

KNITS & WOVENS VENDOR SUPPORT TRAINING

KOHL'S

Part 2: Garment Fit

3:45 PM

Garment Fit - Tops

TECHNICAL DESIGN

KOHL'S

Garment Fit - Tops

Fit Best Practices:

- Review previous fit comments and photos. Were fit corrections made?
- Are critical POMs within tolerance?
- Fit in a methodical way such as fitting from top to bottom, front to back.
- Evaluate appearance as a whole - close up and from a distance.
- Does the neckline lay nicely on the body without pulling or gapping?
- Check for drag lines or areas with excess fabric.
- Does sample have same amount of ease through the body and sleeve?
- Does armhole hit at the correct place on the form? Do not rely on spec alone.
- Does sleeve cap have drag lines or excess fullness?
- Check exterior and interior construction. Does it match the detail page? Is any construction affecting the fit?

Garment Fit - Tops

Not Acceptable:

Excess fullness at neckline.

Possible Corrections:

- Reduce shoulder slope



Garment Fit - Tops

Not Acceptable:

Excess fullness at shoulder seam. Garment does not lay flat against the body.

Possible Corrections:

- Increase shoulder slope
- Reduce AH circumference



Garment Fit - Tops

Not Acceptable:

Neckline does not lay flat. Creating excess fullness at collar or sides of collar.



Possible Corrections:

- Increase neck width
- Scoop out neckline. Maintain neck width and front neck drop
- Check neckline is curved at HPS
- Caution setting collar
- Interfacing is too stiff (knits)
- Reduce shoulder slope
- Check if front neck drop is too deep and stand is pulling is up.
- Check the width & depth of the neck & stand do not align
- *Cut collar vertically at HPS to see where garment naturally falls. Correct accordingly.

Garment Fit - Tops

Not Acceptable:

Neckline stands away from body.



Possible Corrections:

- Reduce neck width
- Reduce binding/trim length
- Check neckline is not stretched when sewn
- Front & back neckline panels are not the same width. True pattern at HPS.

Garment Fit - Tops

Not Acceptable:

Elastic neckline stands away from body.



Possible Corrections:

- Check pattern piece is stretch when sewing encased elastic top stitch
- Check if elastic length needs to be reduced
- Maintain neckline length so elastic pulls neckline edge toward body
- Check elastic is the correct height for neckline seam
- Ruffle: check ruffle pattern is cut circular
- Tank: angle straps when setting into neckline
- Tank: serge and set elastic to neckline, fold over, and SN/TS

Garment Fit - Tops

Not Acceptable:

Neck trim is standing away from body.



Possible Corrections:

- Reduce shoulder slope
- Reduce neck trim length
- Undercut neck trim
- Check neck trim and neck line are properly notched on pattern

Garment Fit - Tops

Not Acceptable:

Collar does not cover neck seam



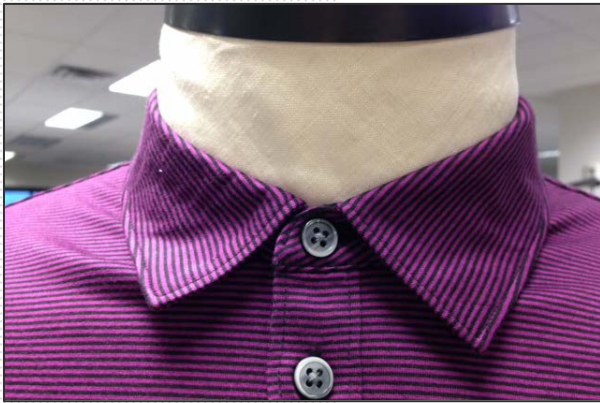
Possible Corrections:

- Increase collar height
- Increase collar stand height (Caution collar is taller than stand)
- Check collar edge isn't too short & pattern needs to be altered
- Reshape collar so pattern curves upward at CB on the flat
- Reduce back neck drop
- Caution collar outer edge stitching is not too tight. Cut and release to check
- Check neck opening is not larger than collar stand length *Don't use top end of tolerance on neck opening, and bottom tolerance on collar. Will cause to roll up

Garment Fit - Tops

Not Acceptable:

Collar and collar points are not laying flat



Possible Corrections:

- Reduce collar height
- Increase collar stand height
- Add curve inward along collar edge where collar meets HPS.
- Undercut underside of collar

Garment Fit - Tops

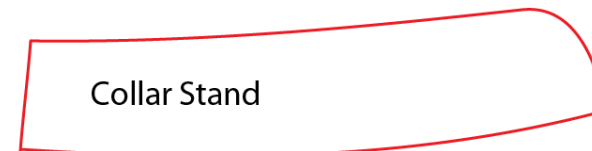
Not Acceptable:

Collar stand shape is too straight, not curved properly. Front edge pushes down.



Possible Corrections:

- Shape collar stand so it curves upward where sewn to placket
- Caution collar stand curves mirror each other at CF
- Caution placket is trued to collar stand shape at CF
- Common Collar Stand Shape:



Garment Fit - Tops

Not Acceptable:

Shoulder seam / sleeve cap is peaking.



Possible Corrections:

- Check that shoulder seams align
- Check shoulder seam stitching is not too tight
- Check shoulder tape not too short
- Sweater: Check that linking of a sweater is not too tight at the shoulder seam
- Sweater: Check sleeve does not have a sleeve cap

Garment Fit - Tops

Not Acceptable:

Drag lines up from armhole.



Possible Corrections:

- Increase armhole drop. Update sleeve accordingly
- Check AH width is not too narrow
- Check Across Front and Across back specs are allowing enough room for armhole
- Check armhole and sleeve saddle shape align

Garment Fit - Tops

Not Acceptable:

Sleeve is winging out and not hanging straight.



Possible Corrections:

- Sleeve cap may be too short. Increase sleeve cap height. Adjust cap shape and AH as needed to walk together
- Check armhole shape and sleeve cap saddle shape align

Garment Fit - Tops

Not Acceptable:

Excess fullness eased into seam.



Possible Corrections:

- Reduce sleeve cap width, update armhole accordingly
- Check across back is not too narrow
- Check if sleeve cap needs to be reduced
- Be sure to place sleeve ease between notches

Garment Fit - Tops

Not Acceptable:

- Pull lines are visible when model lifts their arm. “Lift” is restricted.



Possible Corrections:

- Check if sleeve cap height needs to be reduced.
Update armhole accordingly
- Check if sleeve cap width needs to be increased.
Update armhole accordingly
- Raise armhole drop, update sleeve cap accordingly
- Check pattern armhole and sleeve cap shapes walk together
- Caution armhole, sleeve cap, and sleeve notches align when walking pattern.
- Caution fabric is cut following pattern grainline.
- Caution grainline is at center of sleeve pattern

Garment Fit - Tops

Not Acceptable:
“Lift” is restricted.



Possible Corrections:

- Reduce shoulder slope
- Reshape shoulder slope / sleeve cap

Garment Fit - Tops

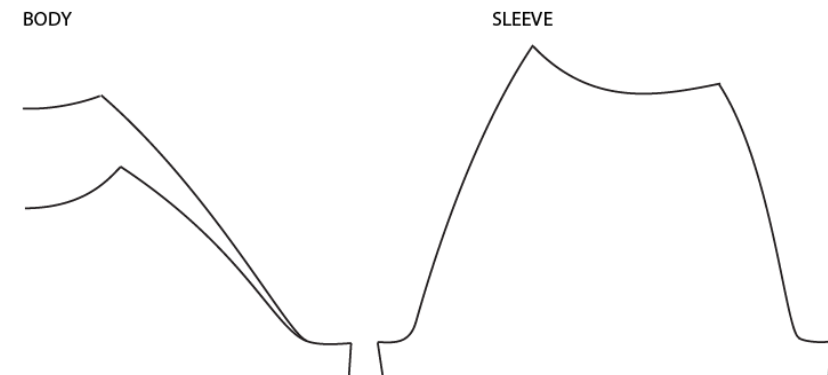
Not Acceptable:

Raglan sleeve is tight on shoulder. Raglan shape is not symmetrical.



Possible Corrections:

- Increase sleeve cap width.
- Reduce sleeve cap height.
- Raglan body is too narrow. Increase across front and back.
- Reduce shoulder slope
- Improve raglan shape. See image:



Garment Fit - Tops

Not Acceptable:

Drag lines at side seam and yoke. Sweep is standing away from body at side seam.



Possible Corrections:

- Reduce waist shaping
- Distributed waist shaping in darts and on side seam
- Drop down waist placement spec

Garment Fit - Tops

Not Acceptable:

Garment is hiking at side seam.



Possible Corrections:

- Caution fabric is not stretched when sewing side seam, or hem
- Check waist shaping and waist placement
- Caution sweep fullness is created using slash/spread technique

Garment Fit - Tops

Not Acceptable:

Fullness is falling only at side seams.



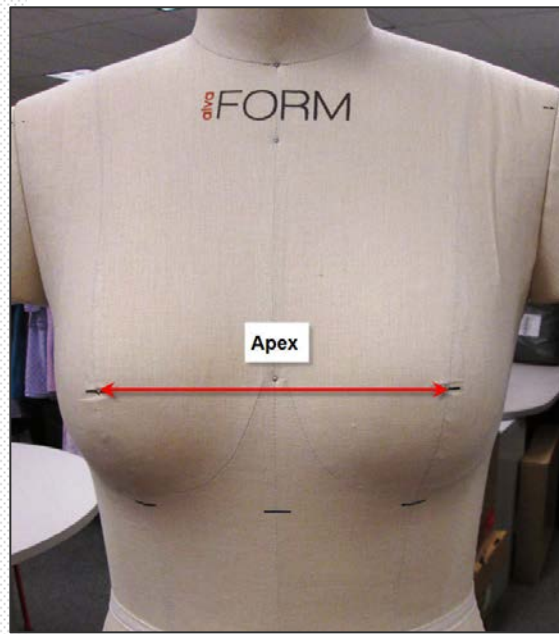
Possible Corrections:

- Caution sweep fullness is created using slash/spread technique.
- When adding slash/spread for fullness, on pattern, do not over correct the pattern distortion created to achieve the fullness distribution.

Garment Fit - Tops

Women's Blouses & Shirts Button Placement:

- ❑ Position 2 buttons: 1st button & apex button.
- ❑ Position button @ apex level for women's blouses and shirts
- ❑ Remaining buttons to space evenly above & below apex excluding 1st button as placed
- ❑ Top Button can be greater or less spacing between top button and collar stand button).



Garment Fit - Jackets

TECHNICAL DESIGN

KOHL'S

Garment Fit - Jackets

Fit Best Practices:

- Review previous fit comments and photos. Were fit corrections made?
- Are critical POMs within tolerance?
- Fit in a methodical way such as fitting from top to bottom, front to back.
- Evaluate appearance as a whole - close up and from a distance.
- Does the neckline lay nicely on the body without pulling or gapping?
- Check for drag lines or areas with excess fabric.
- Does sample have same amount of ease through the body and sleeve?
- Does armhole hit at the correct place on the form? Do not rely on spec alone.
- Does sleeve cap have drag lines or excess fullness?
- Check exterior and interior construction. Does it match the detail page? Is any construction affecting the fit?

Garment Fit - Jackets

Not Acceptable:

Front collar is not aligned at CF. Front edge pushes down



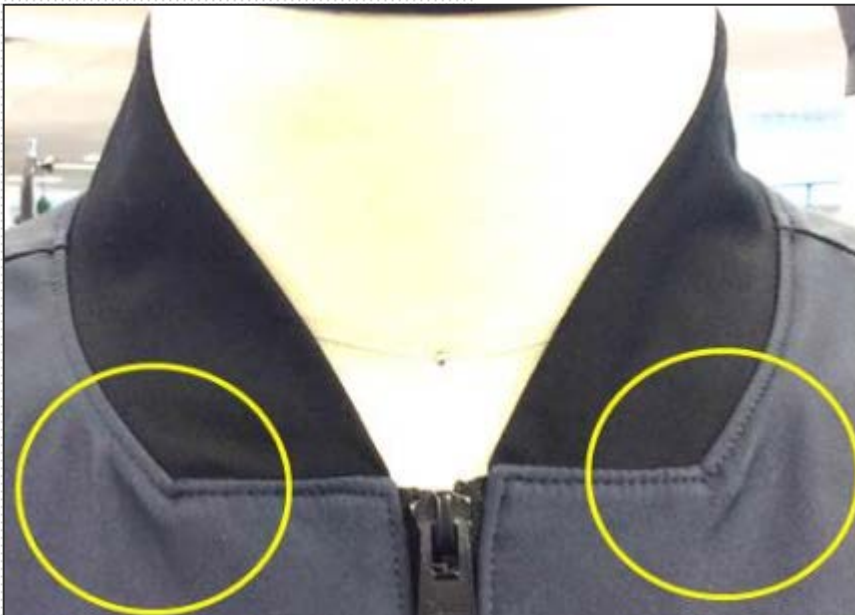
Possible Corrections:

- Reduce collar length
- Check shape of collar stand aligns with neckline
- Shape collar so it curves upward where sewn to placket
- Caution collar curves mirror each other at CF
- Caution placket is trued to collar stand shape at CF
- Check front neck drop spec meets desired placement

Garment Fit - Jackets

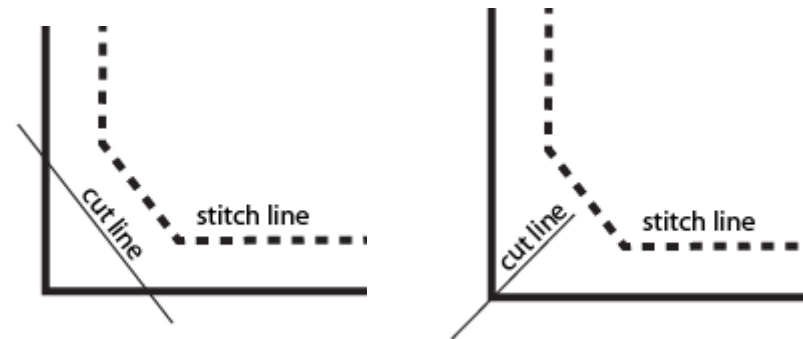
Not Acceptable:

Front neckline has drag lines.



Possible Corrections:

- Reduce collar length
- Caution collar shape mirrors neckline shape
- Check front neck drop spec meets desired placement
- Check neckline is not stretched when sewn
- Check sewing of corner. See image below:



Garment Fit - Jackets

Not Acceptable:

Front neckline stands away from body.



Possible Corrections:

- Reduce neck width
- Reduce collar length
- Check shoulder alignment
- Check shape of collar stand aligns with neckline
- Reduce pattern width at CF on either side of zipper above chest.
- Front & back neckline panels are not the same width. True pattern at HPS.
- *Cut collar vertically at CB to see where garment naturally falls. Update pattern accordingly.

Garment Fit - Jackets

Not Acceptable:

Pull lines are visible when model lifts their arm. "Lift" is restricted



Possible Corrections:

- Check if sleeve cap height needs to be reduced.
Update armhole accordingly
- Check if sleeve cap width needs to be increased.
Update armhole accordingly
- Raise armhole drop, update sleeve cap accordingly
- Check pattern armhole and sleeve cap shapes walk together
- Caution armhole, sleeve cap, and sleeve notches align when walking pattern.
- Check shoulder slope
- Caution fabric is cut following pattern grainline.
- Caution grainline is at center of sleeve pattern

Garment Fit - Jackets

Not Acceptable:

Draglines at front of sleeve. Forward movement is restricted.



Possible Corrections:

- Caution fabric is cut following pattern grainline
- Caution grainline is at center of sleeve pattern
- Check across back is not too narrow
- Caution armhole, sleeve cap, and sleeve notches align when walking pattern.
- Check if sleeve cap height/width needs to be reduced/increased. Update armhole accordingly
- Check fabric is not stretched to meet specs

Garment Fit - Jackets

Not Acceptable:

Arm movement is restricted below bicep.



Possible Corrections:

- Check if sleeve width needs to be increased.
- Check if dart can be added at elbow
- Check that lining is not restricted when jacket is turned inside out:



Garment Fit - Jackets

Not Acceptable:

Excess fullness eased into seam



Possible Corrections:

- Reduce sleeve cap width, update armhole accordingly.
- Check across back is not too narrow
- Check if sleeve cap needs to be reduced
- Caution armhole, sleeve cap, and sleeve notches align when walking pattern.
- Be sure to place sleeve ease between notches.

Garment Fit - Jackets

Not Acceptable:

Tight across lower body. Drag lines at waist



Possible Corrections:

- Increase hip spec
- Increase waist spec
- Check shirring at waist is right for fit intent

Garment Fit - Jackets

Not Acceptable:

Lapel edge is not rolling under. Lapel breaks at top button



Possible Corrections:

- Increase lapel facing and ease onto body. This will cause facing to roll toward body. Caution to follow lapel notches.
- Caution button is placed in correct position for lapel shaping.



Garment Fit - Dress

TECHNICAL DESIGN

KOHL'S

Garment Fit - Dress

Fit Best Practices:

- Review previous fit comments and photos. Were fit corrections made?
- Are critical POMs within tolerance?
- Fit in a methodical way such as fitting from top to bottom, front to back.
- Evaluate appearance as a whole - close up and from a distance.
- Does the neckline lay nicely on the body without pulling or gapping?
- Check for drag lines or areas with excess fabric.
- Does sample have same amount of ease through the body and sleeve?
- Does armhole hit at the correct place on the form? Do not rely on spec alone.
- Does sleeve cap have drag lines or excess fullness?
- Check exterior and interior construction. Does it match the detail page? Is any construction affecting the fit?
- Are the waist seam and sweep level to the ground? (Not a design detail)

Garment Fit - Dress

Not Acceptable:

Side seams are swinging forward only at waist.



Possible Corrections:

- Check if front bodice needs to be increase, and back bodice reduced at waist seam
- Check front & back bodice & skirt pattern are balanced
- Check skirt shirring is being evenly distributed
- Check workmanship when sewing

Garment Fit - Dress

Not Acceptable:

Waist seam comes to a point at side seam



Possible Corrections:

- Check pattern is balanced
- Check pattern is trued at side seam
- Check side seams walk together
- Improve joining intersection of seams

Garment Fit - Dress

Not Acceptable:

Skirt side seams are dipping or peaking.



Possible Corrections:

- Check pattern is trued at side seam
- Check side seams are not stretched when sewn

Garment Fit - Dress

Not Acceptable:

Fullness is falling only at side seams.



Possible Corrections:

- Caution sweep fullness is created using slash/spread technique.
- When trueing up pattern, caution to not counter act the new shaping created when slashing and spreading pattern
- Check armhole inner taping isn't too tight

Garment Fit - Dress

Not Acceptable:

Fullness is bowing at side seam.



Possible Corrections:

- Check side seam pattern shape
- Check workmanship when sewing side seam.
- Check skirt is not hard pressed
- Check side seam is not stretched when sewn
- Check side seam stitch tension

Garment Fit - Skirt

TECHNICAL DESIGN

KOHL'S

Garment Fit - Skirt

Fit Best Practices:

- Review previous fit comments and photos. Were fit corrections made?
- Are critical POM's within tolerance?
- Fit in a methodical way such as fitting from top to bottom, front to back.
- Evaluate appearance as a whole - close up and from a distance.
- Does the waist sit at the specified distance below waist tape nicely without hiking or excess fabric?
- Check for drag lines or areas with excess fullness.
- Does the sample have same amount of ease front and back?
- Is the sweep level to the ground? (Not a design detail)
- Check exterior and interior construction. Does it match the detail page? Is any construction affecting the fit?

Garment Fit - Skirt

Waist Placement on the Form:

Review sample where it naturally falls on form first. Adjust pattern accordingly. Once sample is balanced check placement on dress form, and adjust to hit given specs. Placement is given from the center of the waist tape.

POM # A003
WAIST POSITION ON FORM AT CENTER FRONT



This measurement is for fit reference on the dressform. Measure from center of waist tape on dressform to top edge of garment waist at Center Front

POM # A004
WAIST POSITION ON FORM AT CENTER BACK



This measurement is for fit reference on the dressform. Measure from center of waist tape on dressform to top edge of garment waist at Center Back

POM # A005
WAIST POSITION ON FORM AT SIDE SEAM



This measurement is for fit reference on the dressform. Measure from center of waist tape on dressform to top edge of garment waist at side seam

Garment Fit - Skirt

Not Acceptable:
Waist seam is wavy.



Possible Corrections:

- Reduce shirring ratio
- Add elastic tape into join seam
- Check seam is not stretched when sewn

Garment Fit - Skirt

Not Acceptable:

Skirt is not level to the ground.



Possible Corrections:

- Check if sample is balanced
- Check pitch is correct
- Increase back yoke height
- Increase back skirt/tier height

Garment Fit - Bottoms

TECHNICAL DESIGN

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Garment Fit - Bottoms

Fit Best Practices:

- Review previous fit comments and photos. Were fit corrections made?
- Are critical POM's within tolerance?
- Fit in a methodical way such as fitting from top to bottom, front to back.
- Evaluate appearance as a whole - close up and from a distance.
- Does the waist sit at the specified distance below waist tape nicely without hiking or excess fabric?
- Do the front and back rises on shorts/pants lay nicely on the body without hiking or excess fabric?
- Check for drag lines or areas with excess fullness.
- Does the sample have same amount of ease front and back?
- Do the inseam and out seam hang straight?
- Check exterior and interior construction. Does it match the detail page? Is any construction affecting the fit?

Garment Fit - Bottoms

Waist Placement on the Form:

Review sample where it naturally falls on form first. Adjust pattern accordingly. Once sample is balanced check placement on dress form, and adjust to hit given specs. Placement is given from the center of the waist tape.



This measurement is for fit reference on the dressform.
Measure from Center of waist tape on dressform to top edge of garment waist at Center Front.



This measurement is for fit reference on the dressform. Measure from Center of waist tape on dressform to top edge of garment waist at Center Back



This measurement is for fit reference on the dressform.
Measure from Center of waist tape on dressform to top edge of garment waist at side seam

Garment Fit - Bottoms

Waist Pitch:

'Pitch' is used to describe the angle of the waist band in relation to the waist tape of the form. Bottom of garment must be balanced when the garment is set at the correct waist "pitch" placement



Garment Fit - Bottoms

Not Acceptable:

CB waist is gapping, standing away from body.



Possible Corrections:

- Reduce waist spec
- Reduce waistband at CB. Blend to zero at hip
- Check grain of waistband
- Caution top edge of waistband is not stretched when sewn

Garment Fit - Bottoms

Not Acceptable:

Rise shape not similar to body shape. Excess fullness at bottom of fly



Possible Corrections:

- Reduce front rise hook length
- Reduce front rise angle
- Scoop out front rise at saddle
- Reduce fly length
- Check crotch points align. Back rise should be $\frac{1}{4}$ " lower than front, unless specified differently.

Garment Fit - Bottoms

Not Acceptable:

Front rise has pull lines from the curve. Front pulling towards body



Possible Corrections:

- Increase front rise hook extension
- Reshape front rise angle
- Check through room
- Check crotch points align. Back rise should be $\frac{1}{4}$ " lower than front, unless specified differently.

Garment Fit - Bottoms

Not Acceptable:

Front and Back rises are cutting into body.



Possible Corrections:

- Increase through room
- Add to the crotch point, increasing front and back rises
- Check front and back rise angles
- Change angle of inseam
- Increase hip spec

Garment Fit - Bottoms

Not Acceptable:

CB waist is sitting low on body and pulls down when model moves. Back Rise is cutting into body at seat.



Possible Corrections:

- Saddle width is too narrow. Increase through room
- Increase back rise hook extension
- Reshape back rise hook
- Check the balance

Garment Fit - Bottoms

Not Acceptable:

Thigh is collapsing against leg. Side seam is angled



Possible Corrections:

- Caution pattern is balanced
- Re-angle inseam
- Increase front rise hook extension. Reduce front rise length
- Increase back rise & outseam height
- Check through room
- Check Design Intent for side seam placement call outs

Garment Fit - Bottoms

Not Acceptable:

Drag lines on back thigh. Garment leg is collapsing against form leg. Excessive fabric at the back of the knee (Tea Cup Holder).



Possible Corrections:

- Caution pattern is balanced
- Increase back rise hook extension
- Check through room
- Scoop out back rise
- Front rise too short. May pull back rise forward

Garment Fit - Bottoms

Not Acceptable:

Inseam is hiking up – bottom hem is not parallel to the ground



Possible Corrections:

- Caution inseam is not stretched when sewn.
- Caution pattern is cut on grain
- Check front and back rise angles
- Back rise may be too short at inseam.
- Check crotch points align. Back rise should be $\frac{1}{4}$ " lower than front, unless specified differently.

Garment Fit - Bottoms

Not Acceptable:

Excess fullness at side seam



Possible Corrections:

- Reduce shaping at outseam
- Reduce hip if needed
- Check pattern is balanced

Part 3: Workmanship & Construction

3:45 PM

Workmanship & Construction - Symmetry

TECHNICAL DESIGN

KOHL'S

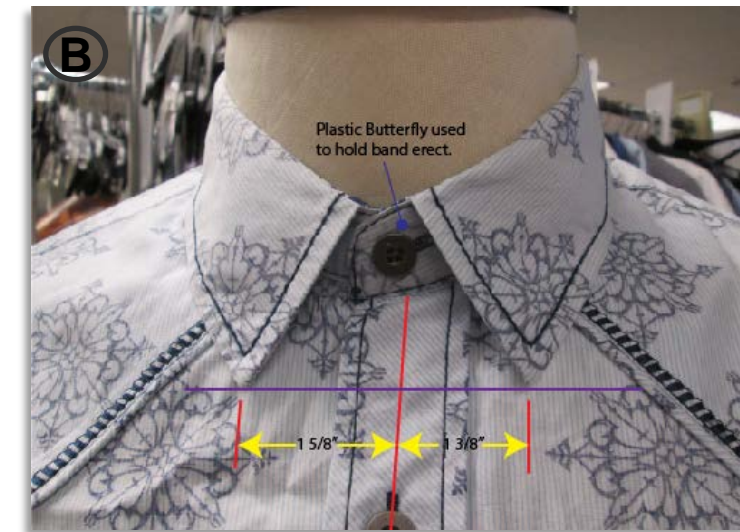
Workmanship & Construction - Symmetry

Not Acceptable: Collars

- Collar A is asymmetrical, as the collar points are not balanced.
- Collar B is asymmetrical. Distances from the center placket not balanced.

Correction Notes: Collars

- Evaluate symmetry on form buttoned & unbuttoned. If band is collapsing use either a pin or a plastic butterfly that mirrors band height to evaluate.



Workmanship & Construction - Symmetry

Not Acceptable: Collars

- Collar C appears to be asymmetrical, but this is caused by the band breaking down over the closure.

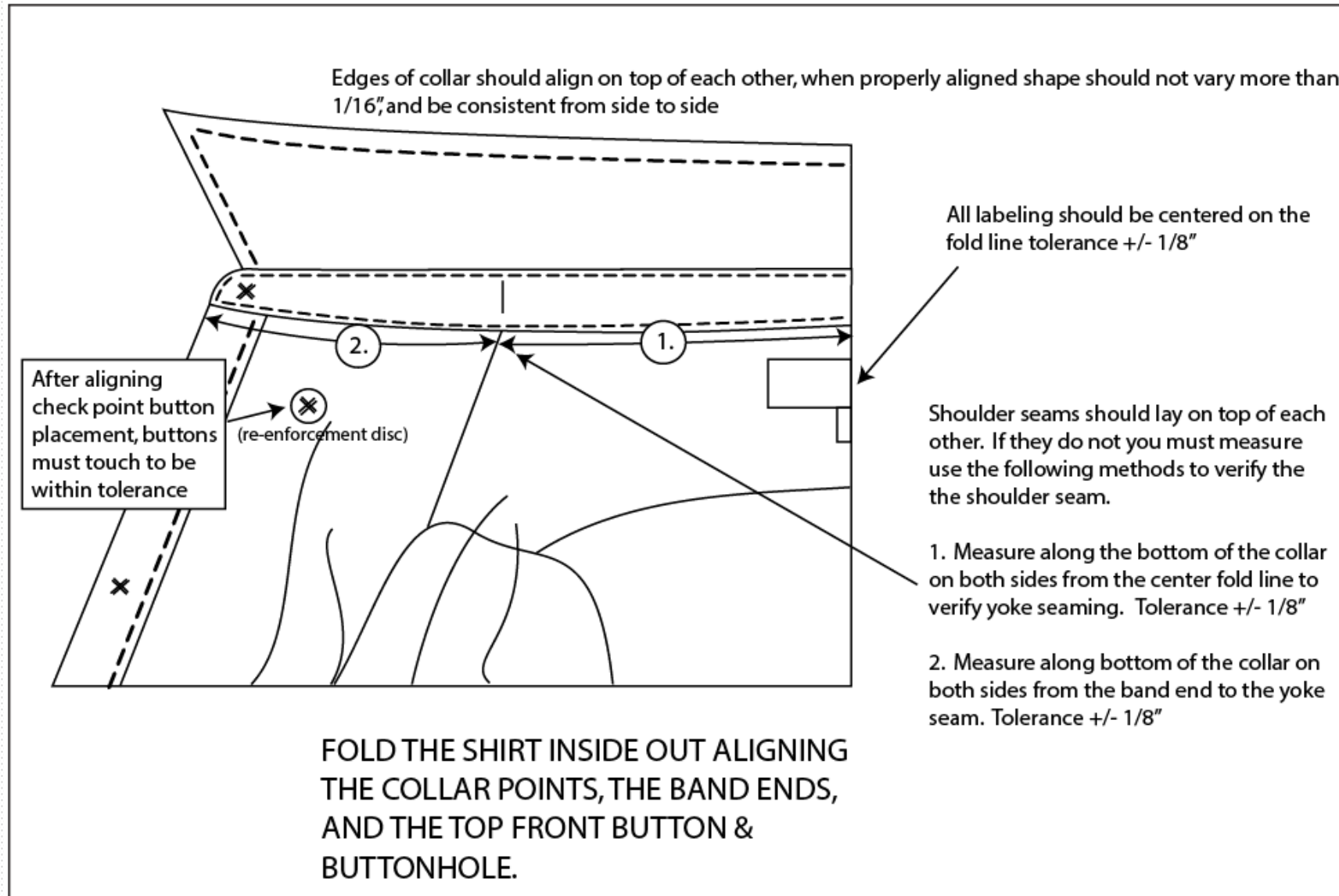
Correction Notes: Collar

- Refer to & use the Quartering Guideline.
- This should be addressed at every operation in production that would affect the setting of the collar.



Workmanship & Construction - Symmetry

Correction Notes: Collars



Workmanship & Construction - Symmetry

Correction Notes: Collars

- As per the Guideline, Align collar & band up, matching right to left sides
- Align collar and band to check for symmetry in shape and size
- Align button to buttonhole to ensure proper setting of both. Button sewing thread should be sitting inside the inside edge of the buttonhole.
- Check that collar is evenly attached to band – ensure that there are no high-low differences from right to left.
- Check that the band is evenly attached to the neck opening. If band has notches, ensure that the notches align to the shoulder seam and the center back notch on the neckline.



Workmanship & Construction - Symmetry

Not Acceptable: Collars

- Yokes are different sizes, and are not aligned
- When quartered shoulder piece seams do not align

Correction Notes: Collars

- As per the Guideline, Align collar & band up, matching right to left sides
- Align collar and band to check for symmetry in shape and size
- Align button to buttonhole to ensure proper setting of both. Button sewing thread should be sitting inside the inside edge of the buttonhole.
- Check that collar is evenly attached to band – ensure that there are no high-low differences from right to left.
- Check that the band is evenly attached to the neck opening. If band has notches, ensure that the notches align to the shoulder seam and the center back notch on the neckline.



Workmanship & Construction - Symmetry

Correction Notes: Body

- Center Back seam should be straight
- Body should be symmetrical from left to right

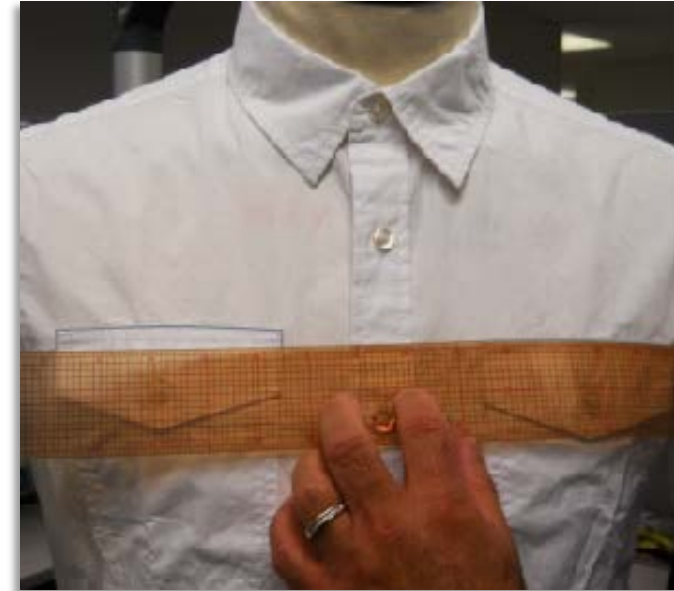


Workmanship & Construction - Symmetry

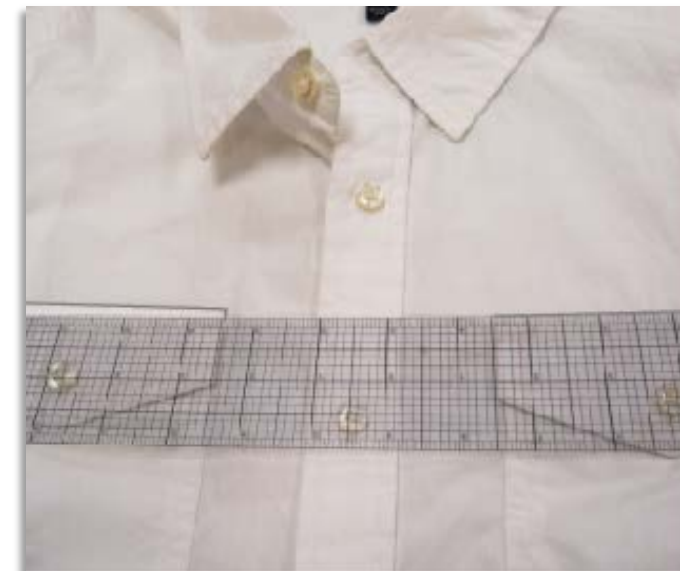
Not Acceptable: Dual Pocket

- Pocket setting is asymmetrical

Appearance on Form



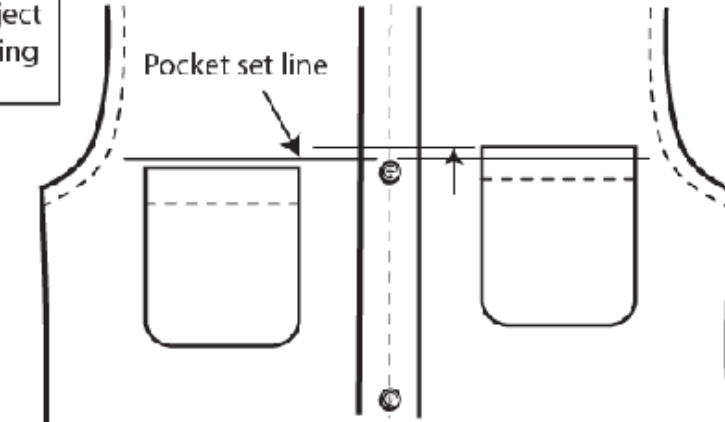
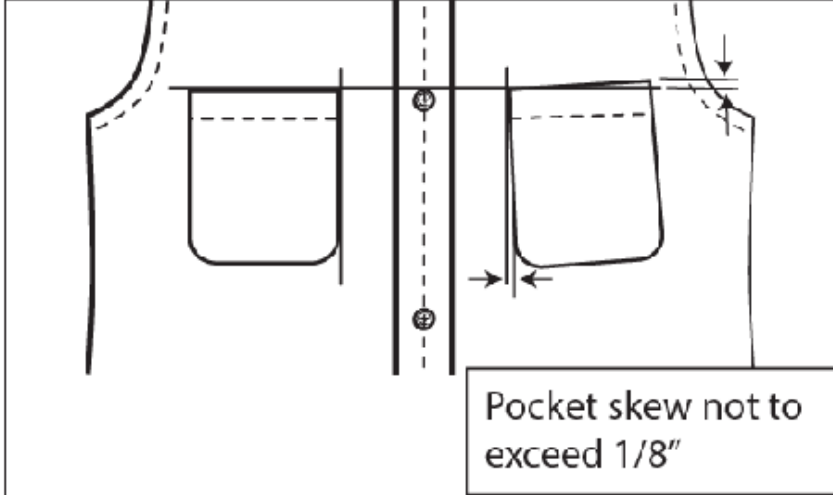
Appearance Flat



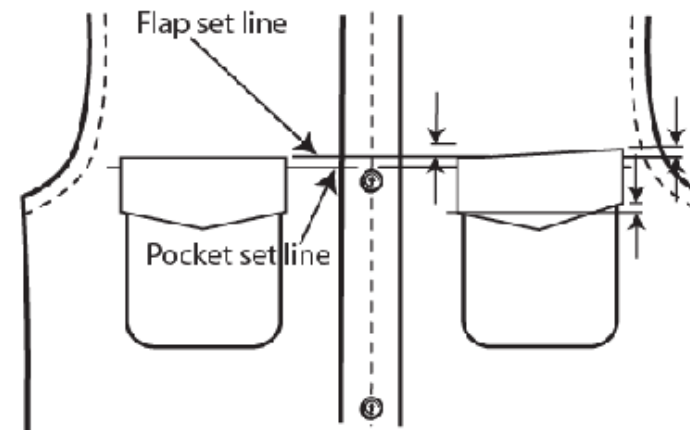
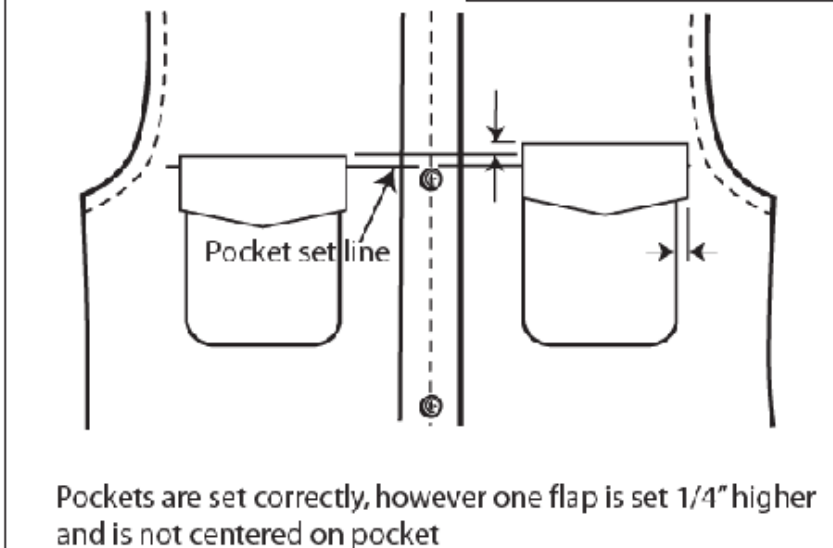
Workmanship & Construction - Symmetry

Correction Notes: Dual Pocket & Flap Alignment

Shown are examples of variables of pocket and flap attaching, If you can visually see misalignments or skewed pockets or flaps, it is safer to reject then accept. When checking, you must make sure buttons or packaging is not forcing the garment to be appear off.



Even though both pockets when measured from high point shoulder are within the normal one pocket tolerance. The left pocket is higher then the right pocket by 1/4". This is unacceptable



Pockets and one flap are set correctly, the left flap is skewed more than 1/8" and is rejectable

Workmanship & Construction - Symmetry

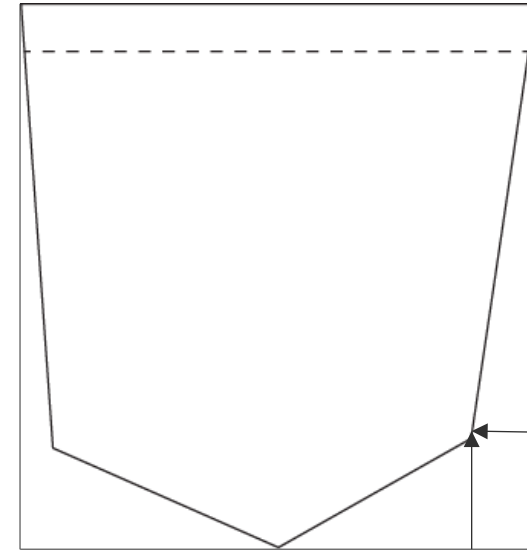
Not Acceptable: Pocket

- Pocket shape is not the same from side to side

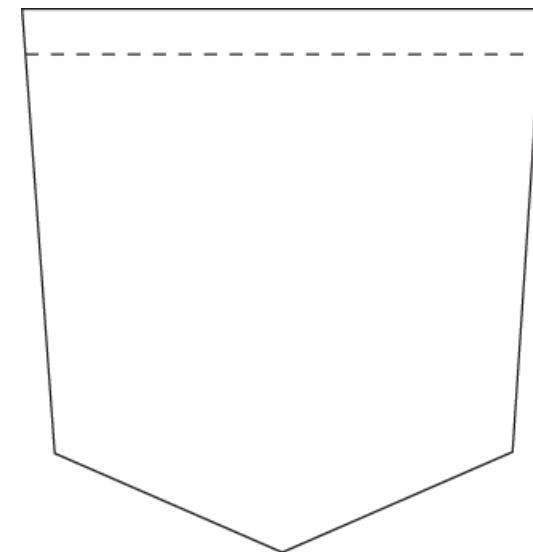
Correction Notes: Pocket

- Both pockets shape should follow requested shape and design
- Pocket shape is symmetrical

Asymmetrical



Symmetrical



Workmanship & Construction - Symmetry

Not Acceptable: Pocket

- Pocket top edge is not symmetrical

Correction Notes: Pocket

- Both pockets shape should follow requested shape and design
- Pocket shape is symmetrical



Workmanship & Construction – Wovens Sewing & Construction

TECHNICAL DESIGN

KOHL'S

Workmanship & Construction – Wovens Sewing & Construction

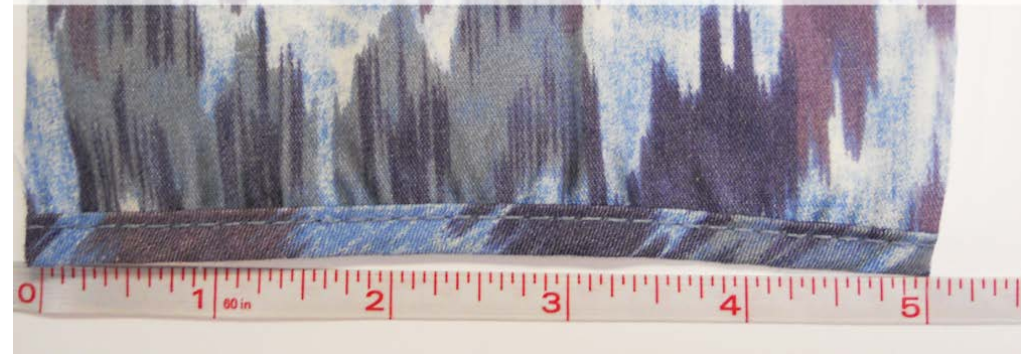
Note Acceptable:

- Unintentional fullness

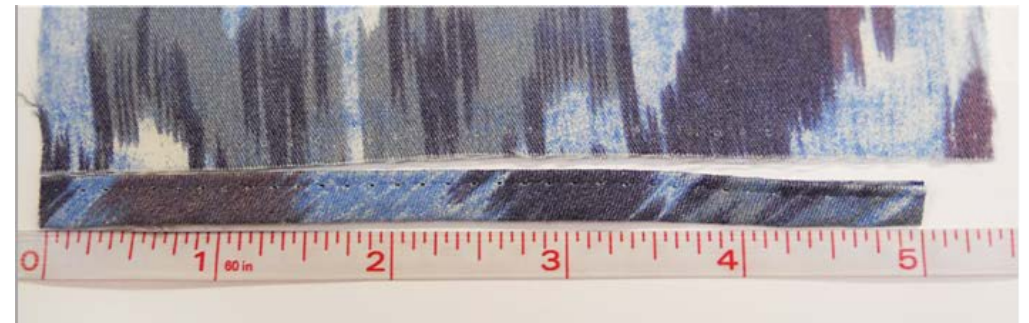
Correction Notes:

- Bias binding should be fully relaxed before applying to body.
- Folder and set up should be appropriate for fabric. Fabric should feed evenly on top and bottom. Binding and body fabric should be moving through the folder at the same speed.
- Presser foot pressure should be just enough to feed the garment through, so the fabric feeds smoothly.
- Check the thread tension to ensure it is not too tight. Tight thread tension will hold in the binding and cause puckering.
- Operator should not be holding binding or fabric as it feeds through the folder. Curved edges should not be pulled or straightened when sewn.

BEFORE: Binding and body measure 5".



Notice the difference between the binding and the body on this garment when the stitches are taken out. The binding, relaxed, remains the same length. The body gains in width.



AFTER: Too much of the body is taken in when sewing: Body measures 5 1/2", gaining in width

Workmanship & Construction – Wovens Sewing & Construction

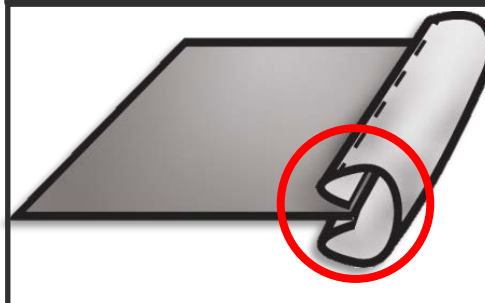

Not Acceptable:

- Too much of the body fabric is taken in as the tape is sewn.
- Fabric should not overcrowd the folder, as this can cause bulk in bound edges, twisting, and result in incorrect fit. Operator should take care not to force too much body fabric into the folder when sewing.

Correction Notes:

- Binding should be feeding through evenly without catching. Body fabric should lay flat in binding, without getting folded into it.



Overcrowding Examples	
	
Good example: folder is not overcrowded, and fabric lays flat in binding.	Poor example: folder is overcrowded, causing body fabric to curl in binding.

Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Wavy seams
- Uneven lengths

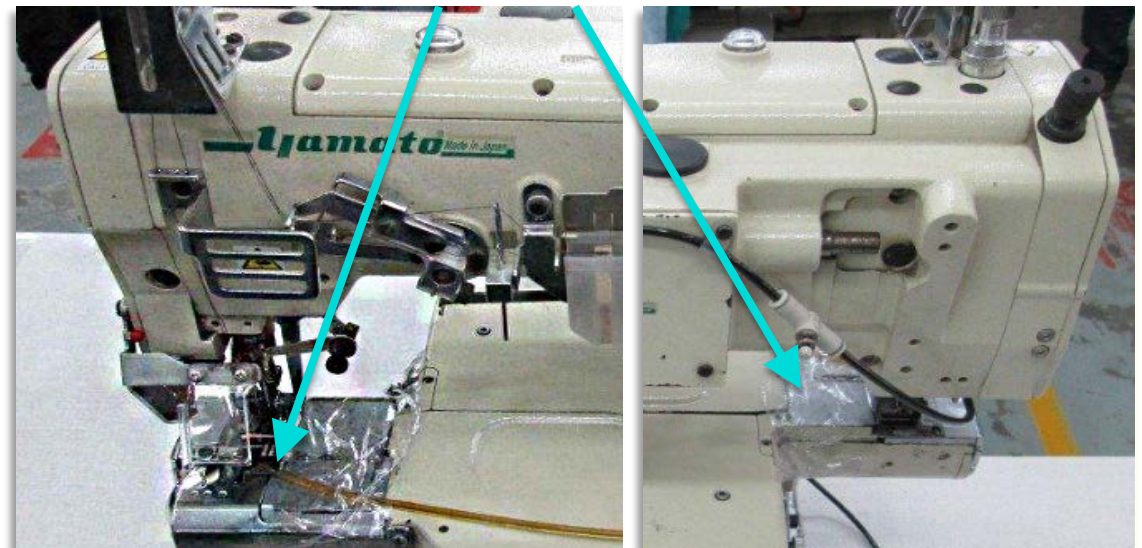
Correction Notes:

- Check that presser foot pressure is appropriate for the fabric and the operation, to allow even feeding of both layers of fabric.
- Check that the folder set up is correct for the fabric type and operation. It must feed the fabric through evenly without stretching or holding.
- Make sure the operator is not stretching or holding the fabric as it feeds through the machine, as this will cause the bias seam to stretch and make the seam wavy.
- Depending on the fabric and operation, it can help to have air tubes blowing fabric flat when seaming, or to assist in feeding the fabric through the machine.

Bias side seams are stretched when sewn, causing a difference of 1/2" in length.



Air tubes are hooked up to machine to blow across fabric, allowing the edge to lay flat while sewing.



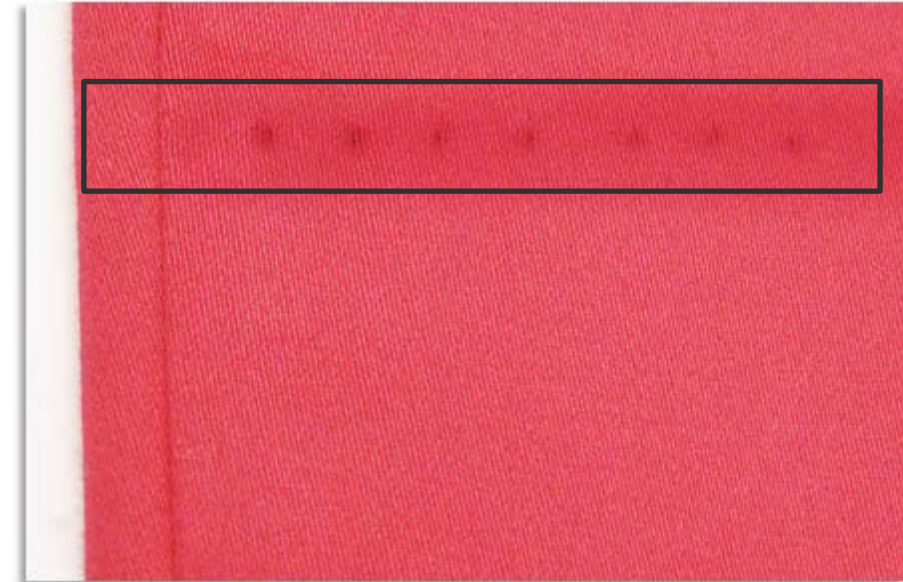
Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Stitches are showing on face of garment

Correction Notes:

- Needle is taking too large of a bite out of the fabric as it stitches. Make sure machine is calibrated and aligned correctly for this operation.
- Check that needle is inserted into machine correctly, and is not bent or damaged.
- Check that the thread tex size, thread type, and needle size are matched for optimal performance, and appropriate for the fabric type.



Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Lack of ease in sleeve cap; restricts movement
- Armhole is straight, curve has been cut off during sewing

Correction Notes:

- Curve is eased into armhole, allowing space and movement
- Easing can be done without having a differential feed or gathering mechanism. Flip the garment when sewing so the piece being eased in (the sleeve) is against the feed dogs, while the piece being eased to (the armscye) is against the presser foot.
- The feed dogs push more fabric through per inch than the presser foot, allowing the sleeve to ease into the armhole.

Not Acceptable:



Acceptable:



Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Front rise shape is being distorted when sewing, causing pulls at front crotch point.



Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Zipper is wavy

Correction Notes:

- If the operator is stretching or skewing the fabric when sewing, it will cause the zipper to wave.
- Make sure the zipper is the correct length for the opening, and that it is not being forced in.
- Check that the presser foot pressure is correct, and that both fabric and zipper are feeding through evenly, at the same speed.
- Check the thread tension to make sure it is not too tight, and thus holding in the fabric.
- Check that the thread tex size, thread type, and needle size are matched for optimal performance, and appropriate for the fabric type.
- Ensure that zipper tape is pre-shrunk.
- The number of operations used to set the zipper can affect the zipper set as well.
- To minimize the number of operations needed, ensure that all above steps are checked for each operation involving the zipper set.



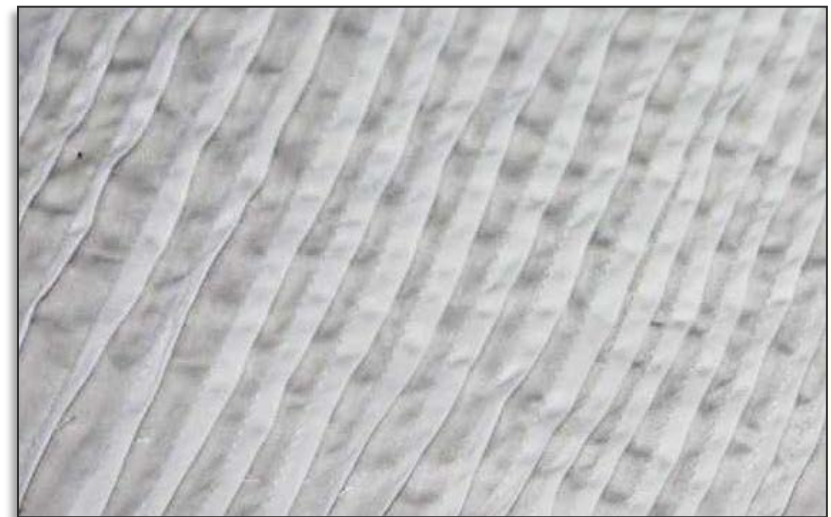
Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Puckering
- Tension of the tucks causing garment to hike

Correction Notes:

- Check that the thread tex size, thread type, and needle size are matched for optimal performance, and appropriate for the fabric type.
- Check that there is not too much pressure from the presser foot, so that the fabric feeds through evenly
- Stitch tension should be checked to ensure that it is not holding or causing puckering
- Check that nothing is causing the thread to catch anywhere – for example, make sure fans are not blowing toward the thread.
- Make sure the folder setup is correct and appropriate for the fabric weight, as this will make a difference in how it is feeding through the machine.



Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Skipped stitches
- Broken stitches
- Open seams

Correction Notes:

- Check that the machine is threaded correctly, and that nothing is causing the thread to catch anywhere – for example, make sure fans are not blowing toward the thread.
- Check that the thread tex size, thread type, and needle size are matched for optimal performance, and appropriate for the fabric type.
- Check that the thread tension is balanced between needle and bobbin or looper. Tight tension can lead to skipped stitches.
- Use preferred supplier thread. Local supplier thread frequently does not meet Kohl's requirements for stitch elongation at break. If thread stretches too much, it causes poor stitch formation and skipped stitches.
- Check that the needle is sharp, straight, and is inserted into the machine correctly.

Skipped Stitches



Broken Stitches



Broken Stitches

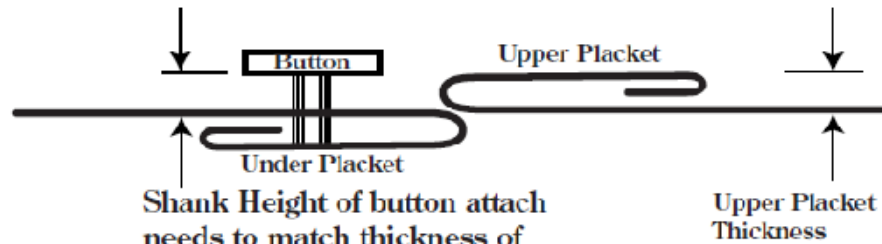


Open Seam



Workmanship & Construction – Wovens Sewing & Construction

Correction Notes:



Shank Height of button attach needs to match thickness of the upper placket. Should not exceed thickness.

Button sewing thread tails should be trim to be no more than 1/16" in length.

No looping threads or bulky thread nests

Unless specified as parallel stitch, all button sewing is to be a locking cross stitch.

16 stitch count minimum

Button hole should be a minimum of 1/8" longer than button.

Knife should cut from bar to bar, no more than 1/16" left uncut inside buttonhole

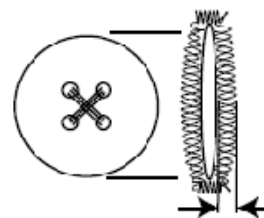
Width or needle throw of buttonhole stitch should be adjusted so buttonhole stitch is as close to the knife as possible to reduce frayed yarns.

The needle throw may need to be adjusted due to the fabrication or thickness of the placket

Minimum throw width is 3/64"

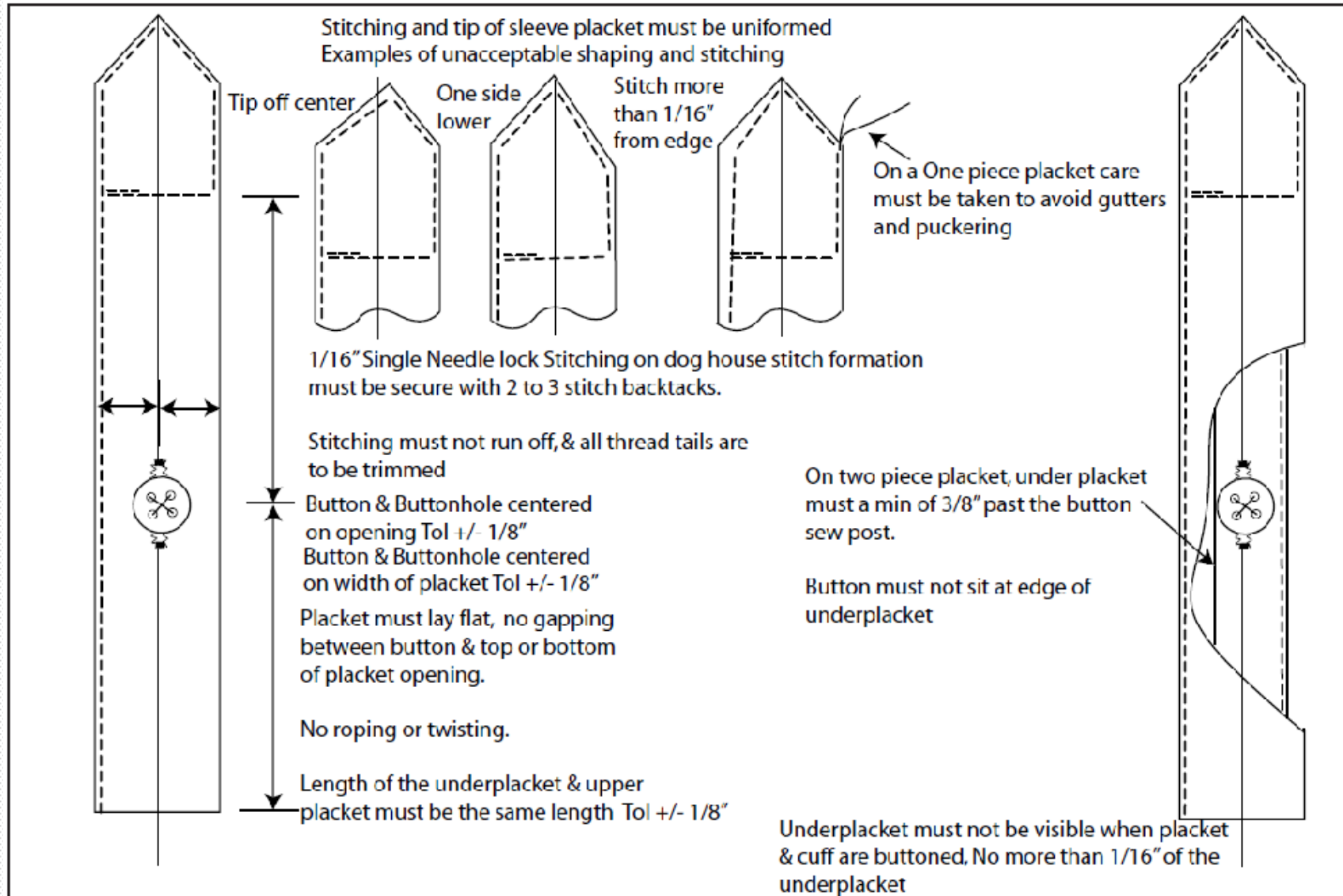
5/64" width to be used on fabrics such as Knit Pique or Woven Flannels

Buttonholes should be cleanly cut with no untrimmed warp or wale yarns or badly frayed weft or course yarns



Workmanship & Construction – Wovens Sewing & Construction

Correction Notes:



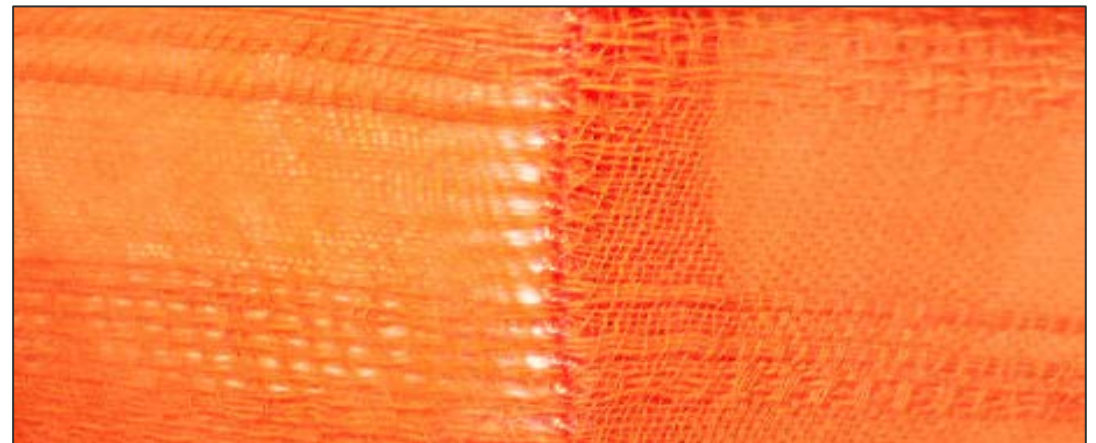
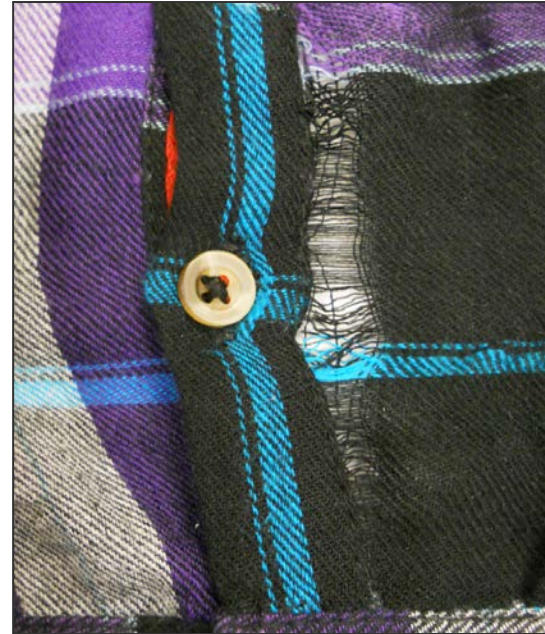
Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Seam slippage is the pulling away or separation of the fabric at the seam, causing gaps or holes to develop. It involves warp and weft threads pulling apart, but not yarn breakage.

Correction Notes:

- Check that SPI is appropriate for fabric type. It may need to be adjusted to eliminate seam slippage.
 - Having the SPI too low or too high for the fabrication will cause seam slippage
 - If currently at 10 SPI try going to 12-14. If currently at 18 SPI try going to 12-14
- Check that stitch class is appropriate for fabric type. For example: using lockstitch instead of chain stitch to put less strain on the fabric.
- Depending on fabric type, try using a french seam folder to strengthen the seam.
- Check that the thread tex size, thread type, and needle size are matched for optimal performance, and appropriate for the fabric type.



Workmanship & Construction – Wovens Sewing & Construction

Not Acceptable:

- Seam grinning

Correction Notes:

- Balance top and bottom thread tension
- Tighten stitch tension
- Increase pattern ease



Workmanship & Construction – Knits Sewing & Construction

TECHNICAL DESIGN

KOHL'S

Workmanship & Construction – Knits Sewing & Construction

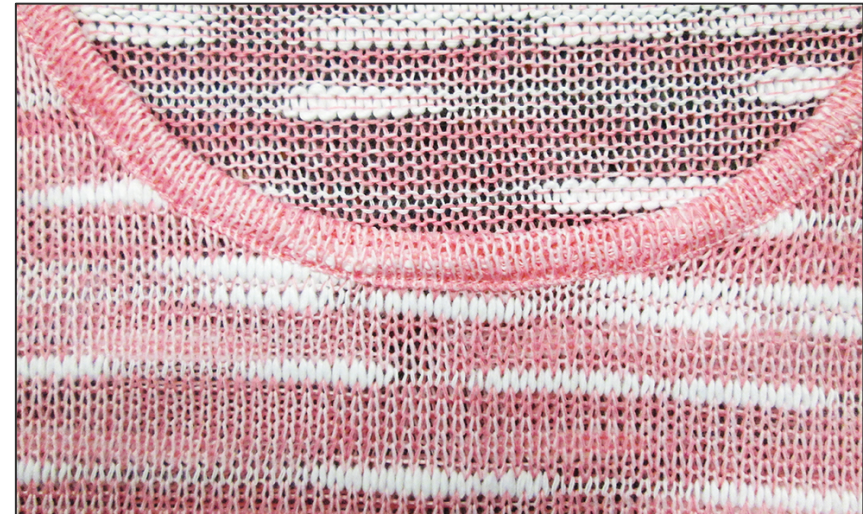
Not Acceptable:

- Loops are not all caught in binding, creating a hole
- Raw edges are not fully encased in binding



Correction Notes:

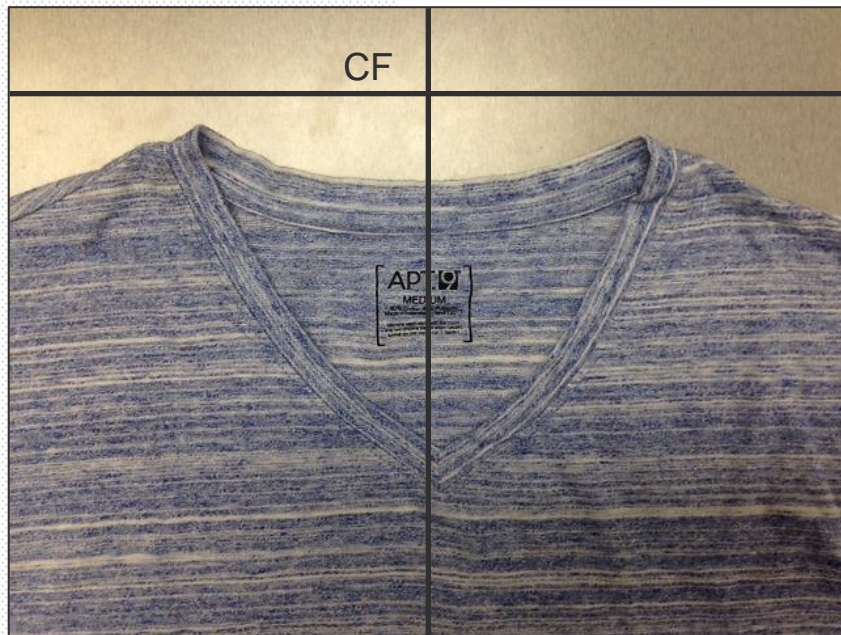
- Loops are all caught in binding, eliminating holes
- Raw edges are fully encased in binding for a clean finish



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- The neckline is not lining up with CF creating a distorted off center neckline



Correction Notes:

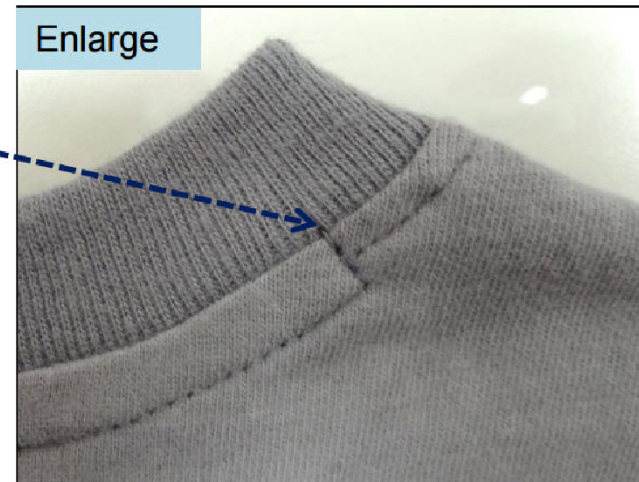
- The neckline is lining up with CF and symmetrical from side to side



Workmanship & Construction – Knits Sewing & Construction

Correction Notes:

- Extend SN/LS at the back as “L” shape
- Extend SN/CS from the front to meet SN/LS at the back



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Not straight on body
- Upper placket does not cover under placket
- Buttons are not aligned



Correction Notes:

- Straight on body
- Upper placket fully covers under placket
- Buttons are aligned



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Smocking tension is too tight
- X-frt & Neckline are too narrow



Correction Notes:

- Smocking tension is adjusted
- Bodice now has appropriate coverage



Workmanship & Construction – Knits Sewing & Construction

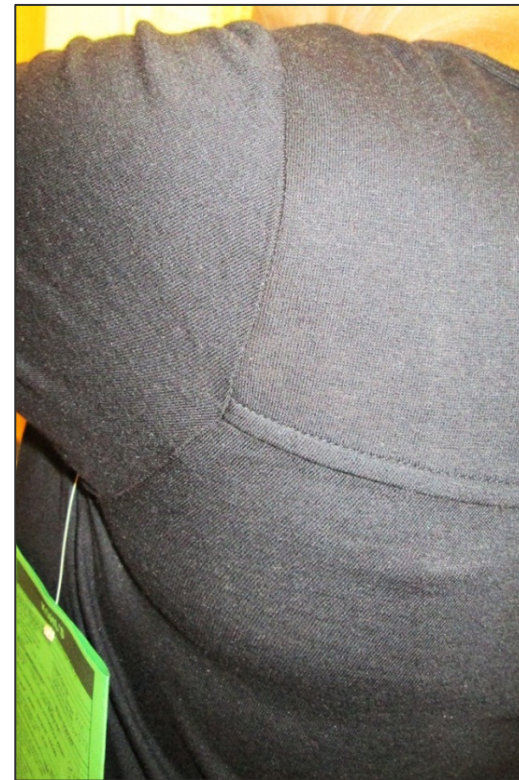
Not Acceptable:

- Thread tension at yoke seam is too tight



Correction Notes:

- Seam is sewn with proper tension



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Sleeve was hard-pressed
- Sleeve is winging out and standing away from body



Correction Notes:

- Sleeve was not hard-pressed and is now laying nicely



Workmanship & Construction – Knits Sewing & Construction

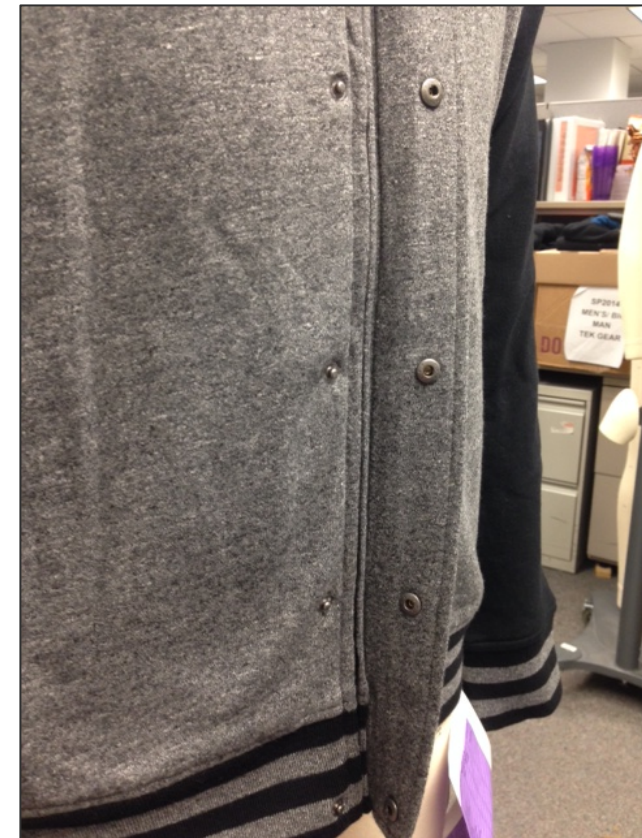
Not Acceptable:

- Zipper length is incorrect
- Zipper is wavy



Correction Notes:

- Zipper length is calculated properly for this garment
- Zipper is smooth



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Seam tension is too tight causing puckering at inseam



Correction Notes:

- The outseam is laying correctly due to proper stitch tension at inseam



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Fabric is torqueing and unbalanced
- Sleeve is twisting
- Neckline is not symmetric
- Side seam twists



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Raw edge is jagged



Correction Notes:

- Raw edge is smooth



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Elastic ends are left hanging loose and not cut to clean finish (when there isn't a seam to clean finish into)



Correction Notes:

- Ends are securely reinforced
- No thread tails



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Shirring is not evenly distributed, causing pleats to form



Correction Notes:

- Shirring is evenly distributed and there is no pleating



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Hem is roping



Correction Notes:

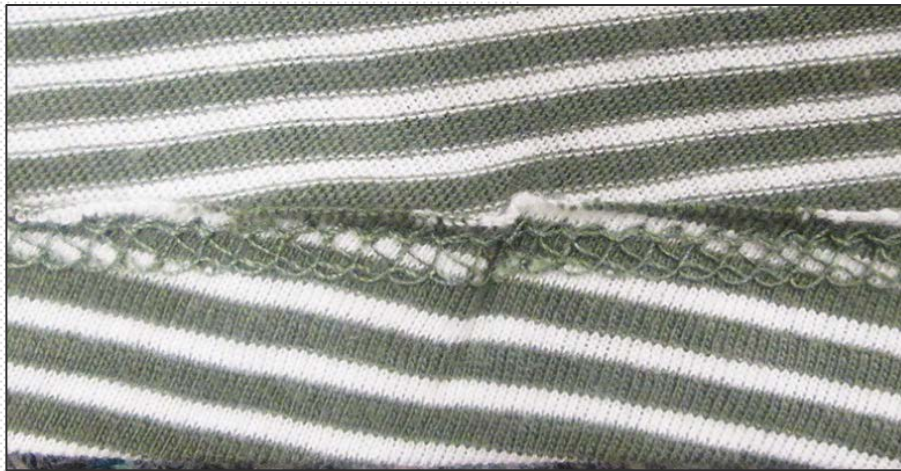
- Hem appearance should be flat



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Raw edge/seam allowance are uneven



Correction Notes:

- Turn back hem is even and smooth
- Coverstitch is encasing all the raw edges



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Seam is stretched when applying coverstitch



Correction Notes:

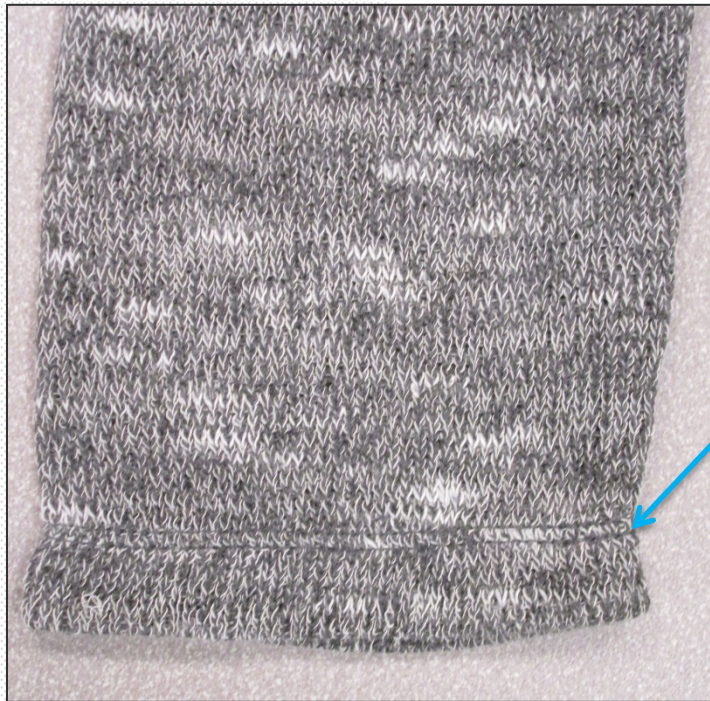
- Seam is not stretched and has a smooth transition from sleeve to cuff



Workmanship & Construction – Knits Sewing & Construction

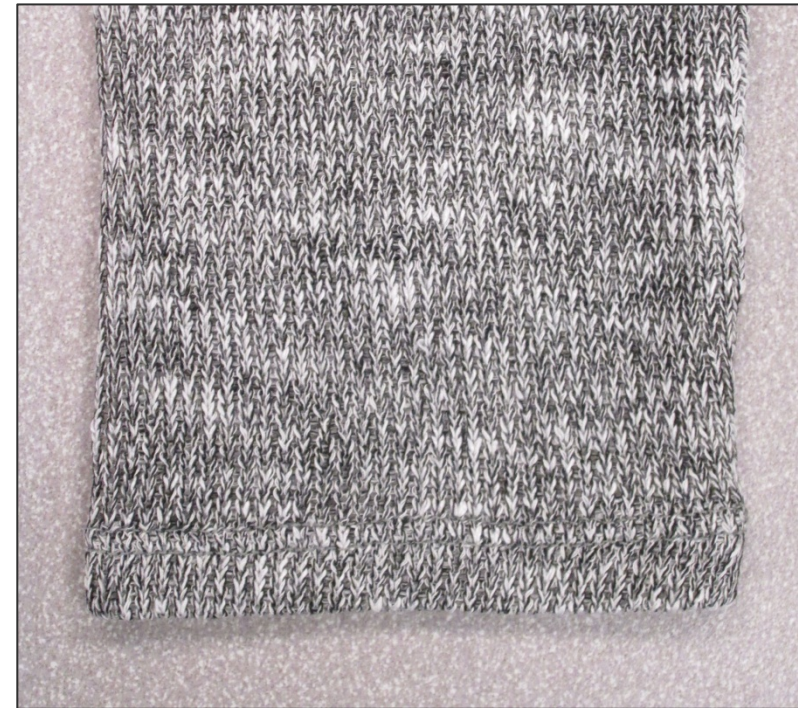
Not Acceptable:

- The thread tension of 2N bottom coverstitch is too tight, and sleeve is pulling in at hem



Correction Notes:

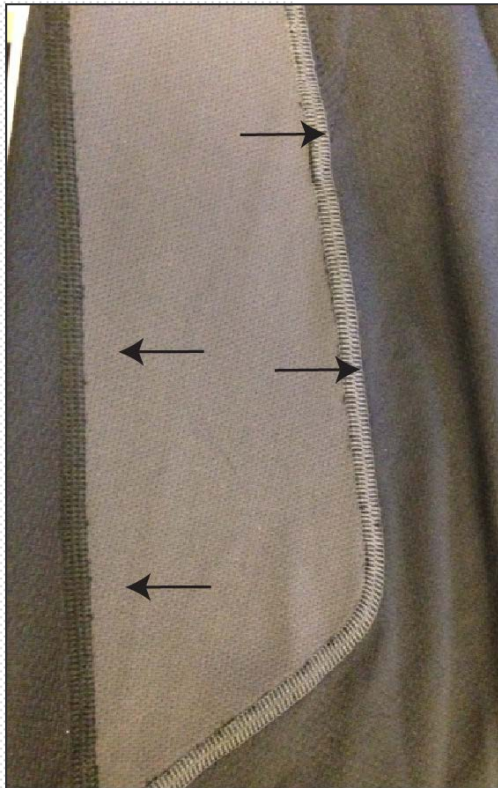
- The thread tension of 2N bottom coverstitch is loosened to achieve a smooth profile



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Flatlock stitching does not appear clean due to order of operations
- SPI is too low



Correction Notes:

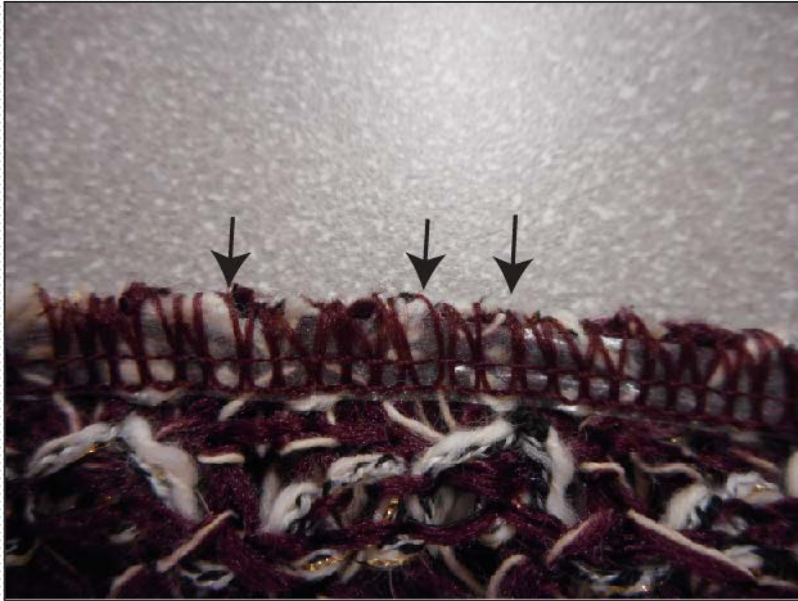
- Thread tension and SPI are appropriate and stitch coverage is good



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Poor coverage due to low SPI count
- Raw edges are exposed



Correction Notes:

- SPI count increased for better coverage
- Raw edges are encased



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Pocket/Placket corners were not reinforced properly to withstand harsh wash process
- Stress points are particularly vulnerable in abrasive chemical washes



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Seams are stretched/puckering



Workmanship & Construction – Knits Sewing & Construction

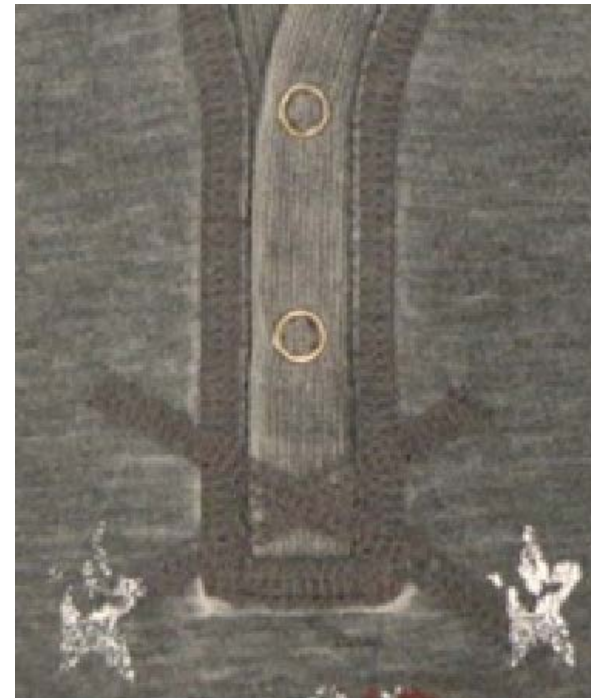
Not Acceptable:

- Coverstitching is unraveling
- Snap placement is uneven
- Bartacks have not been applied



Correction Notes:

- Even coverstitching with bartacks properly applied
- Snaps are evenly placed



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Woven fabric is puckered when seamed to knit fabrication
- Should be a smooth seam with no puckering



Correction Notes:

- No puckering where knit and woven are seamed together
- Smooth clean appearance



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Piecing seam is pointed at hem due to stretching during seaming
- Hem shape should be smooth



Correction Notes:

- Piecing seam was sewn appropriately with no stretching
- Hem is now a smooth shape



Workmanship & Construction – Knits Sewing & Construction

Not Acceptable:

- Rises were stretched out during sewing



Correction Notes:

- Rise shapes are nice and smooth and seams were not stretched during sewing



Part 4: Critical Points of Attention

Critical Points of Attention

Best Practices:

- Kohl's TD may add a Critical Points of Attention page to the tech pack. This calls out an area of the garment that has been identified as being visually important and should be given extra attention by the vendor and QA team. This is a way that Kohl's TD can communicate expectations for quality before going into production.
- The areas of a style that may be noticed right away by the customer.
 - What is the 1st thing the customer sees?
 - Would it stop them from buying the garment or cause them to return?
 - Would it alter their view of Kohl's and/or the brand?
- KAG/VTD should identify additional critical points of attention when evaluating a sample.

Critical Points of Attention

How to identify critical points of attention:

- Identify highly visible areas such as the neckline or any embellishment.

Visual Check:

- Lay garment flat on the table, check symmetry, shaping, and surface of the garment.
- Neckline, armhole curves, pocket shaping, etc. should be same on both sides.
- There should be no significant shiny or press-marked areas.
- Fold garment in half lengthwise at CF and CB. Align side seams on top of each other to check symmetry.
Are side seam lengths and sleeve lengths even on both sides?

Critical Points of Attention

What are some of the critical points of attention on this style?



Critical Points of Attention

What are some of the critical points of attention on this style?

Neckline is highly visible:

✓ Check for symmetry and quality of collar setting.

A placket is a special feature on this style:

- ✓ Does placket look straight?
- ✓ Is placket well executed?
- ✓ Are buttons evenly spaced?
- ✓ Does upper placket fully cover under placket?



Critical Points of Attention

What are some of the critical points of attention on this style?

Fold garment in half lengthwise:

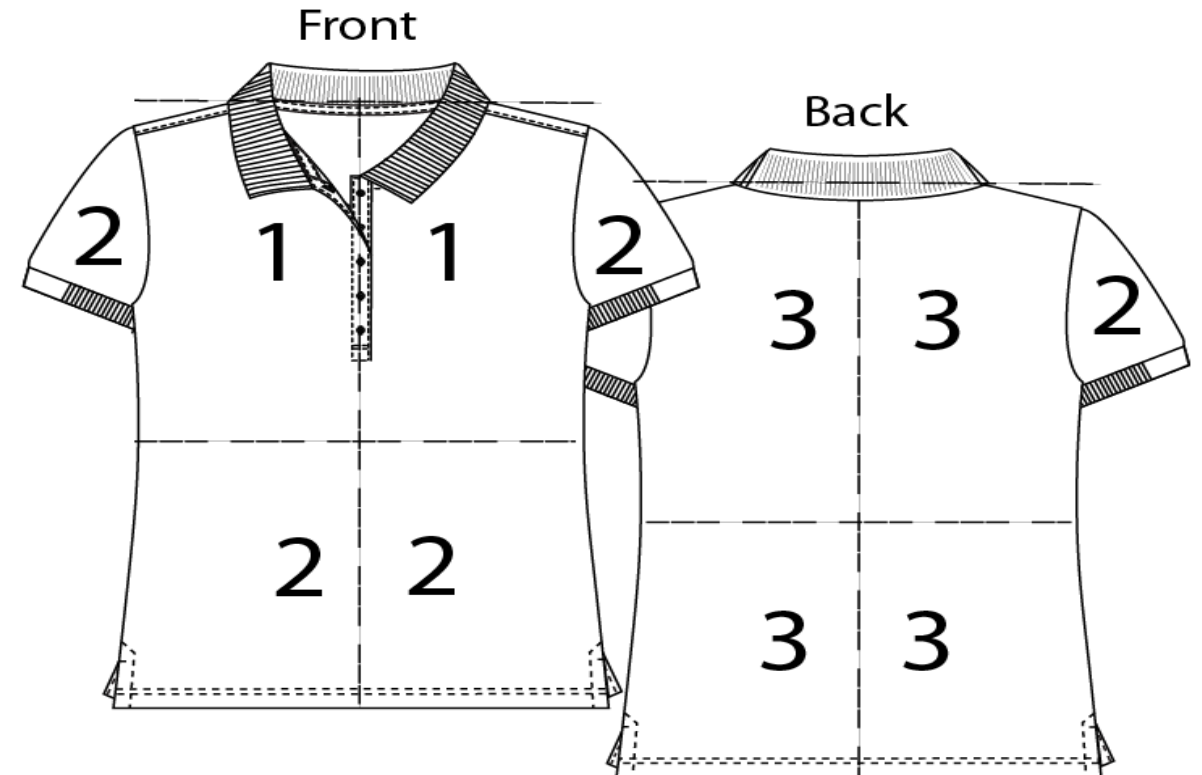
- ✓ Are side seams the same length?
- ✓ Are sleeves the same length and width?
- ✓ Are armhole depths the same?



Critical Points of Attention

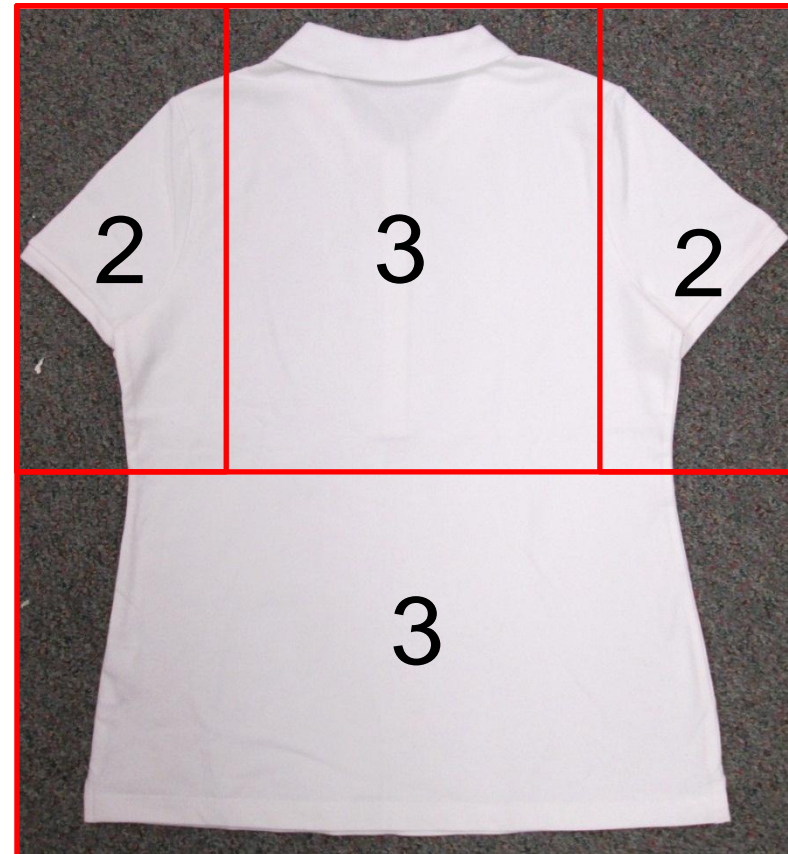
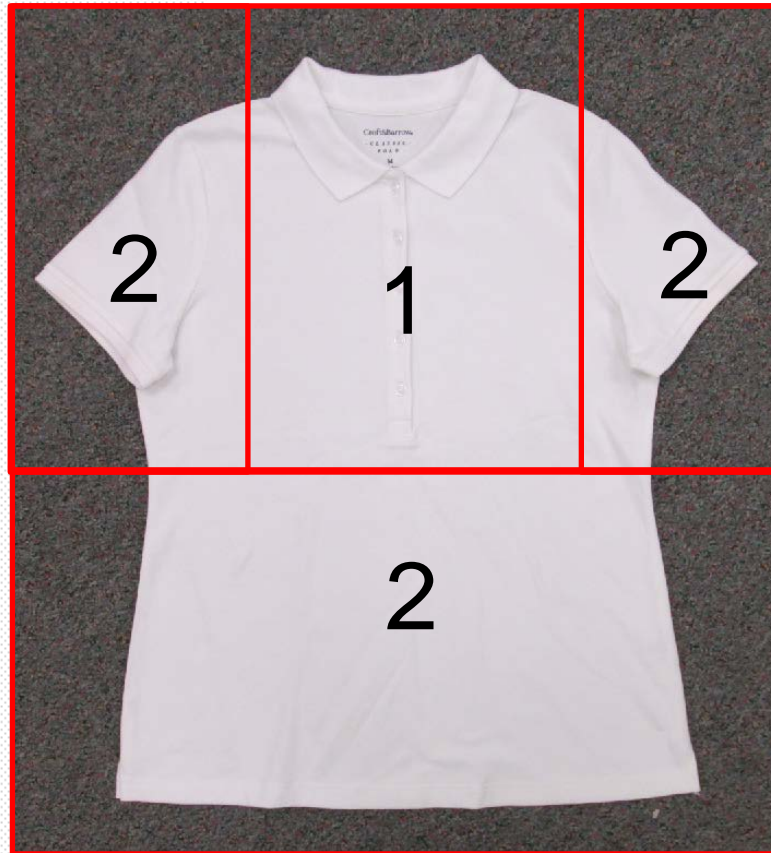
Garment is broken into zones based on visibility to the customer:

- Zone 1 is the most critical and is the first area the customer sees. Zone 1 should be carefully reviewed for quality of construction and workmanship. Any area that has special design details should also be considered zone 1, such as sleeve shirring or a back yoke.
- Zone 2 is also important and is visible when garment is hanging in the store. Carefully review features in zone 2 such as pockets and bottom trim.
- Zone 3 is the least visible to the customer, however any design details on the back panel should be considered zone 1.



Critical Points of Attention

Garment is broken into zones based on visibility to the customer:



Critical Points of Attention

Garment is broken into zones based on visibility to the customer:

Sample has design details on



Critical Points of Attention

What are some of the critical points of attention on this style?



Critical Points of Attention

What are some of the critical points of attention on this style?

Neckline is highly visible:

✓ Check for symmetry and quality of collar setting.

A placket is a special feature on this style:

- ✓ Does placket look straight?
- ✓ Is placket well executed?
- ✓ Are buttons evenly spaced?
- ✓ Does upper placket fully cover under placket?



Critical Points of Attention

What are some of the critical points of attention on this style?

Fold garment in half lengthwise:

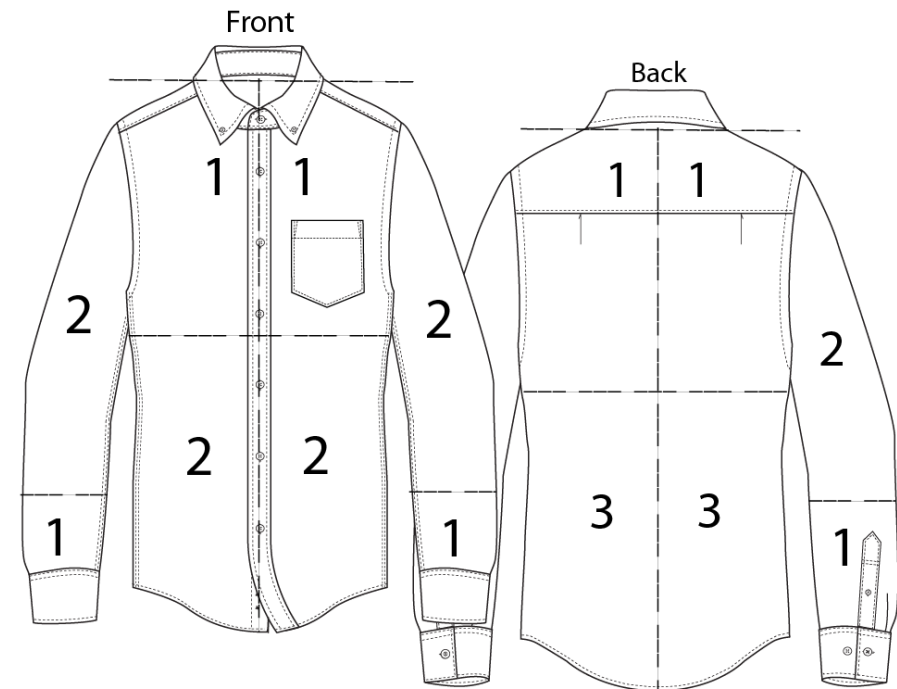
- ✓ Are side seams the same length?
- ✓ Are sleeves the same length and width?
- ✓ Are armhole depths the same?



Critical Points of Attention

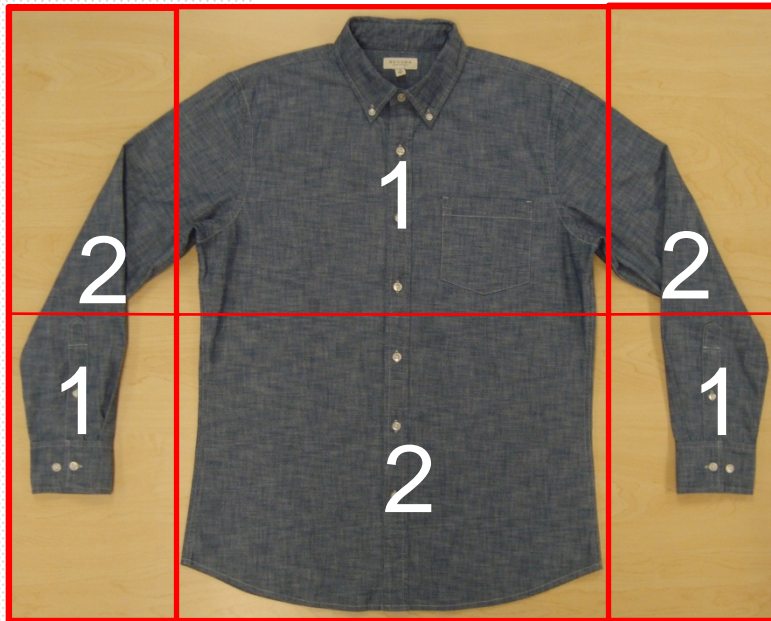
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Critical Points of Attention

Garment is broken into zones based on visibility to the customer:



Critical Points of Attention

Garment is broken into zones based on visibility to the customer:

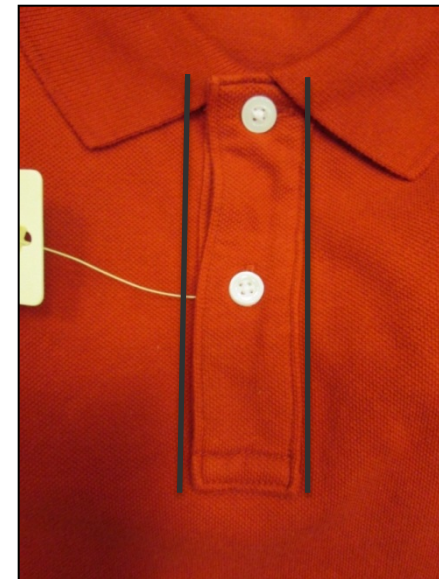
Sample has yoke details on back panel



Critical Points of Attention

Common Critical Points: Not Acceptable

- Placket should be set straight
- Placket should align at edges
- Buttons in placket should be centered and evenly spaced.
- Bottom edge of placket must be straight.



Critical Points of Attention

Common Critical Points: Not Acceptable

- Fabric tuck on princess seam



Critical Points of Attention

Common Critical Points: Not Acceptable

- Hanging threads should be trimmed



Critical Points of Attention

Common Critical Points: Not Acceptable

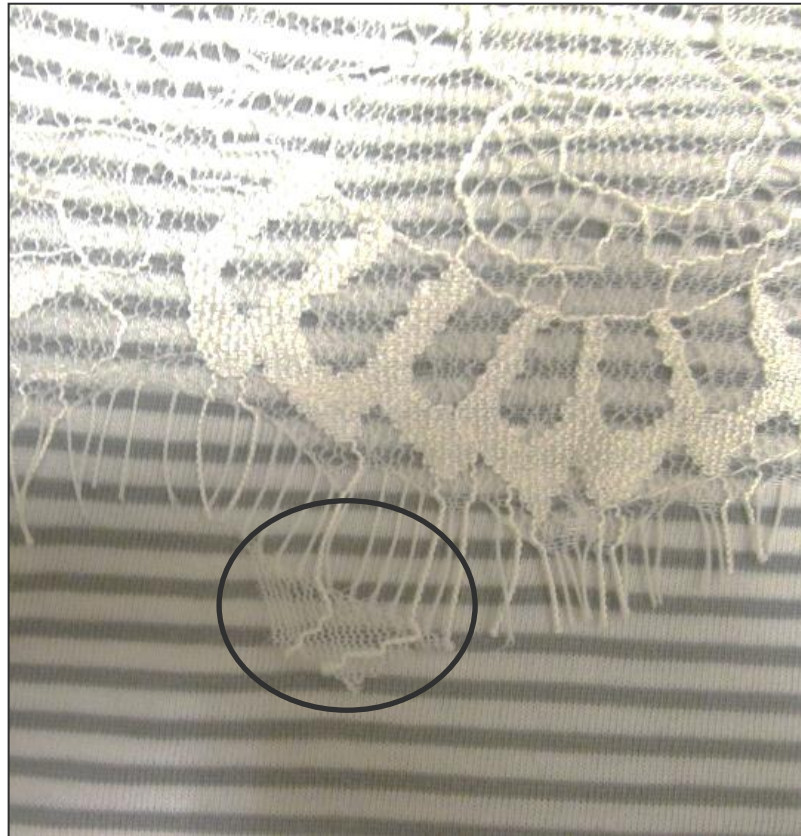
- Applied trim should not distort sleeve



Critical Points of Attention

Common Critical Points: Not Acceptable

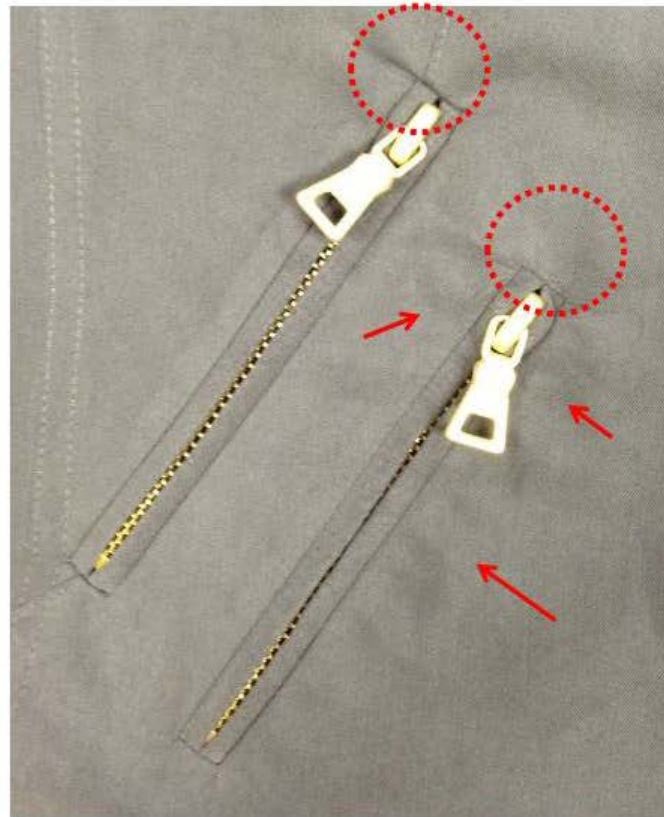
- Lace should be cut cleanly



Critical Points of Attention

Common Critical Points: Not Acceptable

- Front welt setting needs to avoid lines at the corner of welt and puckering.



Critical Points of Attention

Common Critical Points: Not Acceptable

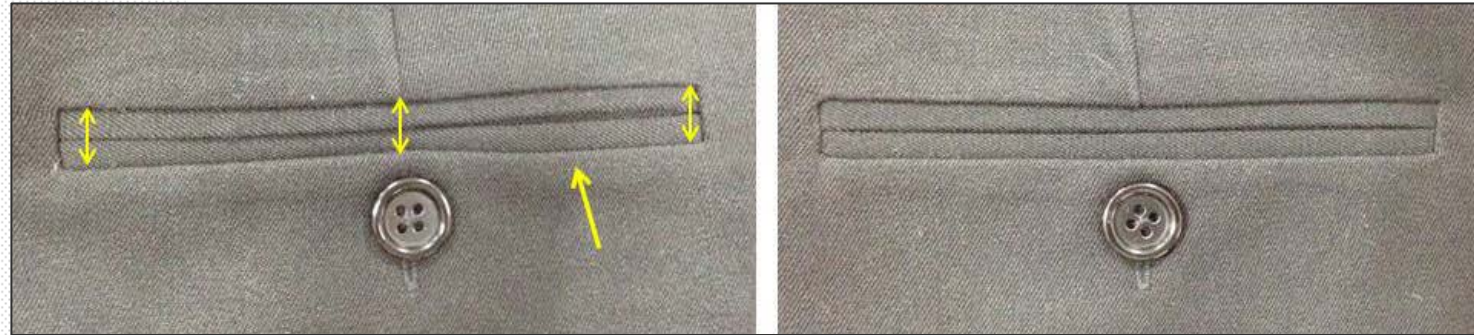
- The collar shape / stand is stretched, collapsing, and wavy.



Critical Points of Attention

Common Critical Points: Not Acceptable

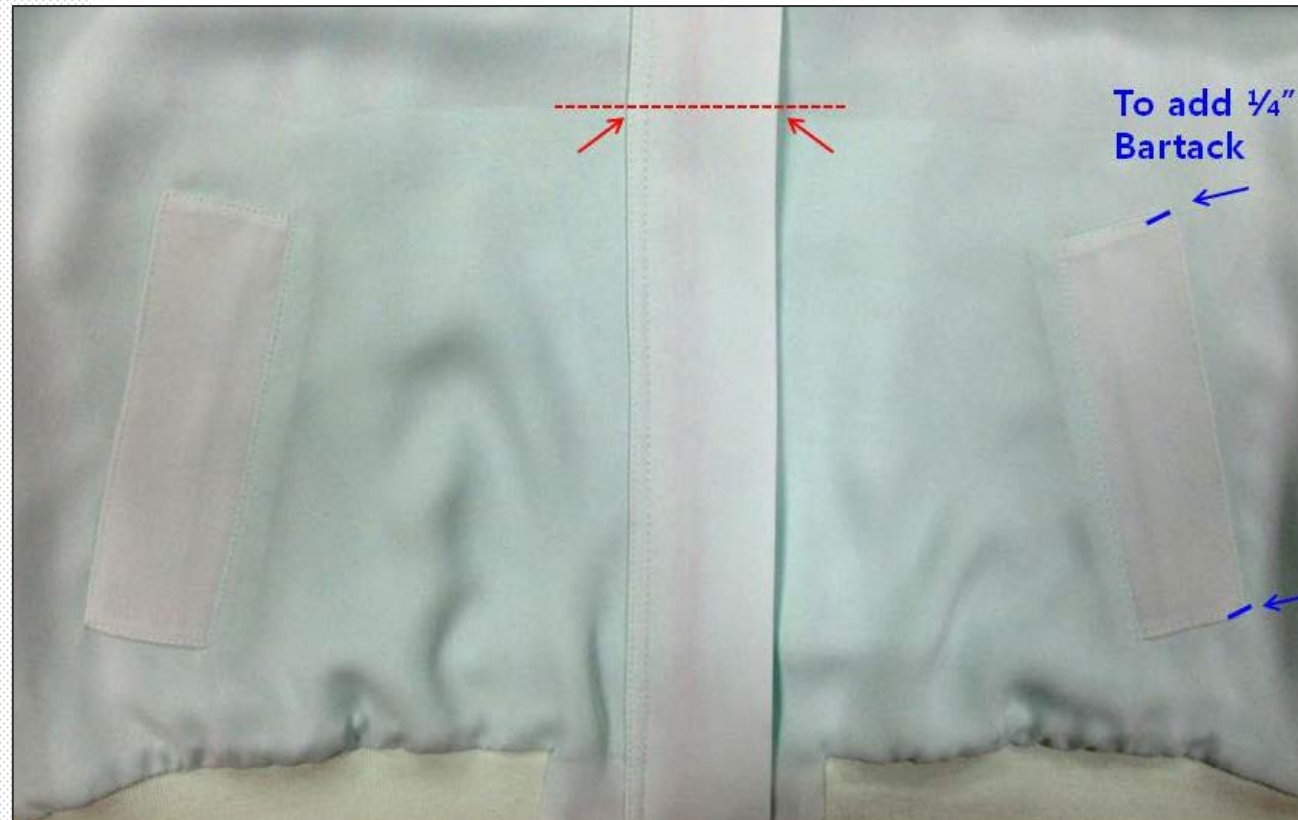
- Welt pocket shape is uneven



Critical Points of Attention

Common Critical Points: Not Acceptable

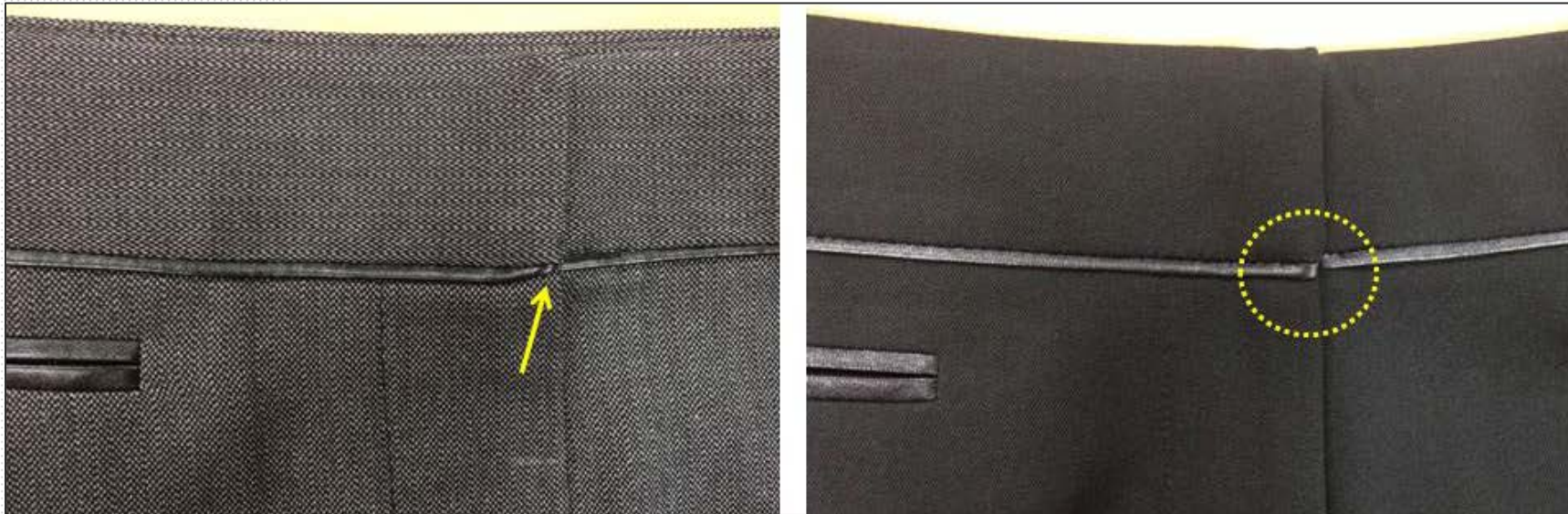
- Pocket bag size, and insertion point is not the same



Critical Points of Attention

Common Critical Points: Not Acceptable

- Piping is not even



Critical Points of Attention

Common Critical Points: Not Acceptable

- Denim details:



Pre-setting beltloops before bartack. Looks poorly executed and doesn't achieve consistent beltloop length



Broken stitches

Asymmetrical stitching execution



Unbalanced topstitch tension

Consistent SPI throughout the garment

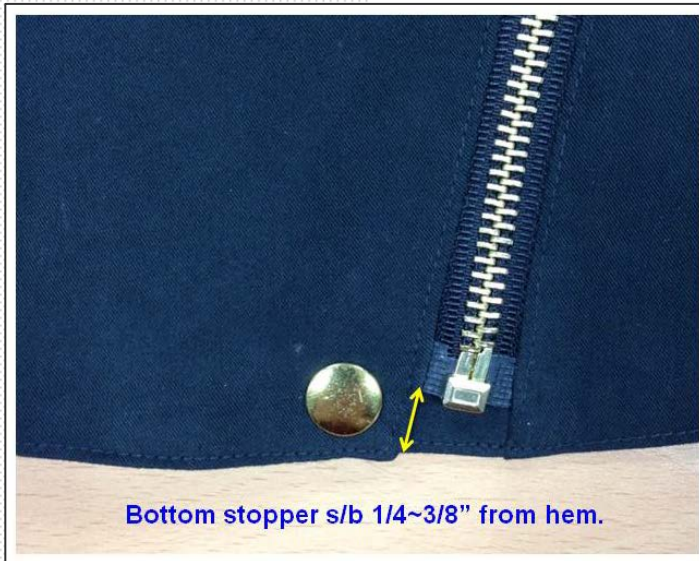


Repairs and loose threads

Critical Points of Attention

Common Critical Points: Not Acceptable

- Zipper is too long for garment
- Zipper shoulder not cause garment sweep to dip down
- Garment should not be stretched to fit zipper
- Zipper length is calculated appropriately to fit garment length:



Critical Points of Attention

Common Critical Points: Not Acceptable

- Elastic twisting inside casing
- Should be tacked at Side seams or caught in seam



Critical Points of Attention

Common Critical Points: Not Acceptable

- Shirring on elastic WB has been set at an angle
- Shirring should be straight up and down

