability	Decoration must survive applicable adhesion, rub, perspiration/saliva simulation and use-and-abuse testing.
Finish	No uncontrolled gloss mismatch; face remains clean, friendly and consistent across production.

4. Engineering, Tooling & Assembly

Control	Requirement
Sculpt development	Factory creates manufacturable 3D sculpt from approved artwork. Preserve silhouette and expression; submit screen rotations before rapid prototype.
Draft and undercuts	Apply sufficient draft for repeatable demoulding without visibly changing the character. Any compromised feature needs written approval.
Part splits	Hide splits on natural colour breaks or low-visibility surfaces. Do not route seams through eyes, mouth or primary face.
Wall / mass design	Optimise for consistent cure/cooling, no sink, voids or deformation. Factory declares construction (solid, slush, rotational, injection or hybrid).
Gate / vent / ejector	Place on rear, underside or concealed surface. Witness marks must not affect display view or stability.
Assembly	Permanent joining only. Bonded or welded parts must resist applicable torque, tension, impact and drop testing.
Base contact	Minimum three stable contact points or controlled planar contact. Bottom shall be flat enough to prevent rocking.
Markings	Discrete underside marking: copyright / brand, item code, batch or date code, country of origin and required conformity marks where applicable.
Tool ownership	Tooling is exclusive to Little World Studios and may not be copied, modified, moved, used or destroyed without written permission.
Tool maintenance	Factory maintains mould, logs shots/repairs and preserves approved texture and dimensions throughout programme life.

4.1 Prototype and approval gates

Gate	Submission	Approval required before
G0 - DFM	Part split, process, material, tooling proposal, risks and costed options	3D sculpt completion
G1 - Digital sculpt	360-degree render, scale comparison, dimensions, centre of gravity	Physical prototype
G2 - Prototype	Unpainted high-resolution sample plus paint master	Steel tooling
G3 - T1	First-off moulded parts, measurement report, defect review	Tool correction / decoration fixtures
G4 - Decorated PP	Minimum 3 complete decorated samples in final materials	Compliance testing and pilot
G5 - Golden sample	Signed/sealed master plus approved packaging	Mass production
G6 - Shipment sample	Random packed units and QC report from production lot	Final release / shipment

NO TOOLING RELEASE A quotation or email acknowledgement is not tooling approval. The factory must receive a written tooling-release instruction referencing the approved sculpt revision.

5. Quality Control & Compliance

5.1 Inspection plan

Stage	Inspection	Minimum control
Incoming	PVC, paint/ink, adhesive, board and accessories	Approved supplier/lot; COA or declaration; colour and contamination check
First article	Dimensions, weight, assembly, decoration, stability, appearance	Full report against signed golden sample
In-process	Moulding, trim, paint registration, bonding, code marking	Documented hourly / batch checks; segregate nonconforming parts
Final	Workmanship, colour, function, quantity, packaging, barcode, carton	Pre-shipment inspection under agreed AQL
Retention	Finished samples and material lot records	Minimum 24 months after production, or longer if law/PO requires

Recommended pre-shipment AQL (ISO 2859-1, General Level II unless PO says otherwise): Critical 0; Major 1.5; Minor 2.5. A critical safety or regulatory failure rejects the lot regardless of statistical acceptance.

5.2 Defect classification

Class	Examples	Disposition
Critical	Safety hazard; prohibited substance; failed small-parts/sharp-point requirement; wrong regulatory marking; contamination	Zero tolerance; lot hold and corrective action
Major	Wrong character/colour; cannot stand; missing component; severe face misprint; open joint; major deformation; barcode failure	AQL 1.5 proposed
Minor	Small hidden paint speck; slight non-display seam witness; minor package rub not affecting presentation	AQL 2.5 proposed

5.3 Market compliance matrix

Market	Baseline standards / regulations to assess	Status
European Union	Toy Safety Directive 2009/48/EC; EN 71-1, EN 71-2, EN 71-3; REACH including restricted phthalates; applicable packaging/EPR rules	Test scope to be confirmed
United Kingdom	UK Toys (Safety) Regulations; designated EN 71 standards; UK REACH and labelling requirements	Test scope to be confirmed
United States	ASTM F963; CPSIA including lead and applicable phthalates; tracking label; CPC based on CPSC-accepted testing where required	Test scope to be confirmed
Canada	Canada Consumer Product Safety Act and Toys Regulations; applicable chemical and mechanical requirements	Test scope to be confirmed
Australia / New Zealand	Applicable AS/NZS ISO 8124 series and mandatory consumer product safety requirements	Test scope to be confirmed

The final importer/distributor, selling markets, age grade and packaging format determine the legally required test programme. Use an accredited third-party laboratory and submit reports in the exact product/material configuration before shipment.

6. Packaging, Labelling & Logistics

6.1 Recommended retail packaging brief

Element	Requirement
Format	Premium recyclable window carton or secure carded format; figure clearly visible; no loose movement or paint rub.
Internal restraint	Paper-based insert preferred. If a clear formed insert is required, use minimum material and declare resin/recycling code.
Pack orientation	Zara faces forward, upright, centred and level. Facial features unobstructed.
Protection	Pass agreed transit simulation without crushed corners, scuffed decoration, deformation or component release.
Consumer information	Product name, character/world, age grading, warnings, contents, responsible economic operator/importer, origin, traceability code, barcode and conformity marks as applicable.
Artwork control	Factory may not alter copy, logo, colours, barcode or legal marks. Print only from approved released artwork PDF.
Suffocation warning	Assess based on bag dimensions/thickness and target markets. Avoid unnecessary individual polybags.
Tamper / access	Pack shall discourage in-store removal while remaining practical for consumer opening under the approved age grade.

6.2 Working dimensions and logistics data

Data field	Factory return / proposal
Retail pack external size (L x W x H)	TBD after figure and pack engineering
Gross retail pack weight	TBD
Inner pack quantity and size	Factory proposal
Master carton quantity	Factory proposal optimised for transport and handling
Master carton external size	TBD; declare in cm
Master carton gross / net weight	TBD; declare in kg
Carton board grade	Export quality; factory to state ply and burst/ECT performance
Pallet pattern	By destination and retailer requirement
Barcode	GS1 data supplied by Little World Studios / licensee
Shipping marks	PO, SKU, character, colour, quantity, carton number, dimensions, weights, origin and handling marks

6.3 Transit validation

Factory to propose an ISTA-aligned or retailer-specific transit test appropriate to pack format and distribution route. At minimum evaluate carton drop, vibration/compression, high-temperature storage where relevant, paint transfer, window scuffing and pack retention.

SUSTAINABILITY TARGET

Minimise mixed materials, eliminate unnecessary plastic, optimise cube efficiency, and provide packaging material weights by component to support future EPR and retailer reporting.

7. Factory Quotation & Approval Return

The supplier shall return a completed, signed response with the quotation. Blank fields are not acceptance.

Commercial / technical item	Factory response
Unit price by quantity break	3,000 / 5,000 / 10,000 / 25,000 units
Tooling cost and cavity count	
Sample / sculpt / decoration setup cost	
Recommended manufacturing process	
Declared material and durometer	
Estimated net figure weight	
Development lead time	DFM / sculpt / prototype / T1 / PP / production
Mass-production lead time	
MOQ and colour MOQ	
Pack-out and master carton proposal	
Compliance testing allowance	
Payment terms / Incoterm / port	
Tool life and maintenance terms	
Known risks / deviations	

7.1 Required submission package

#	Deliverable	Included / due date
1	Signed specification acknowledgement and deviation list	
2	DFM report and dimensioned drawing	
3	3D sculpt files and 360-degree renders	
4	BOM, material declarations, SDS/TDS and colour proposal	
5	Tooling layout, cavity count, part splits and maintenance plan	
6	Decoration map and process capability proposal	
7	Retail pack and master carton dielines / specifications	
8	Compliance test plan and accredited laboratory quotation	
9	Project timeline with approval gates	
10	Quality plan, AQL agreement and traceability method	

7.2 Sign-off

Role	Name / company	Signature	Date
Factory engineering			
Factory quality			
Factory commercial			
Little World Studios approval			

REVISION CONTROL

Any deviation from this specification requires written approval. The latest signed revision, approved artwork, approved CAD, golden sample and purchase order together form the production standard.