

KOHL'S MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS HOME

FILLED PRODUCTS

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



MINIMUM CONSTRUCTION STANDARDS FILLED PRODUCTS

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 Technical Product Specification.

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

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

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

Section IV. [Measurement Tolerances](#)

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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		
<ul style="list-style-type: none">• 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 as hems• 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	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 Kohl's Preferred Supplier <ul style="list-style-type: none">• No monofilament thread. Multi-filament is acceptable for specific uses Embroidery Thread: <ul style="list-style-type: none">• 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 <ul style="list-style-type: none">• Refer to 'Bead & Sequin Attachment Guide' on K-link Thread Color <ul style="list-style-type: none">• 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 <p>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.</p> <p>Thread Size Chart by Fabrication:</p> <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 <ul style="list-style-type: none">• 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	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:													
• 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)													
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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
Section II. Trims and Findings Requirements (cont'd) Trims/Findings in children's products must meet CPSIA requirements		
Zippers <ul style="list-style-type: none"> Aluminum zippers are not allowed Zipper slides must be locking - either auto-lock, pin-lock, or semi-automatic lock Children's Products: <ul style="list-style-type: none"> If using 3-part zipper, it must meet 'pull tab twist test' Must include zipper guard over the slider and pull when closed 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 		
Fasteners (buttons, grippers, snaps, eyelets, grommets) <ul style="list-style-type: none"> 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 Metal components must be plated, lacquered, or enameled to be corrosion resistant. Corrosion proof as specified Must be evenly spaced and centered on width of panel, or as specified Children's Products: <ul style="list-style-type: none"> 4-hole buttons must be sewn with locking cross stitch 2-hole buttons sewn with a minimum of 8 stitches, 4-hole buttons sewn with a minimum of 16 stitches Buttons must be sewn with shank height suitable for fabric thickness Covered buttons must be made from a 'kit' and be securely assembled 	Recommended: Sew 4-hole buttons with locking cross stitch Buttons must have a thread wrapped shank	Allowed: Sew 4-hole buttons with parallel stitch (excluding children's products)
Embroideries <ul style="list-style-type: none"> Must have suitable tear-away or dissolveable 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: <ul style="list-style-type: none"> floats no longer than 3/8" 		

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Section II. Trims and Findings Requirements (cont'd)		
Trims/Findings in children's products must meet CPSIA requirements		
Bead/Sequin <ul style="list-style-type: none">No monofilament threadRefer to 'Bead & Sequin Attachment Guide' on K-linkSuitable stabilizer must be used with lightweight fabricsThread must be knotted off sufficiently throughout to prevent excessive beads/sequins from falling off		
Piping <ul style="list-style-type: none">Pre-shrunk cotton cord - smooth not braided. May be foam fillingMust not twist or kink inside piping coveringMaximum finished filed piping diameter - 6.35mm or 1/4"	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">Lockstitch zigzag (ISO 304) all layers together before applying bindingRaw edges of binding must be folded in and securely sewn into bindingIf self-bound (hemmed) - clean finished, double turned, single need lockstitchMinimal number of splices - directly proportional to the size of the productIf 3/4" or wider - stitch sides of binding closed	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">Single ply or Double ply as specified	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
Section III. Sewing and Construction Requirements		
Seams must meet Kohl's seam slippage and strength requirements		
<ul style="list-style-type: none"> Stitches per inch (SPI) of hem, seams, and topstitching as specified by brand and construction requirement Fitted sheet corner pocket seams have higher SPI than hems to increased strength No exposed raw or pinked edges No serged-only edges, hems, or seams No adhesive used to construct products Minimum 3/8" seam allowance. Maximum 3/4" seam allowance Reinforcement Stitching: <ul style="list-style-type: none"> Stitching must be secured at start and stop Back-stitch (minimum 3 stitches), lockstitch thread tails trimmed close 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) For internal seams only: <ul style="list-style-type: none"> Overlock and Chainstitch leave tightly chained thread tails Lockstitch thread tails reinforced and trimmed close Button sew and Buttonholes: Lockstitched or locked chainstitched with 1/8" tail Buttonholes must be stitched through two layers of fabric Decorative whipstitch (over machine stitched hems only): Must be secured at start and stop by back-tack (minimum 3 stitches) Children's Products: <ul style="list-style-type: none"> With blanket-stitch or whipstitch - yarn or thread must be cut in 8" lengths and must be tacked or knotted at the end of each length. Line tack is to be perpendicular (non-parallel) to the edge of the product Knocking is to be done on the backside of the product 	<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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Section III. Sewing and Construction Requirements (cont'd)		
Seams must meet Kohl's seam slippage and strength requirements		
Quilting <ul style="list-style-type: none">• Hand stitched quilting SPI unless otherwise specified• Hand guided machine quilting SPI unless otherwise specified• Automatic machine quilting SPI unless otherwise specified• Jump & Tack quilting SPI and length as specified by fabrication and design Fill <ul style="list-style-type: none">• Fill content and weight as specified by tech pack• Must be evenly distributed without clumping or hollow spots• Must be extended fully to all edges of component, including closure seam• Must retain loft without separation and clumping after multiple launderings	Quilting SPI: 2.5 - 4 6 - 8 8 - 10	Quilting SPI: 2.5 - 4 4 - 6 6 - 8
Pillows <ul style="list-style-type: none">• Brand appropriate Shell/Tick fiber content and thread count• Shell/Tick fiber content must be down-proof for natural fill	Recommended CVC or better	Recommended CVC, 100% Polyester Allowed
Mattress Pads <ul style="list-style-type: none">• Elastic is applied to entire bottom hem circumference• Elastic type: 1/2" W knit elastic, firm power with excellent recovery, unless otherwise specified and with approval only• Elastic stretch ratio: 1:2.5 minimum• Elastic is applied flat with 5-thread safety stitch using texturized polyester thread, knife removed• Elastic hem is closed at corner pocket seam• Elastic is reinforced at seam by turning seam allowance to one side and SN LS TS both ends together across the seam allowance		

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Section III. Sewing and Construction Requirements (cont'd)		
Seams must meet Kohl's seam slippage and strength requirements		
Comforters <ul style="list-style-type: none">• Shell/Tick fiber content and thread count as specified by brand• Natural Fill:<ul style="list-style-type: none">• Shell/Tick fiber content must be down-proof for natural fill.• Quilting stitch for natural fill comforters extends to the edges and is crossed by the joining seam.• Synthetic Fill:<ul style="list-style-type: none">• Use of a non-woven scrim may be required to prevent batting from bearding through the shell if thread count or weave is not sufficient to prevent it from occurring• Scrim and/or Needle Punch layer must be 100% Polyester. Polypropylene/Olefin is not allowed due to its low melting point• Quilting stitch for synthetic fill comforters stops 1/2" minimum – 1" maximum from the edges to prevent pleats and puckers		
Quilted Comforter Covers/Duvet Covers: <ul style="list-style-type: none">• Standard bottom closure construction with internal envelope enclosure• Reinforcement stitching/tack at each edge of bottom opening• 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.• Use of a non-woven scrim may be required to prevent batting from bearding through the shell if thread count or weave is not sufficient to prevent it from occurring• Scrim and/or Needle Punch layer must be 100% Polyester. Polypropylene/Olefin is not allowed due to its low melting point	Button Spacing: 7" maximum	Button Spacing: 9" maximum
Coverlets & Quilts <ul style="list-style-type: none">• Use of a non-woven scrim may be required to prevent batting from bearding through the shell if thread count or weave is not sufficient to prevent it from occurring• Scrim and/or Needle Punch layer must be 100% Polyester. Polypropylene/Olefin is not allowed due to its low melting point		

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Section III. Sewing and Construction Requirements (cont'd)		
Seams must meet Kohl's seam slippage and strength requirements		
Quilted Shams <ul style="list-style-type: none">Standard back overlap construction unless otherwise specified. Overlap widths only apply if there are no buttons, zippers, ties or tabs to hold overlap closed.Reinforce pillow pocket opening at overlap with back-stitch (minimum 5 stitches).Use of a non-woven scrim may be required to prevent batting from bearding through the shell if thread count or weave is not sufficient to prevent it from occurringScrim and/or Needle Punch layer must be 100% Polyester. Polypropylene/Olefin is not allowed due to its low melting point	Back overlap: 5" - 6"	Back overlap: 4" - 5"
Section IV. Measurement Tolerances		
All measurements as specified on the Technical Product Spec. Tolerances apply to finished product dimensions only.		
Component Variation Within A Set <ul style="list-style-type: none">Component variation must not exceed individual measurement tolerances as specified<ul style="list-style-type: none">Length (at center) +/-1/2"Width (at center) +/-1/2"		



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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 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 - Bath and Beach](#)
 - [Label Placement - Bedding](#)
 - [Label Placement - Rugs](#)