Private Brands
Tailored/Career Wear
Apparel Construction Requirements

Listed items are additional requirements to the Woven Minimum Construction Requirements for all private brands that have Tailored or Career wear styles. Standards are minimum unless otherwise specified in the specification construction details by TD.

How to use these Construction Standards:

-Tailored/Career Wear product category is identified by TD in Product Specification.
-**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 that are linen and/or loosely woven fabrications.

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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: follow chart listed in Woven's Minimum Construction Standards unless otherwise specified below or on spec.

Men's Dress Pants, Men's Dress Shirts: Needle/Bobbin=Poly-wrap/Poly-Core, Tex 24. Looper=Spun Polyester, Tex 18.

Blazers/Suit Coats/Sport Coats: Needle/Bobbin = poly-wrap/poly-core Tex 24, Looper = Spun Polyester, Tex 21

Shank Button sew thread quality:
- Poly wrap/Polycore, Tex 40
- Nylon Thread Tex30-45 may be required depending on button type/styling

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:

- **Blazers/Suit Coats/Sport Coats, Men's Dress Pants, Women's Dress Shirts** = 12-14 SPI
- **Men's Dress Shirts** = 14-16 SPI
- **Blind hems** = 4 – 4.5 SPI

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
- **Back Vents** basted closed for shipping.

Pockets:
- **Exterior Welt Pockets or other specified pockets:** Machine baste closed with 1" opening at each end.
- **Woven Shirt Pockets:** Inside upper corners must be turned down, caught under stitch or trimmed at a 45-degree angle.(D-7)

Pant Pocket Bags:
• **Men's** Must be french seamed unless otherwise specified.
• **Women's** French seamed when appropriate for fabrication weight/pocket bag construction

Pleats:
• Must be basted and pressed on grain/plaid.

Fly:
• **Women's Tailored/Dress Closure:** Overlap wearer's right over left.

Belt Loops:
• **Insert Ends:** Insert bottom end into waistband seam when possible

Waistband:
• **Men's Tailored/Dress Pants:** Split (adjustable) center back rise/waistband construction with a busted seam allowance pressed open & interior waistband curtain. Back Rise seam allowances at top edge of waist=1 1/2", tapers to 1⁄2" at crotch point. No top stitch on back rise. (D-14)
• **Women's Tailored Dress Pants:** Split Waistband will be specified by TD when it is required.

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Seams:

- **Unlined garments other than pants:** seams must be felled, SN chainstitch (ISO 401) w/ bound edges and pressed open, or french seamed
- **Sheer fabrications:** french seamed.
- **Side Seams/CB Seams lined garments:** Lockstitch ISO 301 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).

Pants:

• **Busted Seams:** As specified – use 2 separate chainstitch 1/64th apart tandem seamer or SN chainstitch (ISO 401). Pressed open. Overlock (ISO 503/504 seam allowances

Linings: secure lining into bottom hem/slv hem with 1⁄2" ease. (D-16)

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

Lapel:

• Lapel break after pressing to be no more than 1" above center of top button.
Bridle taping along seam.

SECTION E-Trims/Findings:

Tailored Blazers, Suit Coats, & Sport Coat Buttons/Buttonholes:

• **Buttons:** Only 1 stitch of button attachment should penetrate through underside of facing. (E-8)
  • **Keyhole buttonhole** with gimp cord - cut buttonhole 1st, then sew buttonhole.

CF Waistband Shankless Buttons must have thread wrapped shank. Shank height should be suitable for fabric thickness.

Interlining:

• Required on lapel, top collar, pocket flaps/welts, vent openings, front panel, upper back panel, chest piece, shoulder seam.
• **Woven Fusible Tape** required on lapel roll/crease line and armhole seam.
  • **Felt** (Men's only) 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.

SECTION F-Cutting:

Cutting Direction:

- **Napped fabrics:** 1-way cut, all garments in same direction
- ***Uneven plaids/stripes:***
  • Dress Shirtings: 1-way cut, all garments cut in same direction.
  • Men's Dress Pants/Tailored Blazers, Suit Coats & Sport coats: 1-way cut, all garments in same direction.

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Construction Standards

Appendix

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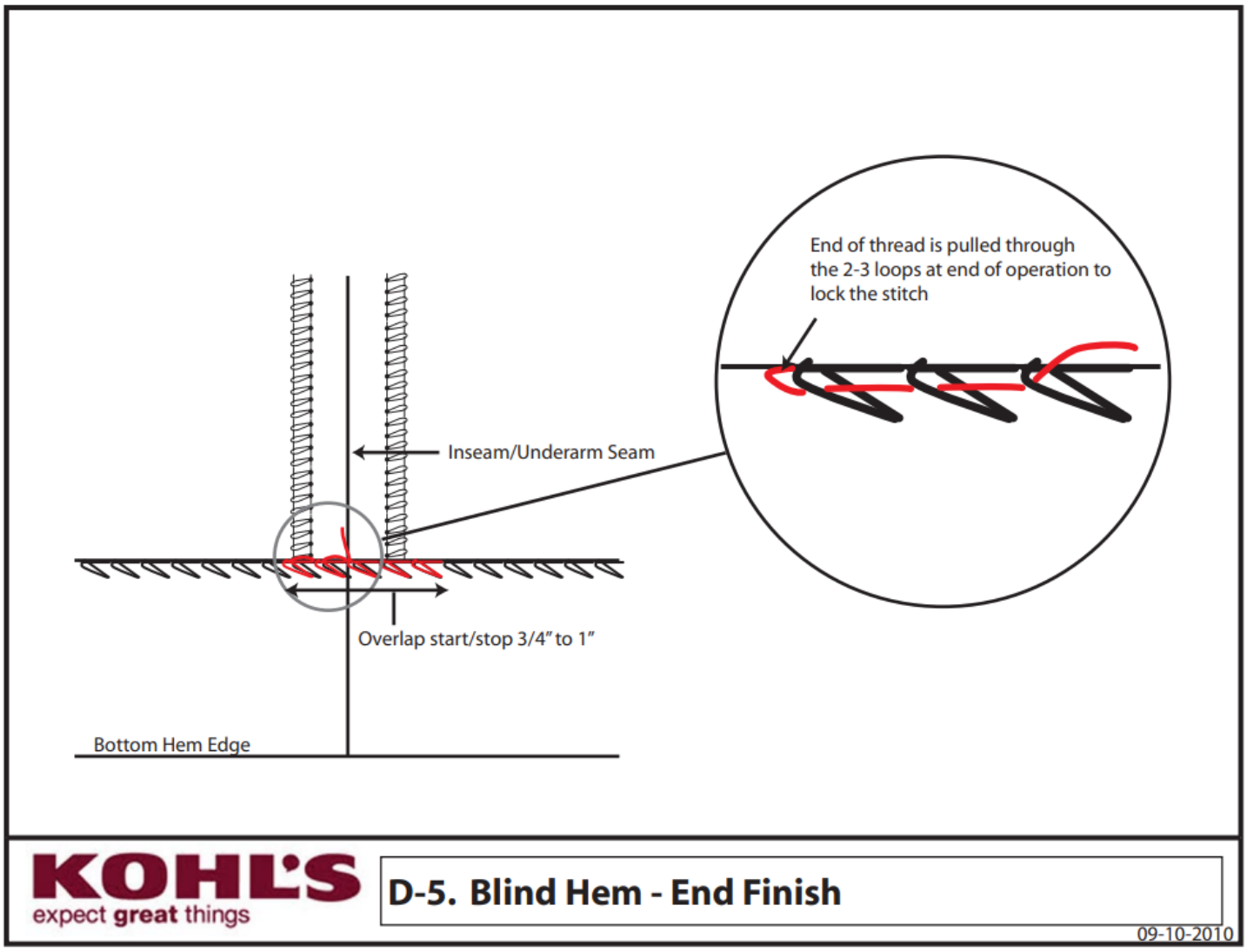
09-10-2010

Listed items are additional requirements to the Woven Minimum Construction Requirements for all private brands that have Tailored or Career wear styles. Standards are minimum unless otherwise specified in the specification construction details by TD.



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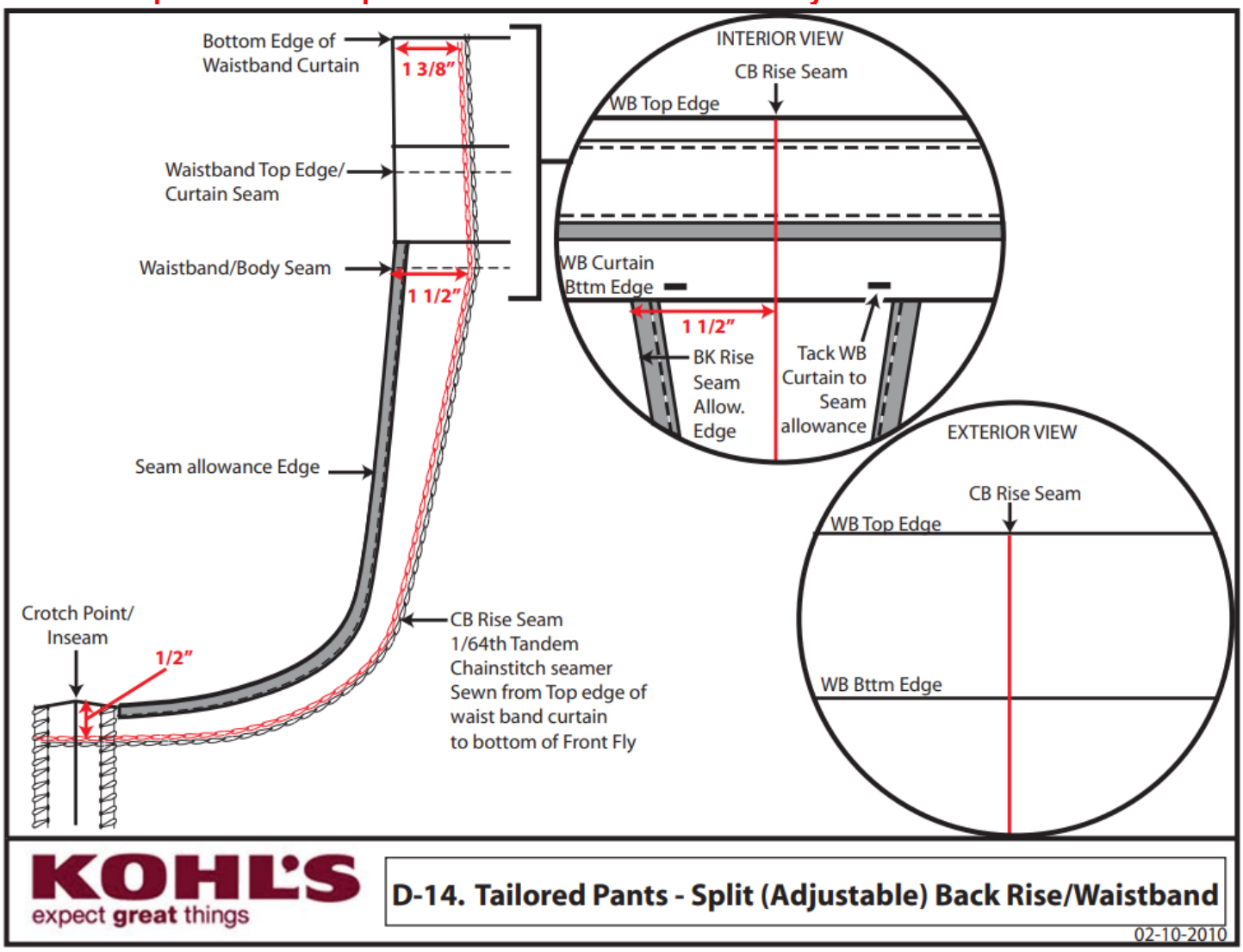

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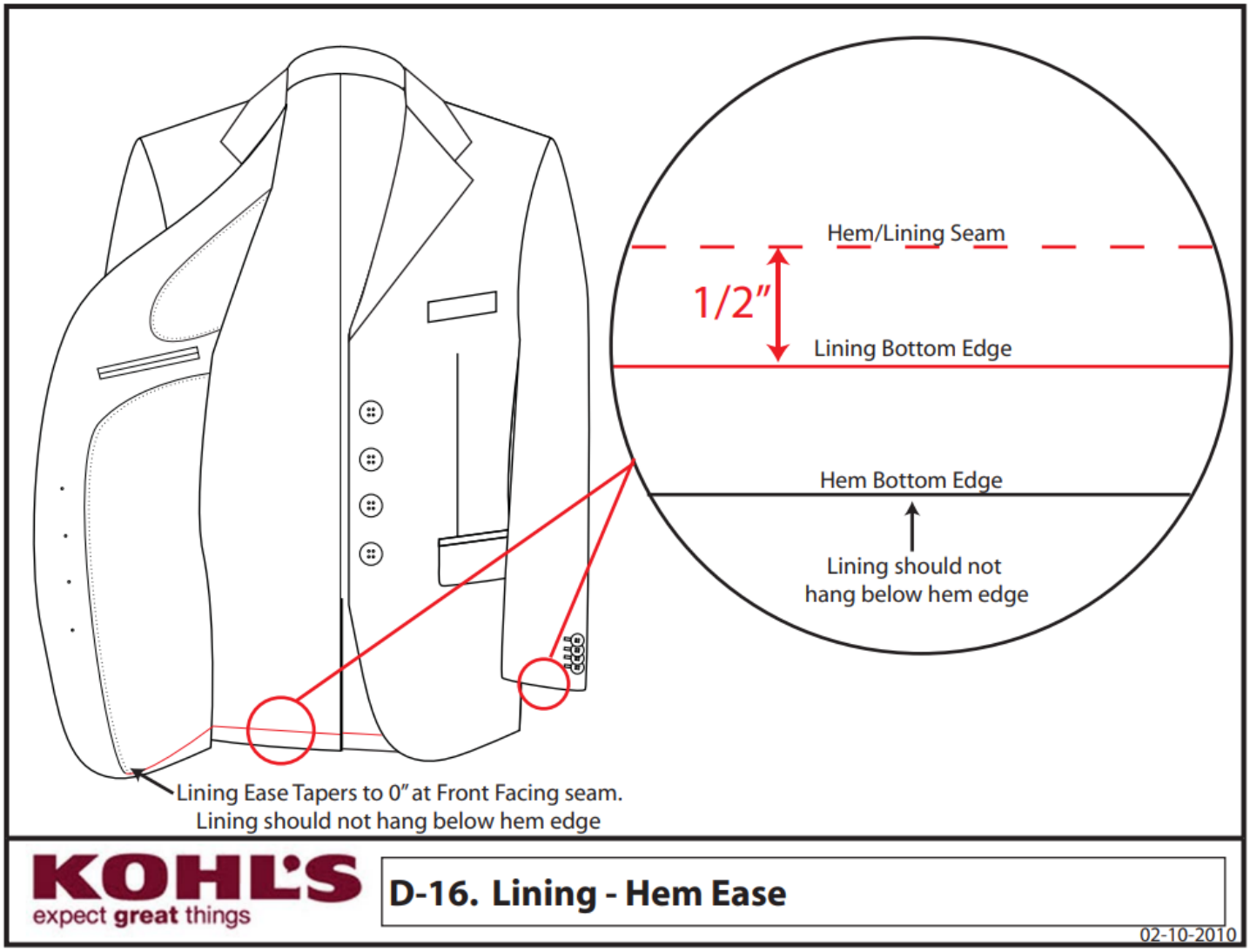

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D-16. Lining - Hem Ease

02-10-2010

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