KOHL'S MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS APPAREL

SWEATERS

* FOLLOW THE <u>GENERAL MINIMUM CONSTRUCTION STANDARDS GUIDELINES (MCS).</u>

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.

FOLLOW THE <u>GENERAL MINIMUM CONSTRUCTION STANDARDS GUIDELINES.</u>

THREAD & SEAM REQUIREMENTS

- Follow the **<u>KNIT SPECIFIC REQUIREMENTS FOR THREAD AND SEAMS</u>, see <u>GENERAL MINIMUM CONSTRUCTION STANDARDS GUIDELINES</u>**

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 **<u>WOVEN MINIMUM CONSTRUCTION STANDARDS;</u>** knit panel follows **<u>KNIT MINIMUM CONSTRUCTION STANDARDS</u>**, 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.

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FOLD OVER TRIMS

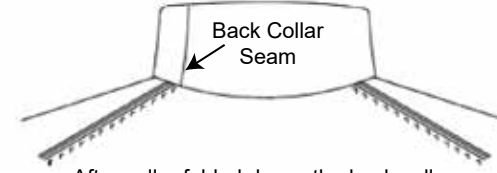### SINGLE SEAM: FOLD OVER COLLAR OR CUFF

- **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.AI

BACK VIEW: COLLAR UNFOLDED

Reversed Linking Seam

Back Collar Seam
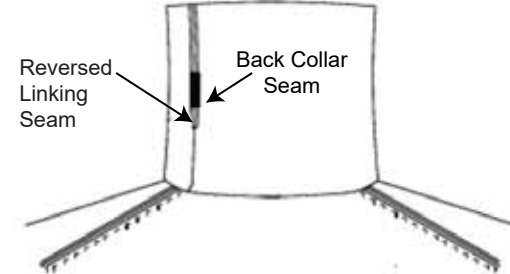
BACK VIEW: COLLAR FOLDED
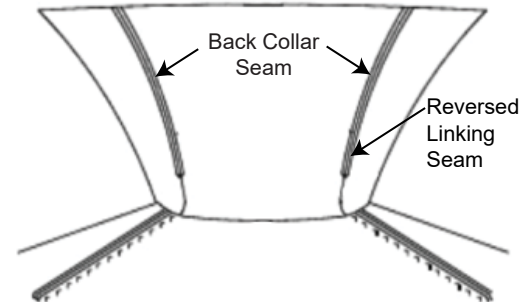
Back Collar Seam

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.AI

BACK VIEW: COLLAR UNFOLDED

Back Collar Seam

Reversed Linking Seam

BACK VIEW: COLLAR FOLDED

Back Collar Seam

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

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3
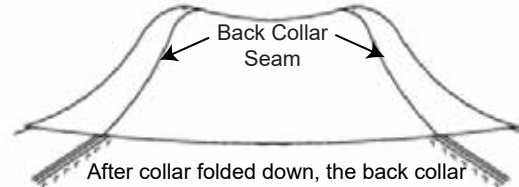
SLEEVE & SWEEP BOTTOM TRIM CONSTRUCTION

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
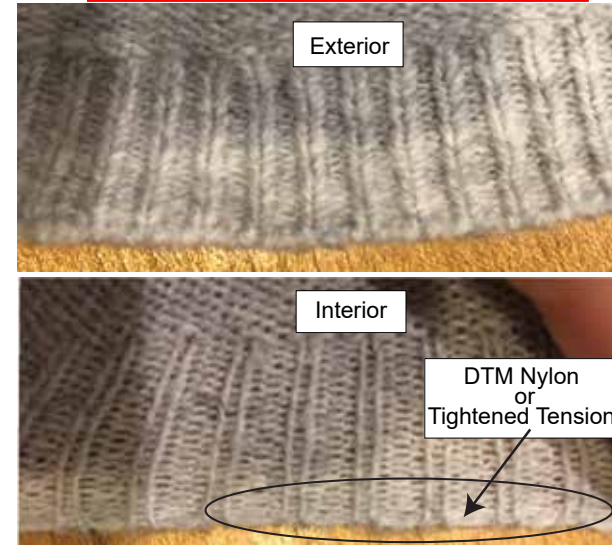
Rolled or Turn Back edges:

- 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

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4

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

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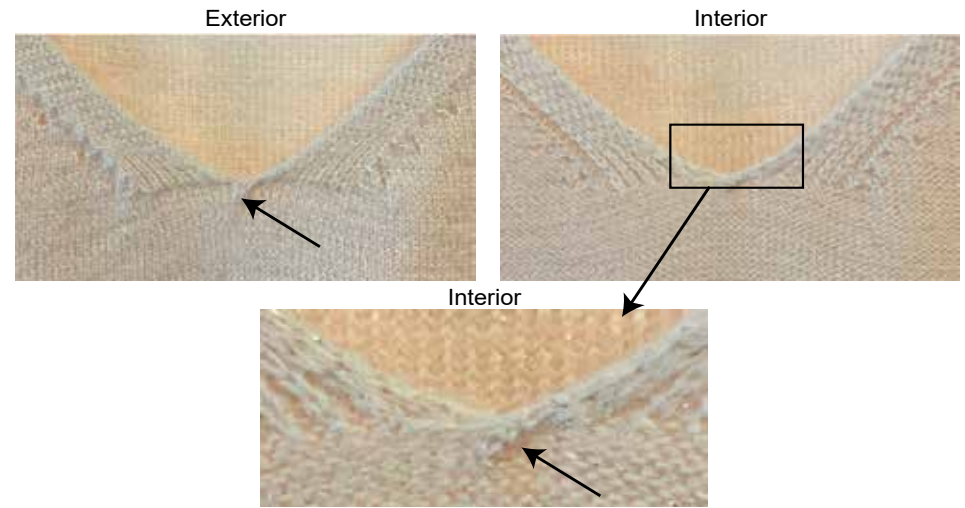**PRIVATE & EXCLUSIVE BRANDS APPAREL**

5

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

Exterior — Interior

Interior

Rollneck:

- Reverse-link join at shoulder seams.
- Hand tack placement as specified.
- See image: **ROLLED AND/OR TURN BACK EDGE HEMS**

ROLLNECK EDGE.AI

Exterior

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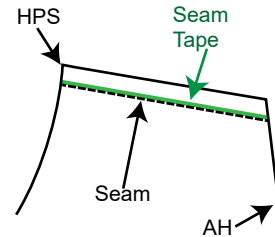**PRIVATE & EXCLUSIVE BRANDS APPAREL**

6

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

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7

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

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8

POCKETS

Patch Pocket Attachment:
- 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

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9

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

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STYLING FEATURES CONTINUED

BELTS:
- Self knit, clean finished ends; no raw edges.
- See image: **BELTS**
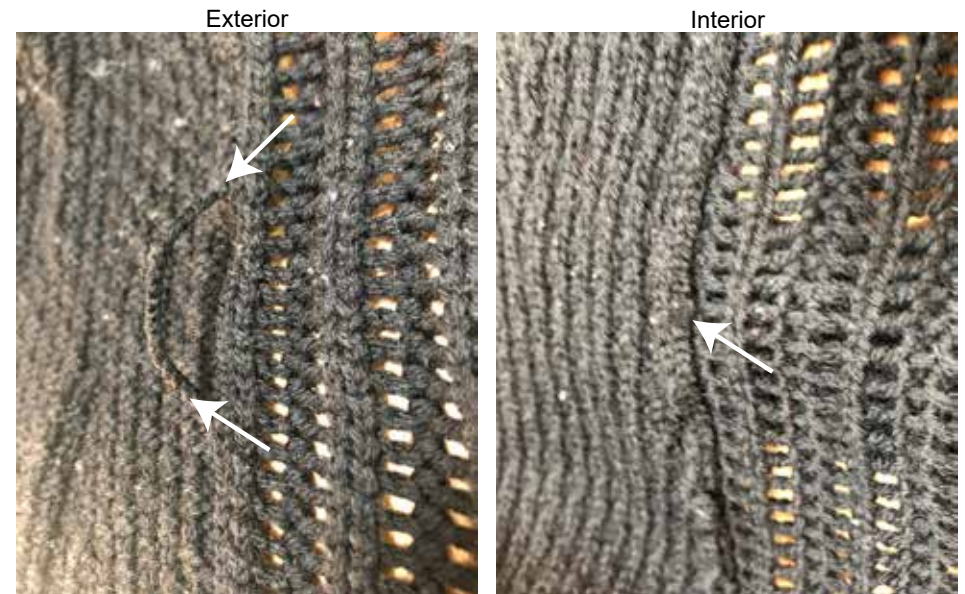
BELTS.AI
Exterior / Interior

BELT LOOPS.AI

Exterior   Interior

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

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11

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.**

KNIT IN SIDE SLITS.AI

Exterior   Interior

LINKED IN SIDE SLITS.AI

Exterior

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12

STYLING FEATURES CONTINUED

BACK NECK TAPE.AI

BACK NECK TAPE:
- **Attachment:** clean join to body securely.
- See image: **BACK NECK TAPE**.

Exterior

Interior

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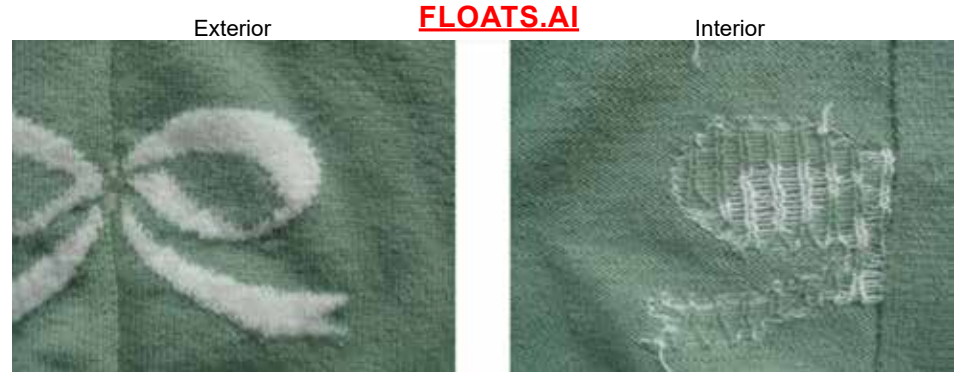Revised Date: 12/9/2024

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13

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.
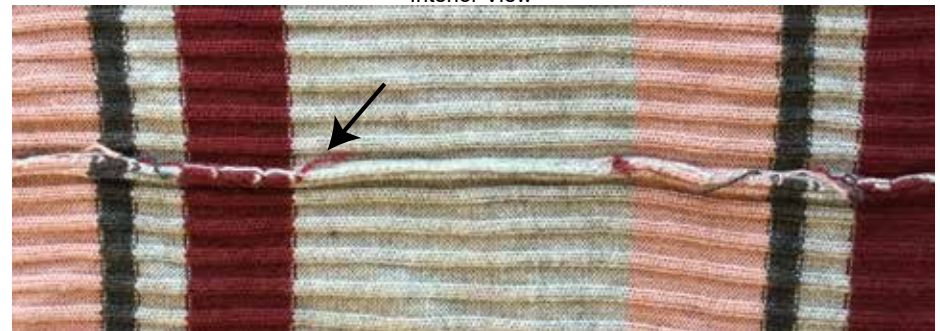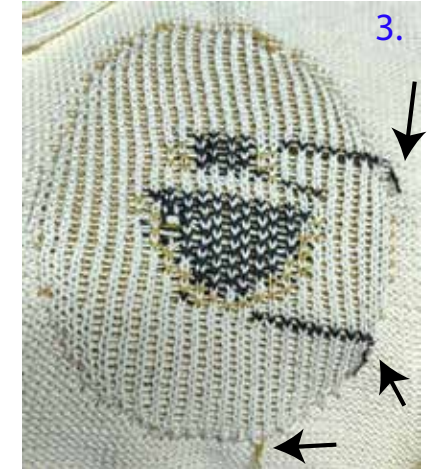- See image: **FLOATS**

Tails:
- ALL Yarn tails must be first tied securely in a knot, then woven back at interior, and finally trimmed to a maximum length of ½".
- No knots or yarn tails should be visible on exterior.
- See image: **TAILS**

FLOATS.AI

Exterior | Interior

TAILS.AI
Interior View

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

1.
2.
3.

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14

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

Exterior   Interior

Back Neck   Shoulder Seam   Jacquard Placket   Back Neck   Shoulder Seam   Jacquard Placket
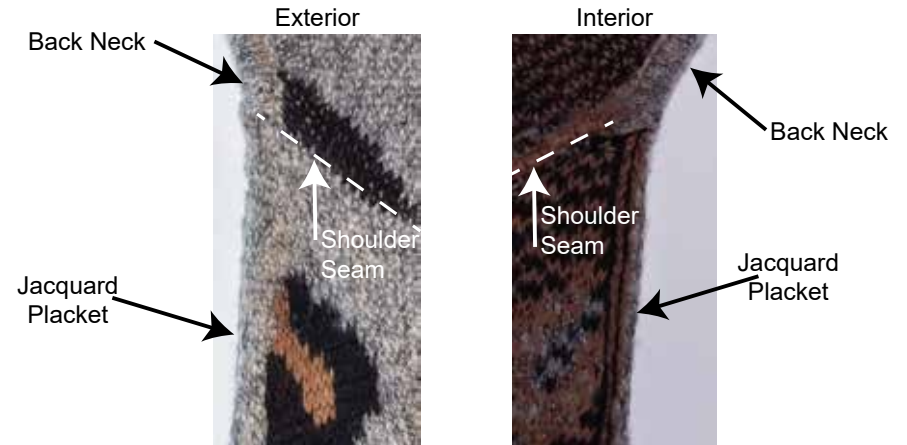
STITCH PATTERN PLACEMENT & MATCHING

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

Exterior   Interior

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15