



Private Brands Construction Standards – Intimates Panties

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 – Knits – NOTE PLEASE SEE FOLLOWING PAGES FOR FULL DETAILS

April 2008

November 2008 – Moments is discontinued and Apt 9 is added.

June 2009 – Add Mudd. Adjust ZZ minimum SPI/PPI



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<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 Testing Protocol for strength and appearance requirements. Thread must come from Preferred Thread Supplier.</p>									
<p>General Intimate Apparel: Needle/Bobbin Thread Quality: - Needle/Bobbin=Poly wrap/poly core Looper Thread Quality: Texturized Microfiber Polyester or Texturized Nylon Minimum thread size given – size up to next Tex size if not available for thread quality required.</p>									
<table border="0"> <tr> <td>Needle/Bobbin Thread size:</td> <td>Looper Thread Size:</td> </tr> <tr> <td>• 70-140g/m2 = Tex 21</td> <td>Tex 18</td> </tr> <tr> <td>• 140-200g/m2 = Tex 24</td> <td>Tex 18</td> </tr> <tr> <td>• 200-270g/m2 = Tex 27</td> <td>Tex 21</td> </tr> </table>	Needle/Bobbin Thread size:	Looper Thread Size:	• 70-140g/m2 = Tex 21	Tex 18	• 140-200g/m2 = Tex 24	Tex 18	• 200-270g/m2 = Tex 27	Tex 21	
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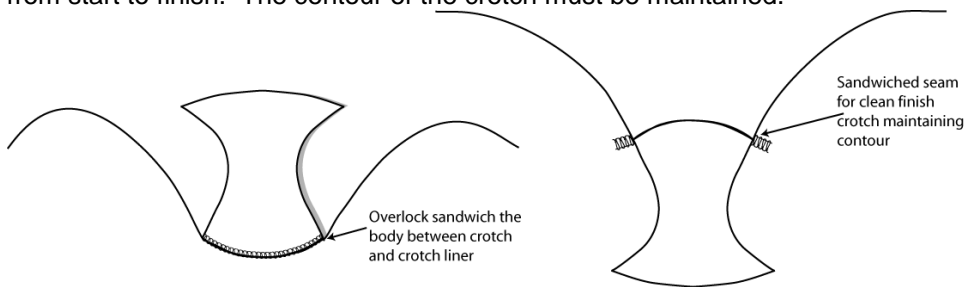
<p>SPI Requirements:</p>	
<ul style="list-style-type: none"> • Overlock should have 16 SPI +/- 2 stitches 	
<p>2N coverstitch should have 16-18 SPI +/- 2 stitches. Looper stitch should not restrict stretch or cause fabric to roll or rope.</p>	
<p>Flatlock should have 16 – 18 SPI +/- 2 stitches. Fabric should be caught by at least 2 needles.</p>	
<p>Zig zag should have 6-7 points per inch +/- 1 point</p>	
<ul style="list-style-type: none"> • 3 Step Zig zag should have 3 point per inch +/- 1 point 	
<ul style="list-style-type: none"> • Ball point needles only 	
<p>Seam Requirements:</p>	
<ul style="list-style-type: none"> • Flatseam (ISO 606 or ISO 607) fabric must be caught in 2 needles. 	
<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 	

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<ul style="list-style-type: none"> No seams in binding or taping within a garment. Splicing must be inconspicuous. 	<ul style="list-style-type: none"> No splicing
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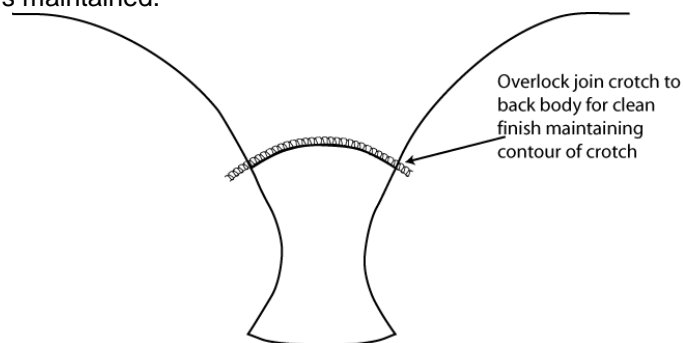
Construction:	
<p>Waist:</p> <ul style="list-style-type: none"> Overlock close waist seam: The waist seam should be on the left side wearing except boyshorts. Boyshorts should be closed at center back. Waist elastic of the left side wearing should be tacked. The seam should lie toward the back and tack the full width of the leg elastic. (May vary according to style lines) The seams should be tacked with a 28 stitch bartack or equivalent SN tack. Seam must be secure. 	<ul style="list-style-type: none"> The seams should be tacked with a 28 stitch bartack or equivalent bartack.
<p>Bottom Hem:</p> <ul style="list-style-type: none"> Hems must be circular finished unless otherwise specified. Vents/slits must be overlocked, taped or clean finished as specified. Binding or taping must be continuous piece. Raw Edge hems must have side seams secured on inside at hem edge so that stitching cannot unravel. 	
<p>Crotch:</p> <ul style="list-style-type: none"> Front w/crotch as part of the front pattern: Back body should be sandwiched between front body and cotton crotch liner for a clean finish. All layers must align from start to finish. The contour of the crotch must be maintained.  <p>Overlock sandwich the body between crotch and crotch liner</p> <p>Sandwiched seam for clean finish crotch maintaining contour</p>	

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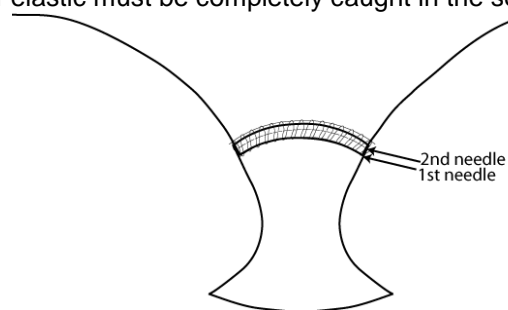
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- Separate crotch assemble:** Back crotch seam should be clean finished with the back body sandwich between the crotch fabric and the crotch liner. The contour of the crotch must be maintained. All layers of fabric must align. The front seam should be overlock joined catching all plies of fabric making sure that the contour of the seam shape is maintained.



- Flatlocked crotch seam:** Both fabrics should be caught by at least 2 Needles. Both ends of elastic must be completely caught in the seam allowance.



- Flatlocked crotch seam** should be tacked the full width of the flatlock seam. The thread tail should be pulled back and caught under the bartack. The seam should be tacked with a 28 stitch bartack.



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<p>Legs:</p> <ul style="list-style-type: none"> Leg elastic set: The set should follow the construction detail sheet in the spec pack but all garments should be symmetrical for right leg to left leg. NO Greater than 1/2" difference in total circumference from right to left leg. 	<ul style="list-style-type: none"> NO Greater than 3/8" difference in total circumference from right to left leg.
<p>Styling Features:</p> <ul style="list-style-type: none"> Shirring must be evenly distributed. 	

Trims/Findings:	
Interlining/Backing, Elastic, Metal Fasteners and Zipper: All Components must be tested by Intertek and pass or Come from Preferred Supplier List.	
<p>Internal Component Trim Color: (Elastics, interlinings, reinforcement tapes, shoulder pads, etc)</p> <ul style="list-style-type: none"> White for all colors unless there is a 'show or grin-through' problem. 	<ul style="list-style-type: none"> White for light colors, Black or Gray for dark colors.
<p>Elastic:</p> <ul style="list-style-type: none"> Rubber/Latex should never be used in foundation garments. Elastic must be woven elastic unless approved by Product Manager or Technical Designer. 	<ul style="list-style-type: none"> Elastic must be woven elastic.

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Crotch Liner:

- Crotch liner must be 100% cotton jersey. Weight and Hand must be approved by Product Manager.

Cutting:

Cutting Direction:

- 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.

Unbalanced plaids/stripes:

- 2-way cut, all parts cut in same direction within a garment.
- **1 way prints:** cut entire quantity in same direction.

Unbalanced plaids/stripes:

- 1-way cut, all garments in same direction.

Plaid/Stripe Matching:

- Stripes ¼" or wider must match horizontally at center front and center back opening/seams.
- Fronts must be vertically paired.
- Garment representing production plaid/stripe match must be submitted to Designer/Product manager before final costing approval.

- Balanced & Unbalanced Plaids/Stripes must be mirrored from left to right.