



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS APPAREL

SWEATERS

*** FOLLOW THE GENERAL MINIMUM CONSTRUCTION
STANDARDS GUIDELINES (MCS).**

**THIS MANUAL CONTAINS GUIDELINES SPECIFIC TO SWEATERS. THESE
SWEATER SPECIFIC GUIDELINES ARE IN ADDITION TO THE GENERAL MINIMUM
CONSTRUCTION STANDARDS GUIDELINES LINES.**

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

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MINIMUM CONSTRUCTION STANDARDS

• SWEATERS

FOLLOW THE GENERAL MINIMUM CONSTRUCTION STANDARDS GUIDELINES.

THREAD & SEAM REQUIREMENTS

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

GENERAL KNITTING REQUIREMENTS:

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

SWEATER SPECIFIC SEAM REQUIREMENTS:

- **Link Seams:** Link join using self-yarn, unless otherwise specified.
- **No seams in binding or taping.**

SWEATER SPECIFIC REQUIREMENTS FOR CUT & SEW (WITH PRE-APPROVAL 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 knit.
- **Ball point needles only.**

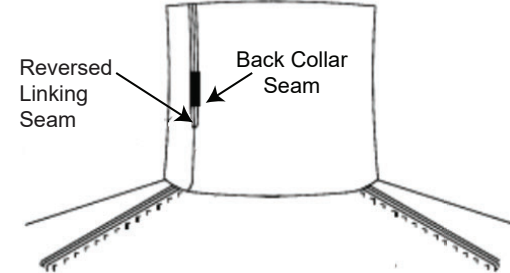
FOLD OVER TRIMS

SINGLE SEAM: FOLD OVER COLLAR OR CUFF

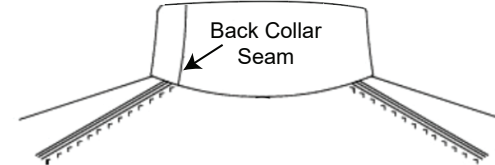
- **Single seam:** placement of seam as specified in tech pack.
- **Reverse linking length:** 2/3 of trim height from top edge, or as specified in tech pack.
- See image: [FOLD OVER TRIM SINGLE SEAM](#)

FOLD OVER TRIM SINGLE SEAM.A1

BACK VIEW: COLLAR UNFOLDED



BACK VIEW: COLLAR FOLDED



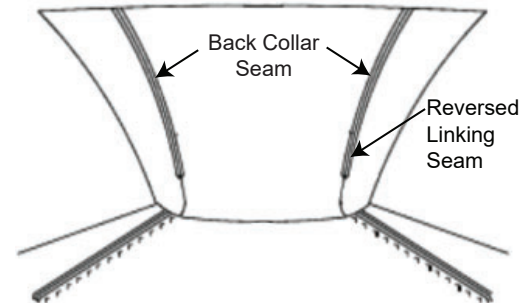
After collar folded down, the back collar seam will be invisible.

DOUBLE SEAM: FOLD OVER COLLAR

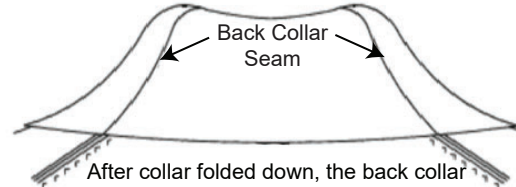
- **Double collar seam:** 2 seams with placement as specified.
- **Reverse linking length:** 2/3 of neck trim height from top edge, or as specified in tech pack.
- See image: [FOLD OVER TRIM DOUBLE SEAM](#)

FOLD OVER TRIM DOUBLE SEAM.A1

BACK VIEW: COLLAR UNFOLDED



BACK VIEW: COLLAR FOLDED



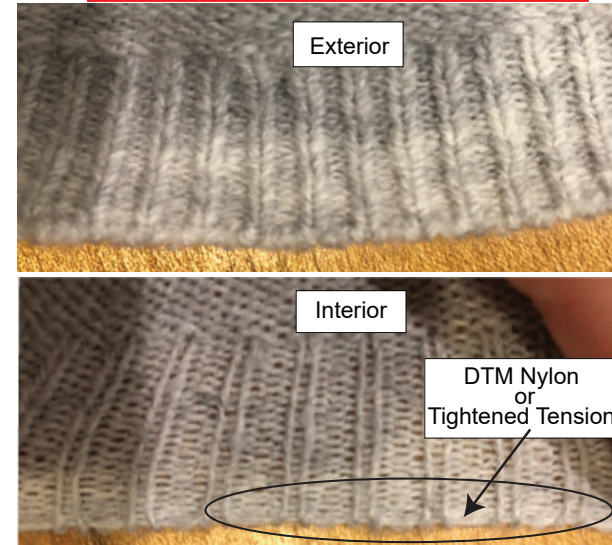
After collar folded down, the back collar seam will be invisible.

SLEEVE & SWEEP BOTTOM TRIM CONSTRUCTION

Rib/Self edges:

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

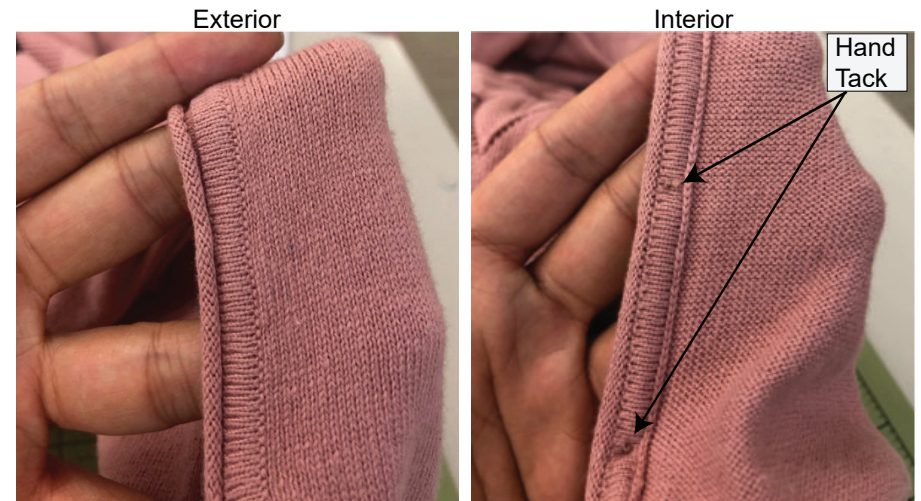
RIB AND-OR SELF EDGE HEMS.AI



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



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

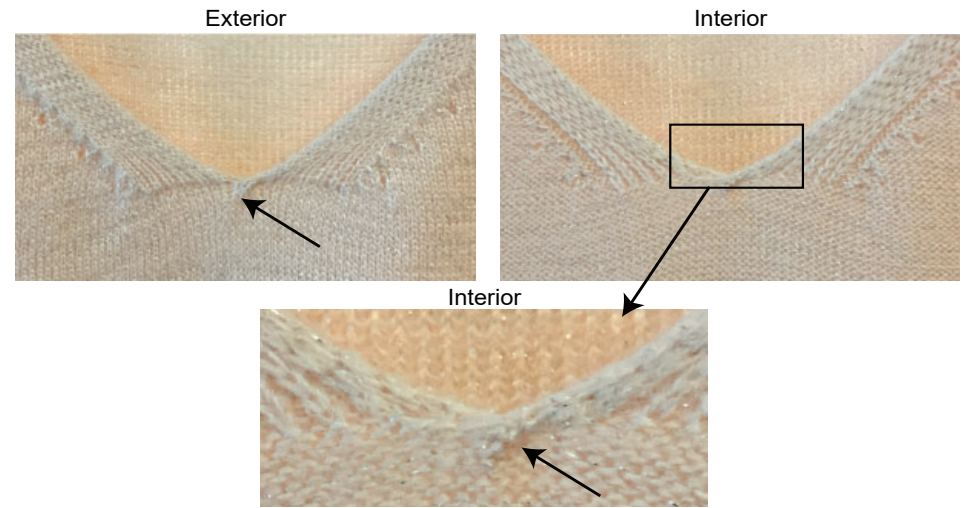


NECKLINE & PLACKETS CONTINUED

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: [ROLLED AND/OR TURN BACK EDGE HEMS](#)

[ROLLNECK EDGE.AI](#)

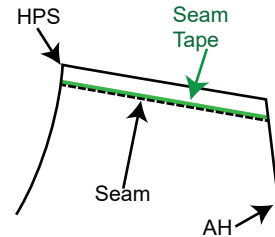


SHOULDER CONSTRUCTION

Forward Shoulder seam join with tape:

- 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.](#)

FORWARD SHOULDER SEAM JOIN WITH TAPE.AI



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](#)

FULLY FASHIONED TO THE BACK SHOULDER SEAM.AI

External



KNIT TO SHAPE ARMHOLE CONSTRUCTION

ARMHOLE WITH SLEEVE

- Saddle: Cast off straight for 1/2 - 3/4" at base of Armhole, or as specified.
- Visible Full Fashioned 2 needles from seam unless otherwise specified
- Sleeve cap: Cast off straight.
- See image: [KNIT TO SHAPE ARMHOLE WITH SLEEVE](#)

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



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](#)

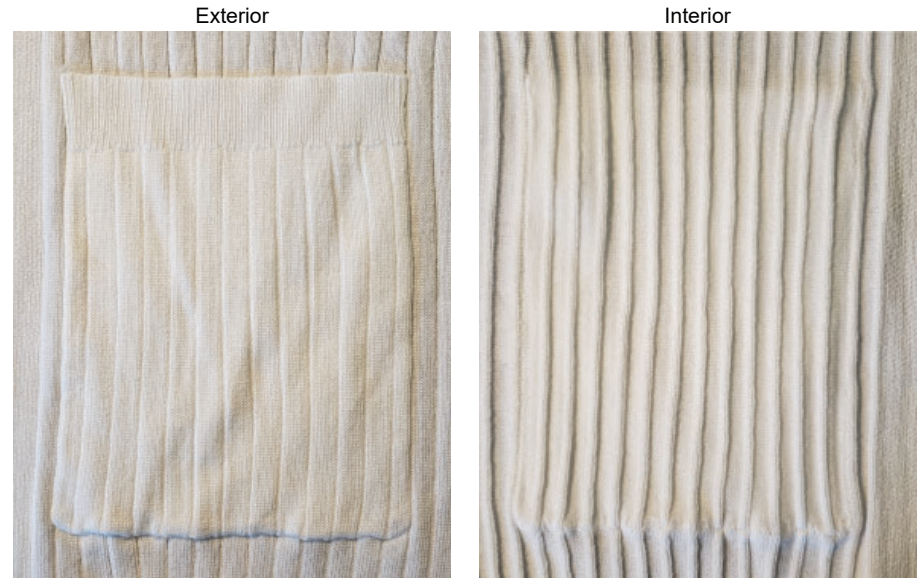


POCKETS

Patch Pocket Attachment:

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

[PATCH POCKET ATTACHMENT.AI](#)



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](#)



STYLING FEATURES

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

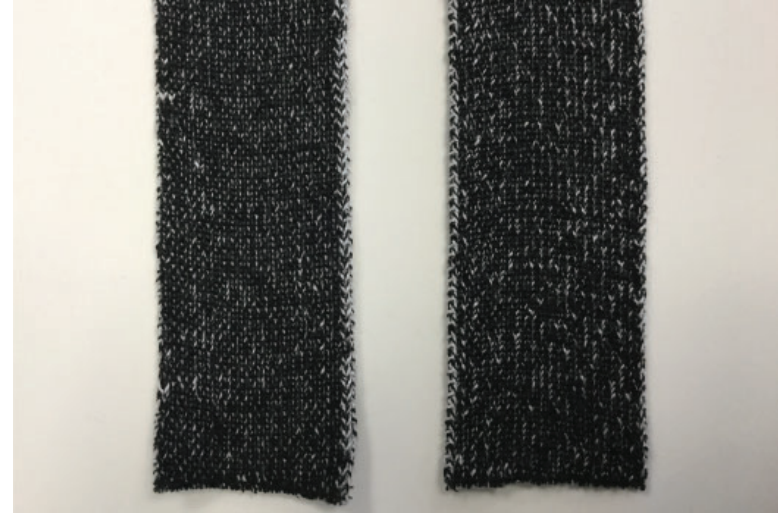


STYLING FEATURES CONTINUED

BELTS:

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

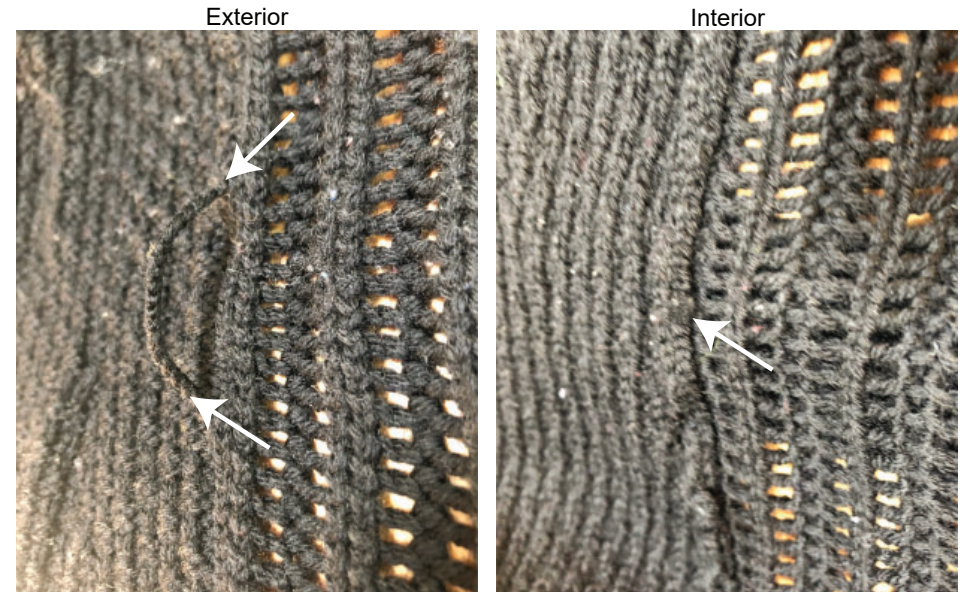
[BELTS.AI](#)
Exterior / Interior



BELT LOOPS:

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

[BELT LOOPS.AI](#)



STYLING FEATURES CONTINUED

SIDE SLITS: Side seam linking secured at top of side slits to avoid unraveling.

- **Knit In:** Clean finished edges with half milano or full needle rib, as specified on DI page. See image: [KNIT IN SIDE SLITS.](#)
- **Linked:** Securely clean join to body using self-yarn, unless otherwise specified. See image: [LINKED IN SIDE SLITS.](#)



[LINKED IN SIDE SLITS.AI](#)
Exterior





MINIMUM CONSTRUCTION STANDARDS

- SWEATERS

STYLING FEATURES CONTINUED

BACK NECK TAPE:

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

BACK NECK TAPE.AI

Exterior



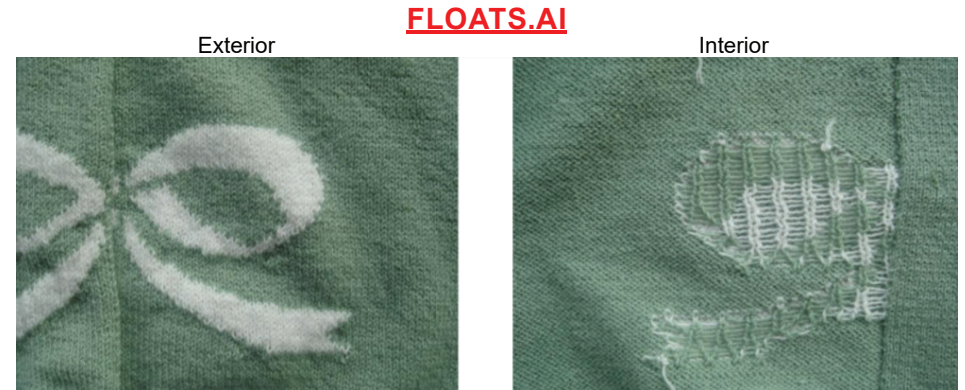
Interior



FLOATS AND TAILS

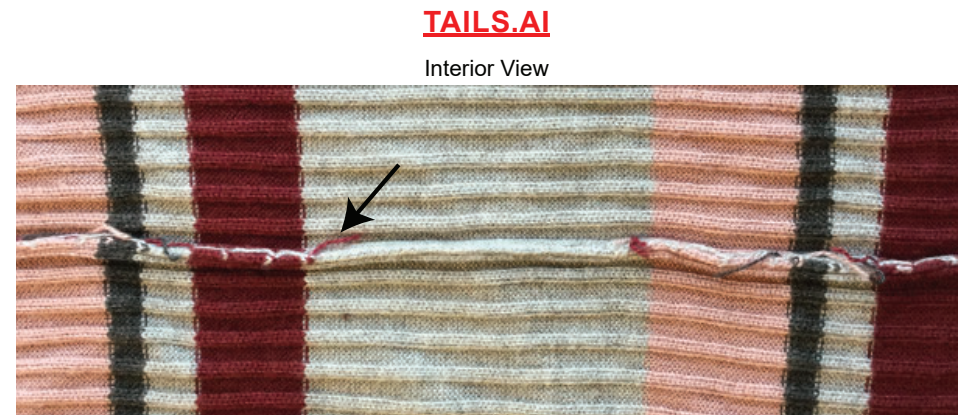
Floats:

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



Tails:

- Tails must be tied securely, woven back, and trimmed to a maximum length of 1/2".
- See image: [TAILS](#)

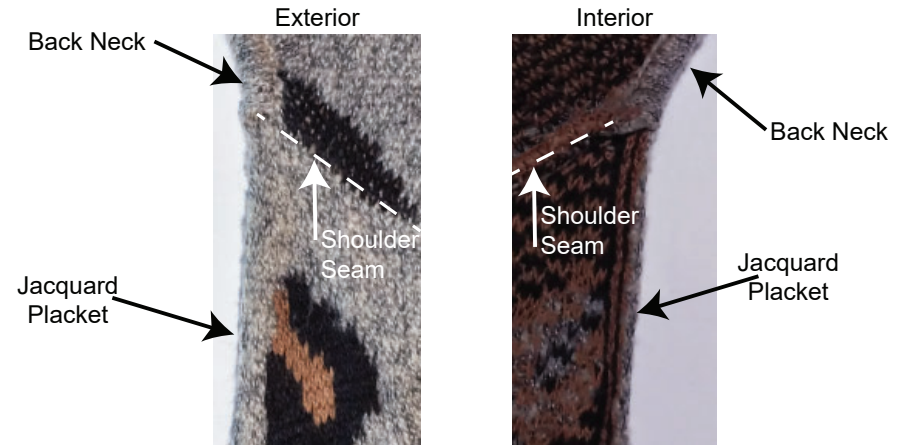


FLOATS AND TAILS CONTINUED

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.
- See image: [JACQUARD PLACKET SELF EDGE](#)

JACQUARD PLACKET SELF EDGE.AI



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 photos of size run samples for stitch pattern/stripe grading approval.

STRIPE MATCHING.AI

