



APPEARANCE EVALUATION PROCEDURES: HOME TEXTILES

*Evaluating Appearance of Home Textiles After
Laundering*

Durable Performance Claim Requirements

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Kohl's Appearance Evaluation Requirements Procedures - AATCC/ASTM TS-008 Modified

Overview

Kohl's Appearance Evaluation Procedures (KAR) are performed to ensure that the after wash performance of finished products meet Kohl's Customer's expectations. It will determine the performance of a textile product that has undergone repeated home laundering by comparing it to an unwashed specimen and rating it against a set of Kohl's requirements.

Kohl's requirements evaluate different aspects of the products to ensure that it retains its original appearance after multiple launderings. Some of the requirements evaluated in the procedure are Color Change, Handfeel, Pilling, Seam Puckering, etc. The full list of requirements can be found in the chart titled **"KAR and Durability Testing Requirements: HOME TEXTILES,"** which is included within this document.

In Home Textiles (Soft Home), Kohl's Appearance Evaluation can be broken down into 2 categories, to confirm that every characteristic is taken into account when evaluating different types of samples.

For Apparel, please refer to the [Kohl's Appearance Evaluation & Wash Durability SOP](#) on K-Link.

These 2 KAR Categories for HOME TEXTILES are:

- 1) Finished Products (3 launderings)
- 2) Finished Products with Durability Claim (5, 10, 15, 20 launderings)

Testing Requirements for these evaluations are listed in the chart titled **"KAR and Durability Testing Requirements (Condensed)"**

****All observations are to be made by comparing the washed and unwashed product and using the performance standard indicated below***

Please contact Kohl's Quality Assurance team at Quality.Assurance@kohls.com with any questions or if you are unsure what is applicable to your product.

KAR and Durability Testing Requirements: HOME

Observation	Definition	Finished Products	Products with Durability Claim
		3 Washes	5, 10, 15, and 20 Washes
Color Bleeding/Self Staining	Visual observation of color transfer to another color or portion of the product using the Gray Scale for Evaluating Staining.	Gray Scale Rating: 4.5 or better	Gray Scale Rating: 4.5 or better (all)
Excessive Color Change	Visual observation comparing the washed product to the unwashed product using the Gray Scale for Evaluating Change in Color.	Gray Scale Rating: 4.0 or better Prints, Pigment Dyed, Sulphur Dyed, Indigo: Gray Scale Rating: 3.5 or better	Gray Scale Rating: 4.5 or better Prints, Pigment Dyed, Sulphur Dyed, Indigo: Gray Scale Rating: 3.5 or better
Color Staining (Multifiber test fabric)	Visual observation of color staining to another fiber using the Gray Scale for Evaluating Staining. Evaluate after 3 washes.	Gray Scale Rating: 3.0 or better	Gray Scale Rating: 3.0 or better
Excessive Wrinkling	Kohl's Overall Smoothness Appearance Standard – AATCC 3D Smoothness Appearance Replicas is compared to the product to verify that Kohl's requirement has been met.	Observation results are Pass, Fail, or N/A with rating. Smoothness Appearance = 3.5 Below requirement <i>does not</i> apply to Durable Press/Wrinkle Resistant items: Evaluate fabric as is after wash, if excessive wrinkling – iron fabric as needed per care instruction and evaluate.	Observation results are Pass, Fail, or N/A with rating. Smoothness Appearance = 3.5 Below requirement <i>does not</i> apply to Durable Press/Wrinkle Resistant items: Evaluate fabric as is after wash, if excessive wrinkling – iron fabric as needed per care instruction and evaluate.
Excessive Pilling	Visual observation comparing the washed product to the unwashed product using the ASTM D 3512 Photographic Standards for evaluating pilling.	Photographic Rating: 4 (Slight pilling or fuzzing) or better	Photographic Rating: 4 (Slight pilling or fuzzing) or better
Torque/Skew * See diagram for determining torque/skew	The side seam and AATCC 179-2004 Inverted T methods are used to verify that Kohl's requirements have been met. Observation results are indicated in %. (one decimal place, ex. 3.4% 2.4%)	Wovens: Tier 1 & 2: 3%; Tier 3: 2% Knits: Tier 1: 5%; Tier 2: 4%; Tier 3: 3% Garment Indigo Dyed Wovens: 4% max.	Wovens: Tier 1 & 2: 3%; Tier 3: 2% Knits: Tier 1: 5%; Tier 2: 4%; Tier 3: 3% Garment Indigo Dyed Wovens: 4% max.
Holes or other signs of excessive abrasion	Visual observation for any evidence of holes or other signs of excessive abrasion after wash.	Observation results are Pass, Fail, or N/A.	Observation results are Pass, Fail, or N/A.
Handfeel	Physical evaluation to determine if the handfeel is the same as the before wash sample.	Observation results are Pass, Fail, or N/A.	Observation results are Pass, Fail, or N/A.
Filled Products	Visual observation for any evidence of fiber fill migration, voids in the fiber fill, or fiber fill penetrating through the surface.	Observation results are Pass, Fail, or N/A.	Observation results are Pass, Fail, or N/A.

Observation	Definition	Finished Products	Products with Durability Claim
		3 Washes	5, 10, 15, and 20 Washes
ADDITIONAL REQUIREMENTS: Embellishments OR Durability Claim			
Needle Cuts or Chews	Visual observation for any evidence of needle cuts or chews after wash.	n/a	Observation results are Pass, Fail, or N/A.
Raveled Edges	Visual observation for any evidence of raveled edges after wash.	n/a	Observation results are Pass, Fail, or N/A.
Seam Pucker	Kohl’s Seam Smoothness Standard – AATCC Photographic Seam Smoothness Replicas is compared to the product to verify that Kohl’s requirement has been met. This includes seam puckering on all split fronts, such as snap fronts, zipper fronts and button front products.	n/a	Observation results are Pass, Fail, or N/A with a rating. Seam Smoothness = 3.0 Evaluate garment as is after wash, if excessive wrinkling – iron garment as needed per care instruction and evaluate.
Zippers or other trim items functioning properly	Physical inspection to determine whether or not all trim items are functioning properly.	n/a	Observation results are Pass, Fail, or N/A.
Coating of Metal Trims	Visual observation for any loss of color or coating in metal trims using photographic Reference image Fig. 1	n/a	Observation results are Pass, Fail or N/A with a rating Class: 3
Appliqués, buttons or trim items securely attached	Visual observation that all appliqués, buttons and trim items are securely attached after wash.	n/a	Observation results are Pass, Fail, or N/A.
Peeling, Flaking, Cracking, or other evidence of delamination	Visual observation that no peeling, flaking, cracking or other evidence of delamination occurs in a screen print after wash.	n/a	Observation results are Pass, Fail, or N/A.
Legibility of text	Visual observation that the text of a screen print is legible after wash.	n/a	Observation results are Pass, Fail, or N/A.
Detachment	Visual observation that no detachments of the decorative/embellished trims occur during the wash.	n/a	Observation results are Pass, Fail, or N/A.
Multiple broken stitches	Visual observation that no broken stitches are present in the decorative/embellished trims after wash.	n/a	Observation results are Pass, Fail, or N/A.
Color loss of trim or label	Visual observation comparing the color change of the washed item to the unwashed washed product and reporting whether there was any color loss.	n/a	Observation results are Pass, Fail, or N/A.
Change in sheen or gloss to the extent that a metallic finish no longer appears shiny	Visual observation that no change in the sheen or gloss of the metallic finish has occurred after wash.	n/a	Observation results are Pass, Fail, or N/A.
Loss of surface texture	Physical observations to determine that the texture/handfeel of the washed item is the same as the original item.	n/a	Observation results are Pass, Fail, or N/A.
Softening or melting	Visual observation that no softening or melting of the screen prints or decorative/embellished items has occurred after wash.	n/a	Observation results are Pass, Fail, or N/A.

1) KAR - Home Textiles Finished Products

3 Launderings

Overview

The purpose of the Kohl's Appearance Evaluation Procedure for finished products is to compare the before washed and unwashed products (original sample) to ensure that the after wash product meets Kohl's Customer's expectations and standards. Two finished products of each colorway are submitted to be washed & dried 3 times, according to the care label instructions. The after wash appearance of that product is then compared to the unwashed product.

Exception: Any finished product that is not machine washable will use the lab test results to evaluate the appearance requirements, such as leather or suede. Reference the approved care instructions for the product.

Procedure for Home Textile Finished Products

- Two finished products are submitted in each colorway.
- Compare the products to each other, to confirm they are identical.
- Wash one finished product according to care instructions provided. For care instructions that include machine wash with "mild detergent", proceed with using Woolite detergent.
- If needed, include one (1) Twin FLAT sheet, in 100% white cotton, to help balance the wash and dry load.
- Dry according to care instructions provided. May also dry with one Twin Flat sheet. The sheet may be used on multiple evaluations, as long as no color transfer has occurred.
- Multiple specimen groupings may be included in a wash or dry cycle as long as the color family is complimentary and there are no "wash separately" instructions included in the care label instructions.
- Repeat the above wash and dry cycle 3 times, according to the care label instructions.

Appearance Requirements

Refer to the KAR and Durability Testing Requirements Chart for appearance requirements.

Compare the washed and unwashed product. Where appropriate, the performance requirement should be given.

The performance rating is observed using a standard, such as the Gray Scale or a visual observation, and must be entered on the applicable **Kohl's Worksheet** on the line in front of each appearance requirement.

2) KAR - "Durable" Performance Claim Testing Requirements

5,10,15 & 20 Launderings

Durability performance claims must be verified by third party lab testing. The below requirements, found in the '1000 - Performance Claims for Home Textiles' Protocol, are available on KLINK, if product has a Durability claim.

Reference 1000 Protocol:

Durability For "Durable" Claims	Appearance Retention (KAR) AATCC/ASTM TS 008 Modified Tide Powder Detergent Original & After 5, 10, 15, 20 Washes	Must meet all Applicable Kohl's Appearance Evaluation Requirements	Fabric & Garment Stage
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Overview

The purpose of Kohl's Durability Evaluation Procedure for finished products is to determine the appearance retention of the finished products after repeated home launderings. Products will undergo testing of Appearance after Three Home Launderings, as well as Durability evaluation for repeated home launderings to ensure that the samples retain their original appearance.

For finished products where durability testing is required, three finished products must be submitted. One sample will be retained as control. The second sample will be tested for Appearance After Three (3) or Five (5) Launderings. The remaining sample will be subjected to repeated home launderings per the item's intended care instructions using the procedure outlined on the following page (Durability Evaluation). Therefore, products will undergo the following two procedures:

Procedure for Home Textile Finished Products

- Three finished products are submitted in each colorway. One is reserved as control, one is for appearance after 3 and 5 launderings.
- Compare the products to each other, to confirm they are identical.
- Wash one finished product according to care instructions provided. For care instructions that include machine wash with "mild detergent", proceed with using Woolite detergent.
- If needed, include one (1) Twin FLAT sheet, in 100% white cotton, to help balance the wash and dry load.
- Dry according to care instructions provided. May also dry with one Twin Flat sheet. The sheet may be used on multiple evaluations, as long as no color transfer has occurred.
- Multiple specimen groupings may be included in a wash or dry cycle as long as the color family is complimentary and there are no "wash separately" instructions included in the care label instructions.
- Repeat the above wash and dry cycle per the specified number of cycles below, according to the care label instructions. (wash/dry, wash/dry, wash/dry)
- Report the results by using the Extended (Durability) Evaluation appearance requirements. This reporting will be for the appearance of the product.

Appearance Requirements for Finished Products (Durability Evaluation)

Refer to charts on page 4 & 5. Assess only the change in the appearance of the product against the control (original) sample. Report the changes using the below appearance requirements.

The performance rating observed using a standard, such as the Gray Scale or a visual observation, must be entered on the **Kohl's worksheet** on the line in front of each appearance requirement. **All observations are to be made by comparing the washed and unwashed product and using the performance standard indicated.**

Finding Fabric Torque/Skew

Torque

Procedure for using the Side Seam method (AATCC/ASTM TS-004), see figure 1:

1. After washing and drying, lay specimen flat and allow to condition for a minimum of 4 hours. The product should be gently smoothed and free of large wrinkles or creases. Begin smoothing at the top of the product and work down.
2. Using a marker pen, one skewing mark should be placed at the uppermost point of the product folded edge - point E and the other skewing mark should be placed at the lower most point of the same folded edge - point G.
3. Follow the seam down to the bottom edge, mark as point F.
4. Measure the distance from point F across to the nearest fold edge - point G. Measure the distance from E to G.
5. Calculate the percentage of torque after wash as follows: Line EG

Line EG x 100

Skew

Procedure for using the AATCC test method 179-2004/Inverted T Method 2, Option 3, see figure 2:

1. Using a marker pen, draw a reference line YZ across the width of the panel approximately 3 inches, above the bottom edge. Draw benchmark A perpendicular to and in the middle of YZ. Draw benchmark B, both parallel to YZ and perpendicular to A.
2. After washing and drying, lay specimen flat and allow to condition for a minimum of 4 hours. The product should be gently smoothed and free of large wrinkles or creases. Begin smoothing at the top and work down.
3. Draw a line from B to line YZ, following the grain line. Mark this intersection as C.
4. Measure the distance from A to C. Measure the distance from A to B.
5. Calculate the percentage of skewing after wash as follows: Line AC

Line AB x 100

Figure 1: Torque

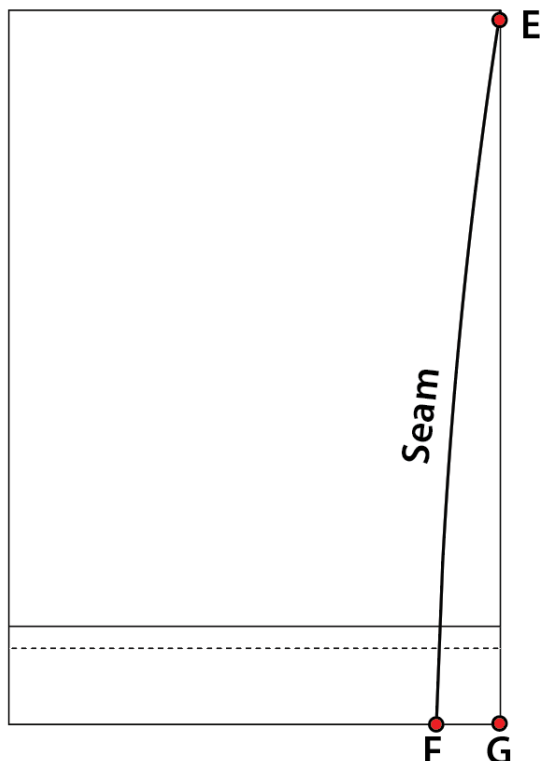
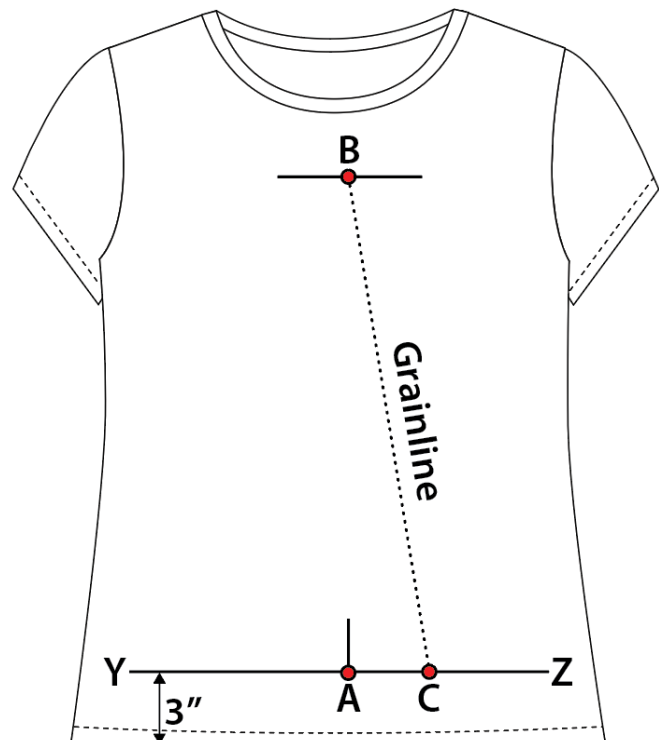


Figure 2: Skew

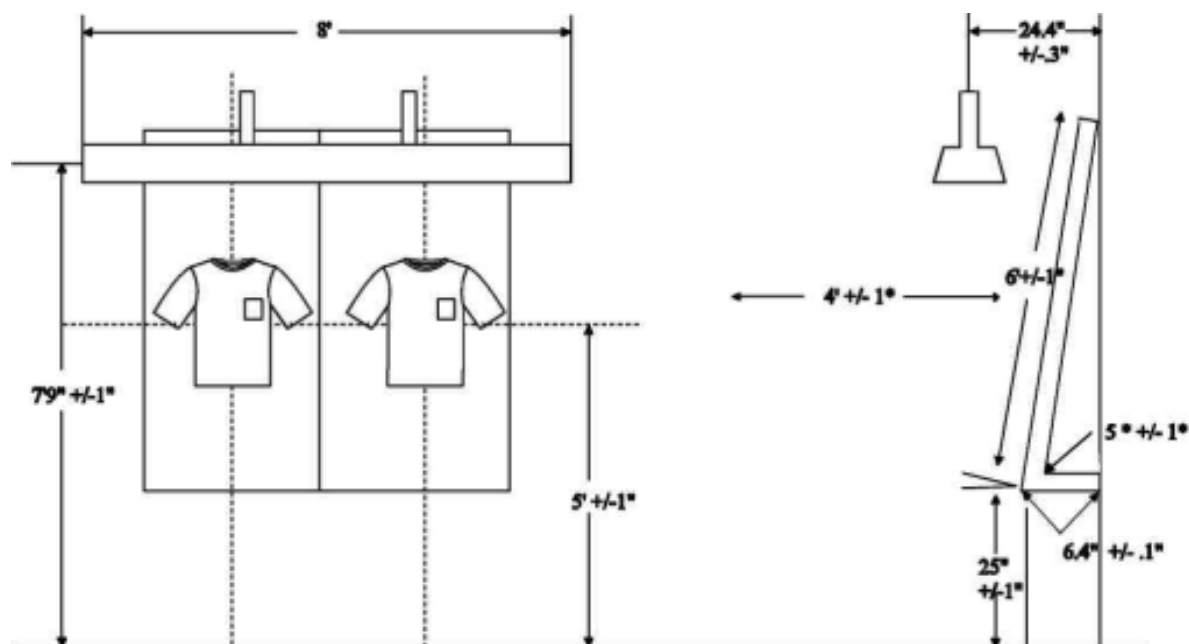


Exception

Skew is not measured on those products that have a horizontal engineered stripe or wide horizontal stripes, over 3" in width. The horizontal stripe(s) is the predominant element of the product and the fabric must be cut and sewn with the stripe straight on the horizontal.

Viewing Board

Observer - stand directly in front of the specimen 4-ft (+/- 1") away from the board. It has been found that normal variations in the height of the observer above and below the arbitrary 5-ft eye level have no significant effect on the grade given.



Front View Side View

Supplies Required

- **Lighting** – 4 4-ft Sylvania bulbs CW (cool white) UL3500K 128 WATTS.
- **Board** – 6-ft X 6-ft (+/- 1") piece of 1/4" plywood for the front of the board and a 6-ft X 6.4" (+/- 0.1") piece of 1/4" plywood to mount the board so that the bottom is a 5 +/- 0.1 degree angle (see diagram).
- **Paint** – After mounting, paint the 6-ft X 6-ft plywood board to match No. 2 gray chip in the AATCC gray Scale for Staining.

Kohl's Appearance Evaluation Requirements

Worksheet AATCC/ASTM TS-008 Modified

For home textile products

Date Tested _____ Color _____

Style Number _____ Signature _____

APPEARANCE/KAR: 3X

Appearance Observation Results Are To Be Recorded As **Satisfactory (Pass)** or **Unsatisfactory (Fail)**, except where the gray scale/photographic standards are used and torque/skew %'s, which are indicated to one decimal point (ex. 3.4% 2.4%).

Grade: _____ Excessive Wrinkling (min. 3.5)

Grade: _____ Excessive Pilling (min. 4.0)

Grade: _____ Excessive Color Change (with suppressor if below 4.0)

Grade: _____ Excessive Color Change (Gray Scale 4.0 or better without suppressor)

Grade: _____ Color Bleeding/Self Staining (Gray scale 4.5 or better)

Grade: _____ Color Staining on Acetate (min 3.0)

Grade: _____ Color Staining on Cotton (min 3.0)

Grade: _____ Color Staining on Nylon (min 3.0)

Grade: _____ Color Staining on Polyester (min 3.0)

Grade: _____ Color Staining on Acrylic (min 3.0)

Grade: _____ Color Staining on Wool (min 3.0)

Torque/Skew _____ (Indicate both results as %'s)

Rating: _____ Handfeel: Same as before Wash (Req PASS rating)

Overall Rating of Appearance: _____ Satisfactory (PASS) or

_____ Unsatisfactory (FAIL)

Additional Comments: _____

NEW:

Kohl's Durability Performance Claim Evaluation Worksheet

For home textile products with "durable" performance claim

Date Tested _____ Color _____

Style Number _____ Signature _____

EVALUATION OF GARMENTS WITH DURABILITY PERFORMANCE CLAIM (PLEASE CHECK BOXES FOR NUMBER OF WASHES)

☐ 5X ☐ 10X ☐ 15X ☐ 20X

Appearance — Observation Results Are To Be Recorded As **Satisfactory (Pass)** or **Unsatisfactory (Fail)**, except where the gray scale/photographic standards are used and torque/skew %'s, which are indicated to one decimal point (ex. 3.4% 2.4%).

P ☐, F ☐, N/A ☐ Appliques, buttons or trim items
securely attached

P ☐, F ☐, N/A ☐ Needle cuts or chews

P ☐, F ☐, N/A ☐ Raveled Edges

_____ Torque/Skew (Indicate both results as %'s)

Rating: _____ Metal Coating (Req PASS rating)

Rating: _____ Handfeel: Same as before Wash (Req
PASS rating)

Grade: _____ Excessive Wrinkling (min. 3.5)

Grade: _____ Excessive Pilling (min. 4.0)

Grade: _____ Excessive Color Change (with
suppressor if below 4.5)

Grade: _____ Excessive Color Change (Gray Scale
4.5 or better without suppressor)

P ☐, F ☐, N/A ☐ Seam Pucker

P ☐, F ☐, N/A ☐ Holes or Other Signs of Excessive
Abrasion

P ☐, F ☐, N/A ☐ Zippers or Other Trim Items
Functioning Properly

Grade: _____ Color Bleeding/Self Staining (Gray
scale 4.5 or better)

Grade: _____ Color Staining on Acetate (min 3.0)

Grade: _____ Color Staining on Cotton (min 3.0)

Grade: _____ Color Staining on Nylon (min 3.0)

Grade: _____ Color Staining on Polyester (min 3.0)

Grade: _____ Color Staining on Acrylic (min 3.0)

Grade: _____ Color Staining on Wool (min 3.0)

Overall Rating of Appearance: _____ Satisfactory (PASS) or

_____ Unsatisfactory (FAIL)

Additional Comments: _____

Revision History

1. March 2021:
Added Revision section, added 5 x washes for Appearance Retention on Tier 2 and 3 products
2. September 2025:
 - a. Reformatted and condensed to remove pages not relevant to home
 - b. Added 'KAR and Durability Testing Requirements: HOME' chart