



Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

Summary of Changes – BRAS – NOTE PLEASE SEE FOLLOWING PAGES FOR FULL DETAILS

April 2008

June 2009

Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

<p>Thread: Thread types sizes may vary based on fabric characteristics and weight and are subject to approval by TD. Seams must meet Kohl's strength and appearance requirements. See Preferred Supplier List for Sourcing requirements.</p>	
<p>General Knit Apparel: Needle/Bobbin Thread Quality: Poly wrap/poly core Looper Thread Quality: Texturized Nylon/Texturized <i>Microfiber</i> Polyester Minimum thread size given – size up to next Tex size if not available for thread quality required. Needle/Bobbin Thread size: <ul style="list-style-type: none"> • 70-140g/m2 = Tex 21 • 140-200g/m2 = Tex 24 • 200-270g/m2 = Tex 27 Looper Thread Size: <ul style="list-style-type: none"> Tex 18 Tex 18 Tex 21 </p>	

<p>SPI Requirements:</p>	
<ul style="list-style-type: none"> • Single Needle should have 12 SPIs +/- 1 stitch in all non basting operations. 	
<ul style="list-style-type: none"> • 2N Lockstitch should have 14 SPIs +/- 1 stitch. 	
<ul style="list-style-type: none"> • Overlock should have 16 SPI +/- 2 stitches 	
<ul style="list-style-type: none"> • 2N Coverstitch should have 16-18 SPI +/- 2 stitches. Looper stitch should not restrict stretch or cause the fabric to roll or rope. 	
<ul style="list-style-type: none"> • Zig zag should have 6-7 points per inch +/- 1 point for Hook & Eyes. 	
<ul style="list-style-type: none"> • Zig zag should have 6 points per inch +/- 1 point for Elastics. 	
<ul style="list-style-type: none"> • 3 Step Zig zag should have 3-4 point per inch +/- 1 point 	
<ul style="list-style-type: none"> • Flatlock should have 16 – 18 SPI +/- 2 stitches. Fabric should be caught by at least 2 needles 	
<ul style="list-style-type: none"> • Ball point needles only 	



Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

Seam Requirements:	
<ul style="list-style-type: none"> Overlock (ISO 504) must be latched, tacked or completely secure in next operation. 	
<ul style="list-style-type: none"> Flat seam (ISO 606 or ISO 607) fabric must be caught in 2 needles. Flatlock must be tacked or completely secured in next operation. 	
<ul style="list-style-type: none"> No raw edges, open, or twisted seams. 	
<ul style="list-style-type: none"> Stitches must be secured at start and stop with 3-4 stitch back-tack, overlapping ½”, or SN line tack = to topstitch width. Ends of overedge seams must be SN tacked or have self-latched end 	
<ul style="list-style-type: none"> No seams in binding or taping within a garment. Splicing must be inconspicuous. 	

Trims/Findings:	
<p>Elastic, Hook & Eyes, Wire Channeling Suppliers, or any other components: Must be tested by Intertek or come from a preferred vendor. All components must be free of lead, nickel, and rubber.</p>	
<p>Elastic:</p> <ul style="list-style-type: none"> Rubber/Latex should never be used in foundation garments. All elastic at armhole, straps and wings that will be against body must be plush backed woven elastic unless specified. 	
<p>Rings & Slides:</p> <ul style="list-style-type: none"> Rings and Slides must be metal and nylon covered. Exceptional must be signed off by Product Manager/Technical Design on good only. Rings and Slide must be nickel free, lead free and hypoallergenic. 	<ul style="list-style-type: none"> Rings and Slides must be metal and nylon covered.
<p>Wire, Boning, & Channeling</p> <ul style="list-style-type: none"> All boning should be thin, flexible plastic, unless other wise specified. All wire must have the wire tips covered. Channeling for wires and boning should be brushed flannel on the outer ply and tightly woven taffeta or equivalent for the inner ply. Premade channeling is acceptable but must pass testing. 	

Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

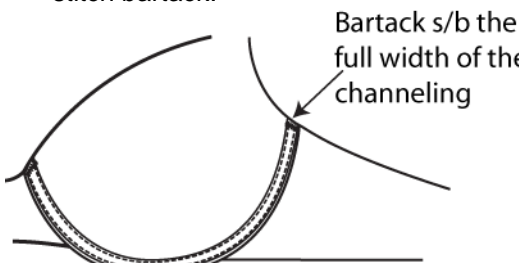
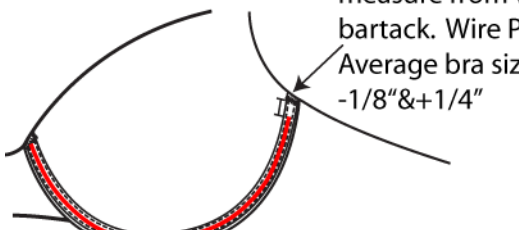
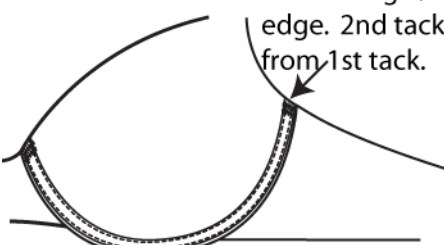
GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

<p>Closures:</p> <ul style="list-style-type: none"> • Hooks & Eyes must have flannel, plush or micro fiber backing approved by Product Manager/Technical Design. Any exception must be approved by Product Manager/Technical Design. • Hooks & Eyes must sonic sealed edges. Ends must have smooth edges. Front Closure can be plastic but quality of front closure must be approved by Product Manager/Technical Design 	
<p>Pads:</p> <ul style="list-style-type: none"> • All white, ivory and pale colors must have an extra liner between outer fabric and pad to mask any potential yellowing. 	

<p>Construction:</p>	
<p>Center Gore:</p> <ul style="list-style-type: none"> • Center Gore should be reinforced. • Any laminated gores should be passed to testing to check for hand and delaminating. • No raw edges on any CF gore. Gore should be finished with tricot binding stitched with 2N lockstitch (no chainstitch) or sewn and turned. 	
<p>Straps:</p> <ul style="list-style-type: none"> • Straps should be thread thru Metal rings and bartacked with 28 stitch bartack. Tack must completely cover the width of the strap. • Straps should be looped thru slide with 2" loop for average & 2 ½" for Full Figure. • Laminated reinforced strap should be passed to testing to check hand and delaminating. 	
<ul style="list-style-type: none"> • Binding, taping, elastic must be continuous piece. 	
<p>Channeling for wire and boning:</p> <ul style="list-style-type: none"> • Cup set seam should be concealed inside both plies of wire channeling on a hidden wire set up. • Wire should be completely covering inside taffeta channeling. • Wire Channeling should be bartacked to completely covering wire channeling with 42 	<ul style="list-style-type: none"> • Wire channeling should have double bartack completely

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

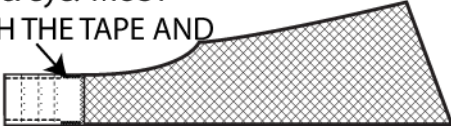
GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

<p>stitch bartack.</p>  <ul style="list-style-type: none"> If elastic is set over wire channeling, the wire channeling must be bartacked before elastic is set. Wire Play should be measured with wire against Center Front bartack. Measure from wire tip to bartack at armhole. Wire play should be 1/4" with a tolerance of -1/8" & +1/4" <p>With wire against CF bartack measure from wire tip to bartack. Wire Play s/b 1/4" for Average bra size. Tolerance -1/8"&+1/4"</p> 	<p>covering the wire channeling with 42 stitch bartack. Bartacks are place 1/16" apart.</p> 
<p>Hook & Eyes:</p> <ul style="list-style-type: none"> Hook & eyes are attached to the back with ZZ stitch with 14 PPIs (Points per inch). Back wing must be completely inserted in the hook tape and the eye tape. No Raw Edges should be showing of the tape or garment. Back tack at the start of attaching of the hook and eye tape and at the end of sewing the hook and eye tape. 	

Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera

<p>Must back tack at start and finish when setting hook & eye. MUST COMPLETELY CATCH THE TAPE AND THE GARMENT</p> 	
<p>Styling Features:</p> <ul style="list-style-type: none"> • Shirring must be evenly distributed. • Darts: No dimples at the ends of darts. 	

<h3>Cutting:</h3>	
<p>Cutting Direction:</p> <ul style="list-style-type: none"> • All components within the garment and multiple garments in sets are to be cut in same direction. • Plaids/Stripes must be pinned or blocked and re-laid. <p>Unbalanced plaids/stripes:</p> <ul style="list-style-type: none"> • 2-way cut, all parts cut in same direction within a garment. • 1 way prints: cut entire quantity in same direction. 	<p>Unbalanced plaids/stripes:</p> <ul style="list-style-type: none"> • 1-way cut, all garments in same direction.
<p>Plaid/Stripe Matching:</p> <ul style="list-style-type: none"> • <u>Stripes 1/4" or wider must match horizontally at center front and center back opening/seams.</u> • <u>Stripes 1/2" or wider must match at side seam.</u> • <u>Fronts must be vertically paired.</u> • <u>Garment representing production plaid/stripe match must be submitted to Designer/Product manager before final costing approval.</u> 	<ul style="list-style-type: none"> • <u>Must match horizontally at side seams, side panel/princess seams</u> • <u>Unbalanced Plaids/Stripes must be mirrored from left to right.</u>



Private Brands Construction Standards – Intimates: Bras

Listed items are minimum construction standards unless otherwise specified in the specification construction details by TD.

GOOD	BETTER/BEST = GOOD requirements plus below
BRANDS: So, Apt 9, Mudd	BETTER BRANDS: Elle BEST BRANDS: Candies, Simply Vera