



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS APPAREL

LEATHER SUEDE & PU

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

For constructions not called out in this section, please follow woven's MCS where applicable.

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MINIMUM CONSTRUCTION STANDARDS

- LEATHER, SUEDE & PU

THREAD REQUIREMENTS

Polyester thread is the most common thread quality used for leather & suede garment.

- **Leather seaming:** Polycore, Tex 60.
- **Alternative Overedge & Coverstitch:** Textured Polyester, Tex 70
- **Decorative topstitching:** Polycore; Tex 90
- **Threads must be trimmed & removed from garment.**
- **As a general rule, decorative thread** can be one size heavier than the thread used to sew seams.
- **Bobbins:** bobbin's thread usually one size smaller than the topstitch thread.

SPI REQUIREMENTS

TOP STITCHING

- 8 SPI +2
- Topstitching with 4 stitch over run in an inconspicuous location.
- Needle for leather: Tripoint or Diamond point #18

INTERNAL SEAMS

- 8 SPI +2for Leather
- 10SPI +2 for Lining
- Seams with zipper to be set with single needle lockstitch.
- Stitches must be secured at start and stop, overlapping with a minimum of 4 stitches.



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SEAM ALLOWANCE GUIDELINES

Seam allowance will vary due to thickness of the fabric and manufacturing needs.

Recommended seam allowance as below:

- 1/4" at neckline of front and back bodice (notch required)
- 1/4" at collar and collar stand at neckline seam (notch required)
- 1/4" at seam joining collar stand with collar (notch required)
- 1/2" at all other seams, including outside edge of collar (no notch required)

ADDITIONAL INFORMATION

Shaping through seams

- we recommend avoiding darts and instead using princess seams, side panels and yoke seams to achieve desired shape.

Lining Fabrication recommendations

- For general use: synthetic polyester
- For outerwear: poly twill
- For pocketing: microfiber

CONSTRUCTION REQUIREMENTS

WAISTBAND - LEATHER/SUEDE ONLY WB

- **Exterior:** Waistband seam is clean finished w/Chainstitch ISO 401.
- **Interior:** Waistband seam is raw edge.

IMAGE L-16 LEATHER WB

Exterior waistband

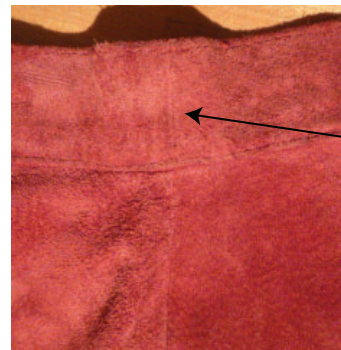


Folded edge, clean finished

Interior waistband



Raw edge



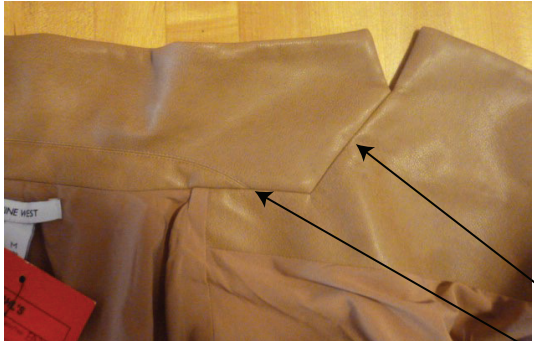
Side seams on waistband split open, align with skirt/pant side seam

IMAGE L-17 COLLAR AND LAPEL SEAMS SPLIT OPEN

CONSTRUCTION REQUIREMENTS

COLLAR SEAMS - LEATHER/SUEDE/PU

- Collar/neck seams split open and kissing. Stitched closed.



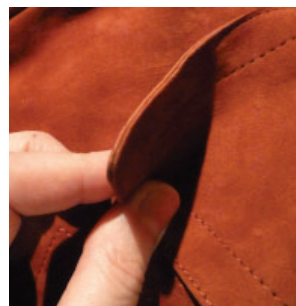
Collar/neck seams split open and kissing
--Stitch closed

CONSTRUCTION REQUIREMENTS

RAW EDGES ON ALL 2-PLY OPENING EDGES - LEATHER/SUEDE ONLY

- Raw edges on collar edge, front opening and hem. Edgestitch and 3/8" topstitch w/Chainstitch ISO 401

IMAGE L-18 RAW EDGE ON REAL SUEDE/LEATHER



Raw edges on collar



Raw edges edgestitched together on unlined jacket

CONSTRUCTION REQUIREMENTS

RAW EDGES ON LEATHER/SUEDE ONLY

- **Seaming:** Raw edge on exterior and interior overlapped 3/8" in 1/8" DNL.

IMAGE L-21 LEATHER/SUEDE OVERLAPPED SEAMS

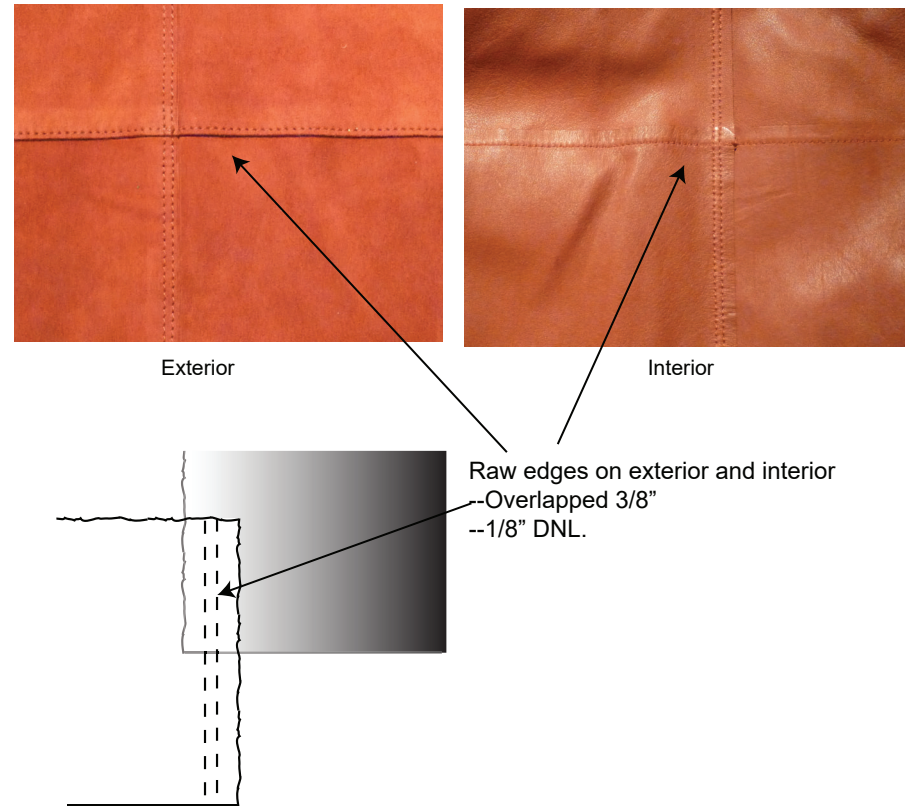


IMAGE L-19 FUSIBLE "BLINDHEM" IN LINED SKIRT

CONSTRUCTION REQUIREMENTS

BLIND HEM - LINED SKIRT LEATHER/SUEDE/PU

- 3" wide fusible folded edge 1/2" below hem cut edge to create blind hem
- Double sided adhesive fusible tape to hold seam allowances open
- Lining attached before applying fusible w/Chainstitch ISO 401

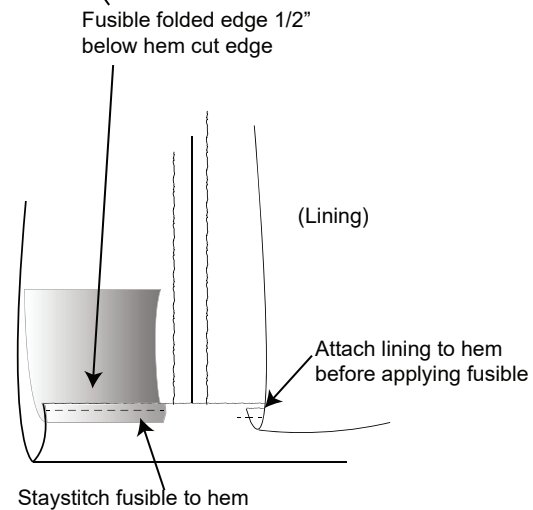
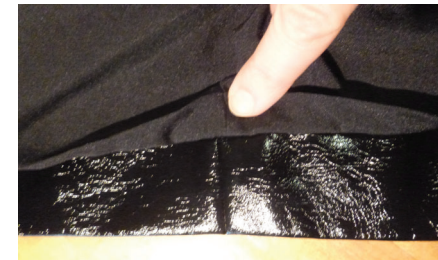


IMAGE L-20 HEMS**CONSTRUCTION REQUIREMENTS****FUSIBLE APPLICATION LEATHER/SUEDE/PU**

- Single sided fusible extends 1/2" above hem
- Fusible stitched to hem edge with chainstitch ISO401.

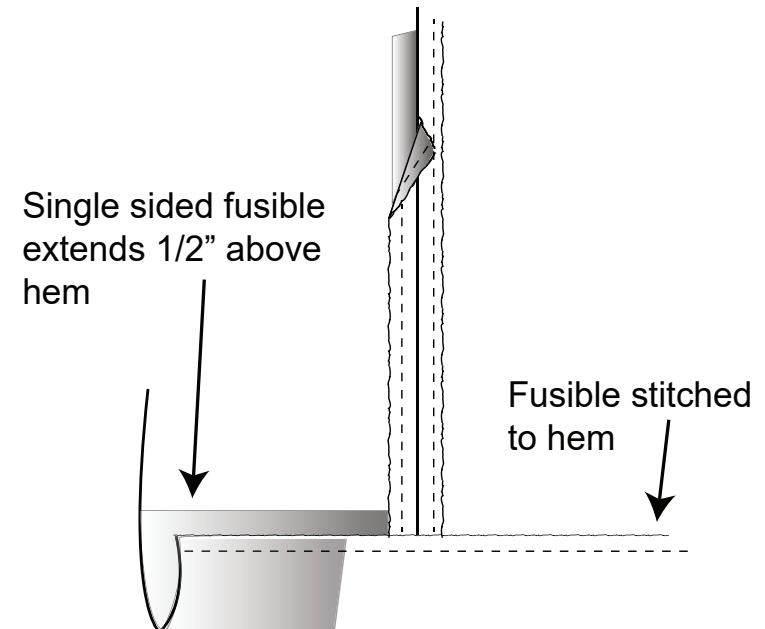
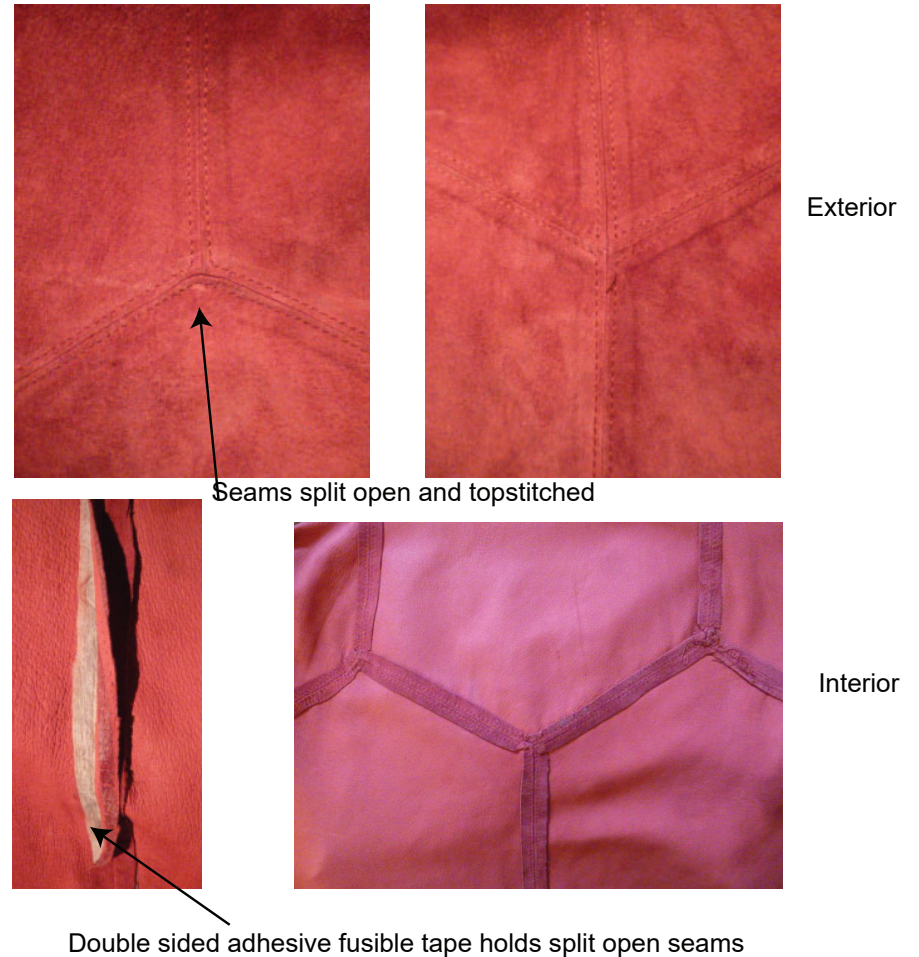


IMAGE L-22 GLUED SEAMING

CONSTRUCTION REQUIREMENTS

SEAMS SPLIT OPEN - LEATHER/SUEDE/PU

- Split open seams. Double sided fusible fused to seam allowance and stitched to seam allowance w/Chainstitch ISO 401



CONSTRUCTION REQUIREMENTS

SEAMS SPLIT OPEN - LEATHER/SUEDE/PU

- Split open seams. Double sided fusible fused to seam allowance and staystitched to seam allowance

IMAGE L-23 SPLIT OPEN SEAMS NO TOPSTITCHING



Split open seams
--1/4" Double sided fusible fused to seam allowance
--Staystitch to seam allowance before fusing





MINIMUM CONSTRUCTION STANDARDS

- LEATHER, SUEDE & PU

IMAGE L-24 UNLINED GARMENT W/BINDING OVER SEAM!

CONSTRUCTION REQUIREMENTS

UNLINED SEAMS WITH BINDING - LEATHER/SUEDE

- Topstitch binding straddles seam w/Chainstitch ISO 401



Exterior seam



Interior seam

TRIMS/FINDINGS

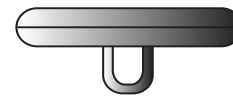
BUTTONS

- Button must have a shank (thread and/or as part of the button) to accommodate the fabric thickness when closure is fastened. The button should rest just above the buttonhole when fastened.
- Buttons must be reinforced, according to their use and the fabric type, with interfacing and/or another button.

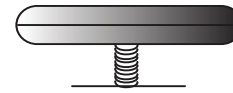
BUTTONHOLES

- Buttonholes must be sized according to the button size, button thickness and the fabric thickness.

IMAGE L-70: BUTTON/ BUTTONHOLE



Shank Button



Button w/ Thread Shank

Bound Buttonhole
Exterior View



Buttonhole
Exterior View



SNAPS

- Snaps must be applied with washers as reinforcement.
- All eyelets must be reinforced with backing material or 2-ply self fabric.

IMAGE L-72: SNAPS

Snap with Washer



Washer/ Snap Backing



BUTTON REINFORCEMENT

- Buttons must be reinforced, according to their use and the fabric type, with another small flat button.
- Backer Button: small, flat button sewn at underneath of self top button at inside as reinforcement.
- Round self fabric piece (leather or suede) can be used instead of back button.

IMAGE L-71: BUTTON REINFORCEMENT

Backer Button



Self fabric reinforcement

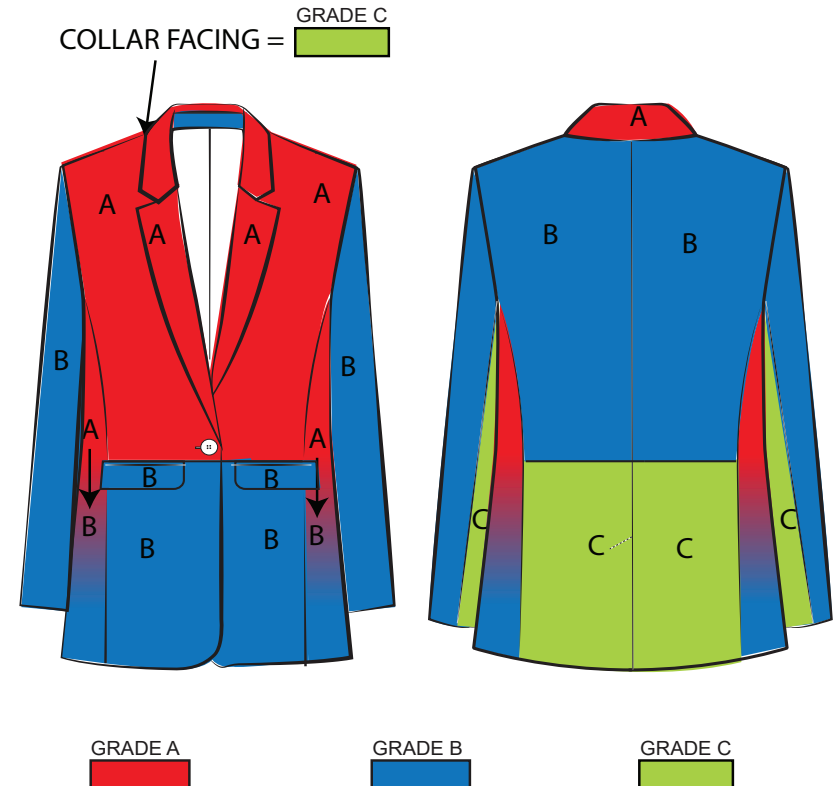


IMAGE L-50: SKIN GRADE LAYOUT (LADIES)

CUTTING REQUIREMENTS FOR GENUINE LEATHER & SUEDE (LADIES)

Must cut as per skin grade layout instruction:

- **Grade A:** Highest skin quality for main front bodice, facings of collar & CF opening upper panel.
- **Grade B:** Second highest quality for bodice such as under layer of collar, front and back yokes, main back bodice & main sleeve outer side panel.
- **Grade C:** Lowest grade quality for any areas that are less visible such as lower part of side panels, lower part of CF inside facing and inner side of sleeve panels.



CUTTING REQUIREMENTS FOR GENUINE LEATHER & SUEDE (MEN'S)

Must cut as per skin grade layout instruction:

- **Grade A:** Highest skin quality for main front bodice, front yokes, facings of collar & upper level of front side sleeves.
- **Grade B:** Second highest quality for bodice such as under layer of collar, facing of collar stand, CF upper portion facings, pocket openings, back yokes, main back bodice & main sleeve upper back side panels.
- **Grade C:** Lowest grade quality for any areas that are less visible such as outer layer of collar stand, lower part of CF facings, lower part of side panels on back bodice and inner side of back sleeve panels.

IMAGE L-10: SKIN GRADE LAYOUT (MEN'S)

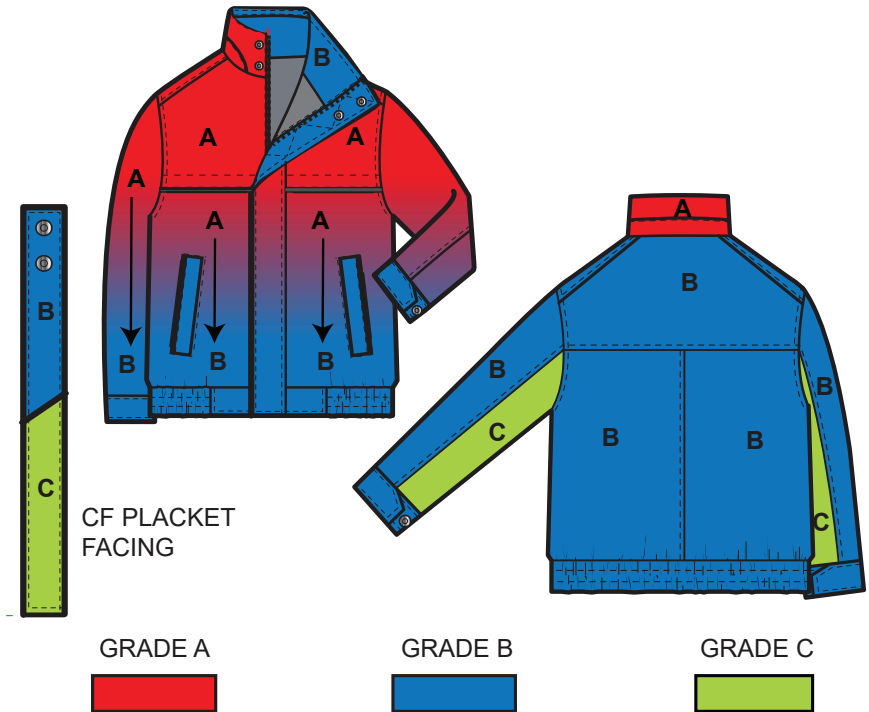


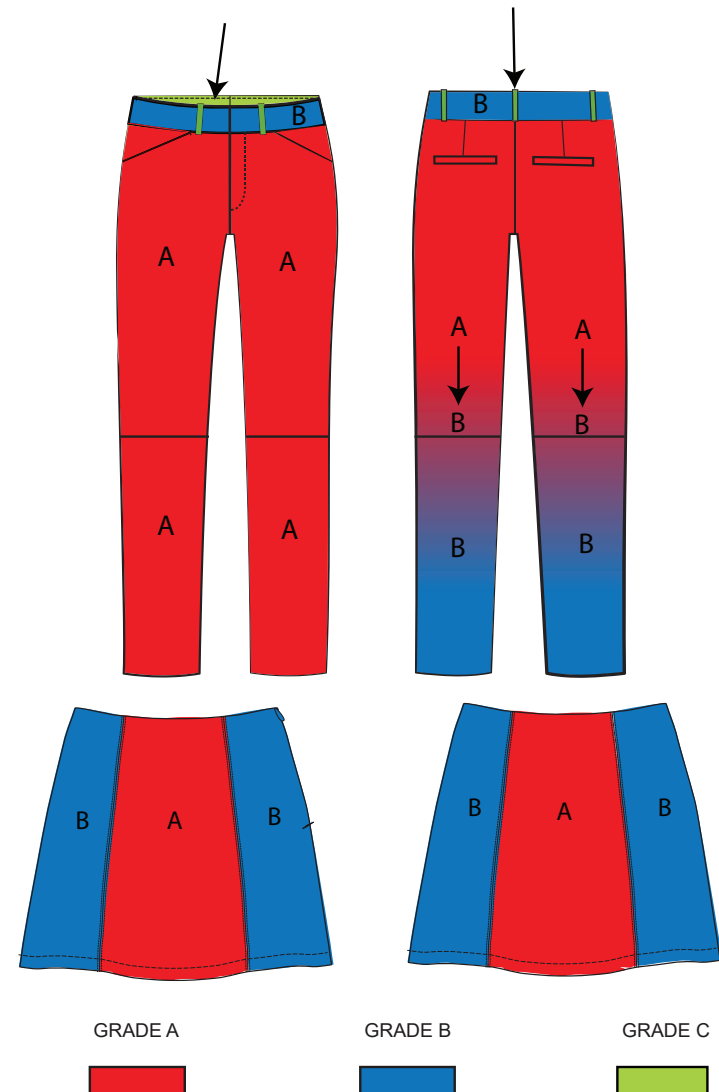
IMAGE L51: SKIN GRADE LAYOUT (LADIES)

BELT LOOPS AND WAISTBAND FACING =  GRADE C

CUTTING REQUIREMENTS FOR GENUINE LEATHER & SUEDE (LADIES)

Must cut as per skin grade layout instruction:

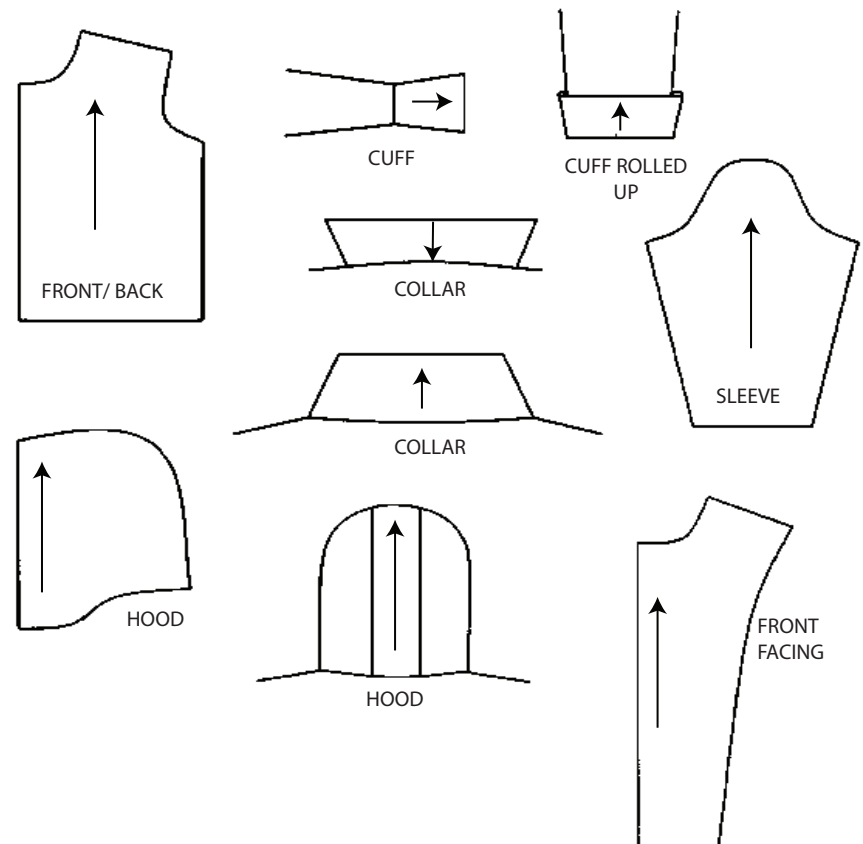
- **Grade A:** Highest skin quality for main front bodice, facings of collar & CF opening upper panel.
- **Grade B:** Second highest quality for bodice such as under layer of collar, front and back yokes, main back bodice & main sleeve outer side panel.
- **Grade C:** Lowest grade quality for any areas that are less visible such as lower part of side panels, lower part of CF inside facing and inner side of sleeve panels.



ADDITIONAL CUTTING REQUIREMENTS FOR SUEDE :

- Must cut one way direction, either NAP UP or NAP DOWN.
- Example: grainline direction for suede nap up cut.

IMAGE L-2: GRAINLINE FOR SUEDE NAP UP



ADDITIONAL CUTTING REQUIREMENTS FOR SUEDE :

- Must cut one way direction, either NAP UP or NAP DOWN.
- Example: grainline direction for suede nap down cut.

IMAGE L-12: GRAINLINE FOR SUEDE NAP DOWN

