



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS APPAREL

ADAPTIVE

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

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MINIMUM CONSTRUCTION STANDARDS

• ADAPTIVE

SECTION 1: TYPES OF ADAPTIVE

- **Sensory and Physical** adaptive product have different Minimum Construction Standard requirements.
- Some styles may have both Sensory & Physical attributes, and both Minimum Construction Standards must be met.
- Follow techpack.

SENSORY ADAPTIVE ATTRIBUTES:

- Garment is made for comfort of wearer, with focus on inside of garment being soft and smooth without seam allowance or excess threads. Garment is engineered for clean finished interior, with seam allowance and coverstitch to the exterior of the garment.

PHYSICAL ADAPTIVE:

- Garment is made for ease of dressing and functionality.

SECTION 2: REQUIRED FOR BOTH SENSORY & PHYSICAL

TAG FREE:

- All adaptive garments Sensory and/or Physical are required to be Tag-Free to avoid tags touching the skin.

Tag Requirements: All label information must be placed on Heat Seal Label including any tracking information.

- Heat Seal Label can be heat sealed directly to garment **(IMAGE V-10)**
- Heat Seal Label can be placed on self fabric patch to attach to garment. Patch must be clean finished to avoid scratching the skin.
- No labels should be visible on outside of garment.

GLOBAL PRODUCT SERVICES/APPAREL TECHNICAL DESIGN
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IMAGE V-10: TAG FREE



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SECTION 3: SENSORY REQUIREMENTS

SENSORY SEAMS:

- No exposed seam allowance on inside of garment.
- Coverstitch loops to outside of garment.
- Looper Thread Quality: Texturized Nylon or Texturized Polyester

KNIT SEAM/STITCH OPTIONS:

- **Reverse Coverstitch** for less thread on interior. Back side of the stitch/loops to the outside of garment. Face side of the stitch is on the inside of the garment. Must have a clean overlap at start/stop due to higher visibility on outside of garment. Suggest ISO 406 2NBC. **(IMAGE V-20)**
- **Reverse Hems** are folded towards the outside of the garment. Back side of fabric is visible at external hem, with coverstitch/overedge loops to outside. **(IMAGE V-30)**

IMAGE V-20: REVERSE COVERSTITCH

External View: Loops to outside



Internal View: 2N to inside, no loops



IMAGE V-30: REVERSE HEM

External View:



Internal View:



SECTION 3: SENSORY REQUIREMENTS

KNIT SEAM/STITCH OPTIONS CONT:

- Double Turnback Hem with reverse coverstitch (IMAGE V-35)
- External Overedge Stitch w/ Reverse Coverstitch (IMAGE V-40)
- Lapped Seam w/ reverse coverstitch. Suggest ISO 605 3N5Th
- Flatlock

WOVEN OPTIONS:

- French Seam (IMAGE V-50)
- Pinched Seam

IMAGE V-35: DOUBLE TURNBACK HEM W/ REVERSE COVERSTITCH



External View:
Hem turned back twice towards interior,
Loops to outside

Internal View:
Clean finished with 2N to inside, no loops

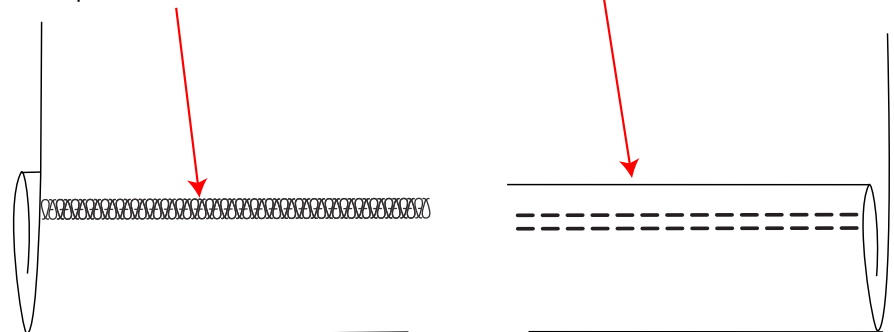


IMAGE V-40: EXTERNAL OVEREDGE SEAM

1. Join panels with right sides outward/wrong sides together. Seam allowance will be to the outside. Join with overedge stitch.

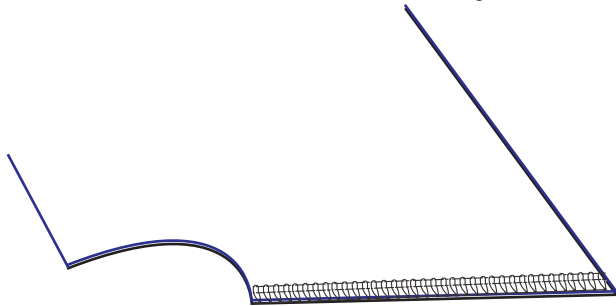


IMAGE V-40: EXTERNAL OVEREDGE SEAM CONT.

External View:
Seam allowance & loops to the outside

Internal View:
Clean finished, 2N to inside



IMAGE V-40: EXTERNAL OVEREDGE SEAM CONT.

2. Open garment and fold seam allowance towards back. Stitch down the seam allowance towards back panel using Single Needle or Reverse Coverstitch.

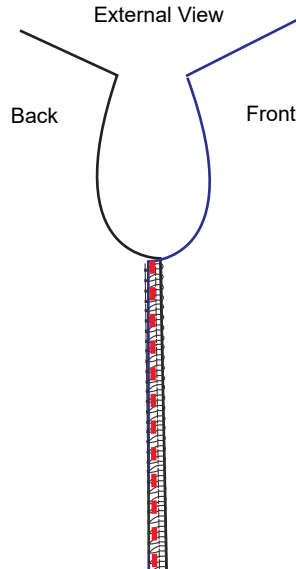
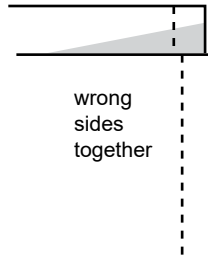


IMAGE V-50: FRENCH SEAMS

Step 1: Place wrong sides together.



Step 2: Stitch down and fold in opposite direction.

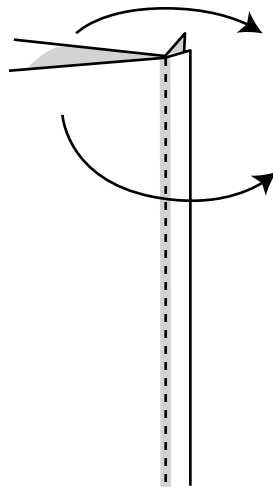
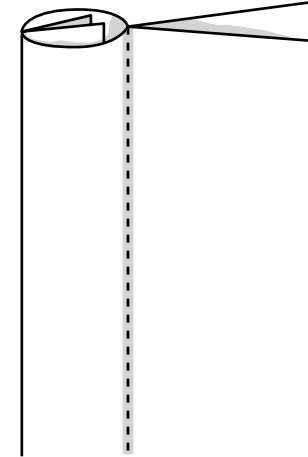
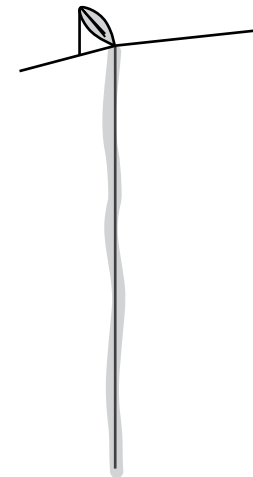


IMAGE V-50: FRENCH SEAMS CONT.

Step 3: Stitch down, hiding seam allowance.



Finished



SECTION 3: SENSORY REQUIREMENTS CONTINUED

CONSTRUCTION:

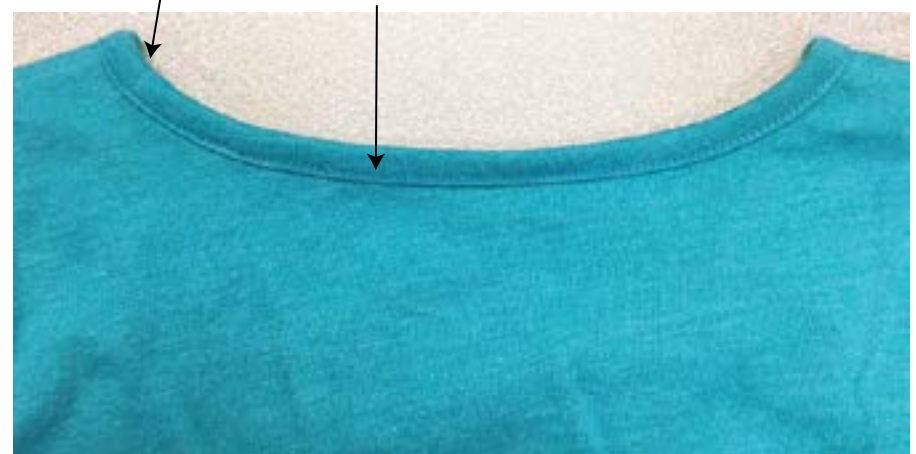
- **Neck Binding** clean finished on interior and exterior (**IMAGE V-70**)
- **Hood** attached to neckline with typical seaming. Interior back neck tape required to cover seam allowance and must extend to CF neck. (**IMAGE V-80**)
- **Waistband** seam allowance set to outside of garment, or full enclosed inside waistband for clean finish. (**IMAGE V-90**)
- **Rib Trim** at sleeve/bottom hem attached with External Overedge Seam & Reverse Coverstitch, or seam allowance fully enclosed for clean finish (**IMAGE V-100**)

IMAGE V-70: CLEAN FINISHED NECK BINDING

External View:

Neck binding is clean finished with edge turned under. Chain/loop side of stitch to the exterior.

Neck trim seam is clean finished with seam allowance enclosed inside binding



Internal View:

Neck binding edge is turned under. Single needle side of stitch towards interior.



IMAGE V-80: HOOD INTERIOR NECK TAPE

External View:
Typical seam construction used.
Outside is clean finished



Internal View:
Seam clean finished with interior neck tape
extending to CF

IMAGE V-90: DOUBLE TURNBACK WAISTBAND

External View:
Self waistband turned
back twice.



Internal View:
Waistband seam
allowance fully enclosed.



IMAGE V-100: SINGLE TURNBACK WAISTBAND

External View: →
Self waistband turned to the outside. Seam loops on the outside.



Internal View: →
Waistband clean finished with 2N on inside.



IMAGE V-105: CUFF/BOTTOM RIB TRIM

Cuff/Bottom rib trim applied with External Overedge Seam & Reverse Coverstitch



SECTION 3: PHYSICAL REQUIREMENTS

PHYSICAL ADAPTIVE:

- Garment is made for ease of dressing and functionality.
- Follow Techpack for construction.

PHYSICAL SEAMS

- Does not require sensory seaming. Follow typical seaming unless indicated in techpack.
- Looper Thread Quality: Texturized Nylon or Texturized Polyester

PHYSICAL CONSTRUCTIONS MAY INCLUDE, BUT IS NOT LIMITED TO THE BELOW OPTIONS:

- **Leg Openings:** Plackets with closure at leg openings for ease of dressing. **(IMAGE V-110)**
- **Abdominal Access Openings:** Welt or bound slit openings. Single layer garments should have face side to interior. Double layer garments should have face side to exterior as it will be hidden under top layer. **(IMAGE V-120)**
- **Abdominal Access Panel** attached with snaps/snap tape. **(IMAGE V-130)**
- **Reinforced Beltloops-** Top and bottom secured with bartacks or line tacks.

TRIM REQUIREMENTS:

- **Hook & Loop** tape/pieces should be soft and should not have sharp corners/edges.
- **Snap Tape** should be soft/flexible.
- **Zipper Pulls** should not be too small and should be easy for wearer to pull.

IMAGE V-110: LEG OPENING

External View:
Placket at leg openings



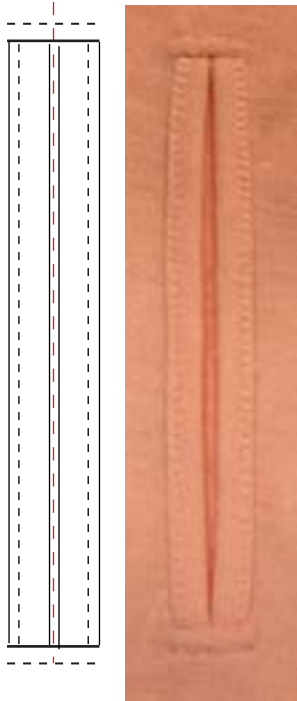
Internal View:
Hook & Loop closure piece edges must be soft and must not be sharp



IMAGE V-120: ABDOMINAL ACCESS BOUND OPENING

Binding set to each side of opening
Overedge top and bottom. SN stitch across binding.

External View:



Internal View:

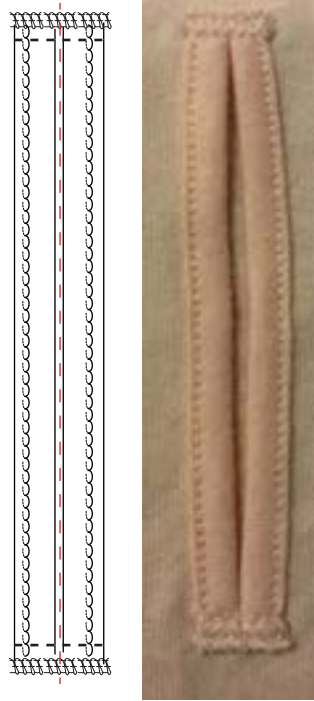
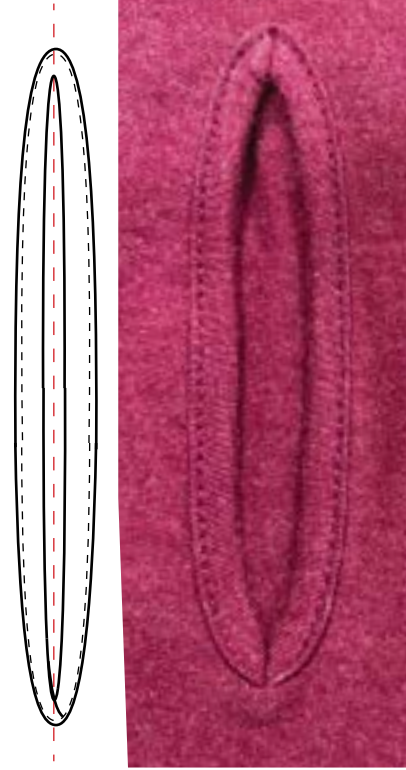
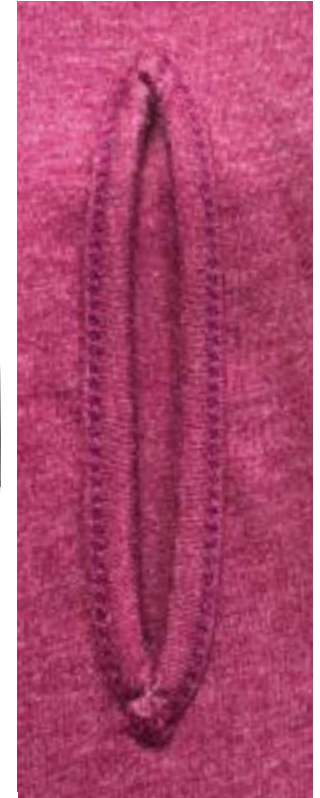


IMAGE V-120: ABDOMINAL ACCESS MITERED BINDING

External View:



Internal View:



Overlap binding at top & bottom
to miter and tack w/ SNLS

IMAGE V-120: ABDOMINAL ACCESS WELT OPENING

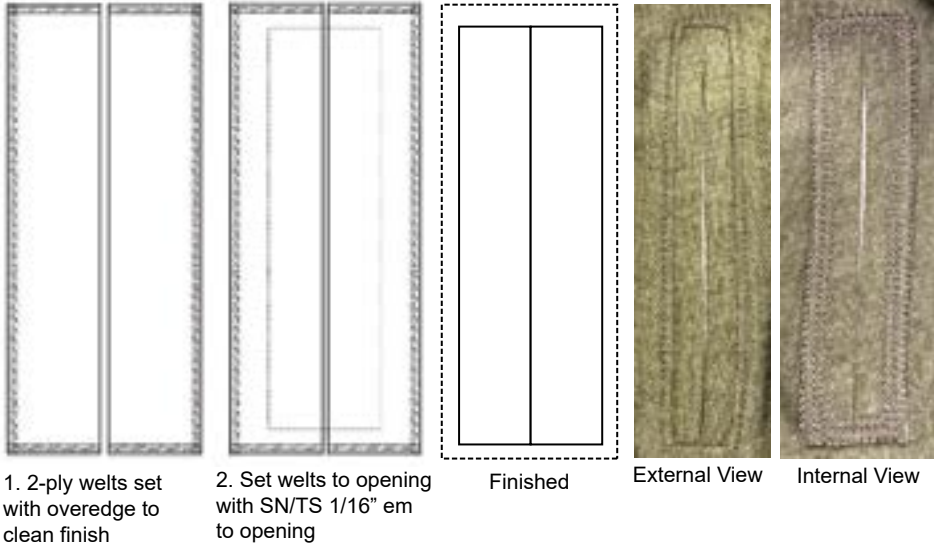


IMAGE V-120: ON-SEAM OPENING



IMAGE V-130: ABDOMINAL ACCESS PANEL

Panel with Snap Tape
Tape quality must be soft and flexible

External View- Snapped:



External View- Unsnapped:

