



# MINIMUM CONSTRUCTION STANDARDS

**PRIVATE & EXCLUSIVE BRANDS HOME**

## **BEDDING & SHEETING**

**All Private and Exclusive brands must follow Minimum requirements unless otherwise specified in the TP.**



# MINIMUM CONSTRUCTION STANDARDS BEDDING & SHEETING

## Overview

The acceptance of an order placed by Kohl's for Private and Exclusive Brand products indicates that, as a vendor, you are aware of the technical and quality standards required by Kohl's, in addition to any applicable laws or regulations existing for this product category. It is your responsibility to supply product to Kohl's that meets those standards. Any variation from Kohl's established standards must be agreed upon in writing by Kohl's and the manufacturer and documented in the Kohl's Tech Pack.

Section I. [Fabric Layout and Cutting Requirements](#)

Section II. [Trims and Findings Requirements](#)

Section III. [Sewing and Construction Requirements](#)

Section IV. [Measurement Tolerances](#)

Section V. [Product Labeling](#)



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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section I. Fabric Layout and Cutting Requirements</b>		
All fabrics as specified, including but not limited to - content, yarn type, weave, weight, dye class & process, finish, etc		
<ul style="list-style-type: none"><li>• All parts of finished products must be compatible with prescribed care instructions</li><li>• Combined fabrications must have compatible shrinkage</li><li>• Cut product pieces on grain unless otherwise specified (length on warp)</li><li>• No selvage edges allowed as hems</li><li>• Heavily napped fabrics, brushed fabrics and one-way prints - all product pieces cut in the same direction within a unit</li><li>• Pattern Matching: Pattern/Plaid/Stripe match must be submitted to Design/Production/Technical Design for approval before final costing acceptance</li><li>• No exposed drill holes, punch holes, or notches</li><li>• Corners must be 90 degrees</li></ul>	1 way cut: Cut all products in the same direction within an entire program	2 way cut: Cut all pieces within a single unit and multiple components within a set in the same direction but it may be different between units/sets.



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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 <a href="#">Kohl's Preferred Supplier</a> <ul style="list-style-type: none"><li>No monofilament thread. Multi-filament is acceptable for specific uses</li></ul> Embroidery Thread: <ul style="list-style-type: none"><li>Preference - Polyester - from <a href="#">Kohl's Preferred Supplier</a></li><li>Allowed - Polyester from a non-Preferred Supplier, contingent upon passing specific thread testing protocols</li><li>Allowed - Rayon - from a <a href="#">Kohl's Preferred Supplier</a></li></ul> Bead/Sequin attachment thread. Very specific thread requirements <ul style="list-style-type: none"><li>Refer to <a href="#">'Bead &amp; Sequin Attachment Guide'</a> on K-link</li></ul> Thread Color <ul style="list-style-type: none"><li>Must match fabric ground unless otherwise specified. Bedskirt thread color to match skirt/drop, not platform</li><li>All operations must use same color thread within internal seams</li></ul> 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.  <b>Thread Size Chart by Fabrication:</b> <table><tr><td>Needle/Bobbin:</td><td>Looper:</td></tr><tr><td><ul style="list-style-type: none"><li>2 - 4oz = Tex 18-21</li></ul></td><td>Tex 18</td></tr><tr><td><ul style="list-style-type: none"><li>4 - 6oz = Tex 21(spun) - 24(core)</li></ul></td><td>Tex 27</td></tr><tr><td><ul style="list-style-type: none"><li>6 - 8oz = Tex 27(spun) - 30(core)</li></ul></td><td>Tex 30</td></tr><tr><td><ul style="list-style-type: none"><li>8 - 10oz = Tex 40</li></ul></td><td>Tex 27-30 or 35 (textured poly)</td></tr><tr><td><ul style="list-style-type: none"><li>10 - 14oz = Tex 60</li></ul></td><td>Tex 40</td></tr></table> Looper Thread: Spun Polyester or Textured Polyester <ul style="list-style-type: none"><li>Tex size of looper thread must be comparable with tex size of needle thread</li></ul>	Needle/Bobbin:	Looper:	<ul style="list-style-type: none"><li>2 - 4oz = Tex 18-21</li></ul>	Tex 18	<ul style="list-style-type: none"><li>4 - 6oz = Tex 21(spun) - 24(core)</li></ul>	Tex 27	<ul style="list-style-type: none"><li>6 - 8oz = Tex 27(spun) - 30(core)</li></ul>	Tex 30	<ul style="list-style-type: none"><li>8 - 10oz = Tex 40</li></ul>	Tex 27-30 or 35 (textured poly)	<ul style="list-style-type: none"><li>10 - 14oz = Tex 60</li></ul>	Tex 40	Needle & Bobbin Thread: Poly-wrap/Poly-core OR Cotton-wrap/Poly-core  Decorative thread as specified	Needle & Bobbin Thread: Spun Polyester  Decorative thread as specified
Needle/Bobbin:	Looper:													
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Revised Date: 4/24/2025



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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section II. Trims and Findings Requirements (cont'd)</b>		
Trims/Findings in children's products must meet CPSIA requirements		
<b>Zippers</b> <ul style="list-style-type: none"><li>Aluminum zippers are not allowed</li><li>Zipper slides must be locking - either auto-lock, pin-lock, or semi-automatic lock</li><li><b>Children's Products:</b><ul style="list-style-type: none"><li>If using 3-part zipper, it must meet 'pull tab twist test'</li><li>Must include zipper guard over the slider and pull when closed</li></ul></li><li>Zipper stops must be in place at both ends of the zipper to prevent the slider from pulling off the tape. Stops can be metal clips, machine stitched bartacks, or hand stitched wrapping of the teeth</li></ul>		
<b>Fasteners (buttons, grippers, snaps, eyelets, grommets)</b> <ul style="list-style-type: none"><li>Must be secured through two layers of fabric. Fasteners on a single ply fabric must be supported with non-woven/non-fusible discs - with approval only</li><li>Metal components must be plated, lacquered, or enameled to be corrosion resistant. Corrosion proof as specified</li><li>Must be evenly spaced and centered on width of panel, or as specified</li><li><b>Children's Products:</b><ul style="list-style-type: none"><li>Functional buttons must be 4-hole and sewn with locking cross stitch, with a minimum of 16 stitches</li><li>Decorative buttons can be 2-hole button, sewn with a minimum of 8 stitches</li></ul></li><li>Buttons must be sewn with shank height suitable for fabric thickness</li><li>Covered buttons must be made from a 'kit' and be securely assembled</li></ul>	Recommended: Sew 4-hole buttons with locking cross stitch  Buttons must have a thread wrapped shank	Allowed: Sew 4-hole buttons with parallel stitch ( <i>excluding children's products</i> )
<b>Embroideries</b> <ul style="list-style-type: none"><li>Must have suitable tear-away or dissolvable backing that must be removed after application</li><li>Stitching must be secured by stacking stitches with increased SPI (minimum 25-30), knotting, back-stitch (minimum 3 stitches), or bar-tack</li><li>Stitching must be knotted/secured every 3/4" with thread floats no longer than 3/4"</li><li><b>Children's Products:</b><ul style="list-style-type: none"><li>floats no longer than 3/8"</li></ul></li></ul>		

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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section II. Trims and Findings Requirements (cont'd)</b> Trims/Findings in children's products must meet CPSIA requirements		
Bead/Sequin <ul style="list-style-type: none"> <li>Refer to <a href="#">'Bead &amp; Sequin Attachment Guide' on K-link</a></li> <li>Suitable stabilizer must be used with lightweight fabrics</li> <li>Thread must be knotted off sufficiently throughout to prevent excessive beads/sequins from falling off</li> </ul>		
Piping <ul style="list-style-type: none"> <li>Pre-shrunk cotton cord - smooth not braided. May be foam filling</li> <li>Must not twist or kink inside piping covering</li> <li>Maximum finished filed piping diameter - 6.35mm or 1/4"</li> </ul>	Piping Cover must be bias cut unless otherwise specified	Piping Cover may be straight cut for straight edges but must be bias cut for curved/shaped edges
Binding <ul style="list-style-type: none"> <li>Lockstitch zigzag (ISO 304) all layers together before applying binding</li> <li>Raw edges of binding must be folded in and securely sewn into binding</li> <li>If self-bound (hemmed) - clean finished, double turned, single need lockstitch</li> <li>Minimal number of splices - directly proportional to the size of the product</li> <li>If 3/4" or wider - stitch sides of binding closed</li> </ul>	Preferred bias cut unless otherwise specified	May be straight cut for straight edges, must be bias cut for curved/shaped edges
Ruffles <ul style="list-style-type: none"> <li>Single ply or Double ply as specified</li> </ul>	Gather ratio: 1.75:1 - 2:1	Gather ratio: 1.5:1 minimum

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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section III. Sewing and Construction Requirements</b>		
Seams must meet Kohl's seam slippage and strength requirements		
<ul style="list-style-type: none"><li>Stitches per inch (SPI) of hem, seams, and topstitching as specified by brand and construction requirement</li><li>Fitted sheet corner pocket seams have higher SPI than hems to increased strength</li><li>No exposed raw or pinked edges</li><li>No serged-only edges, hems, or seams</li><li>No adhesive used to construct products</li><li>Minimum 3/8" seam allowance. Maximum 3/4" seam allowance</li><li>Reinforcement Stitching:<ul style="list-style-type: none"><li>Stitching must be secured at start and stop</li><li>Back-stitch (minimum 3 stitches), lockstitch thread tails trimmed close</li><li>Bar-tack</li><li>Latchback</li><li>Ends of stitching crossed by another seam or line of stitching</li><li>Stack stitches by increasing SPI for 1" (minimum 25-30 SPI)</li><li>Knotted ends (on running stitch only)</li></ul></li><li>For internal seams only:<ul style="list-style-type: none"><li>Overlock and Chainstitch leave tightly chained thread tails</li><li>Lockstitch thread tails reinforced and trimmed close</li></ul></li><li>Button sew and Buttonholes: Lockstitched or locked chainstitched with 1/8" tail</li><li>Buttonholes must be stitched through two layers of fabric</li><li>Decorative whipstitch (over machine stitched hems only): Must be secured at start and stop by back-tack (minimum 3 stitches)</li><li><b>Children's Products:</b><ul style="list-style-type: none"><li>Overlock stitch is required underneath any blanketstitch or whipstitch detail</li><li>All blanketstitching or whipstitching must be cut in 8" lengths and tacked or knotted at the end of each length</li><li>Line tack is to be perpendicular (non-parallel) to the edge of the product</li><li>Knocking is to be done on the backside of the product</li></ul></li></ul>	<p>SPI: 10 - 12</p> <p>SPI: 12 - 14 Fitted sheet corner pockets</p> <p>Tail length: 1 1/2"</p>	<p>SPI: 8 - 10</p> <p>SPI: 10 - 12 Fitted sheet corner pockets</p> <p>Tail length: 1"</p>



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<b>Section III. Sewing and Construction Requirements (cont'd)</b>  Seams must meet Kohl's seam slippage and strength requirements		
<b>Flat Sheet</b> <ul style="list-style-type: none"> <li>Top hem design treatment/construction as specified. Should follow low duty classification construction</li> <li>Sides are hemmed last</li> </ul>	Open ends of top hem are stitched closed with lockstitch	
<b>Fitted Sheet</b> <ul style="list-style-type: none"> <li>Corner pocket seam type as specified by brand</li> <li>Elastic is applied to entire bottom hem circumference</li> <li>Elastic stretch ratio: 1:2.5 minimum</li> <li><b>For Woven Sheets</b> <ul style="list-style-type: none"> <li>Woven elastic type as specified. Must source the specified elastic model # from the assigned supplier only</li> <li>Minimum 1" flat overlap reinforcement at elastic start/stop by vertically stitching elastic ends together using SN LS TS with backstitch</li> </ul> </li> <li><b>For Knit Sheets</b> <ul style="list-style-type: none"> <li>Knit elastic as specified with firm power and excellent recovery</li> <li>Elastic is applied flat with 5-thread safety stitch, knife removed</li> <li>Elastic hem is closed at corner pocket seam</li> <li>Elastic is reinforced at seam by turning seam allowance to one side and SN LS TS both ends together in the hem.</li> </ul> </li> </ul>	<b>Corner pocket:</b> Clean finished double turned, single needle lockstitch (ISO 301), reinforced	<b>Corner pocket:</b> Sewn 5-thread safety stitch (ISO 516), mock safety (ISO 512) or 4-thread overedge (ISO 514) for knits, with or without SN or 2N topstitch
<b>Pillowcase</b> <ul style="list-style-type: none"> <li>Seams may be at two long sides only (U-construction) or one long side and one short side (L-construction) but must be the same construction within a paired set. Stitching must be secured at start and stop: tightly chained thread tail for internal seams with latchback at top hem edge.</li> <li>Top hem design treatment/construction as specified. Should follow low duty classification construction</li> </ul>	Tail length: 1 1/2"	Tail length: 1"
<b>Shams</b> <ul style="list-style-type: none"> <li>Standard back overlap construction unless otherwise specified. Overlap widths only apply if there are no buttons, zippers, ties or tabs to hold overlap closed</li> <li>Reinforce pillow pocket opening at overlap with back-stitch (minimum 5 stitches)</li> </ul>	Back overlap: 5" - 6"	Back overlap: 4"

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Section III. Sewing and Construction Requirements (cont'd)		
Seams must meet Kohl's seam slippage and strength requirements		
Comforter/Duvet Covers <ul style="list-style-type: none"><li>Standard bottom closure construction with internal envelope enclosure</li><li>Reinforcement stitching/tack at each edge of bottom opening</li><li>Two 7 1/2" twill tape or clean-finished self-fabric ties attached in each corner, maximum 1" from corner, stitched directly over original seam stitching, reinforced</li></ul>	Button spacing: 7" maximum	Button spacing: 9" maximum
Bedskirts <ul style="list-style-type: none"><li>Platform fabric as specified</li><li>Split corners - must be symmetrical. Maximum side to side variation +/- 1/4"</li><li>Any splices or piecing seams in drop must be engineered to be hidden in corner pleats or box pleats, as approved</li><li>Hemmed top edge of platform – no overlock-only platform hems allowed</li></ul>	Platform fabric: Woven platform fabric preferred, Non-woven allowed  Top hem: No serge & turn platform hem allowed	Platform fabric: Non-woven platform fabric allowed  Top hem: Serge & turn platform hem allowed
Section IV. Measurement Tolerances		
All measurements as specified in the Kohl's Tech Pack. Tolerances apply to finished product dimensions only.		
Component Variation Within A Set <ul style="list-style-type: none"><li>Component variation must not exceed individual measurement tolerances as specified<ul style="list-style-type: none"><li>Length (at center) +/-1/2"</li><li>Width (at center) +/-1/2"</li></ul></li></ul>		



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## REQUIREMENTS

### 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 Kohl's Tech Pack
- For a complete list of label placements, reference the below guides available on K-link:
  - *Resources > Private and Exclusive Brands > Global Technical Design > Home > Label Placement Guides subheading*
  - [Label Placement - Bedding](#)