

## Dimensional Stability SOP

### 1) Overview

Kohl's requires that all apparel be subject to Dimensional Stability during production to assure the quality and performance of the product. The purpose of Kohl's Dimensional Stability SOP for *garments* is to ensure the samples submitted for testing are in line with Kohl's Technical Design tolerances.

**Exceptions to this SOP include:**

- Swimwear
- Outerwear
- Sweaters
- Accessories

### 2) Sample Submission

Production Testing (Preferred and Non-Preferred Suppliers) - Contact test lab for appropriate number of samples to be submitted. Please reference the below chart for core sizes that **MUST** be submitted for production testing of dimensional stability:

Core Sizes				
<b>Childrens</b>				
Infant	Toddler	Little Kids	Girls 7-16	Boys 8-20
12 mo.	3T	6	12	12
<b>Juniors</b>				
7				
<b>Womens</b>				
Apt 9/Sonoma/Tek Gear		C&B		LC/ R&R
RTW: M (8-10) or 10		M (10-12) or 12		M (10)
Sonoma Sleep: M (12)				JLo/Elle/Dana Buchman/Fila/SVWV
				A:GLOW
				M (8-10) or 8
				M(8-10) or 10
<b>Mens</b>				
Sonoma/C&B/Marc Anthony/APT 9/Tek Gear/Fila				
Tops		Bottoms		
M - 40" Chest		34" Waist/ M		
<b>Young Mens</b>				
Urban Pipeline			Rock & Republic	
Tops		Bottoms		Bottoms
M - 39" Chest		34" Waist/M		M-40" Chest
				34" Waist/M

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### 3) Procedure

1.1 Vendor/ MR download and print Fit Approved Points of Measure (POM) page from Bamboo Rose (onePLM).

Note: Re: Vendor Assist Programs- Any POM pages that come directly from vendors can be used to document POM measurements in Dimensional Stability Reporting. These vendors create their own tech specs that are then uploaded into the OnePLM.

1.2 Vendor/ MR highlight benchmark locations on POM, applicable to product. Please reference the Benchmark Location Chart Below. ***If you do not see your product listed, please reach out to your third party approved lab for appropriate benchmark locations.***

<b>Shirt (Dress)</b>	<b>Pants</b>	<b>T-Shirt</b>	<b>Polo Shirt</b>
Collar Length	Waist	Neck Width	Collar Length at Neck Seam - folded
Across Shoulder	Hip	Across Shoulder	Bust/Chest
Bust/Chest	Leg Opening	Bust/Chest	Sweep
Sweep	Front Rise	Sweep	Length - HPS to Hem
Length - HPS to Hem	Back Rise	Length - HPS to Hem	Sleeve Length - CB Neck
Sleeve Length - CB Neck	Inseam	Sleeve Length - CB Neck	Waist
Waist		Head Stretch	Across Shoulder
Hood Length		Waist	
Hood Width			
(if different from body)			
<b>Romper</b>	<b>Bodysuit</b>	<b>Overall</b>	<b>Panties</b>
Neck Width	Neck Width	Waist	Total Waist - Relaxed
Bust/Chest	Bust/Chest	Hip	Leg Opening - Relaxed
Length - HPS to Edge	Sleeve Length - CB to Hem	Leg Opening	Front Rise
Sleeve Length - CB Neck	Seat - Bodysuit	Inseam	Back Rise
Leg Opening	Leg Opening	Front Rise	Hip (Seat Width)
Vertical Trunk	Vertical Trunk	Back Rise	Crotch Width
Inseam - Total		Strap Length - Total	
<b>Dress</b>	<b>Camisole</b>	<b>Coverall</b>	<b>Bra</b>
Neck Width	Bust/Chest	Neck Width	Strap Length
Bust/Chest	Sweep	Bust/Chest	Bottom Band Length
Low Hip	Length - Front	Length - HPS to Hem	Wing Length
Sweep	Length - CB to Hem	Sleeve Length - CB Neck	Cup Length
Length - HPS to Hem	Strap Length - Folded	Vertical Trunk	Cup Width
Sleeve Length - CB Neck	Waist		Cup wire Channel
Waist			

# Kohl's Department Stores


## Product Services

<b>Panties</b>	<b>Skirt</b>	<b>Thong</b>
Total Waist - Relaxed	Waist	Waist
Leg Opening - Relaxed	Hip	Front Length
Front Rise	Hem	Front Width
Back Rise	CB Skirt Length	
Hip (Seat Width)		
Crotch Width		

1.3 Vendor/ MR submit highlighted POM, appropriate number of core size samples (per test lab requirement) and Test Request Form (TRF) to third party approved lab.

### Example of highlighted POM submission:

**FIT APPROVED**



**BASE - LS ESSENTIAL CREW**

Points of Measure

Fiscal Season	FA16	Brand	SONOMA	Points of Measure						Create Date	
Division	WOMENS	Request No		Grade Table	LADIES					X-Factory Date	
Tech Designer											
Tolerance Model LADIES TOPS ALPHA											
P/S	POM Code	POM Description	TOL (-)	TOL (+)	2	6	10	14	18	20	
P	A001-LA000-20	LADIES ALPHA SIZES XXS(000-00) XS(0-2) S(4-6) M(8-10) L(14-16) XL(18) XXL(20)									
	A008	ALL MEAS AFTER GARMENT WASH									
P	A300	LEN HPS TO HEM	-1/2	1/2	25 1/2	26	26 1/2	27	27 1/2	27 3/4	
P	A100	NK WIDTH@SEAM	-1/4	1/4	8 1/4	8 1/4	8 1/2	8 3/4	9	9 1/8	
S	A110	FRT NK DROP@SEAM	-1/8	1/8	4 3/4	4 7/8	5	5 1/4	5 3/8	5 3/8	
S	A120	BK NK DROP@SEAM	-1/8	1/8	3/4	3/4	7/8	7/8	1	1 1/8	
	A124	NK TRIM HEIGHT	-1/8	1/8	1/2	1/2	1/2	1/2	1/2	1/2	
	A569	BACK NECK TAPE HEIGHT	-1/8	1/8	3/8	3/8	3/8	3/8	3/8	3/8	
	A151	FORWARD SHLDR SEAM @HPS-STRAIGHT	-1/8	1/8	1/2	1/2	1/2	1/2	1/2	1/2	
P	A250	ACROSS SHOULDER	-3/8	3/8	13 1/4	13 1/2	14	14 3/4	15 3/8	15 5/8	
S	A253	XFRT/BK PLCMT # FM HPS	0	0	5 1/2	5 7/8	6	6 1/4	6 3/8	6 3/8	
S	A255	ACROSS BACK	-3/8	3/8	13 3/8	13 5/8	14 1/8	14 7/8	15 1/2	15 3/4	
S	A254	ACROSS FRONT	-3/8	3/8	12 1/4	12 1/2	13	13 3/4	14 3/8	14 5/8	
P	A260H	CHEST 1" BLW AH RLXD-1/2 MEAS	-1/2	1/2	16 7/8	17 7/8	18 7/8	20 3/8	22 1/8	23 1/8	
	A272HPS	WAIST PLCMT FM HPS	0	0	15	15	15 1/2	16	16 1/2	16 3/4	
	A270H	WAIST RLXD-TOPS-1/2 MEAS	-1/2	1/2	16 1/4	17 1/4	18 1/4	19 3/4	21 1/2	22 1/2	
P	A290H	SWEEP RLXD@HEM-1/2 MEAS	-1/2	1/2	18 1/4	19 1/4	20 1/4	21 3/4	23 1/2	24 1/2	
	A568	BTM HEM HEIGHT	-1/8	1/8	3/4	3/4	3/4	3/4	3/4	3/4	
P	A330	ARMHOLE DRUP-F-KUM HPS	-1/4	1/4	8 1/2	8 5/8	8 7/8	9 1/8	9 1/2	9 3/4	
P	A362-4W	SLV LEN FROM SHLDR PT-L/SLV	-1/4	1/4	24 1/2	24 3/4	25	25 1/4	25 1/2	25 5/8	
S	A340H	UAMUSCLE 1" BLW AH-1/2 MEAS	-1/4	1/4	5 7/8	6 1/8	6 5/8	7 1/8	7 3/4	8 1/8	

1.4 Test Lab to confirm receipt of highlighted POM, appropriate number of core size samples and TRF.

1.5 Test Lab to complete AATCC 150 according to the product's care instruction. When measuring samples, please be sure to reference the "Kohl's How to Measure Guide" (K-Link) to ensure accurate analysis.

1.6 Test Lab records the difference in measurement between the original sample and the POM sample as **DATA**. **If the difference (in inches) between the POM and Original is outside the tolerance of the POM, the lab needs to email of Kohl's PI team (testing.softlines@kohls.com). Do not mark the test report as Fail based on Tech Spec information:**

POM (IN.)	ORIGINAL (IN.)	DIFFERENCE IN INCHES BETWEEN POM & ORIGINAL (report as DATA only)	AFTER WASH (IN.)	SHRINKAGE (%) BETWEEN ORIGINAL & AFTER WASH (report % as PASS/ FAIL)	KOHL'S REQUIREMENT (LABS TO LIST)
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**\*\*Note: Shrinkage between Original & After Wash should be marked Pass/Fail based on Kohl's requirements.**

## Dimensional Stability SOP

1.7 Be sure to include sample size submitted and POM highlighted measurements, as indicated below:

DIMENSIONAL CHANGES OF GARMENTS AFTER HOME LAUNDERING(AATCC 150) -3.0 TO +1.0 % MODIFIED, ULTRA TIDE ® POWDER DETERGENT, WASH INSIDE OUT, 3 WASHES, NORMAL CYCLE AT 27 DEGREE CELSIUS (80 FAHRENHEIT TEMP), LINE DRY					
Size M (8-10)	POM (IN.) *	ORIGINAL (IN.) *	AFTER WASHED (IN.)	SHRINKAGE (%)	KOHL'S REQUIREMENT
300 WAIST@ TOP EDGE - RLXD	15	15.1	15.1	0	
303c Hip-X FROM CROTCH POINT	20	19.7	19.7	0	
309 LEG OPENING RLXD	12	12	12	0	
325A FRONT RISE TOP EDGE	8.5	8.6	8.6	0	
326A BACK RISE TOP EDGE	13	12.9	12.9	0	
321 INSEAM	28.5	28.7	28.5	-0.7	
SHELL-LENGTH (MEASURED)	N/A	10	10	0	
SHELL-WIDTH (MEASURED)	N/A	7	7	0	
(+ ) DENOTES ELONGATION (- ) SHRINKAGE					
* These measurements should be within POM tolerance.					

**NOTE: The lab should match up any measurements in the Dimensional Stability test and the POM, and report these as data. If there are benchmark locations that do not match up in the POM, the lab should record this as N/A.**

1.8 Test Lab scan POM and include in Test Report document as final page.

1.9 Test Lab upload Test Report to onePLM.

## **Kohl's Department Stores**

### **Product Services**

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#### **4) Revisions**

1/20/20 – Removed “FlexPLM” and replaced with “onePLM”. Replaced “Kohl’s Connection” with “K-Link”.