



CONSTRUCTION REQUIREMENTS

PRIVATE & EXCLUSIVE BRANDS

HOME TEXTILES

RUGS

All Private and Exclusive brands must follow construction requirements unless otherwise specified by the Kohl's design or production teams.



CONSTRUCTION REQUIREMENTS RUGS

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Partner with Kohl's Production and Design teams if there are any design aesthetics or techniques that may vary from the Construction Requirement standards

**** SEE THE FOR THE FULL LIST OF SOFTLINES DEFECTS ON K-LINK:****

<https://link.kohls.com/resources/subcategory/quality-assurance>

Resources > Private and Exclusive Brands > Quality Assurance > Product Inspections / Defect Classification Lists subheading > Softlines



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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
Section I. Fabric Layout and Cutting Requirements		
All fabrics as specified, including but not limited to - content, yarn type, weave, weight, dye class & process, finish, etc		
• All parts of finished products must be compatible with prescribed care instructions • Combined fabrications must have compatible shrinkage • Cut product pieces on grain unless otherwise specified (length on warp • No selvage edges allowed within any product • Heavily napped fabrics, brushed fabrics and one-way prints - all product pieces cut in the same direction within a unit • Pattern Matching: Pattern/Plaid/Stripe match must be submitted to Design/Production/Technical Design for approval before final costing acceptance • No exposed drill holes, punch holes, or notches • Corners must be 90 degrees		



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Section II. Trims and Findings Requirements														
Trims/Findings in children’s products must meet CPSIA requirements														
Thread: Must source thread with Kohl's Preferred Supplier • No monofilament thread. Multi-filament is acceptable for specific uses Embroidery Thread: • Preference - Polyester - from Kohl's Preferred Supplier • Allowed - Polyester from a non-Preferred Supplier, contingent upon passing specific thread testing protocols • Allowed - Rayon - from a Kohl's Preferred Supplier Bead/Sequin attachment thread. Very specific thread requirements • Refer to 'Bead & Sequin Attachment Guide' on K-link Thread Color • Must match fabric ground unless otherwise specified. Bedskirt thread color to match skirt/drop, not platform. When in doubt, check with Design team. • All operations must use same color thread within internal seams NOTE: Thread types/sizes may vary based on fabric characteristics and weight, and are subject to approval by TD. Seams must meet Kohl's strength and appearance requirements. Thread Size Chart by Fabrication: <table><tr><td>Needle/Bobbin:</td><td>Looper:</td></tr><tr><td>• 2 - 4oz = Tex 18-21</td><td>Tex 18</td></tr><tr><td>• 4 - 6oz = Tex 21(spun) - 24(core)</td><td>Tex 27</td></tr><tr><td>• 6 - 8oz = Tex 27(spun) - 30(core)</td><td>Tex 30</td></tr><tr><td>• 8 - 10oz = Tex 40</td><td>Tex 27-30 or 35 (textured poly)</td></tr><tr><td>• 10 - 14oz = Tex 60</td><td>Tex 40</td></tr></table> Looper Thread: Spun Polyester or Textured Polyester • Tex size of looper thread must be comparable with tex size of needle thread	Needle/Bobbin:	Looper:	• 2 - 4oz = Tex 18-21	Tex 18	• 4 - 6oz = Tex 21(spun) - 24(core)	Tex 27	• 6 - 8oz = Tex 27(spun) - 30(core)	Tex 30	• 8 - 10oz = Tex 40	Tex 27-30 or 35 (textured poly)	• 10 - 14oz = Tex 60	Tex 40	Decorative thread as specified	Decorative thread as specified
Needle/Bobbin:	Looper:													
• 2 - 4oz = Tex 18-21	Tex 18													
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Section II. Trims and Findings Requirements (cont'd)		
Trims/Findings in children's products must meet CPSIA requirements		
Embroideries • Must have suitable tear-away or dissolvable backing that must be removed after application • Stitching must be secured by stacking stitches with increased SPI (minimum 25-30), knotting, back-stitch (minimum 3 stitches), or bar-tack • Stitching must be knotted/secured every 3/4" with thread floats no longer than 3/4" • Children's Products: • floats no longer than 3/8"		
Binding • If layers must be stitched together prior to binding, must use a basting stitch with low SPI (4 or less) • Raw edges of binding must be folded in and securely sewn into binding • If self-bound (hemmed) - clean finished, double turned, single need lockstitch • Minimal number of splices - directly proportional to the size of the product	Preferred bias cut unless otherwise specified	May be straight cut for straight edges, must be bias cut for curved/shaped edges
Ruffles, Crochet Edging, Fringe Tape, Tassels, Pom poms, etc • Lockstitch zigzag (ISO 304) all layers together before applying trims • Ruggles single ply or double ply as specified	Gather ratio: 1.75:1 - 2:1	Gather ratio: 1.5:1 minimum



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Section III. Sewing and Construction Requirements		
Seams must meet Kohl's seam slippage and strength requirements		
- Stitches per inch (SPI) of hem, seams and topstitching as specified by tech pack - Reinforcement Stitching: Stitching must be secured at start and stop; - Back-stitch (minimum 3 stitches), lockstitch thread tails trimmed close or using Schmale backtacking chainstitch sewing machine head - Bar-tack - Latchback - Ends of stitching crossed by another seam or line of stitching - Stack stitches by increasing SPI for 1" (minimum 25-30 SPI) - Knotted ends (on running stitch only) - No exposed raw or pinked edges. - No inconsistent pile height, missing tufts/loops, bare spots, cut holes - Decorative whipstitch (over machine stitched hems only): Must be secured at start and stop by back-tack (minimum 3 stitches) Children's Products: - Overlock stitch is required underneath any blanketstitch or whipstitch detail - All blanketstitching or whipstitching must be cut in 8" lengths and tacked or knotted at the end of each length - Line tack is to be perpendicular (non-parallel) to the edge of the product - Knotted ends is to be done on the backside of the product	SPI (binding or hemming): 8 - 10	SPI (binding or hemming): 6 - 8
Lid Covers - Woven elastic type as specified. Must source the specified elastic model # from the assigned supplier only - Elastic stretch ratio: 1:2.5 minimum. - Elastic applied as binding over edge of lid cover, approx. 1/2" inside and outside. - Elastic is sewn using SN chainstitch, chain on inside - knife removed. - Minimum 1 1/2" flat overlap reinforcement at elastic start/stop. Maximum chain-off 1"		
Rugs - Knit Circular knit, split, usually laminated to polyurethane foam or backing for stability		
Rugs - Braided (Flat, Rag) Sew braids together with Zig Zag LS (ISO 304) 2.5 - 3 SPI		



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Section III. Sewing and Construction Requirements (cont'd)		
Seams must meet Kohl's seam slippage and strength requirements		
Rugs - Machine Made - Tufted / Hooked / Needle Punched • Reversible: - Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face and back of rug. • One Sided: - Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face only - Secondary Backing (if applicable) – woven – adhered over primary backing using natural, synthetic, or blended rubber latex (must identify) • Non-Skid: - Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face only - Secondary Backing – Natural, synthetic, or blended rubber latex (must identify secures pile yarns on back of rug. Latex is not covered with fabric. Latex may be sprayed on, or, padded on with no design or with embossed design - No latex that is uncured/soured/odorous, cracking/crumbling/powdered, holes, delaminated/peeling, or over-sprayed • All rug edges must be finished - bound, serged, hemmed or fringed • Rug must lie flat, without rolling or curling along the edges • Hem long sides first; then hem short ends, crossing long side hem stitching SN LS TS (ISO301) or SN CS (ISO 401) or 2N Bottom Coverstitch (ISO 406) • Binding ends – specific to tech pack – turn to face or to back – as specified • Refer to Construction Details page in Technical Product Specification • Oval or Round rugs: Position overlap of edgefinish (binding or serging) at an inconspicuous location. Full overlap – binding: 1"minimum / 1 1/2" maximum; overlock: 1 1/2" minimum / 2" maximum. No excessive thread chain-off tails (max 1")	Secondary Backing: Cotton canvas backing Hooked rugs must have latex adhesive coating to secure yarns. Double turn hems CS-chain on face or as specified 2N Coverstitch: needles on face	Secondary Backing: Cotton canvas backing. Jute burlap backing with approval Overlock raw edge, single turn hem (only with approval) CS-chain on face or as specified 2N Coverstitch: needles on face
Rugs - Hand Woven / Knotted Rugs (Dhurrie, Kilim, etc) • Double turn hems to back, SN LS TS (ISO 301) • Knotted fringe (warp ends). No loose cut warp ends without reinforcement stitching on last weft insertion		



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Section IV. Measurement Tolerances

Tolerances apply to finished product dimensions only. Refer to the [Brand IDs](#) for the specific product type on K-link:

Resources > Private and Exclusive Brands > Home Technical Design > Measurements subheading > Brand IDs by Product Types

If no Brand ID is available, standard length and width tolerances are -0" / +2"

Component Variation Within A Set

- Component variation must not exceed individual measurement tolerances as specified
 - Length (at center) +/-1/2"
 - Width (at center) +/-1/2"

Section V. Product Labeling

For a full details regarding labeling, please refer to the Kohl's [Labeling Guidelines for Home Textiles](#), on K-link:

Resources > Private and Exclusive Brands > Performance Testing > Soft Home - Home Textiles > "Labeling Guidelines" under Regulatory Compliance & Safety subheading

Label Placement

- Follow instructions as specified in the Kohl's Label Placement Guides
- For a complete list of label placements, reference the [Label Placement Guides](#) on K-link:
- *Resources > Private and Exclusive Brands > Home Technical Design > Standards > Label Placement Guides subheading*