

KOHL'S

Apparel Pattern Application









KOHL'S TECHNICAL DESIGN | March 2026

AGENDA

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Kohl's Pattern Requirements

PATTERN/CAD SOFTWARE: Kohl's Technical Designers use Browzwear V-stitcher to open, view, and analyze patterns. Below are CAD pattern file types and compatibility:

File Extension	File Type	Acceptable for Kohl's
.dxf	Standard Universal CAD pattern file format.	 Kohls is only able to accept .dxf patterns exported as ASTM or AAMA .dxf file format.  Kohls is NOT able import .dxf <i>standard AutoCAD</i> file format.
.aam	.aam standard CAD pattern file may be .aam or .dxf after 2D pattern file is exported as AAMA format.	 Yes
.bw	Browzwear file	 Yes: Kohl's can also accept 2D patterns in Browzwear V-stitcher* even if style is missing 3D details. <i>* Please verify Browzwear version/release with your KTD before uploading. Kohl's IT determines when we are able to update to the newest software release.</i>
.rul	Universal CAD grade rule file	 Yes
.txt	Universal CAD grade rule file	 No - only able to accept .rul grade rule files. some .aam dxf files may automatically include grade information without a separate grade rule file.
.zip	Compressed File Folder containing one or multiple files and file types.	 Yes: Pattern and grade rule files must be combined together as a .zip file before uploading in OnePLM and will need to be extracted once the .zip file folder is downloaded. .BW files must also be compressed as a .zip file before uploading in OnePLM.
.dsn or .pds	Optitex CAD pattern	 No - Kohl's Technical Design team no longer uses Optitex pattern software for reviewing patterns

Kohl's Pattern Requirements

All Fit/3D/PP Fit samples must include an electronic pattern file. 2D & 3D patterns should be the same pattern.

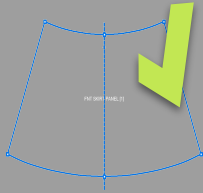
Remove any
non-latin
characters



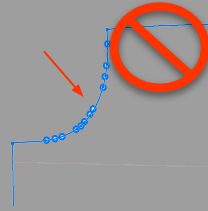
Working
Units =
Inches
Export
Patterns in
Inches.



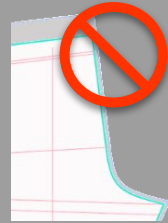
Use pattern piece
symmetry where
possible.



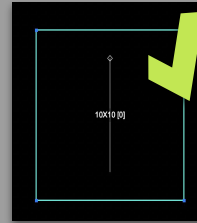
Delete/
Reduce
excessive
points.



Export **NET**
pattern or Sew
Lines.
(No Seam
allowances or
shrinkage)



10X10 inch
square pattern
piece

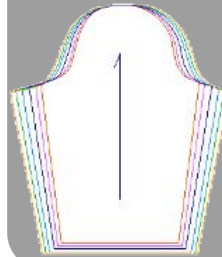


Ensure
pattern is
exported in
DXF (ASTM)
or
DXF or .aam
(AAMA)



PP Pattern Only

**Include Grading
& Grade Rule file
(.rul)**



1. Include all pattern pieces in production pattern marker - including facings and pockets. Follow pattern piece naming guidelines and digital fit requirements in [Sample Standard Output requirements](#) for 3D found in DPC on K-Link.
 - 2D: Only exclude pattern pieces that are not included in production marker-bindings, slit goods.
 - 3D: Label patterns added for 3D simulation (ex. bindings, belt loops, any slit goods) as **3D simulation only**.
2. Follow [Vendor Pattern Attachment Naming convention](#) found in CTD OnePLM Manual on K-Link.
3. Follow instructions for [Uploading Patterns](#) found in CTD OnePLM Manual on K-Link.
 - Fit = OnePLM Fit Evaluation Attachments
 - 3D: Counter and Fit Images = OnePLM Fit Evaluation Attachments
 - 2D and 3D PP = OnePLM Overview Attachments Tab

Kohl's Pattern Requirements



CORRECT PATTERN EXAMPLE: See [APPENDIX A](#) for Pattern Export/Import Settings

VStitcher 2023.1 - KOS-WMT7M12-1903_D_120820 - P1-S24-R-WM34K005-JSY-N-VDR - Size: (10) *

File Edit View Tools 3D Environment Garment Help

Pattern file name follows Pattern Naming Convention

The screenshot displays the VStitcher software interface with a pattern layout. The interface includes a top menu bar, a toolbar with icons for Select, Texture, Stitch, Assign, Insert, Pen, Annotate, and Arrange, and a main workspace. The workspace shows a pattern layout with various pieces and lines. Annotations in red text and arrows point to specific features:

- Pattern = NET pattern shape**
No Seam Allowances are included on pattern pieces
- Internal lines included for measurement verification**
- Pattern includes 10" x 10" square**
- Symmetrically shaped pieces have internal symmetry**

The pattern pieces are labeled in the left sidebar:

- 10x10 SCALE [11]
- 3D simulation bk nk tape [25]
- WM34K005-NK TRM [14]
- WM34K005-BK [12]
- WM34K005-FRT [13]
- WM34K005-WL L SLV [21]
- WM34K005-WR L SLV [10]

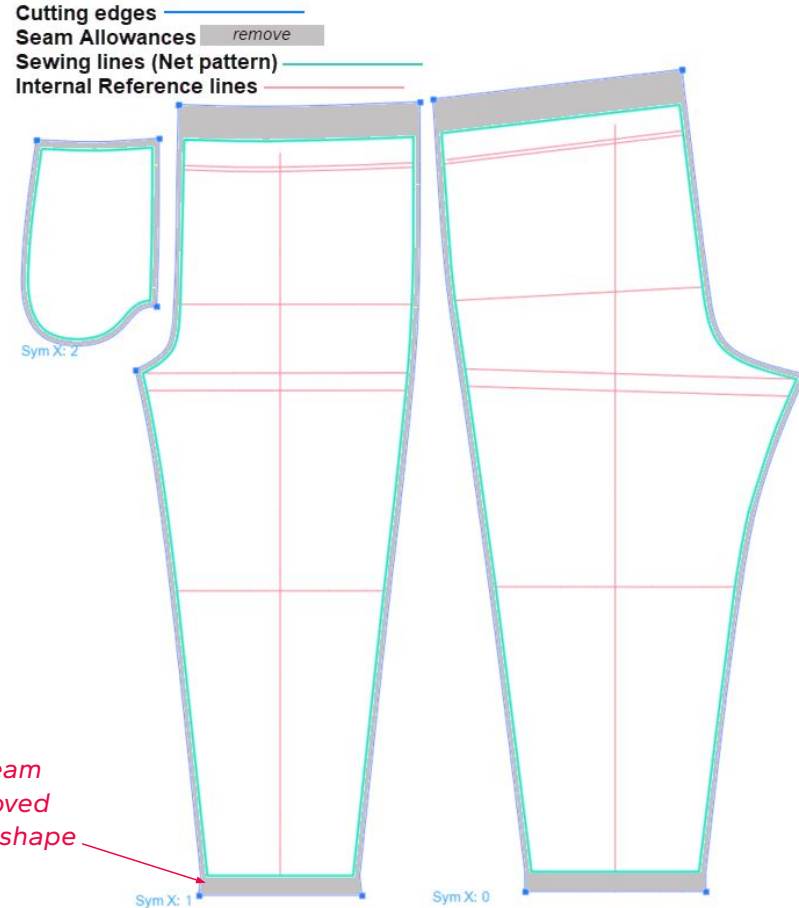
The text **Pattern Pieces are clearly labeled** is also present in the bottom left of the sidebar area.

Pattern Definitions - Net


NET PATTERN: The actual sewing lines or sewing pattern shape used to make the fit sample.

- Does not include seam allowance, hems, shrinkage, and production sewing allowances.
- Should measure close to finished garment specs (*or within tolerance*).
- **Main body pattern shape: 2D & 3D patterns should be the same - 3D exceptions:**
 - Bindings/tapes that are cut as slit goods, fed on a roll in production, & not cut in pattern marker can be simulated patterns in 3D. (see example).
 - Turn back hems/waistbands may be simulated using force multiplier in 3D

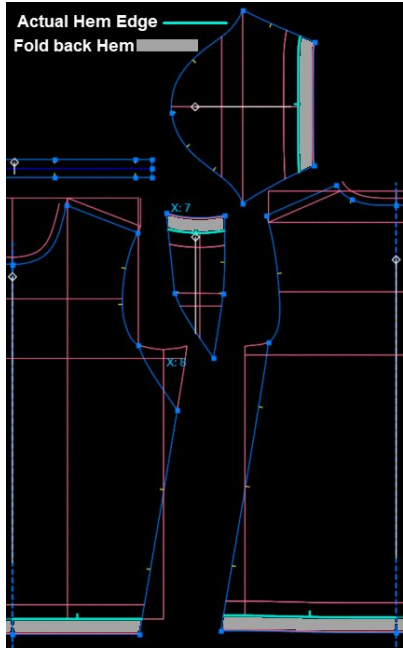
The gray area represents the seam allowances that should be removed before submitting NET pattern shape to Kohls.




Pattern Definitions - Net

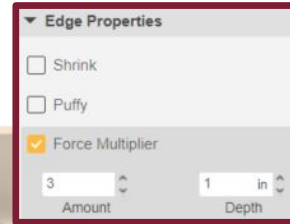
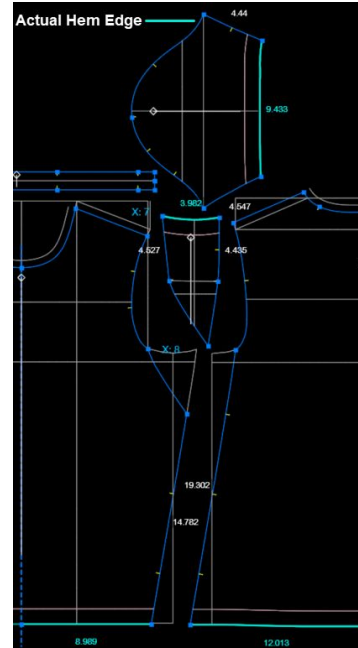
 **NET PATTERN:** Incorrect Hem Application 3D pattern
Example

*Fold back hem included in NET pattern.
NET pattern shape is not the same between 2D & 3D pattern.*



 **NET PATTERN:** Correct Hem Application 3D pattern
Example

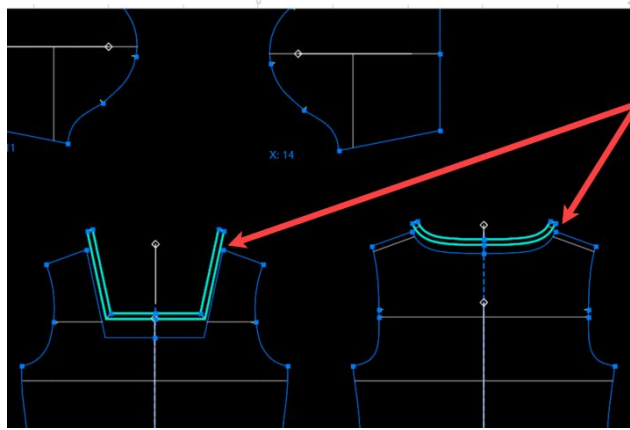
*Force Multiplier used to simulate hem thickness.
NET pattern shape is the same between 2D & 3D pattern.*



Pattern Definitions - Net

❌ NET PATTERN: Incorrect Binding Application 3D pattern Example

3D pattern and 2D pattern body shapes are not the same



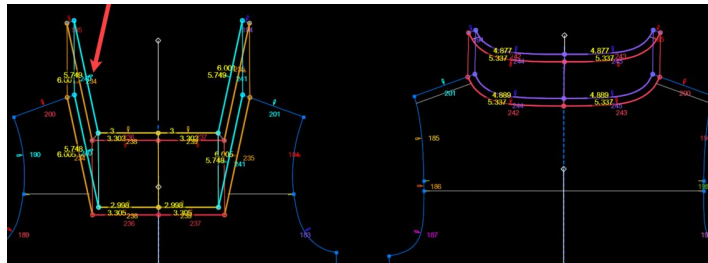
Pattern is not actual sewing pattern - the neck binding has been cut away from the neck opening so it is 'set in' instead of top applied



✅ NET PATTERN: Correct Binding Application 3D pattern Example

Simulated Binding pieces are stitched to internal lines and edges of pattern to simulate top applied neck binding. The Net Pattern shape integrity of front/back pattern pieces has been maintained.

Example of 3D binding simulation that maintains the same body shape as the physical 2D sample pattern



Pattern Definitions - Reference

REFERENCE PATTERN: Final graded PP pattern that is used as a starting point by Kohl's TD's for new pattern/style development.

- May or may not have same style # as the new style.
- Provided for reference of pattern balance, shaping, styling details.
- May include style lines from the reference style.
- Several reference patterns may be used to combine different pattern components together to make the new style.
- Usually created by our vendors, they may not always represent Kohl's NET PATTERN guidelines.

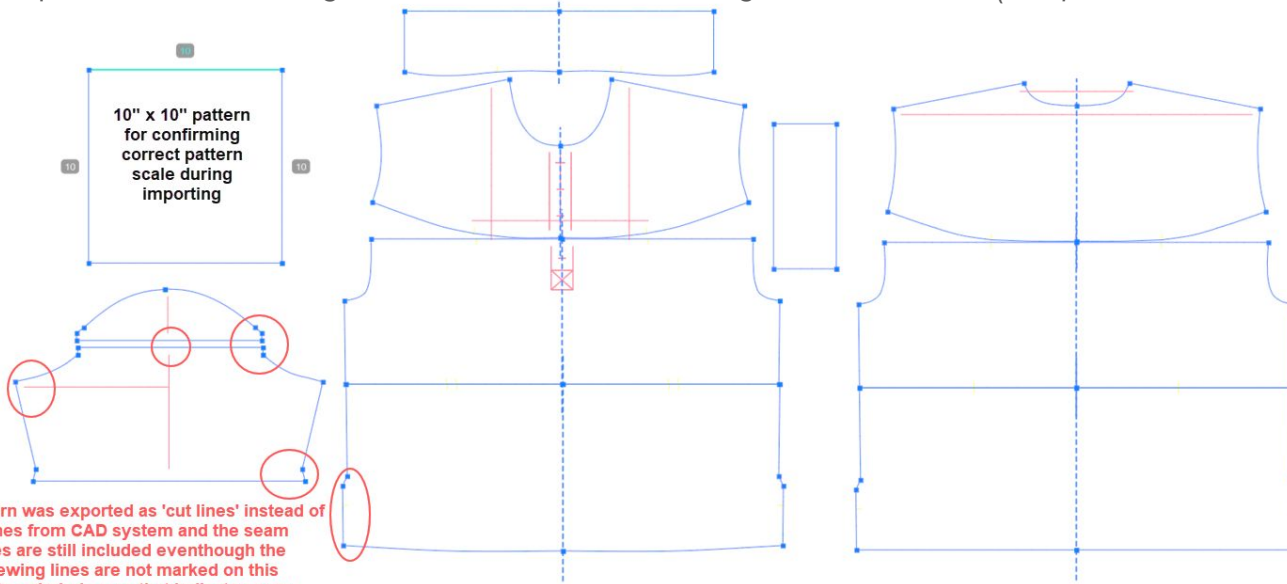
The patternmaker should always review the reference pattern measurements vs the new style measurements to verify that the reference pattern does not include seam allowances, production sewing allowances, and shrinkage before using the pattern for new style development.

If there is a concern with following the reference pattern shape, the patternmaker/CTD should contact the KTD with any questions or concerns or suggest options in 3D that could further improve the fit of the garment.

Pattern Definitions - Reference

❌ Example of imported pattern that still has seam allowances included:

- ❑ Square measures 10"x10" (scale is correct)
- ❑ Seam allowances are still included (see shapes of sleeve/bottom hem)
- ❑ No exported internal sewing lines to reference for removing seam allowances (this pattern is not usable)



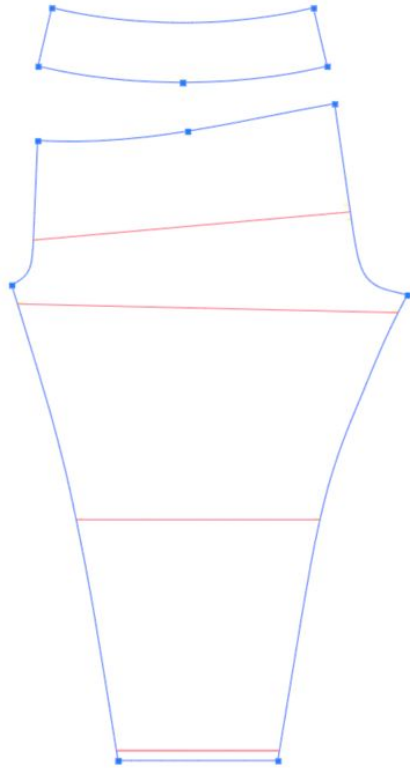
This pattern was exported as 'cut lines' instead of sewing lines from CAD system and the seam allowances are still included eventhough the internal sewing lines are not marked on this pattern. See circled areas that indicate seam allowances are still included on the pattern.



If all vendors follow the NET pattern guidelines, it will be easier to use Reference patterns!

Pattern Definitions - Block

BLOCK PATTERN: NET pattern shape but without style lines. Block pattern can be used as starting point for developing other styles. May have a unique block style #. These are PROVEN patterns for shape and balance that should be followed with minimal deviations.



*This no outseam leggings pattern is an example of a **block pattern** that may be used as a consistent starting pattern for all other leggings styles with seams/piecing details to maintain consistent fit/shaping across all leggings styles.*



Where to Find Patterns

ONEPLM TECH SPEC ATTACHMENTS: KTD provided reference or block patterns for style development. Multiple patterns may be attached with instructions in the 'Description' field for how the reference patterns may be combined to create the new style.




If no pattern provided - ask the KTD if there is a pattern that can be referenced.

Style: WM41W012

Overview Design Intent Constructions Instructions POM Samples BOM **Attachments** Indicators Events >>

▼ Attachments

Attachments Report

<input type="checkbox"/>	Sort	Attachment No	Attachment Type	File Name	Description	Attached By	Date Attached
<input type="checkbox"/>		1	IMAGE	--Select--	 WM41W012 SMOCKED BABYDOLL TOP.ai	OLIVIA-CAPRI FARRELL	2023-06-15 07:49:41
<input type="checkbox"/>		IMG2	--Select--	 Screen Shot 2023-08-02 at 7.43.31 PM.p...	*REFERENCE OF SMOCKING LAYOUT	OLIVIA-CAPRI FARRELL	2023-08-02 19:45:05
<input type="checkbox"/>		REF PATTERN	PATTERN FILE	 P1-FA23-R-WM33W507-RYNC-GUZ-N-SH...	P1-FA23-R-WM33W507-RYNC-GUZ-N.ZIP - REFERENCE PATTERN	JERILYN BOOTH	2023-06-18 10:46:32

Click 'L' to download file. File may be .zip compressed file and need to be 'extracted' before importing pattern file.

Where to Find Patterns

ONEPLM FIT LIBRARY: Pattern Library by brand and category can be used for all styles including Vendor Owned and Vendor Collaboration style development for accurate fit starting point. Includes:

- Reference or Block Patterns
- Body Landmarks specific to the brand/category
- Specification charts and images of approved core fits.

If OnePLM search does not bring up the Fit Library listed on the Fit Library Index chart, email the the KTD. Your vendor information may need to be added to the OnePLM Tech Spec bid line in order to see the Fit Library.

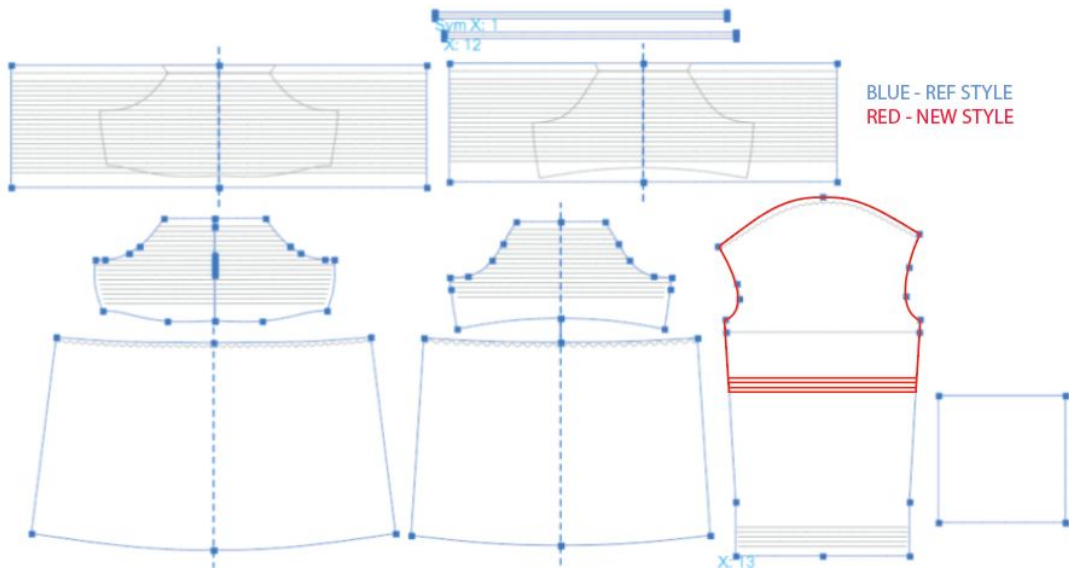
FIT LIBRARY INDEX									
**USE DEVELOPMENT STAGE AS "COSTING" FOR ALL FILES									
Fit Libraries may be updated after Benchmark. Use Fit Library in Development Season most relevant to current Style.									
NAME OF 1PLM FILE DESCRIPTION	STYLE NO	CUSTOMER	BUSINESS	TD Manager/ Contact Info	BRAND	GARMENT TYPE	SEASON	REQUEST #	LAST UPDATE
LIBRARY: MENS ACTIVE TOPS&BTMS/TG/FILA	FIT LIBRARY: MENS ACTIVE TOPS&BTMS	MENS	ACTIVE	Cheri.Andressek@kohls.com	TG/FILA	TOPS & BOTTOMS	SP18	00398663	UPDATED 6-6-17
LIBRARY: MENS BTMS/ALL BRANDS	FIT LIBRARY: MENS BTMS/ALL BRANDS	MENS	SPORTSWEAR	Cheri.Andressek@kohls.com	ALL	BOTTOMS	SP18	00398667	UPDATED 6-6-17
LIBRARY: MENS TOPS/ALL BRANDS	FIT LIBRARY: MENS TOPS/ALL BRANDS	MENS	SPORTSWEAR	Cheri.Andressek@kohls.com	ALL	TOPS	SP18	00398665	UPDATED 6-6-17
LIBRARY: YMTOPS&BTMS/ALL BRANDS	FIT LIBRARY: YMTOPS&BTMS/ALL BRANDS	YM	SPORTSWEAR	Cheri.Andressek@kohls.com	ALL	BOTTOMS	SP18	00370971	UPDATED 6-6-17
LIBRARY: BOYS 8-20 TOPS&BTMS/ALL BRANDS	FIT LIBRARY: BOYS 8-20 TOPS&BTMS	BOYS 8-20	SPORTSWEAR	Cheri.Andressek@kohls.com	ALL	TOPS	SP18	00370467	UPDATED 6-6-17
LIBRARY: GIRL 50-7-TOPS-DRESSES-10F 4	FIT LIBRARY: GIRL 50-7-1	GIRLS 0-7	SPORTSWEAR	Andrea.Peasde@kohls.com	ALL	TOPS & DRESSES	SP18	00420334	UPDATED 9-12-17
LIBRARY: GIRL 50-7-BOTTOMS-2 OF 4	FIT LIBRARY: GIRLS 0-7-2	GIRLS 0-7	SPORTSWEAR	Andrea.Peasde@kohls.com	ALL	BOTTOMS	SP18	00420333	UPDATED 9-12-17
LIBRARY: BOYS 0-7-BOTTOMS-3 OF 4	FIT LIBRARY: BOYS 0-7-2	BOYS 0-7	SPORTSWEAR	Andrea.Peasde@kohls.com	ALL	BOTTOMS	SP18	00420331	UPDATED 9-12-17
LIBRARY: BOYS 0-7-TOPS-4 OF 4	FIT LIBRARY: BOYS 0-7-1	BOYS 0-7	SPORTSWEAR	Andrea.Peasde@kohls.com	ALL	TOPS	SP18	00420327	UPDATED 9-12-17
LIBRARY: WMIN5-APT 3	FIT LIBRARY: WMIN5-APT 3	WOMENS	ACTIVE	Michal.Sedivy@kohls.com	SONOMA	ALL GARMENTS	SP18	00374166	UPDATED 6-7-17
LIBRARY: WMIN5-SONOMA	FIT LIBRARY: WMIN5-SONOMA	WOMENS	SPORTSWEAR	Michal.Sedivy@kohls.com	SONOMA	ALL GARMENTS	SP18	00380122	UPDATED 6-7-17
LIBRARY: WMIN5-C&B	FIT LIBRARY: WMIN5-C&B	WOMENS	SPORTSWEAR	Michal.Sedivy@kohls.com	C&B	ALL GARMENTS	SP18	00380123	UPDATED 6-7-17
LIBRARY: WMIN5-PLUS-MLWALKEE	FIT LIBRARY: WMIN5-PLUS-MKE	WOMENS	SPORTSWEAR	Michal.Sedivy@kohls.com	ALL	ALL GARMENTS	SP18	00423674	CREATED - Available after 10/1
LIBRARY: WMIN5-TEK DEAR	FIT LIBRARY: WMIN5-TEK DEAR	WOMENS	ACTIVE	Jerilyn.Booth@kohls.com	TEK DEAR	TOPS & BOTTOMS	SP18	00435398	CREATED - Available after 10/1
LIBRARY: WMIN5-SLEEPWEAR/C&B	FIT LIBRARY: WMIN5-SLEEPWEAR/C&B	WOMENS	SLEEPWEAR	Jerilyn.Booth@kohls.com	C&B	TOPS & BOTTOMS	FA18	00440106	Ready to bid - Available after 3/18
LIBRARY: WMIN5-SLEEPWEAR/SONOMA/APT 3	FIT LIBRARY: WMIN5-SLEEPWEAR/SONOMA/APT 3	WOMENS	SLEEPWEAR	Jerilyn.Booth@kohls.com	SONOMA	TOPS & BOTTOMS	FA18	00440107	CREATED - Available after 10/1
LIBRARY: MATERNITY A GLOW	FIT LIBRARY: MATERNITY A GLOW	WOMENS	MATERNITY	Jerilyn.Booth@kohls.com	A GLOW	ALL GARMENTS	SP18	00426643	CREATED 6-26-17
LIBRARY: JR-SPRTSWEAR-SO-TOPS-DRESS	FIT LIBRARY: JRS-1	JUNIORS	SPORTSWEAR	Lisa.Vetch@kohls.com	SO	TOPS & DRESSES	SP18	00439905	3/15/17
LIBRARY: JR-SPRTSWEAR-SO-BTMS	FIT LIBRARY: JRS-2	JUNIORS	SPORTSWEAR	Lisa.Vetch@kohls.com	SO	BOTTOMS	SP18	00433143	3/15/17
LIBRARY: JR-ACTIVE-SO-ALL GARMENTS	FIT LIBRARY: JRS-3	JUNIORS	ACTIVE	Lisa.Vetch@kohls.com	SO	ALL GARMENTS	SP18	00442222	3/15/17
LIBRARY: JR-SPRTSWEAR-MIDD-TOPS-DRESS	FIT LIBRARY: JRS-4	JUNIORS	SPORTSWEAR	Lisa.Vetch@kohls.com	Mudd	TOPS & DRESSES	SP18	00442114	3/15/17
LIBRARY: JR-SPRTSWEAR-MIDD-BTMS	FIT LIBRARY: JRS-5	JUNIORS	SPORTSWEAR	Lisa.Vetch@kohls.com	Mudd	BOTTOMS	SP18	00433175	3/15/17
LIBRARY: G 7-16-SPRTSWEAR-ALL-TOPS-DRESS	FIT LIBRARY: GIRLS 7-16-1	GIRLS 7-16	SPORTSWEAR	Lisa.Vetch@kohls.com	SOIMudd	TOPS & DRESSES	SP18	00426932	7-31-17
LIBRARY: G 7-16-SPRTSWEAR-ALL-BTMS	FIT LIBRARY: GIRLS 7-16-2	GIRLS 7-16	SPORTSWEAR	Lisa.Vetch@kohls.com	SOIMudd	BOTTOMS	SP18	00433155	8-2-17
LIBRARY: G 7-16-ACTIVE-SO-TOPS & BTMS	FIT LIBRARY: GIRLS 7-16-3	GIRLS 7-16	ACTIVE	Lisa.Vetch@kohls.com	SO	TOPS & BOTTOMS	SP18	00431747	7-31-17
LIBRARY: G 7-16-SLEEP-SO-ALL GARMENTS	FIT LIBRARY: GIRLS 7-16-4	GIRLS 7-16	SLEEPWEAR	Lisa.Vetch@kohls.com	SO	ALL GARMENTS	SP18	00432662	7-31-17
LIBRARY: G 7-16-OUTERWEAR-SO-JACKETS	FIT LIBRARY: GIRLS 7-16-5	GIRLS 7-16	OUTERWEAR	Lisa.Vetch@kohls.com	SO	ALL GARMENTS	SP18	00423582	7-31-17
LIBRARY: WMIN5-ELLE	FIT LIBRARY: WMIN5-ELLE	WOMENS	SPORTWEAR	mainuoung.ton@kohls.com	ELLE	ALL GARMENTS	SP18	432425	7-31-17
LIBRARY: WMIN5-LC	FIT LIBRARY: WMIN5-LC	WOMENS	SPORTWEAR	mainuoung.ton@kohls.com	LC	ALL GARMENTS	SP18	432151	7-26-17
LIBRARY: WMIN5-R&R	FIT LIBRARY: WMIN5-R&R	WOMENS	SPORTWEAR	mainuoung.ton@kohls.com	R&R/R&R PLUS	ALL GARMENTS	SP18	428518	7-11-17
LIBRARY: JR-CANDIES	FIT LIBRARY: JR-CANDIES	WOMENS	SPORTWEAR	mainuoung.ton@kohls.com	CANDIES/CANDIES PLUS	ALL GARMENTS	SP18	429783	8-21-17
LIBRARY: WMIN5-DANA BUCHMAN	FIT LIBRARY: WMIN5-DANA BUCHMAN	WOMENS	SPORTWEAR	elena.shuster@kohls.com	DANA regular and plus	ALL GARMENTS	SP18	428067	7-6-17
LIBRARY: WMIN5-FILA	FIT LIBRARY: WMIN5-FILA	WOMENS	ACTIVE	elena.shuster@kohls.com	FILA regular and plus	ALL GARMENTS	SP18	435068	8-8-17
LIBRARY: WMIN5-JLO	FIT LIBRARY: WMIN5-JLO	WOMENS	SPORTWEAR	elena.shuster@kohls.com	JLO regular and plus	ALL GARMENTS	SP18	430736	8-25-17
LIBRARY: WMIN5-SULLY	FIT LIBRARY: WMIN5-SULLY	WOMENS	SPORTWEAR	elena.shuster@kohls.com	SULLY regular and plus	ALL GARMENTS	SP18	431988	7-6-17

The [Fit Library Index](#) is a list of all the searchable Fit Libraries in OnePLM and is found on K-Link under Apparel Resource Tools.

How to Use Reference Patterns

REFERENCE PATTERN: Pattern & PP image example

Overlay new pattern and reference pattern to confirm shapes/proportions have been maintained per reference pattern.



NEW STYLE SKETCH: half sleeve version of Reference style.

The reference pattern sleeve length and sleeve opening will need to be adjusted to create new style pattern to meet requested POM spec.

Ref Style

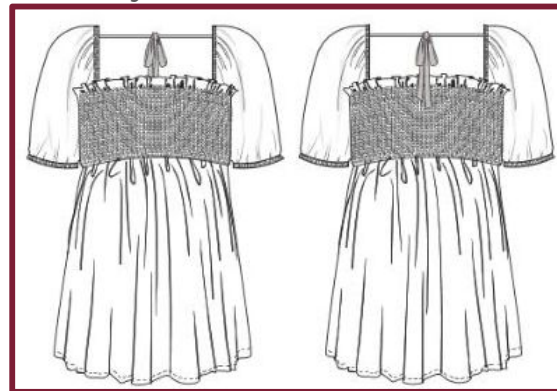
FA23 WM33W507

HPS FOLD@DRESSFORM SHOULDER SEAM

PP Sample



New style



Guide for Reviewing Patterns - Bottoms

BEFORE/AFTER PATTERN CORRECTION SCREENSHOTS:

WM13D002 & WM13D000 JEGGING

— BLOCK

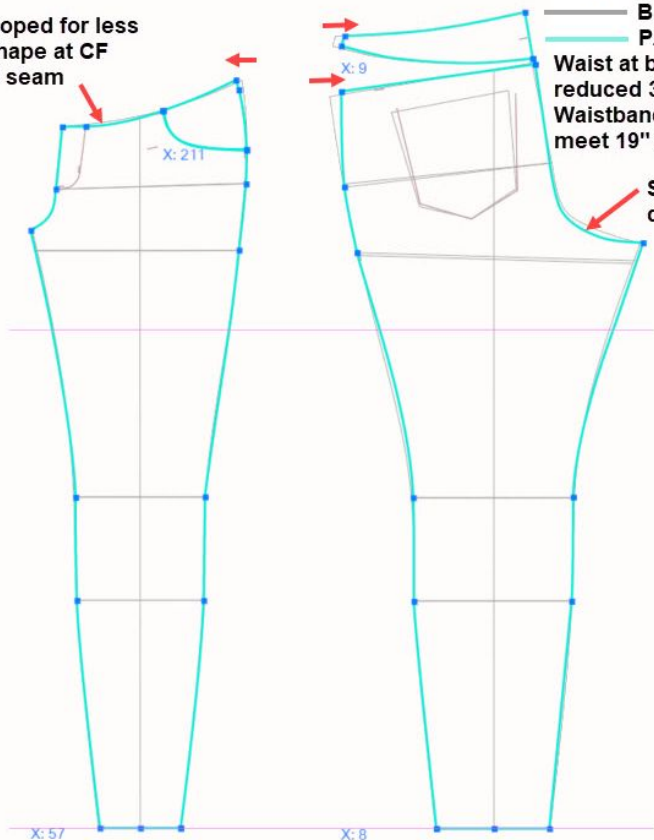
— PATTERN SHAPE UPDATE 7/19

Waist at belly band/WB seam has been reduced 3/8" from 18" to 17 5/8"

Waistband length can be maintained to meet 19" after wash.

Scooped for less draglines under seat

Scooped for less V-shape at CF rise seam

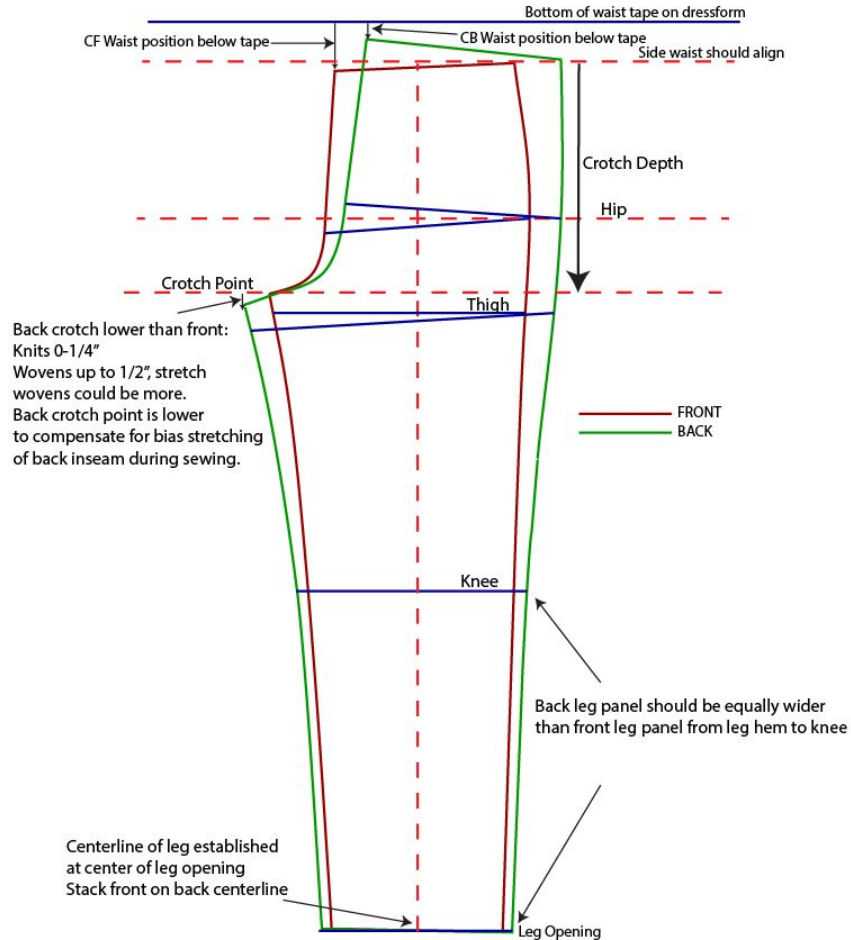


Pattern Comparison Example:

- ❑ When fit/pattern changes are requested by KTD, CTDs should use pattern comparison screenshots for reviewing pattern change accuracy and ensure patternmakers understood the KTD fit comments.
- ❑ Pattern Comparison Screenshots should show:
 - ❑ Before/after pattern corrections of all pattern pieces
 - ❑ Patterns must be clearly labeled,
 - ❑ Give explanation of what was changed and why.
- ❑ For complex pattern adjustments, suggest to review the pattern adjustments in 3D first before proceeding to physical fit sample to **improve the Fit Sample Pass Rate**

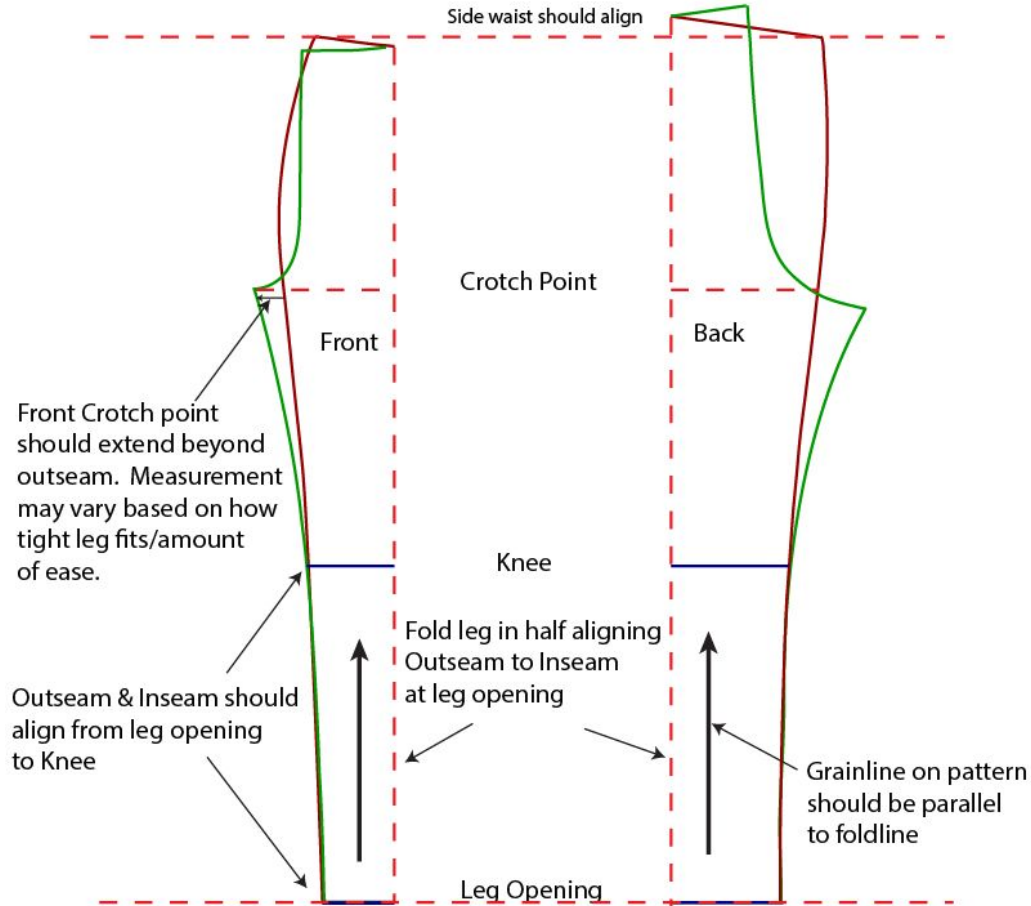
Guide for Reviewing Patterns - Bottoms

REVIEWING PANT PATTERNS:



Guide for Reviewing Patterns - Bottoms

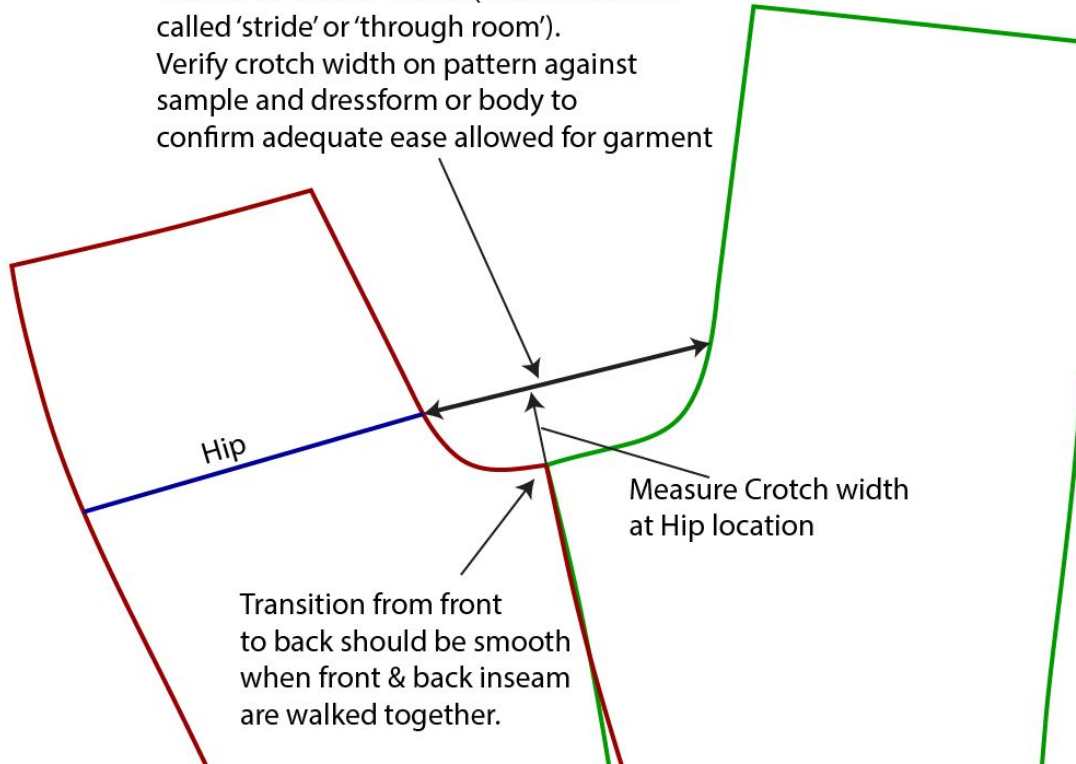
REVIEWING PANT PATTERNS:



Guide for Reviewing Patterns - Bottoms

REVIEWING SADDLE WIDTH ON BOTTOMS:

'Saddle' or 'Crotch Width' (sometimes also called 'stride' or 'through room').
Verify crotch width on pattern against sample and dressform or body to confirm adequate ease allowed for garment



Saddle is unbalanced and off from the center



Guide for Reviewing Patterns - Bottoms

BOTTOMS-BALANCE:

When you have a perfectly balanced pant, the horizontal reference lines on pattern should hang parallel to floor & vertical reference lines on pattern perpendicular to floor.



Guide for Reviewing Patterns - Bottoms

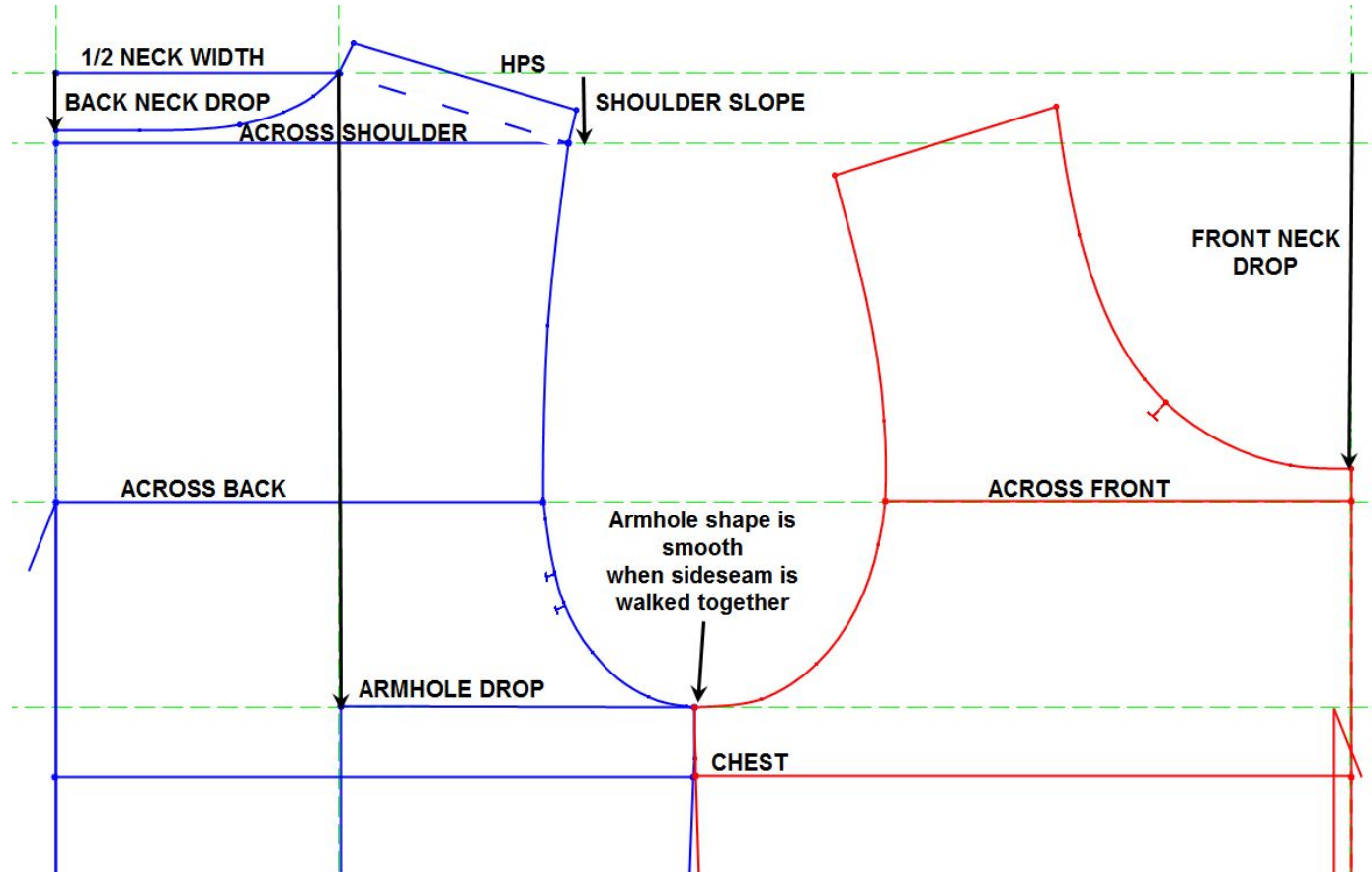
BOTTOMS-BALANCE: Setting Material Transparency to 15 to 20% in 3D and using visible reference lines on the pattern can assist with reviewing the pattern balance.

Avatar Measuring Tapes can be added to Digital Avatar based on Waist Placement body landmarks for waist placement accuracy



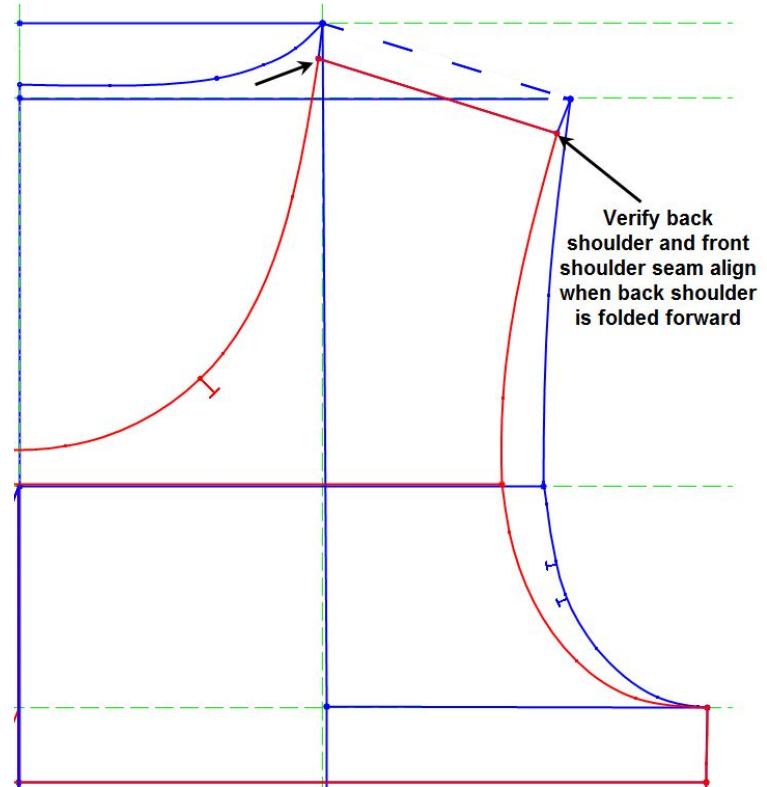
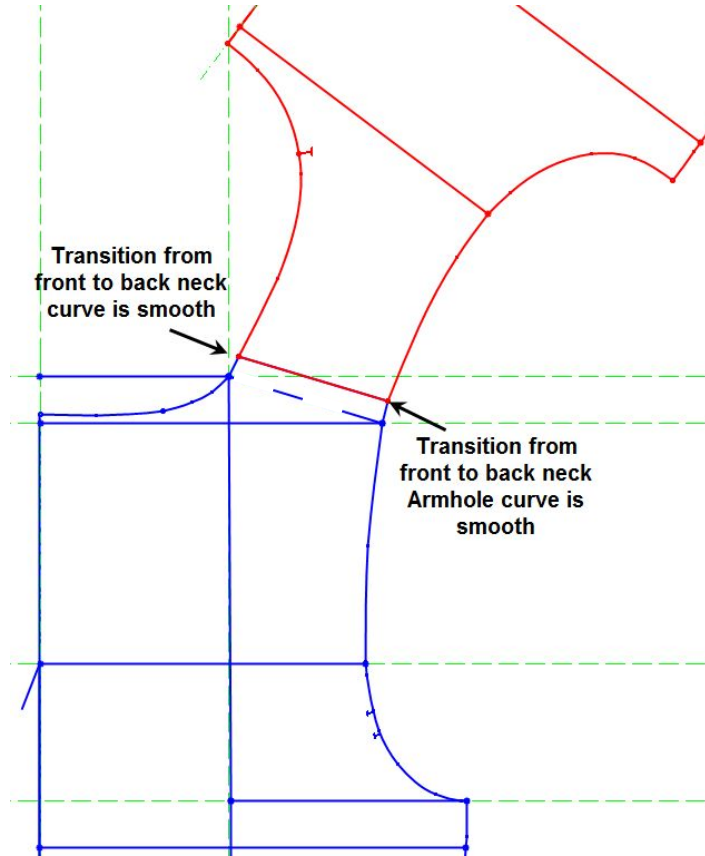
Guide for Reviewing Patterns - TOP

REVIEWING TOPS PATTERNS:



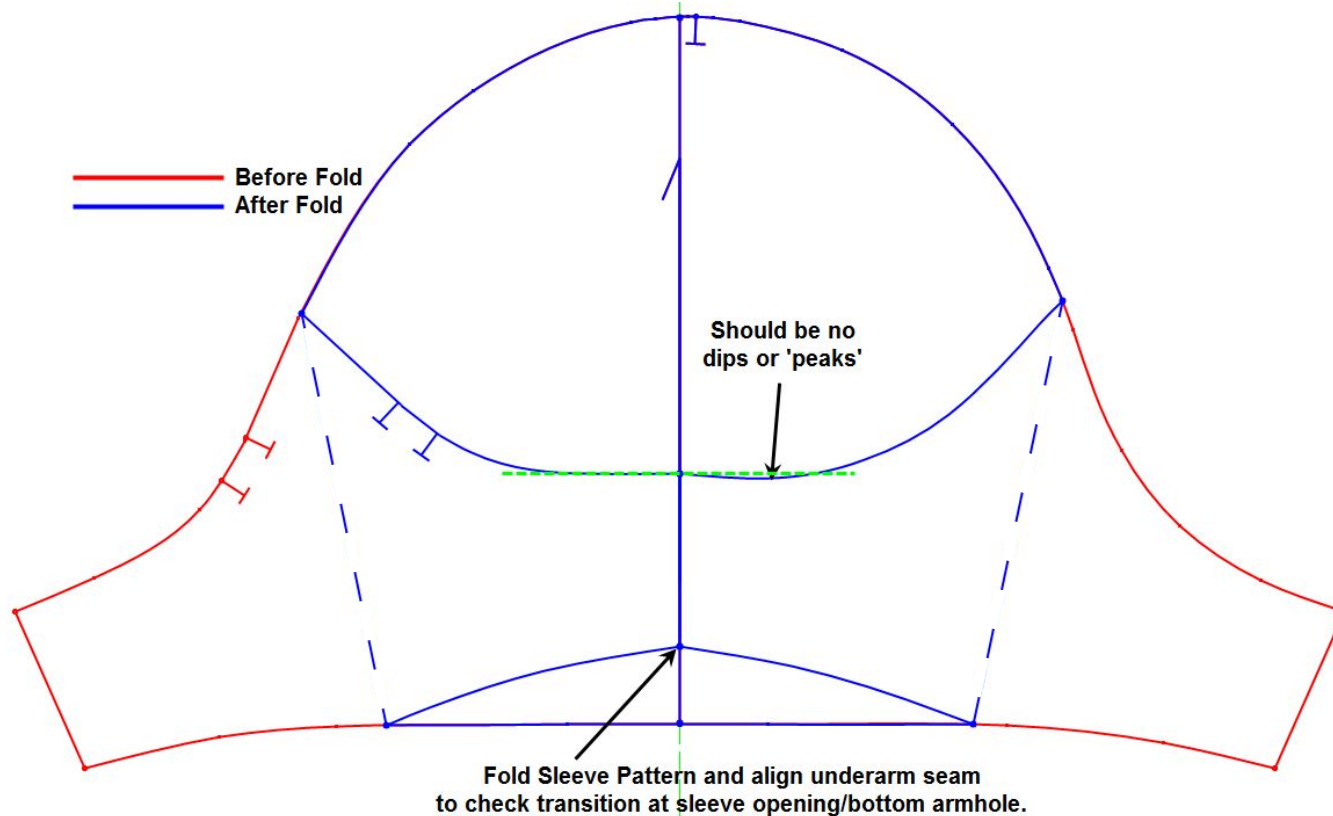
Guide for Reviewing Patterns - Tops

REVIEWING TOPS PATTERNS:



Guide for Reviewing Patterns - Tops

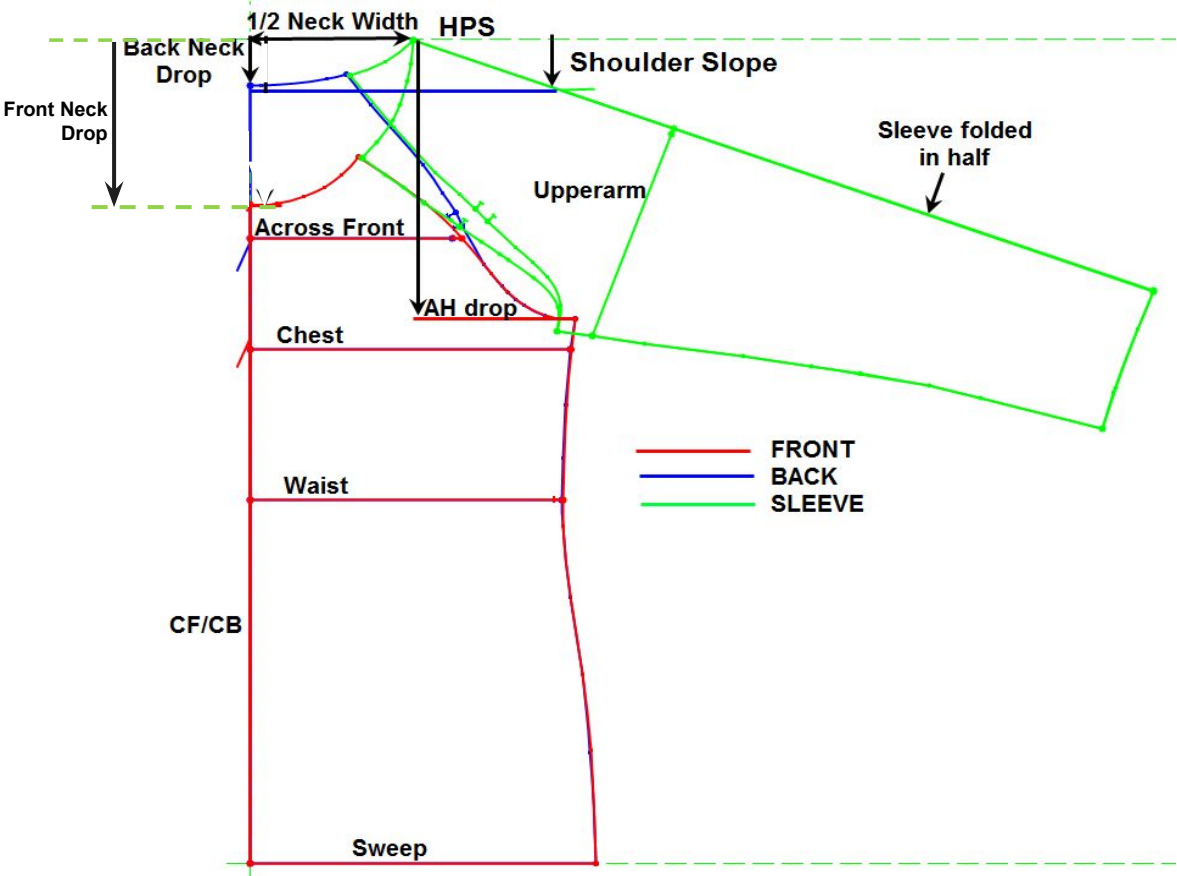
REVIEWING TOPS PATTERNS:



This sleeve may not fit well due to 'peak'/pull up at underarm seam.

Guide for Reviewing Patterns - Tops

REVIEWING TOPS PATTERNS:



Guide for Reviewing Patterns - Tops

TOPS BALANCE:



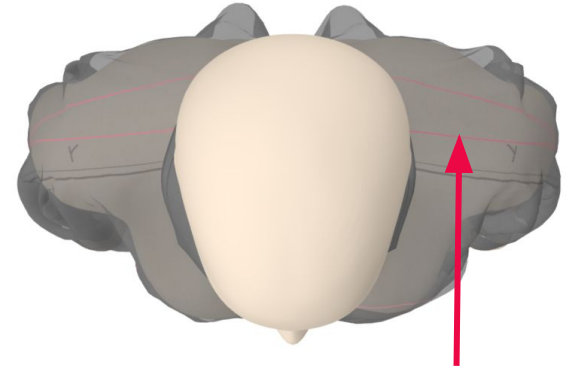
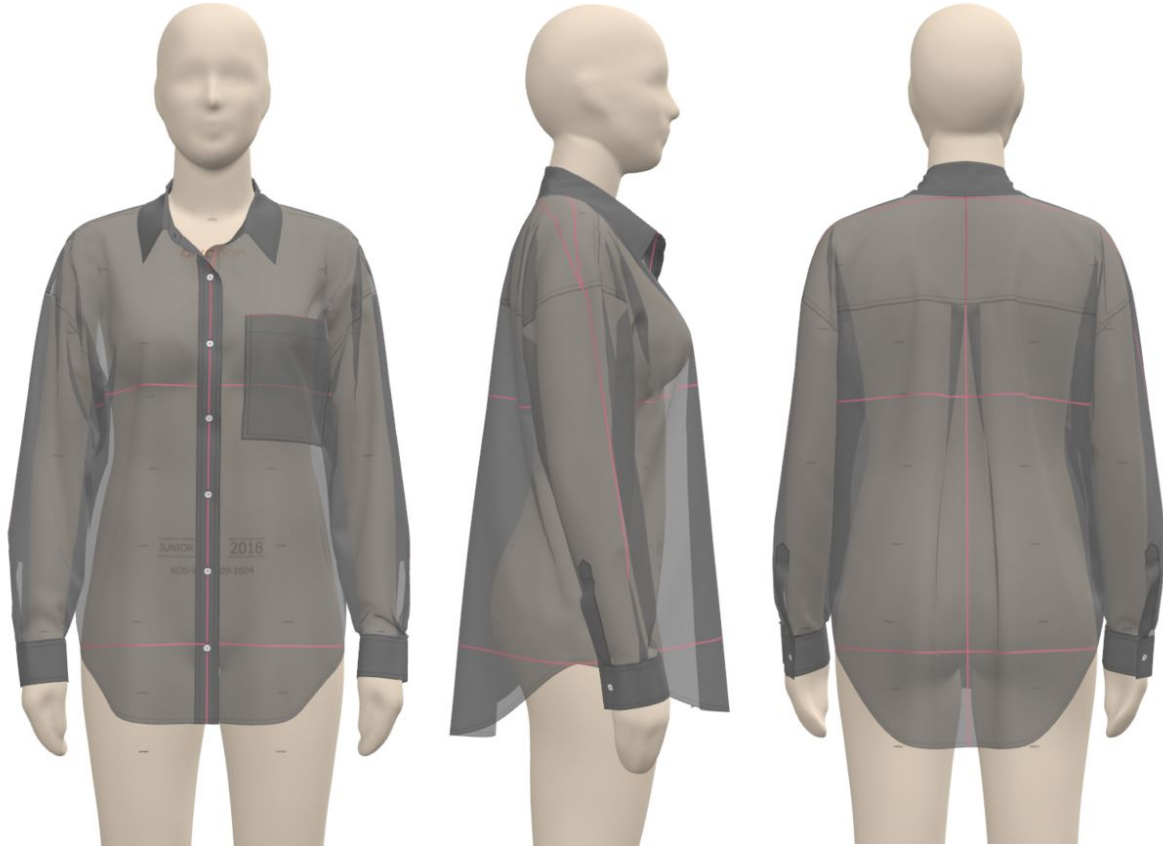
Center Front should be perpendicular to Floor and Chest Line should be parallel to Floor.

Center of sleeve should be in centered with Arm

Center Back should be perpendicular to Floor and Chest Line should be parallel to Floor.

Guide for Reviewing Patterns - Tops

TOPS BALANCE: Setting Material Transparency to 15 to 20% in 3D and using visible reference lines on the pattern can assist with reviewing the pattern balance.



HPS Fold can be compared to Avatar Shoulder seam for placement accuracy

Applying Shrinkage

WHAT IS THE DIFFERENCE BETWEEN SHRINKAGE & MANUFACTURING LOSS/GAIN?

Shrinkage is the adjustment applied to the pattern for changes in fabric length and width after garment is washed to meet the requested finished garment spec.

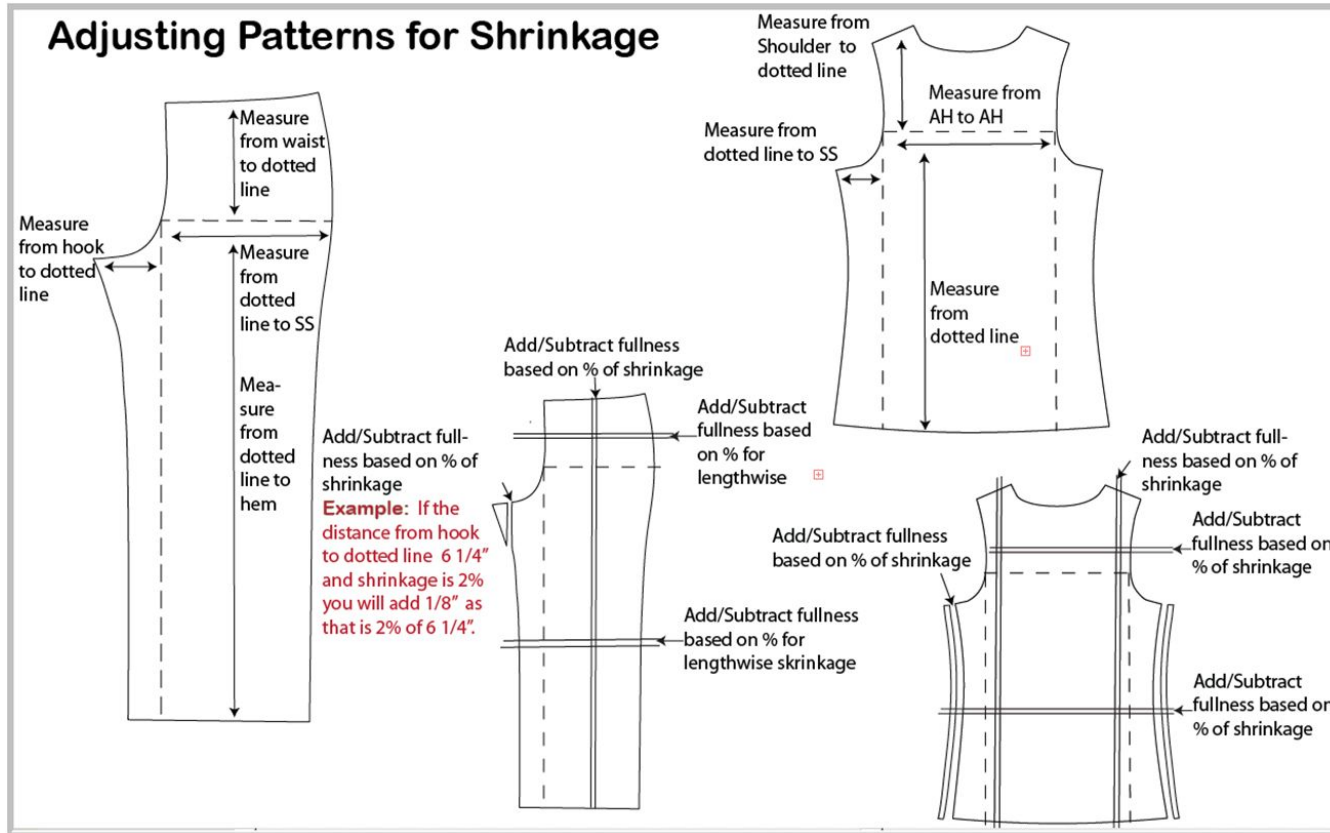
1. NOT included in the NET pattern.
2. Added to the pattern before manufacturing loss/gains.
3. Applied similar to grading (see example on next slide) so integrity of NET pattern shape is maintained.
4. When should CTD/Vendor review the shrinkage pattern?
 - a. If sample is measuring consistently out of tolerance in length or width after wash, shrinkage pattern may need to be reviewed/adjusted.
 - b. If garment balance/fit is adversely affected and not matching the garment balance of the original reference pattern fit, then shrinkage pattern may no longer be following NET pattern shaping.

Manufacturing loss/gains are adjustments that are applied to pattern for changes that may happen due to spreading, cutting, fusing, sewing and pressing.

5. **Manufacturing adjustments should be applied **after** the graded PP pattern is provided to Kohls.**

Applying Shrinkage

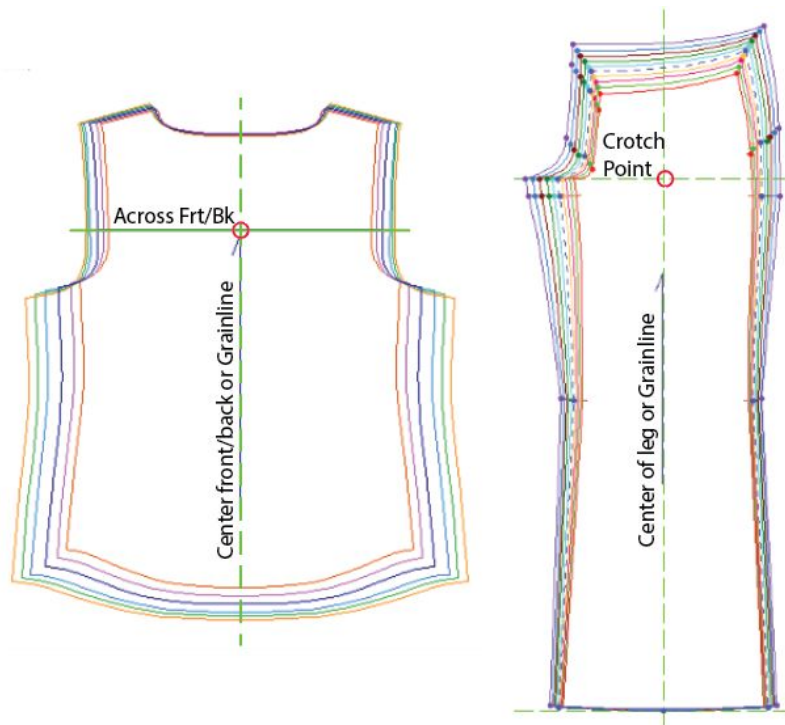
SHRINKAGE APPLICATION EXAMPLE:



Applying Grading & Size Conversions

STACKING/NESTING GRADED PATTERNS: Graded patterns should be nested together and stacked based on suggested stack points below. The Kohl's TD may request a different stack point.

NOTE: Pattern grader may start their grading based on whatever location they normally use based on their grade rules, but final graded pattern should be the same as the Kohl's grading schematics when the pattern is re-stacked on these points.



Submitting Pattern & Grading Questions

GRADING CONSIDERATIONS/CHANGES:

- ❑ Kohl's standard grade rules/schematics are based on general styles, and will not work for every style. Some grading adjustments may need to be made to maintain the integrity/shape of the pattern across the entire size range.
- ❑ Examples of styles where grading is usually reviewed:
 - ❑ Style that have shirring ratio vs following the Kohl's standard grade.
 - ❑ Dolman/dropped shoulder tops.
 - ❑ Styles with darts built into seam lines.
- ❑ Grading is reviewed by vendor at fit approval stage or earlier to allow time to resolve grading concerns before PP approval.

REQUESTING GRADING CHANGES:

- ❑ When requesting grading changes, include the following information:
 - ❑ The current grade
 - ❑ The proposed grade, with changes highlighted
 - ❑ Why the change is being suggested
 - ❑ Screenshot/capture image of the nested pattern before vs after the proposed grade change.
- ❑ Upload the grading proposal into the fit evaluation attachments tab for the current sample round and notify the KTD.
 - ❑ **Categories with full size runs of Avatars available in 3D:** KTD may request to see the before and after grading change as a 3D size run if the grading suggestion is more complex.

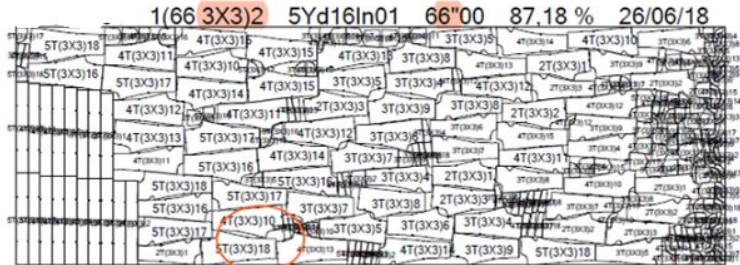
Submitting Markers & YY Calculations

WHEN MARKERS ARE REQUESTED: If a pattern adjustment results in an excessive upcharge, or not as much cost savings as expected, the Kohls technical team may request to see the marker.

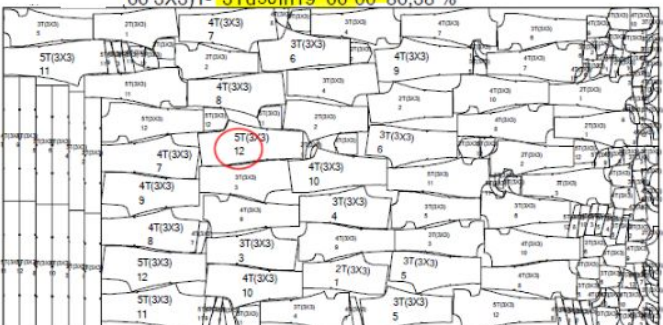
When showing a cost increase or savings, the markers must be comparable:

- ❑ Same number of pieces
- ❑ Same width of piece goods
- ❑ Same cutting direction
- ❑ Total YY calculation
- ❑ Clearly show piece orientation

- **Original mini marker**



- **updated mini marker w/ pull-up spec**



*** 2:4:4:2(12PCS)**
*** BDY - 2WAY**



Poor Marker Example:

See circled differences. The cutting size ratio and # of pieces must be same when comparing total YY calculations.

Pattern Marker Best Practices to Ensure Consistency

BEST PRACTICES:

- ❑ Have same pattern makers always working on Kohls styles, brand, size range so they are familiar with Kohls expectations and grade rules
- ❑ Organize/named patterns by Kohls style #, size range, fabric, season, fit round, & date, and saved in central location so that the most recent pattern is always referenced during fit development, 3D Fit, and PP approval process
- ❑ Once fit approved Net pattern is sent to factory for bulk production, compare factory production pattern back to NET fit approved pattern after final adjustments made for shrinkage, production allowances to confirm shape integrity
 - ❑ Ensure PP sample is available in the factory for comparison to ensure the changes are not impacting the production fit and appearance
- ❑ Verify final grading of pattern vs. approved spec and measure a full size run of each color way at the start of bulk production.
- ❑ Verify with KTD if there are any changes to block, reference pattern, or grade rule during costing stage so corrections are applied and factored into costing

Thank You

KOHL'S

Technical Design Training & Standards Team

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