



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS APPAREL

SWIMWEAR

Private Brands

Women's/ Juniors/ Girls 0-16

Swimwear Made From High Stretch Fabrications

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

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MINIMUM CONSTRUCTION STANDARDS

• SWIMWEAR

SECTION 1: THREAD REQUIREMENTS

Needle/Bobbin Thread Quality: Poly wrap/Poly Core

Looper Thread Quality: Texturized Nylon or Texturized Polyester

Buttonhole Thread: Needle/Bobbin = Poly Wrap/Poly Core or Nylon
Tex 24

Sewn-on Metal Trims (buttons, snaps, hook/eye): Poly Wrap/Poly Core or Nylon. Must use Lockstitch if machine sewn.

Beading/Sequins: Poly Wrap/Poly Core or Nylon

- No Monofilaments.
- Tex size as specified.

Internal Thread Color:

- Must be DTM ground unless otherwise specified.
- Contrast color is subject to Design approval.

Needle/Bobbin Thread Size

Looper Thread Size

Light Weight Lycra/Spandex up to 200 g/m2
Heavy Weight Lycra/Spandex > 200 g/m2

= or < Tex 24
= or < Tex 30

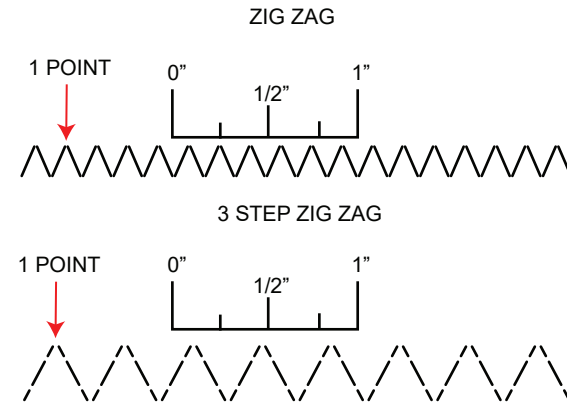
Minimum Thread Size Given - size up to next Tex if not available for thread quality required.

SECTION 2: SPI REQUIREMENTS

SPI may need to be adjusted based on elasticity of the fabric.

- Overlock/Joined Seams = 14-16 SPI, 2N 4 Thread Overedge (ISO 514)
- Neck openings, leg openings, Empire seams, Hems that fit tight against body/dressform = 14-16 SPI
- Bindings and Straps = 14-16 SPI
- Waists/Elastic Openings = 14-16 SPI
- Zig zag should have 6-7 points per inch +/- .5 point (IMAGE T-1)
- 3 Step Zig zag should have 3 points per inch +/- .5 point (IMAGE T-1)
- Ball point needles only
- Multiple needle topstitch must be parallel unless otherwise specified.

IMAGE T-1: ZIG ZAG SPI REQUIREMENTS



SECTION 3: SEAM REQUIREMENTS

General Seams: Mock Safety Stitch (ISO 512) or 2N 4 Thread Over-edge (ISO 514).

- Ends of stitches must be secured at start and stop with 5-6 stitch back-tack, overlapping 1/2".

Coverseam/Coverstitch: Ends of stitching must be secured with SN line tack if not enclosed in a seam. Line tack width = topstitch width.

- Circular Finish (IMAGE T-2)
- Raw Edge Finish (IMAGE T-3)
See Diagram 'IMAGE 1: Overedge Seams - End Finishing' if Side/Underarm Seam Construction = Overedge ISO 503, 504, 505, 514.
Mock-Safety Stitch ISO 512.
Safety Stitch ISO 515, 516.
- No Splice seams in binding or taping.

IMAGE T-2: CIRCULAR COVERSTITCH/COVERSEAM TACK

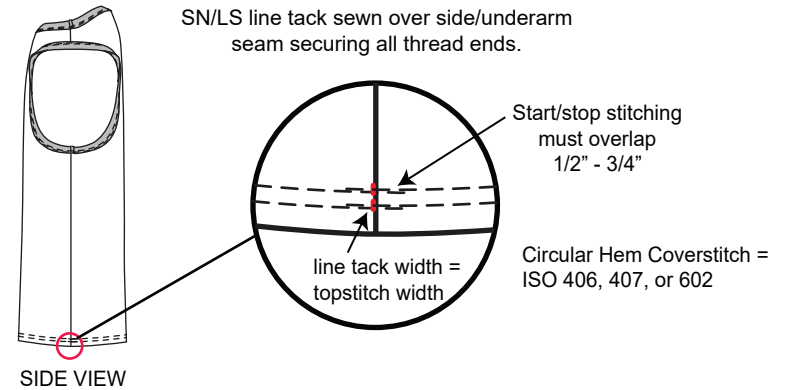
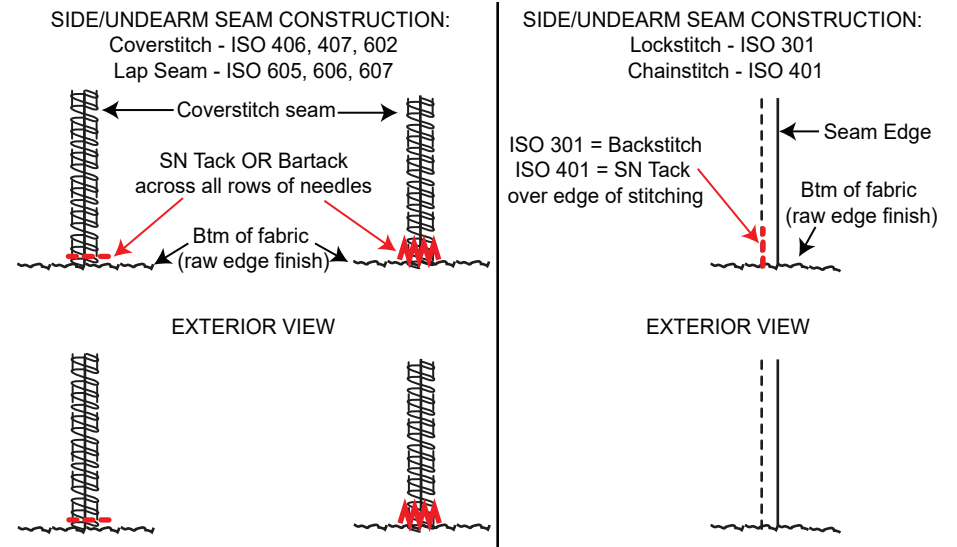


IMAGE T-3: RAW EDGE HEMS - SIDE/UNDERARM SEAM FINISHING

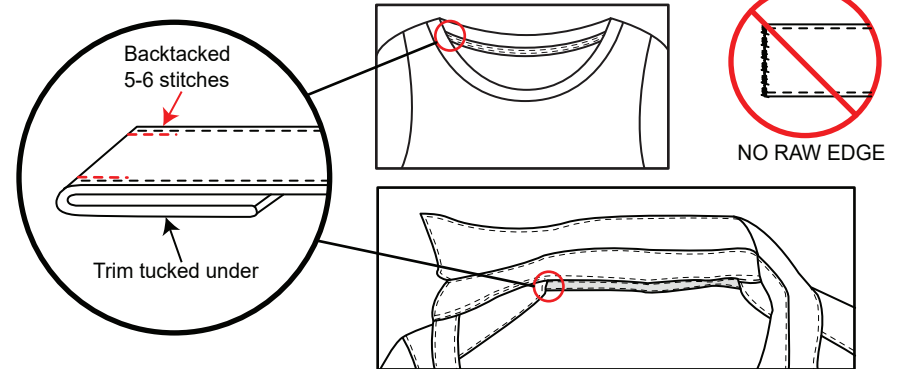


SECTION 4: CONSTRUCTION TOPS

NECKLINE/PLACKET/SHOULDER/SIDE SEAMS:

- **Binding/Taping** ends must be tucked under and have 5-6 stitch back-tack. Seam must be entirely covered by taping/binding and not visible along edges. (IMAGE T-4)
- **Neck Stretch** Product must comply with minimum neck stretch standards.

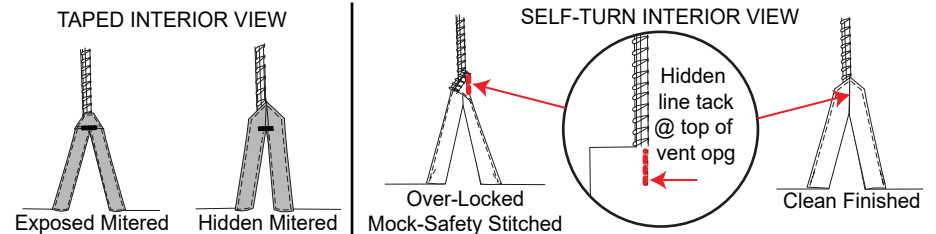
IMAGE T-4: BINDING/TAPING - FINISHING



BOTTOM HEM/OPENINGS:

- **Vents/Slits** must be overlocked, taped or clean finished as specified. (IMAGE T-5)
- **Binding/Taping** must be continuous piece.

IMAGE T-5: VENTS/SLITS FINISHING



STYLING FEATURES:

- **Elastic Openings** should be stitched with chain stitch (ISO 401) or 2N bottom coverstitch (ISO 406).

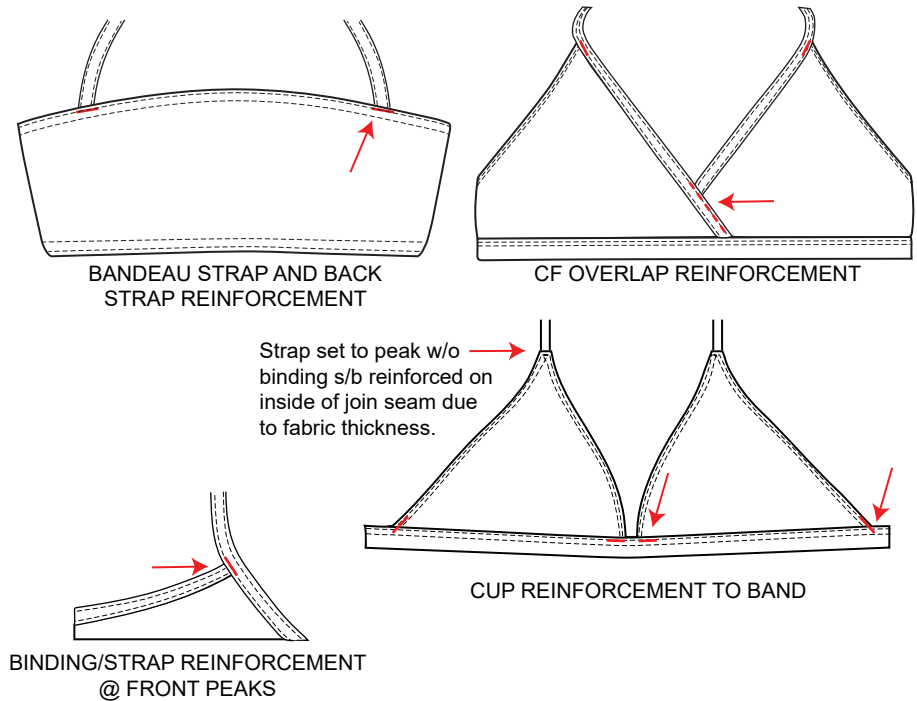
SECTION 4: CONSTRUCTION TOPS CONT.

REINFORCEMENTS:

Tacks = 28 stitch tacking machine either set to bartack (zig-zag) or line tack (straight) configuration. Sewing tacks on SN Lockstitch matching w/ backstitch is not acceptable tacking method.

- **Strap attachment to body:** Bartack at front and back. (IMAGE T-6)
- **CF Cup Overlap:** SN Lockstitch over overlap to hold modesty point in place. Tack length = overlap width. (IMAGE T-6)
- **Cup attachment to band/body:** Tack cups to band at neckline and armhole. (IMAGE T-6)

IMAGE T-6: SWIM REINFORCEMENT REQUIREMENTS



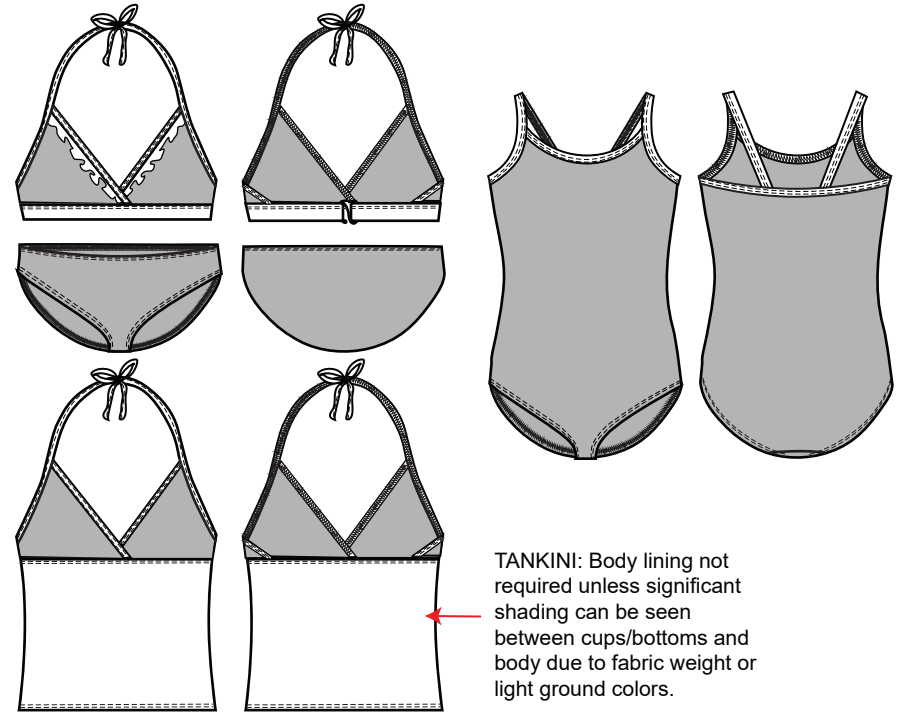
SECTION 4: CONSTRUCTION TOPS CONT.

LININGS:

- Fully lined front and back. (IMAGE T-7)
- Fabric Weight <160g/m2 with black ground or printed with only small areas of white print:
 - Linings required only on front panels.
 - Must be reviewed by PM for approval.

IMAGE T-7: LINING REQUIREMENTS

LININGS REQUIRED ON FRONT & BACK PANELS



■ = LINED AREA

□ = UN-LINED AREA

SECTION 4: CONSTRUCTION BOTTOMS

BOTTOM HEM/OPENINGS:

- **Hems** must be circular finished unless otherwise specified.
- **Vents/Slits** must be overlapped, tapes of clean finished as specified. (IMAGE T-5)
- **Binding/Taping** must be continuous piece.
- **Raw Edge** hems as side seams must be tacked or backstitched at bottoms of raw edge so stitching cannot unravel. (IMAGE T-3)

SECTION 4: CONSTRUCTION BOTTOMS CONT.

COVERSTITCH/COVERSEAM:

- Circular hem must overlap 1/2" at side/underarm seam location with SN line tack sewn over side/underarm seam securing all thread ends. Line tack width = topstitch width (IMAGE T-2)

WAISTBAND:

- **All Chainstitch Seams (ISO 401)** must be secured with a lockstitch (ISO 301) at start/stop with a minimum of 2-3 back stitches or bart-ack.
- **Bounded/Set-In Waistband** closed at wearers left side. Fold Seam Allowance to back and tack. Tack width equals waistband height.

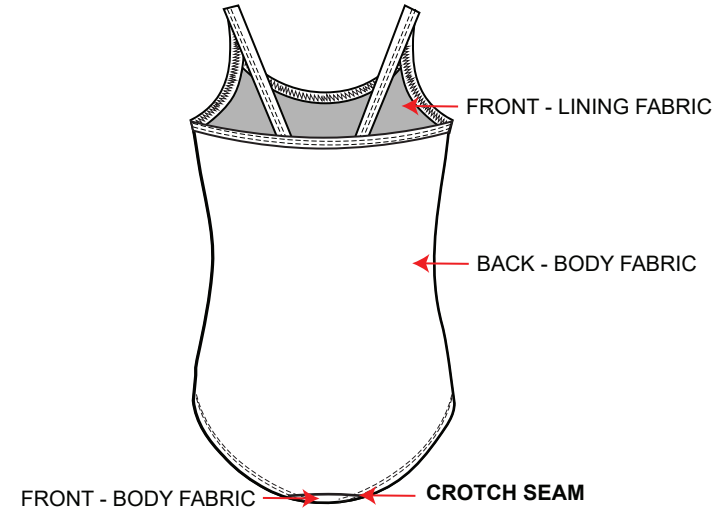
LEG OPENINGS:

- Should be symmetrical from right leg to left leg. **NO** greater than 1/4" difference in total circumference from right to left leg.

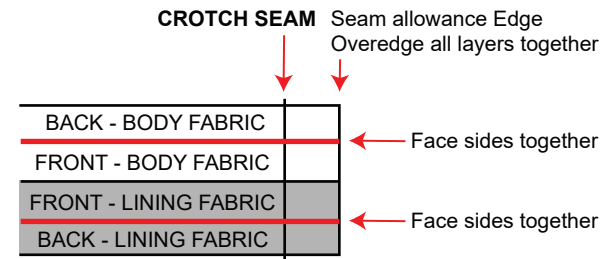
LININGS:

- Fully lined front and back. (IMAGE T-7)
- Crotch Seam: All layers are 2N 4 Thread Overedge (ISO 514) together. Seam is clean finished on lining side, lining is sewn to body. (IMAGE T-8)

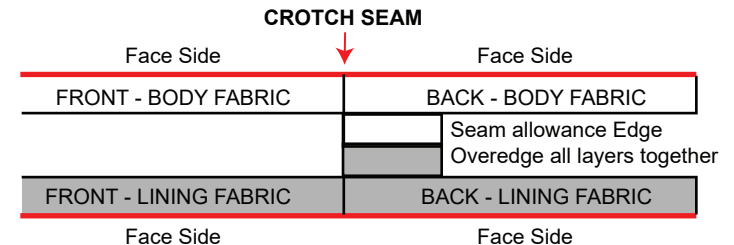
IMAGE T-8: CROTCH SEAM: ALL LAYERS SEWN TOGETHER



CROSS-SECTION VIEW OF CROTCH SEAM
ORDER OF LAYERS FOR SEWING



CROSS-SECTION VIEW OF CROTCH SEAM
LAYERS OPENED AFTER SEWING



SECTION 5: TRIMS/FINDINGS

All Trims must be Chlorine and Ultraviolet (UV) Resistant

Interlining/Backing, Elastic, Fasteners and Zipper Suppliers: Refer to TD. See Preferred Suppliers List for Sourcing requirements.

Internal Component Trim Color: (Elastic, Interlinings, reinforcement tapes, etc)

- White for light colors unless there is 'show or grin-through' problem, then use beige. Black or gray for dark ground.

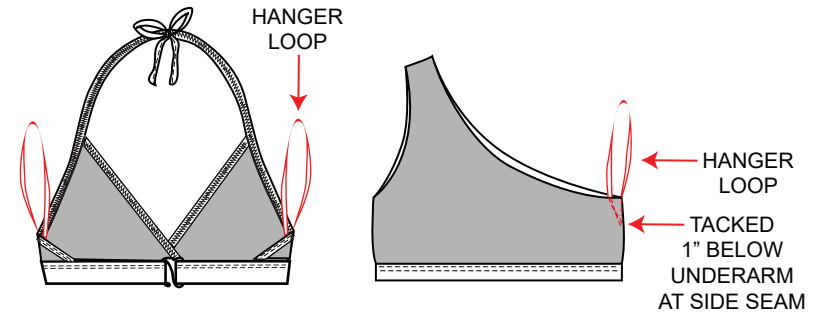
Rubber: Must be fully covered, not touching skin.

Non-Latex Elastic: Can be used instead of rubber, when minimum amount of trim is visible.

- **Rubber/Non-Latex Elastic** at openings must be set circular. Lapped join seam placed at CB/Underarm/Crotch Seam.
- **Rubber/Non-Latex Elastic** = 0.6mm Thickness

Hanger Loops: Use clear stretch elastic to create hanger loops at side seams on halter neck closure or only one shoulder strap styles. Follow Children's Safety Guidelines on K-Link for maximum length allowed by age. (IMAGE T-9)

IMAGE T-9: HANGER LOOPS



CHILDREN'S SIZE 4-20: CLEAR STRETCH HANGER LOOPS MUST BE ABLE TO DETACH AT A MAXIMUM OF 5LBS FOR 10 SECONDS
 CHILDREN'S 0-5T: HANGER LOOPS **NOT ALLOWED**

SECTION 5: TRIMS/FINDINGS CONT.

ZIPPERS:

- See Kohl's Department Stores Product Safety & Regulatory Standards.

CLOSURES:

- **Molded Plastic Hook Closure** for back band closure. Children's 0-6x have 2 adjustments. (IMAGE T-10)
- **Sportswear Buttons** decorative or functional must be attached with a lock-stitch button-sew machine.

PADS (For Bra Cups):

- All white, ivory, and pale colors must have an extra liner between outer fabric and pad to mask any potential yellowing.
- Removable pads unless it's padded for support.

BEADING/SEQUINS:

- See Kohl's Department Stores Product Safety & Regulatory Standards.

IMAGE T-10: BACK CLOSURE REQUIREMENTS

