

KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

PRIVATE & EXCLUSIVE BRANDS APPAREL

SWEATERS

*** FOLLOW THE GENERAL APPAREL CONSTRUCTION
REQUIREMENTS MANUAL**

**THIS MANUAL CONTAINS REQUIREMENTS SPECIFIC TO SWEATERS. THESE
SWEATER SPECIFIC REQUIREMENTS ARE IN ADDITION TO THE GENERAL
APPAREL CONSTRUCTION REQUIREMENTS.**

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

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KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

TABLE OF CONTENTS

SWEATER CONSTRUCTION REQUIREMENTS

SECTION 1: KNITTING & SEAM REQUIREMENTS.....PG	3
GENERAL KNITTING REQUIREMENTS.....PG	3
SWEATER SEAM REQUIREMENTS.....PG	3
SECTION 2: TRIMS & STARTS.....PG	4
SECTION 3: NECKLINES & PLACKETS.....PG	5
SECTION 4: SHOULDERS & ARMHOLES.....PG	10
SECTION 5: STYLING FEATURES.....PG	12
POCKETS.....PG	12
DRAWCORDS/SLEEVE TABS/BELTS.....PG	13
SIDE SLITS.....PG	15
SECTION 6: PATTERN.....PG	16
FLOATS & TAILS.....PG	16
STITCH PATTERN PLMT/MATCHING.....PG	18

KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

FOLLOW THE GENERAL APPAREL CONSTRUCTION REQUIREMENTS MANUAL

KNITTING & SEAM REQUIREMENTS

- Follow the KNIT SPECIFIC REQUIREMENTS FOR THREAD AND SEAMS, see GENERAL APPAREL CONSTRUCTION REQUIREMENTS GUIDELINES

General knitting requirements:

- **PANELS:** All panels must be knit to shape unless otherwise specified.
- **Mixed Media Sweaters:** Mixed panels need to meet General Apparel Construction Requirements based on individual panel. (Woven panel follows WOVEN APPAREL CONSTRUCTION REQUIREMENTS; knit panel follows KNIT APPAREL CONSTRUCTION REQUIREMENTS, etc.)
- **Knitting Tension:** must follow approved sample.
Tolerance +/- 1 SPI/CPI for fine gauge (7 GG or finer)
Tolerance +/- 1/2 SPI/CPI for heavy gauge (1-5 GG)

Sweater seam requirements:

- **Linked Seams:** Link join using self-yarn, unless otherwise specified.
- Linking tension must allow for stretch and recovery of sweater.
- **No seams in binding or taping.**

Sweater requirements for cupped seams:

- For use on straight side seams and sleeve inseams only.
- Yarn ends must be tied to secure, then woven back at interior, and finally trimmed to a maximum length of 1/2".
- Tension must allow for stretch and recovery of sweater.

Sweater requirements for overlock sewn seams (WITH PRE-APPROVAL ONLY):

- For use on straight side seams and sleeve inseams only.
- General Sewing: Must be suitable for sweater gauge/yarn size and hold yarns securely in seam without seam slippage.
- Sewing Tension must allow for stretch and recovery of the sweater.
- Sweater panels must be knit to shape and overlock sewn **without** using machine blade.

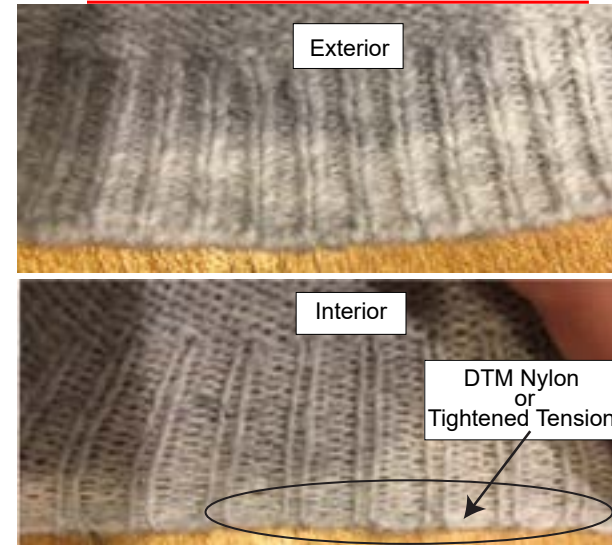
KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

TRIMS & STARTS

Rib or Self edges:

- For use on sleeve, sweep, neckline or trim edges.
- Tension must be tightened at start, minimum of 1/4" unless otherwise specified.
- DTM nylon knit into first 1/4" of start unless otherwise specified.
- Elastic cord may be requested for heavy gauge (1-5 GG).
- See image: [RIB AND/OR SELF EDGE HEMS](#)

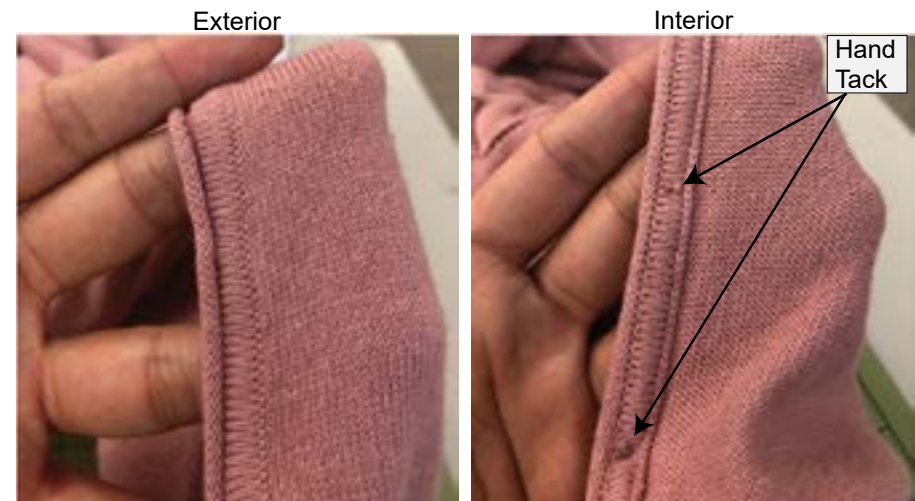
RIB AND-OR SELF EDGE HEMS.AI



Rolled or Turn Back edges:

- Reverse link join at side/underarm seams. Hand tacked as specified.
- See image: [ROLLED AND/OR TURN BACK EDGE HEMS](#)

ROLLED AND-OR TURN BACK EDGE HEMS.AI



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

NECKLINE & PLACKETS

Mitered V-Neck Single Layer: Link join, press open, hand tack seam allowance to neck seam.

- See image: [MITERED V-NECK SINGLE LAYER](#)

MITERED V-NECK SINGLE LAYER.AI

Exterior



Interior



Mitered V-Neck Double Layer: Clean join trim by hand.

- See image: [MITERED V-NECK DOUBLE LAYER](#)

MITERED V-NECK DOUBLE LAYER.AI

Exterior



Interior



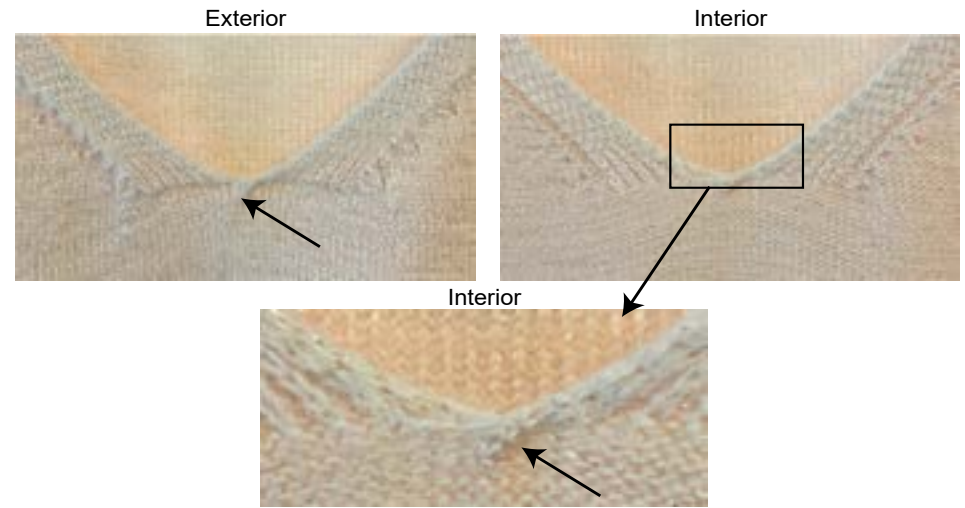
KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

NECKLINE & PLACKETS CONTINUED

Self-edge V-neck:

- Cross or rack needles at base of V to reinforce.
- See image: [SELF EDGE V-NECK](#)

[SELF EDGE V-NECK.AI](#)



Rollneck:

- Reverse-link join at shoulder seams.
- Hand tack placement as specified.
- See image: [ROLLNECK EDGE](#)

[ROLLNECK EDGE.AI](#)



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

NECKLINE & PLACKETS CONTINUED

Placket:

- Self knit, clean finished ends; no raw edges.
- knit in or linked in with self yarn.
- See image: [LINKED PLKT](#)
- See image: [KNIT IN PLKT](#)

[LINKED PLKT.AI](#)

Exterior



Interior



[KNIT IN PLKT.AI](#)

Exterior



Interior



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

NECKLINE & PLACKETS CONTINUED

Fold over collar: single seam

Single seam: placement of seam as specified in tech pack.

- **Reverse linking length:** 2/3 of trim height from top edge, or as specified in tech pack.
- See image: [FOLD OVER TRIM SINGLE SEAM](#)

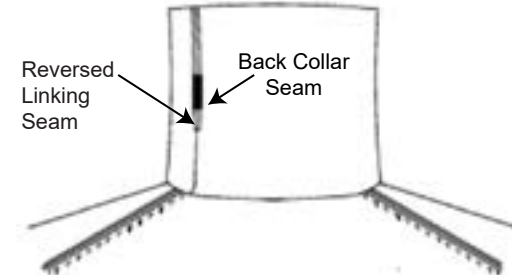
Fold over collar: double seam

Double collar seam: 2 seams with placement as specified.

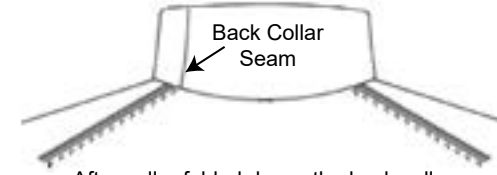
- **Reverse linking length:** 2/3 of neck trim height from top edge, or as specified in tech pack.
- See image: [FOLD OVER TRIM DOUBLE SEAM](#)

[FOLD OVER TRIM SINGLE SEAM.AI](#)

BACK VIEW: COLLAR UNFOLDED



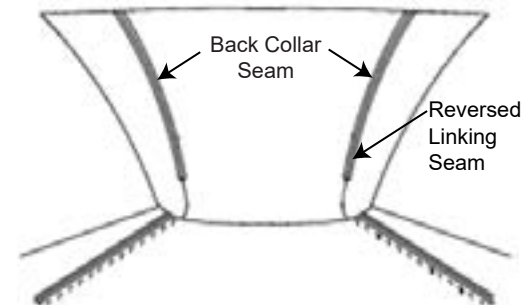
BACK VIEW: COLLAR FOLDED



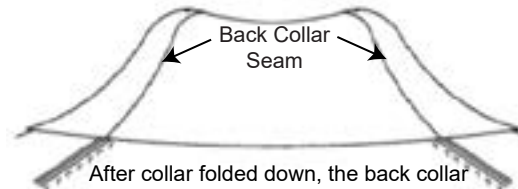
After collar folded down, the back collar seam will be invisible.

[FOLD OVER TRIM DOUBLE SEAM.AI](#)

BACK VIEW: COLLAR UNFOLDED



BACK VIEW: COLLAR FOLDED



After collar folded down, the back collar seam will be invisible.

KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

NECKLINE & PLACKETS CONTINUED

Back neck tape:

- **Attachment:** clean join to body securely.
- See image: [BACK NECK TAPE](#).

BACK NECK TAPE.AI

Exterior



Interior



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

SHOULDER & ARMHOLE CONSTRUCTION

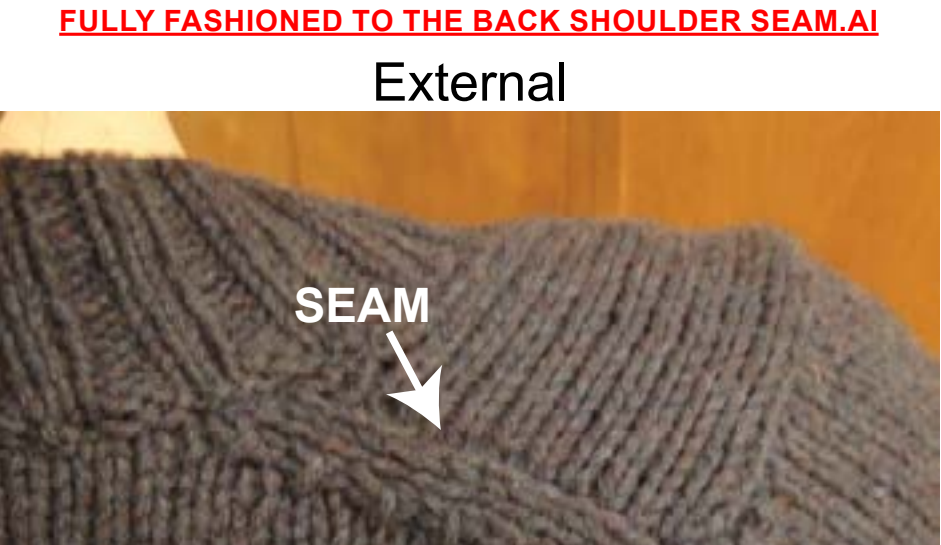
Forward Shoulder seam join with tape (for set-in armholes):

- Must be reinforced with twill, clear, stretch or self knitted tape unless otherwise specified.
- Tape set to back seam allowance.
- See image: [FORWARD SHOULDER SEAM JOIN WITH TAPE](#)



Fully fashioned to the back shoulder seam:

- Visible full fashion marks X number of needles from seam as specified in the tech pack.
- See image: [FULLY FASHIONED TO THE BACK SHOULDER SEAM](#)



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

SHOULDER & ARMHOLE CONSTRUCTION CONT.

Knit to shape set-in armhole with sleeve:

- Saddle: Cast off straight for 1/2 - 3/4" at base of Armhole, or as specified.
- Sleeve cap: Cast off straight.
- See image: [KNIT TO SHAPE ARMHOLE W. SLEEVE](#)

[KNIT TO SHAPE ARMHOLE W. SLEEVE.AI](#)



Knit to shape sleeveless armhole:

- Saddle: Cast off straight for 1/2 - 3/4" at base of Armhole, or as specified.
- See image: [KNIT TO SHAPE SLEEVELESS ARMHOLE](#)

[KNIT TO SHAPE SLEEVELESS ARMHOLE.AI](#)



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

STYLING FEATURES

Patch pocket:

- Clean join to body using self-yarn, unless otherwise specified.
- See image: [PATCH POCKET ATTACHMENT](#)

[PATCH POCKET ATTACHMENT.AI](#)

Exterior



Interior



Pocket bags:

- **Attachment:** Secure to body with chain link swing tack.
- Pocket floating tack must be maximum of 1/2" in length.
See image: [POCKET BAG ATTACHMENT](#)
- **Stitch:** Jersey stitch pocket bags, 12gg, unless otherwise specified.

[POCKET BAG ATTACHMENT.AI](#)

Interior



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

STYLING FEATURES CONTINUED

Drawcords:

- Self knit, clean finished ends; no raw edges.
- See image: [DRAWCORDS](#).

[DRAWCORDS.AI](#)

Exterior / Interior



Sleeve tabs:

- **Attachment:** Clean join to body using self-yarn, unless otherwise specified.
- Self knit, clean finished ends; no raw edges.
- See image: [SLEEVE TABS](#).

[SLEEVE TABS.AI](#)

Exterior

Interior



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

STYLING FEATURES CONTINUED

Belts:

- Self knit, clean finished ends; no raw edges.
- See image: [BELTS](#)

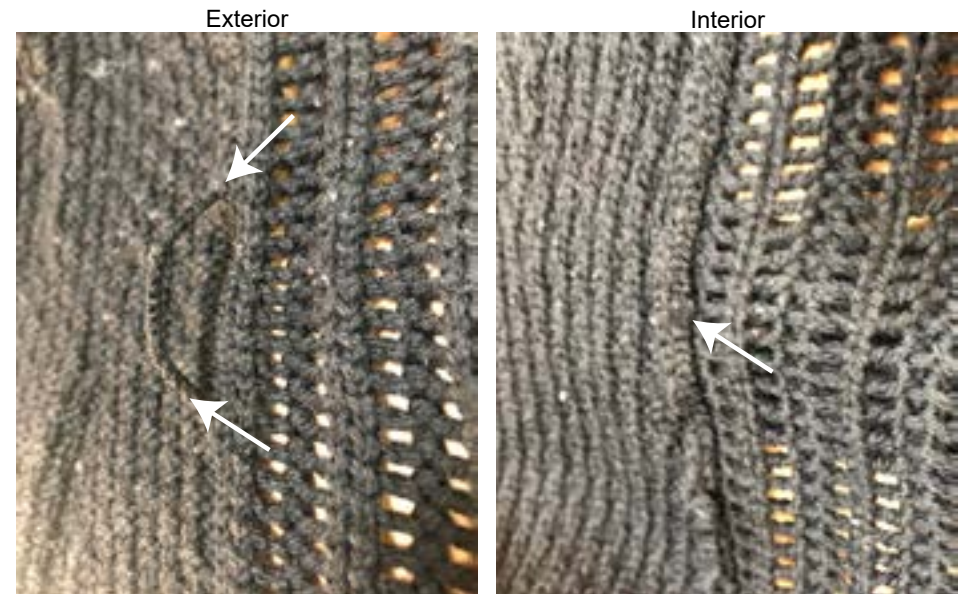
[BELTS.AI](#)
Exterior / Interior



Belt loops:

- **Attachment:** Securely clean join to body using self-yarn, unless otherwise specified.
- See image: [BELT LOOPS](#)

[BELT LOOPS.AI](#)



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

PATTERN

Floats:

- 1" maximum for adult apparel
- 1/2" maximum for children's apparel
- To achieve maximum float lengths listed above, use tuck stitch or knit with ladder back.
- See image: [LADDER BACK FLOATS](#)
- See image: [FLOAT BACK FLOATS](#)

[LADDER BACK FLOATS.AI](#)

Exterior



Interior



[FLOAT BACK FLOATS.AI](#)

Exterior



Interior



KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

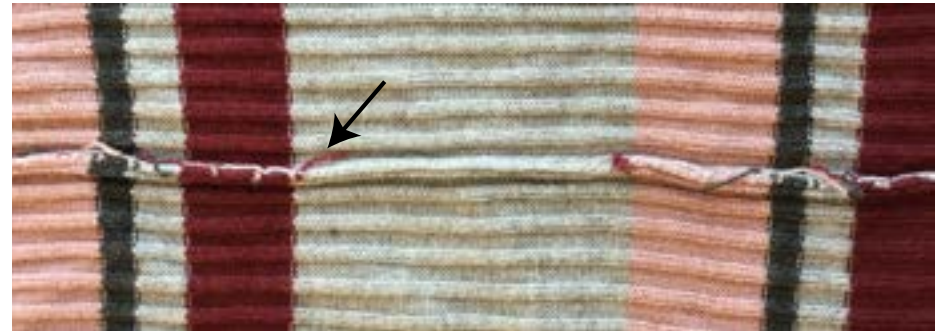
PATTERN CONTINUED

Tails:

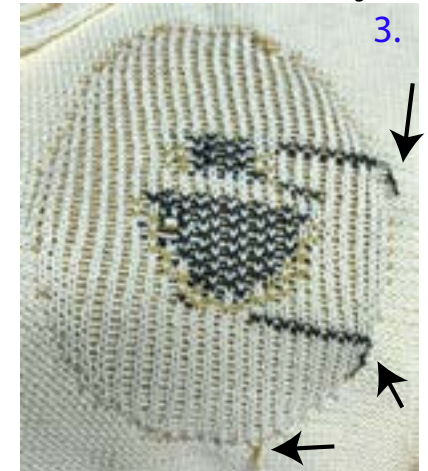
- ALL Yarn tails must be first tied securely in a knot, then woven back at interior, and finally trimmed to a maximum length of 1/2".
- No knots or yarn tails should be visible on exterior.
- See image: [TAILS](#)

[TAILS.AI](#)

Interior View



*Tails should be knotted first, then woven back to secure, and trimmed to a maximum length of 1/2"

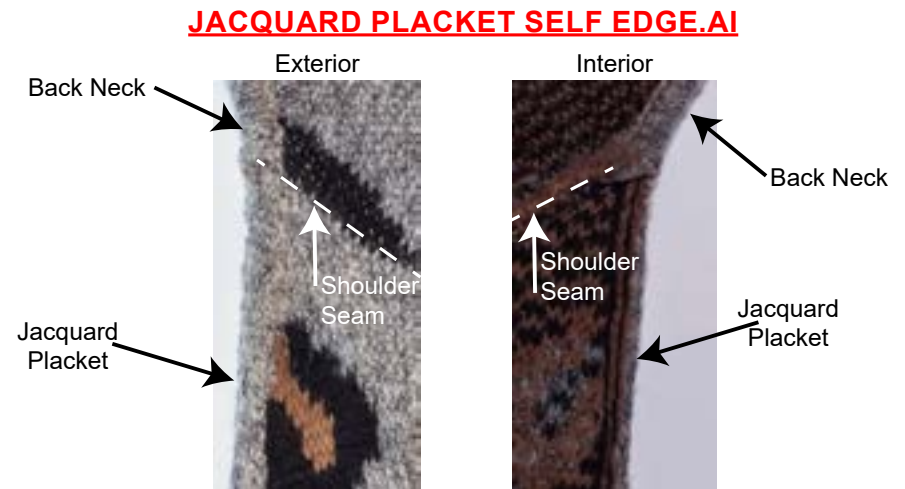


KOHL'S SWEATER CONSTRUCTION REQUIREMENTS

PATTERN CONTINUED

Jacquard CF placket, self edge:

- All yarn ends must be secured to inside, must not be visible to outside.
- Securely knot and clip tails to 1/2" maximum length, weave back to secure.
- See image: [JACQUARD PLACKET SELF EDGE](#)



Stitch pattern placement & matching:

Stripe matching: stripes must match at side seams and at armhole below across front/back point. See image: [STRIPE MATCHING](#)

Grading photos: vendor to submit front/back images of size run samples for stitch pattern/stripe grading approval.

