Private Brands
Outerwear
Apparel Construction Requirements

All Outerwear must follow the Woven Minimum Construction Requirements. The items listed below are additional requirements to these Standards. Listed items are the minimum requirement for all private and exclusive brands unless otherwise specified in the style specific construction details by the TD.

How to use these Construction Standards:

-Outerwear product category applies to any product that is designed to be worn over other garments as outerwear and is made using fabrications/trims specific to Outerwear.
-**Product Safety Standards** list additional requirements to meet CPSC and FTC requirements. Please see Performance Testing – Softlines – Apparel & Apparel Accessories on www.connection.kohls.com
-**Pattern Matching Guidelines** are listed separately on www.connection.kohls.com
-**Defect Classification** is listed separately. Please see Quality Assurance – Defect Classification on www.connection.kohls.com
-Underlined words have definitions/pictures in the Apparel Dictionary on www.connection.kohls.com under Private Brands tab/Technical Design
-**Standards** followed by code (A-1, B-1, etc) have diagrams in the Construction Standard Appendix.
-Construction standards are updated twice a year – before Spring/Summer costing season and before Fall/Holiday costing season. When starting a costing season, vendors should always check www.connection.kohls.com for latest version of Construction Standards and check this summary page for updates.

Summary of Changes – NOTE PLEASE SEE FOLLOWING PAGES FOR FULL DETAILS

October 2026– Page 3, SECTION D - Seams: Revised requirements to clarify the use of overlock (ISO 503) or (ISO 504) clean finished edges on all outer shell and linings of garments.

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SECTION A-Thread: Follow Woven's Minimum Construction requirements unless otherwise listed below.

Needle/Bobbin Thread Quality: Poly-wrap/Poly-Core for all programs.
Looper Thread Quality: Spun Polyester. Texturized polyester is subject to TD approval
Thread Size:

- **Down-Filled/Microfiber Polyester-filled outerwear Polyester/Nylon quilting:** Needle/ Bobbin = Tex 24, Looper = Texturized Polyester Tex 35-40
- **Microfiber:** Needle/ Bobbin = Tex 30, Looper = Tex 21
- **Wool, Coated Nylon:** Needle/ Bobbin = Tex 40, Looper = Tex 40
- **Twill/Canvas/Corduroy:** Needle/ Bobbin = Tex 80, Looper = Tex 60
- **Faux Leather:** Needle = Tex 80, Bobbin = Tex 60, Looper = Tex 45

Large (> 40 Ligne) 4-hole or 2-hole CF Buttons: Nylon Thread, Tex 70

Shank Button sew thread quality:

- Light weight (nylon/Microfiber) Outerwear = Poly wrap/Polycore, Tex 40 **OR** Nylon Thread Tex30-45 may be required depending on button type/styling
- Heavy weight (Cotton, Canvas, faux leather) = Nylon thread, Tex 60-80
- Wool Dress/Tailored Outerwear = Acolite Thread, Tex 60-80

Blind hems: Continuous Filament Polyester – COATS GRAL Tex12 depending on fabrication weight - must source quality as specified – cannot use any monofilament nylon thread.

SECTION B-SPI Requirements:

- **Outerwear** = 8-10 SPI – may vary depending on fabrication.
- **Blind hems** = 4 – 4.5 SPI

SECTION C-Seam Requirements: Follow Woven's Minimum Construction requirements

- **Garment Washed:** All internal seams must be overedged (ISO 504) for both lined and unlined garments.

SECTION D-Construction:

Sleeve/Bottom Hem:

- **Blind hems must be blind lock stitched (ISO 103). Overlap stop/start of blind hem ¾" to 1". Pull thread through loop at the end of operation to lock the stitch. (D-5)**
- **No stitch Hem Tacking:** Apply non-woven fusible, blind stitch or tack hem to body at seam allowances unless otherwise specified
- **Lined Shirt Jackets:** Must have a 1" to 1 ¼" self facing at inside hem to prevent lining from rolling outward after wash.

Pockets:

- **Wool/Tailored Outerwear Exterior Welt Pockets or other specified pockets:** Machine baste closed with 1" opening at each end.

Pocket Bags:

- Tack pocket bags to nearest garment seam with a floating fabric tack.

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Seams:

- **Unlined Outerwear:** Interior seams visible from front opening of jacket must be frenched seamed, felled, or have seam allowances finished with bound edges. Safetystitch can be approved on seams not visible when jacket is open – ex. Front yoke/princess/ AH seams.
- **Wool Outerwear:** Lockstitch ISO 301 or Chainstitch (ISO401) and pressed open
- **Pressing:** In process pressing required - press the following seams open: darts, side panel, side seam, CB seam, shoulders.
- **Linings/Shell Fabrications that fray easily:** All edges must use overlock (ISO 503) or (ISO 504) this includes unlined and/or lined garments (both outer shell and lining).

Woven Linings: secure lining into bottom hem/slv hem with ½" ease. (D-16)
Knit (Sherpa, faux fur, jersey) Linings with Woven Shell:

- Adjust lining pattern for differential shrinkage and differential fabric stretch.
- Tack lining to shell seam allowance with floating fabric tack at side seams 2" above hem to prevent lining from sagging below hem.

Wool Shoulder, Back Neck, Armholes and Center Front: Stabilized with fusible or twill tape.
Wool Upper Back/Around Armhole: Interlining required on upper back and around armhole.

Padding: Scrim requirement (E-7) – see Woven Minimum Standards.

SECTION E-Trims/Findings:

Closures: Hand-sewn Buttons are only permitted on Adult Outerwear.

- **Casual Hand-Sewn Shank Buttons knotted once after vertical stitches. Hand sewn buttons not allowed on children's garments.(E-3)**
- **Casual Hand-Sewn Wrapped Shank Buttons knotted once after vertical stitches, knotted once after horizontal wrap. (E-3)**
- **Wool/Tailored Hand-Sewn Shank Buttons knotted once after 2nd to last vertical stitch, knotted 2nd time after last vertical stitch. (E-3)**
- **Wool/Tailored Hand-Sewn Wrapped Shank Buttons knotted once after vertical stitch, knotted once after 2nd to last horizontal revolution, knotted a 2nd time after last horiztontal revolution (E-3)**

Zippers:

- All metal zippers for tops and outerwear at center front must have auto lock sliders.
- All coil zippers for tops and outerwear at center front must have auto lock or semi auto lock sliders.
- Separating Only: Must be left hand insert, right hand pull.

Separating Only: Reinforce zipper box/pin with Line tack or Bartack sewn on a 28 -stitch tacking machine. (E-1)

Interlining:

- All Garments: Required on lapel, top collar, pocket flaps/welts, vent openings
- Wool Garments: Above locations + front panel, upper back panel, chest piece and shoulder seam.
- **Woven Fusible Tape** required on lapel roll/crease line.
- **Felt** (Tailored Wool Outerwear) use under collar or as specified.

Shoulder Pads: Tack shoulder pad in 3 places –2 at armhole, 1 at shoulder seam near neck. Use specified tack method.

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SECTION F-Cutting:

Cutting Direction:

- **Napped fabrics: Always verify w/ Brand Manager during costing stage!**
- **Uneven/Directional plaids/stripes:** Depends on styling/plaid scale and contrast. Verify with Brand Manager or Production Controller during costing stage.