

CPA

Critical Points of Attention

Global Technical Design
Apparel Resource Tools
7-2021

KOHL'S

Critical Points of Attention Overview

What is a Critical Points of Attention or CPA Image?

- ❑ CPA is an image added to the **overview attachments tab** in the tech pack.
- ❑ The image is meant to **call attention to areas** of the product that must be **reviewed during** and after **production** to ensure the best quality.
- ❑ An image that calls out an area that has been identified as **visually important** and needs extra attention/care.

What information should be included?

- ❑ Areas of concern on the garment identified during fit that may be difficult in production
- ❑ Known challenges/ areas of concern in the production line
 - *We depend on our CTD partners to identify these areas as they have more direct contact with the production line*
- ❑ No need to include style number/date on CPA image, this allows for repeat styles to use the same image as the previous season when the areas of concern have already been identified.

NOTE: Product Safety and Regulatory Standards must ALWAYS be followed according to the most updated standards from Product Integrity. *See [Apparel Product Safety & Regulatory Standards](#)

Critical Points of Attention - Why is it important?

Why is a CPA or Critical Points of Attention important?

- ❑ Method of **communicating** KTD/CTD **expectations** for quality prior to start of production
Who is this for? **Quality Auditors, **factory inspectors**, and **in-line operators***
- ❑ Notes areas of the style that may be **noticed by customer** right away
 - ✓ What is the 1st thing the customer sees?
 - ✓ Would it stop the customer from buying the garment or cause return?
 - ✓ Would it change their perception of the quality of Kohl's and the brand?
- ❑ To draw attention to a defect for **immediate improvement** in quality for the customer.
- ❑ **Calls out a concern** in the garment visual, construction, and or workmanship. These may be areas that are difficult to execute or a focal point of the garment.



Critical Points of Attention Expectations

Attach at any point during development

- ❑ Add image to the **overview** attachments tab to ensure high priority for QA Audit visibility in production.
*See [OnePLM Manual - Uploading CPA page](#)
- ❑ Both KTDs & CTDs (Lv 2-4) are able to add CPAs
- ❑ Attach no later than PP stage.
- ❑ CTDs may also add additional CPA information gathered at a Pilot Run prior to full production.
- ❑ OK to use common CPA content or repeat image, but please be sure it is relative to the style.

Sort	Attachment No	Attachment Type	Description
<input type="checkbox"/>	1	IMAGE	DESIGN SKETCH FRONT/ BACK
<input type="checkbox"/>	2	IMAGE	

Critical Points of Attention

*****Neckline / armhole binding*****
Factory must be monitoring closely to not stretch the binding when set into the body to maintain the shape and balance as per pattern and spec approved.

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****CPA Image should NOT be attached to fit eval attachments tab****

Identifying Critical Points of Attention

How to Identify CPA

- ❑ Construction issues identified during development that could be **challenging in production**.
- ❑ **Highly visible** parts of the garment such as neckline, an embellishment or primary feature.
- ❑ Areas of the garment that require a **more advanced** operator.
- ❑ **Known challenges/ areas of concern** in the production line.
Examples: garment symmetry, pocket setting, top applied trims
- ❑ **Safety Requirements**
- ❑ Accurate **trim application**: snaps, zippers, interlining, etc



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Neckline is highly visible:

- ✓ Check for symmetry and workmanship quality of collar setting.

The placket is a primary feature on this style:

- ✓ Does the placket look straight?
- ✓ Is the placket construction well executed?
- ✓ Are the buttons evenly spaced?
- ✓ Are the button and button holes aligned?
- ✓ Does the upper placket fully cover the under placket?

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are sleeves the same length and width?
- ✓ Are armhole depths the same?



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Neckline is highly visible:

- ✓ Check for symmetry and workmanship quality of collar setting.

The zipper and pockets are a primary features on this style:

- ✓ Does the zipper look straight?
- ✓ Are the pockets symmetrical from side to side?

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are sleeves the same length and width?
- ✓ Are armhole depths the same?

Special Features:

- ✓ Is the fill evenly distributed?
- ✓ Is the quilting consistent throughout garment?
- ✓ Is the binding smooth and consistent width? Free of roping and twisting?
- ✓ Check the garment lining. Is the lining length appropriate and does not hang below the hem? Is it attached correctly so that it does not pull out of the sleeve opening?



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Waistband and fly are highly visible:

- ✓ Check for workmanship quality of button, fly, and waistband.
- ✓ Is the waistband width even and aligned from side to side?
- ✓ Are belt loops symmetrical from side to side?

Pockets and stitching are primary features on this style:

- ✓ Are the pockets symmetrical?
- ✓ Is the pocket construction well executed?
- ✓ Are there thread breaks/restitching in highly visual areas?

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are pant legs the same length and width?
- ✓ Are leg openings the same?
- ✓ Are any seams twisting or torquing?



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Waistband and seaming are highly visible:

- ✓ Check for workmanship quality at waistband, front and back rise, and seam details.

Stitching/Piecing are primary features on this style:

- ✓ Are the piecing seams symmetrical from side to side?
- ✓ Are there thread breaks/restitching in highly visual areas?
- ✓ Are there puckering or over stretched seams?

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are pant legs the same length and width?
- ✓ Are leg openings the same?

Special Features: *Garment stretch is necessary for wearing this style*

- ✓ Are leg openings and waist extended measures meeting spec?
- ✓ Can the garment stretch without broken or cracking stitches?
- ✓ Is stitch tension/balance appropriate for the fabric and garment end use?



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Neckline and placket are highly visible:

- ✓ Check for symmetry and quality of collar setting.

The placket is a primary features on this style:

- ✓ Is the placket straight and well executed?
- ✓ Are buttons evenly spaced?
- ✓ Does upper placket fully cover under placket?

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are the sleeves the same length and width?
- ✓ Are armhole depths the same?

Special Features:

- ✓ Is the neckline meeting the minimum head stretch requirement?
- ✓ Is stitch tension/balance appropriate for the fabric and garment end use?



Identifying Critical Points of Attention

What are the critical points of attention on this style?

Neckline is highly visible:

- ✓ Check for symmetry at neckline symmetry

Check to ensure the garment is symmetrical from side to side:

- ✓ Are side seams the same length?
- ✓ Are sleeves the same length and width?
- ✓ Are armhole depths the same?

Primary Features on this style:

- ✓ Is the shirring evenly distributed at the top of sleeve and sleeve opening?
- ✓ Are the princess seams twisting or torquing?
- ✓ Are smocking rows evenly spaced?
- ✓ Does the back smocking have enough stretch/retention to allow for easy dressing?



Critical Points of Attention Best Practices

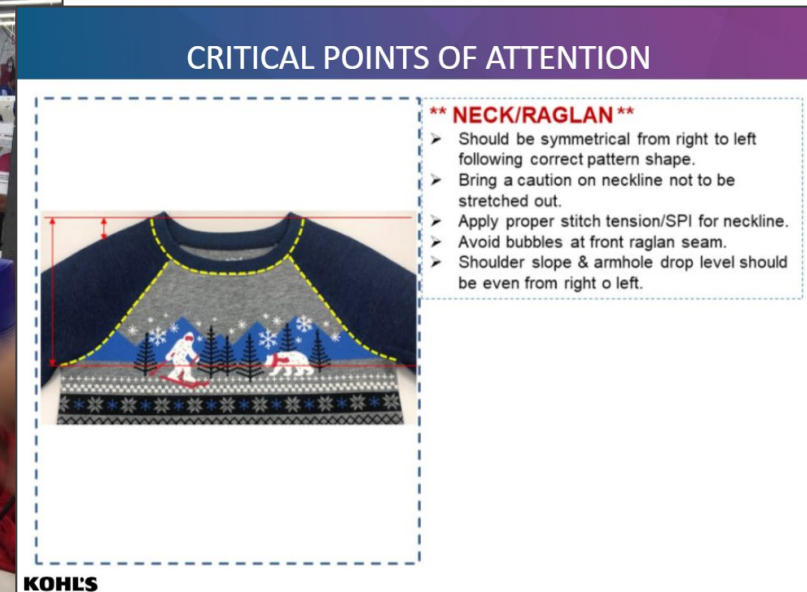
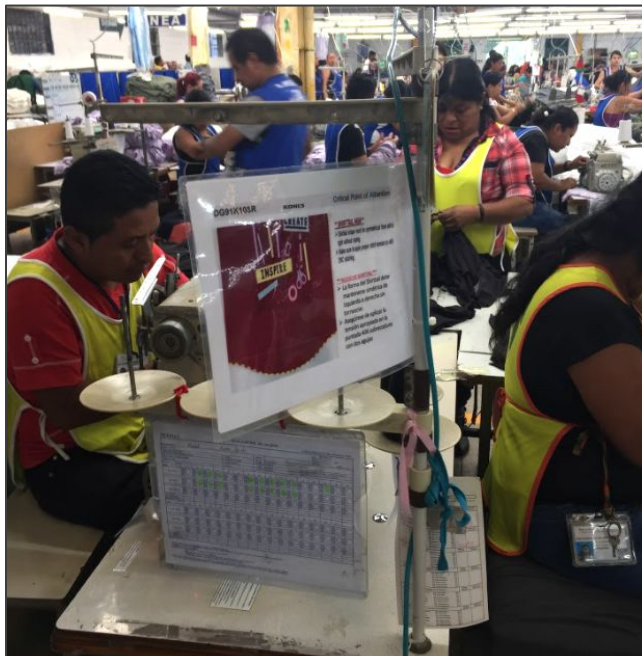
Best Practices

Generally CPA Images are printed and hung in an easy to see location in the production line. They are used to instruct QC/QA in-line & end-of-line to properly assess the product.

- ❑ State the problem and include actionable solutions to correct.
- ❑ Use “Good” vs “Bad” scenarios to show a clear visual for in-line reference.

**This is not required, in some cases there may not be a “Bad” example. Simply showing the “Good” expectation is also sufficient.*

- ❑ Be sure to clearly label what is good and what is bad.
- ❑ Use large, clear images, large clear arrows and indicators.
- ❑ Clear and concise wording for easy reading/translating.
- ❑ Separate multiple areas of focus onto separate pages.



CRITICAL POINTS OF ATTENTION

TEMPLATE

Examples

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CRITICAL POINTS OF ATTENTION

****NECKLINE**

- **Neckline should be symmetrical from side to side**

****PLACKET**

- **Placket should be straight**
- **Placket should be align at edges**
- **Buttons should be centered on placket and evenly spaced.**
- **Please be sure button/button holes are aligned.**
- **Placket should be straight at sides and bottom**



CRITICAL POINTS OF ATTENTION



- Bartacks must NOT extend off the edge of the pocket.
- Bartacks should be set approx 1/8" from the edge of the pocket.
- Bartack should be on an even flat surface.
- Pls ensure proper setting in production.

CRITICAL POINTS OF ATTENTION



ISSUE:

-Collar points not symmetrical from side to side when quartered

ACCEPTABLE:

-Collar symmetry CANNOT be offset more than 3/16"

NOT ACCEPTABLE:

-Collar points offset at a 1/4" or more

IMPROVEMENT:

-Collar must align at collar point, collar length, and CF collar band seam when quartered

-Align notches during sewing to correct.

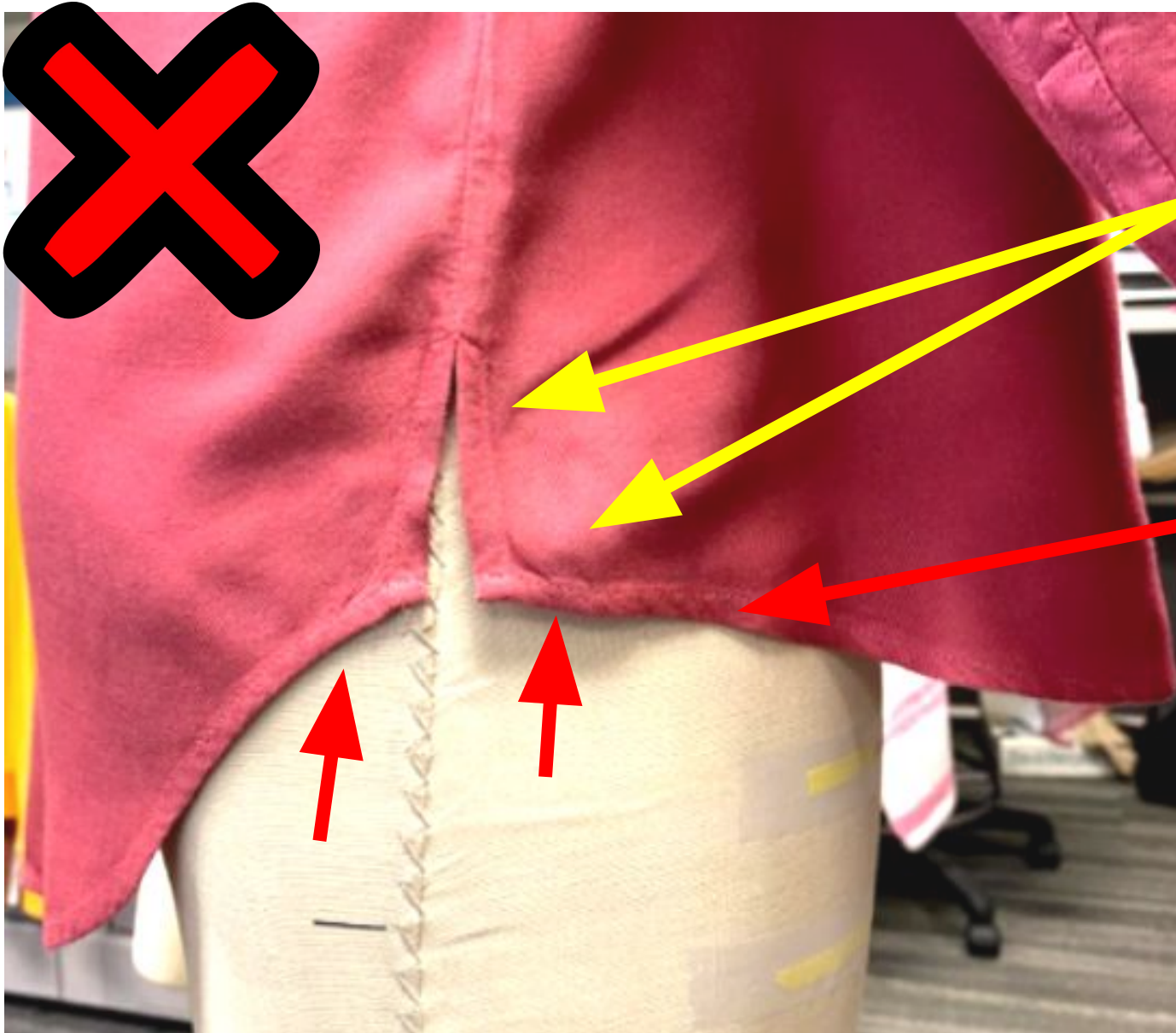
-Apply using a template to maintain consistency.

CRITICAL POINTS OF ATTENTION



- Do not angle rib trim grainline at cuff join seam
- Rib trim grainline should be straight
- Verify pattern shape is align with approval

CRITICAL POINTS OF ATTENTION



NOT ACCEPTABLE:

Stitch tension is tight creating bubbling effect above hem stitching.

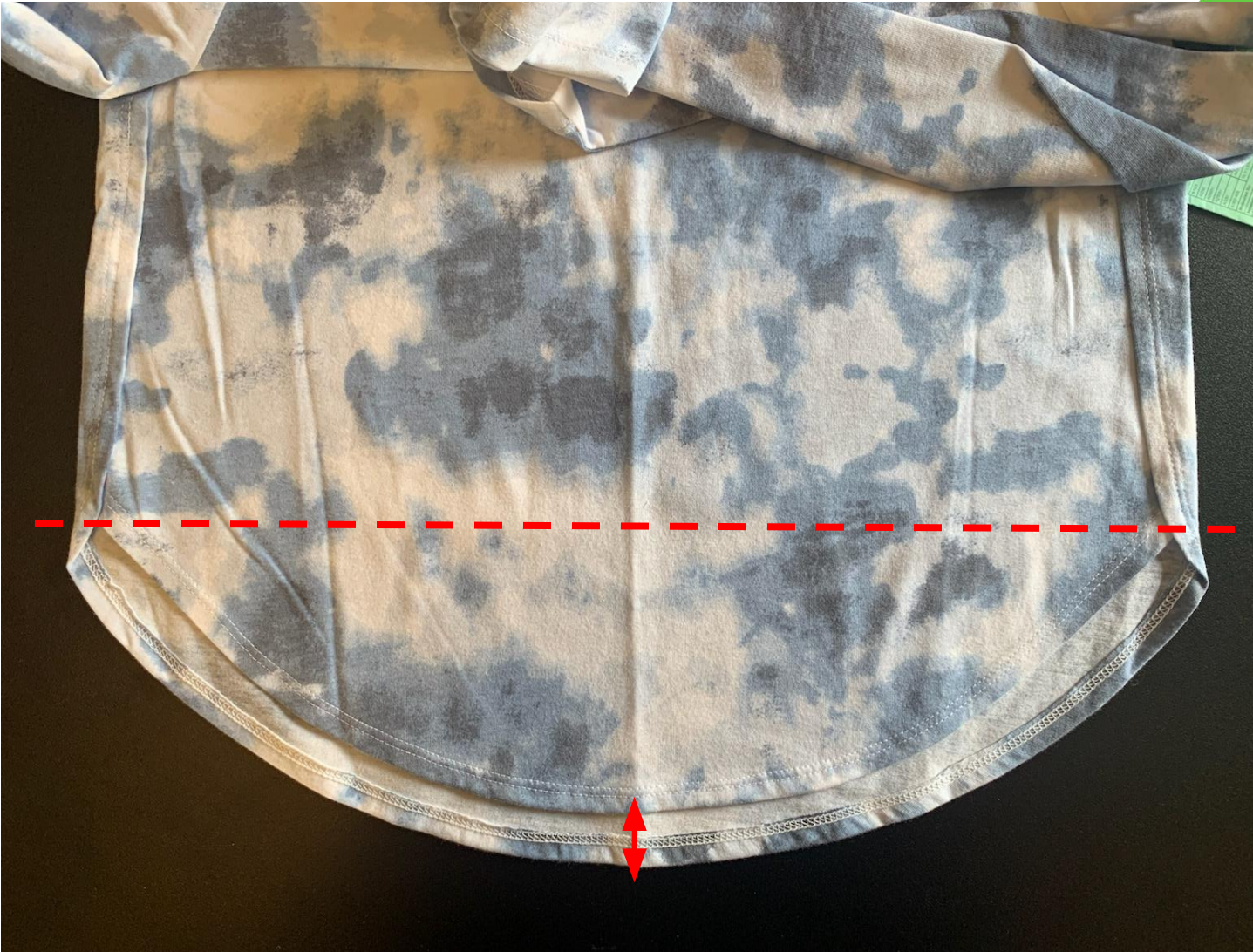
NOT ACCEPTABLE:

Hem is twisting during sewing creating roping effect at hem seam.

Adjust machine tension appropriately for this fabric weight.

Please monitor hem workmanship during production and inspection.

CRITICAL POINTS OF ATTENTION



Side Seam

-Please make sure side seams/forwarded seams are the same length at both sides

Sweep

-Please be sure shirt tail is symmetrical from side to side and that front/back length difference is even 1" all around

CRITICAL POINTS OF ATTENTION



- Panel to bottom seam join should be smooth. Take care of sewing and cutting to avoid curve & peak up at top of CB.
- BK yoke should avoid wavy & curved.
- The CB seam should be straight at center.
- CB belt loop should be straight.
- Pls monitor workmanship.