

FOOTWEAR

Vendor Owned Process Training

[Recording Available Here](#)

Technical Design Training & Standards Team | 2024

KOHL'S

PRESENTATION AGENDA

01

CTD Expectations

02

Tools & Resources

03

Delivering Consistent Fit

04

Attaching Tech Pack to PLM

CTD Expectations



CTD EXPECTATIONS

CTD VENDOR EXPECTATIONS:

- *Always Fit on live models[^]
- *Follow Kohl's Last & Flip Minimums
- *Meet or Exceed Kohl's Minimum Construction Standards
- *Responsible to own and deliver amazing fit
- *Validate comfort and movement
- *Upload factory tech pack in onePLM
- *Validate that production quality follows final tech pack

KOHL'S EXPECTATIONS:

- *Provide Fit & Quality Resources including:
 - Last & Flip Minimums
 - Minimum Construction Standards
 - Boot Calf Standards
 - Sock & Insole Standards
 - How to Measure Manual & Videos
- *Support vendors questions regarding consistency and quality
 - Pre Development: Training & Standards Team
 - In Development: Testing/Inspections Team

CTD EXPECTATIONS

Sampling

- **Engage CTD to set your Kohl's sample for successful execution**
- Use Live Models for all fittings
 - Maintain a model roster. Ensure model sizing is consistent with Kohl's Standards and routinely measured.
 - Rubber Feet should only be used in children's sizing where models are limited
- Leverage Fit & Quality Resources:
 - Last & Flip Minimums
 - Minimum Construction Standards
 - Boot Calf Standards
 - Sock & Insole Standards
 - How to Measure Manual & Videos

NOTE:

- Access to K-Link is essential to a successful execution of the Vendor Owned Process. To reset your K-Link account, please call +1-262-703-1515

Fit Approval

- Apply any revisions as advised from the Kohl's Production team
- CTD internally evaluates/approves samples from counter to pre-production
- **CTD uploads factory tech pack/specification to the 'Attachments' tab in PLM for record keeping**
- **CTD sends a duplicate of the approved fit sample for reference to Kohl's Production**

Production

- Participate in Pre-Production meeting to ensure production matches approval
- Ensure product is meeting or exceeding Minimum Construction Standards and Execution Standards are met

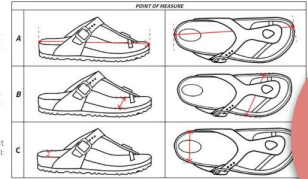
Tools & Resources



Fit & Quality Consistency - Requirements

Molded Footbeds Minimums - Women's

		MOLDED FOOTBEDS						
	SIZE	5	6	7	8	9	10	11
A	INSIDE LENGTH	234.46	242.92	251.38	259.84	268.3	276.76	285.22
	GRADE	8.46	8.46	8.46	8.46	8.46	8.46	8.46
B	INSIDE WIDTH AT BALL	89.88	92	94.12	96.24	98.36	100.48	102.6
	GRADE	2.12	2.12	2.12	2.12	2.12	2.12	2.12
C	INSIDE WIDTH AT CENTER HEEL	65.88	67	68.12	69.24	70.36	71.48	72.6
	GRADE	1.12	1.12	1.12	1.12	1.12	1.12	1.12



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Minimum Construction Standards

Last & Flip Minimums

Boot Calf Standards*

FIT & QUALITY CONSISTENCY

How to Measure Guide

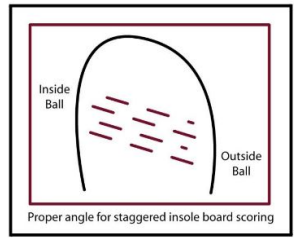
Sock & Insole Standards

Minimum Construction Standards – Footwear/Slippers/Flip Flops



Scored Insole Board

Rows of scoring across the insole board from inside to outside ball for flexibility and rows need to be offset (see diagram).



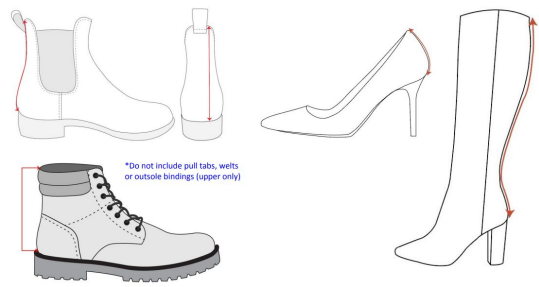
When board leave soles.

POM F210 *CRITICAL POINT OF MEASURE

Center Back Height on Actual Sample

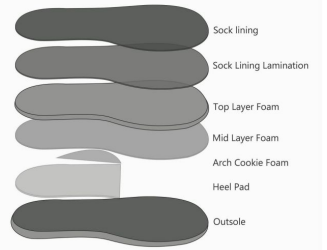
Measure along center back from top of heel/outsole to topline.

Tolerance: -2.00/+2.00



*Do not include pull tabs, welts or outside bindings (upper only)

SOCK & INSOLE FOAM LAYERS



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*not pictured on this slide

Fit & Quality Consistency - Last and Flip Minimums

Last and Flip Minimums provide a baseline of measurements for Kohl's Private label footwear.

These documents provide a wide range of information including various shoe types (boots, sandals, etc), as well as molded and flip-flop styles.

As a Kohls CTD, it is your responsibility that all samples and production adhere to these requirements.

- [Last & Flip Minimums - Kids](#)
- [Last & Flip Minimums - Mens](#)
- [Last & Flip Minimums - Womens](#)

Last Minimums - Womens

	High Heel Boot >75mm		Med Heel Boot 51-75mm		Low Heel Boot 25-50mm		Flat Boot <25mm	
	REC MIN	AVERAGE	REC MIN	AVERAGE	REC MIN	AVERAGE	REC MIN	AVERAGE
Ball Girth on Last	210	211.7	210	211.7	206	208.9	208	209.3
Waist Girth on Last	211	211.3	213	216.8	212	212.5	216	216.1
Instep Girth on Last	216	217.2	218	225.3	218	219.1	220	224.5
Bottom Length on Last	237	240.9	237	240.5	237	241.0	237	239.2
Bottom Ball Width on Last	78	78.2	78	76	78	76	78	76
Toe Thickness on Last	16	20.5	16	3	16	3	16	3
Boot Shaft Calf Girth Outside	381	372.0	381		381		381	

FLIP FLOPS								
SIZE	5	6	7	8	9	10	11	GRADE
Footbed Length	234.5	243.0	251.5	260	268.5	277	285.5	8.46

Examples:

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Molded Footbeds Minimums - Womens

MOLDED FOOTBEDS								
	SIZE	5	6	7	8	9	10	11
A	INSIDE LENGTH	234.46	242.92	251.38	259.84	268.3	276.76	285.22
	GRADE	8.46	8.46	8.46	8.46	8.46	8.46	8.46
B	INSIDE WIDTH AT BALL	89.88	92	94.12	96.24	98.36	100.48	102.6
	GRADE	2.12	2.12	2.12	2.12	2.12	2.12	2.12
C	INSIDE WIDTH AT CENTER HEEL	65.88	67	68.12	69.24	70.36	71.48	72.6
	GRADE	1.12	1.12	1.12	1.12	1.12	1.12	1.12

POINT OF MEASURE

Inside Length: (edge to edge)

Inside width at Ball:

Inside width at center heel:

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Beveled Edge: excludes bevel

Welt Stitch: excludes stitch margin

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Fit & Quality Consistency - Minimum Construction Standards

Minimum Construction Standards (MCS) provide minimum requirements for quality in Kohl's Private Label goods.

These documents provide a wide range of information include guidance on insole boards, construction components, outsoles, and more.

As a Kohls CTD, it is your responsibility that all samples and production adhere to these requirements.

KOHL'S
Minimum Construction Standards
Footwear/Slippers/Flip Flops


Minimum quality and construction standards for footwear/sli

KOHL'S
Minimum Construction Standards – Footwear/Slippers/Flip Flops

Heel Attachment will be checked both in fit evaluation and intermittently via inspections. Confirmation samples, fit samples, and production samples should all match in heel attachment. BOM and Construction tab in OnePLM should also match.


3 Screw Method

The preferred heel attachment method for Kohl's Private Branded Footwear is the 3-screw method due to its superior strength and integrity – especially for skinnier heels 65mm or higher. Should the factory have recommendations for an alternative heel attachment, please reach out to Kohl's TD.




4 Nail + 1 Center Screw Method

The less stable, but more efficient 4 nail + 1 center screw method can be submitted on an individual style basis for Kohl's approval. This method is recommended for lower, chunky or block heels, 64mm or lower. As heel strength and integrity could be compromised depending on heel construction, a passing test report must be submitted.



Ultrasonic Plate

Ultrasonic plates are recommended only for lower, chunky heels (<50mm) or wedges/platforms – but can be submitted on an individual style basis for Kohl's approval. A passing test report must also be submitted.



Fit & Quality Consistency - Boot Calf Standards

[Regular & Wide Calf Boot Standards](#) provide minimum calf measurement requirements for Kohl's Private Label tall boots.

This document includes a minimum measurement for outside calf circumference, as well as other helpful points of measure (ie ankle girth, how to find max calf circumference, etc).

As a Kohls CTD, it is your responsibility that all samples and production adhere to these requirements.



Women's Tall Boot Standards

Boots styles and silhouettes will vary and impact measurements. However, measurements listed below must be met for each size as a **minimum**. This includes both stretch and non-stretch styles, as well as zipped and non-zipped.

Measurements are in millimeters unless otherwise specified.

Regular Calf	#5	#6	#7	#8	#9	#10	#11
Outside Circumference @ Max Calf Girth	356 (14.0 in)	366 (14.4 in)	376 (14.8 in)	386 (15.2 in)	396 (15.6 in)	406 (16.0 in)	417 (16.4 in)
Change from LY	-17.4	-15.2	-13.1	-10.9	-8.8	-6.6	-4.4
Center Back Height of Max Calf Girth, Above Top of Outsole	293	298	303	308	313	318	323
Min Outside Circumference @ Ankle Girth	264	270	276	282	288	294	300

Wide Calf	#5	#6	#7	#8	#9	#10	#11
Outside Circumference @ Max Calf Girth	394 (15.5 in)	404 (15.9 in)	414 (16.3 in)	424 (16.7 in)	434 (17.1 in)	445 (17.5 in)	455 (17.9 in)
Change from LY	-17.3	-15.1	-13.0	-10.8	-8.7	-6.5	-4.3
Center Back Height of Max Shaft Girth, Above Top of Outsole	293	298	303	308	313	318	323
Min Outside Circumference @ Ankle Girth	273	279	285	291	297	303	309

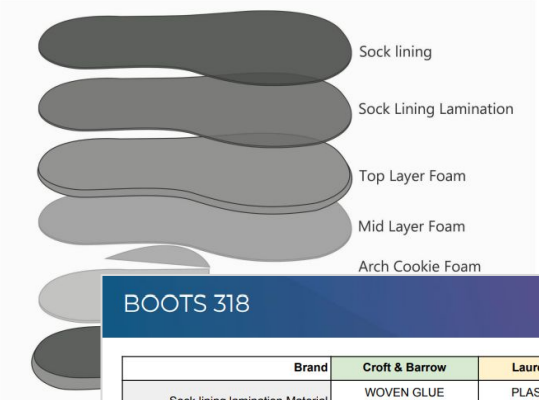
Fit & Quality Consistency - Sock & Insole Standards

The [Footwear Sock & Insole Foam Standards](#) provide a recommended guidance for sock & insole qualities for Kohl's Private Label shoes.

This document includes qualities for various shoe types (boots, sandals, etc) for all categories (womens, mens, kids).

As a Kohls CTD, it is your responsibility that all samples and production adhere to these requirements.

SOCK & INSOLE FOAM LAYERS



BOOTS 318

Brand	Croft & Barrow	Lauren Conrad	SO	Sonoma
Sock lining lamination Material	WOVEN GLUE ADHESIVE	PLASTIC GLUE ADHESIVE	PLASTIC GLUE ADHESIVE	PLASTIC GLUE ADHESIVE
Sock lining lamination Thickness	0.1MM	0.2MM	0.2MM	0.2MM
Top Layer foam Material	ORTHOLITE	MEMORY FOAM	LATEX	ORTHOLITE
Top Layer foam Thickness	5MM	2MM	4MM	5MM
Top Layer Density (Shore C)	25D	25D	25D	25D
Mid Layer foam Material	Latex	Latex	N/A	Latex
Mid Layer foam Thickness	2MM	4MM	N/A	2MM
Mid Layer foam Density (Shore C)	25D	25D	N/A	25D
Heel Pad foam Thickness, Density & Materials	N/A	N/A	N/A	N/A
Arch Cookie foam Thickness, Density & Materials	N/A	N/A	N/A	N/A
Other/Notes	uses "ORTHOLITE ECO"			

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Fit & Quality Consistency - [How to Measure Guide](#)

The [How to Measure Guide](#) provides guidance on consistent measuring methods for Kohl's Private Label shoes.

This document includes both last and shoe measurements. Additionally, there are helpful how to measure videos (see list below) for the most critical points of measure.

As a Kohls CTD, it is your responsibility that all samples and production adhere to these requirements.

- ### HOW TO MEASURE VIDEOS: CRITICAL POINTS OF MEASURE
- [WAIST WIDTH](#)
 - [INSTEP WIDTH](#)
 - [PLUG LENGTH](#)
 - [CENTER FRONT HIGH POINT TOE](#)
 - [CENTER BACK HEIGHT](#)
 - [OUTSOLE LENGTH](#)
 - [OUTSOLE WIDTH](#)
 - [TOE SPRING](#)
 - [MAX CALF GIRTH OUTSIDE CIRCUMFERENCE](#)
 - [TOPLINE CIRCUMFERENCE](#)
 - [VAMP LENGTH](#)

POM F210 *CRITICAL POINT OF MEASURE

Center Back Height on Actual Sample

Measure along center back from top of heel/outsole to topline.
*Marked "Primary" on POM tab
Tolerance: -2.00/+2.00

11/2021 Kohl's Department Stores

The diagram shows two types of shoes: a boot and a high-heeled shoe. Red arrows indicate the measurement path from the top of the heel/outsole to the topline. A note specifies to exclude pull tabs, welts, or outside bindings on the upper only.

POM F410

Toe Post Placement from Inside Footbed

Measurements taken from toe thong post to inside edge of footbed or edge of binding
Tolerance: -2.00/+2.00

11/2021 Kohl's Department Stores

The diagram shows two views of a flip-flop: a top-down view and a side view. Red arrows indicate the measurement from the toe thong post to the inside edge of the footbed or binding. A dashed yellow line highlights the measurement area in the top-down view.

**Delivering
Consistent Fit**



Customer Reviews

Regular monitoring and analysis of Kohl's customer reviews will be critical to your success as a Kohl's Supplier.

Sonoma Goods For Life® Lizzzy Girls Dress Shoes

[Sonoma Goods For Life](#)
★★★★★ 4.8 (19) [Write a review](#) [Ask a question](#)



Sonoma Goods For Life® Catahoula Women's Slip-On Shoes

[Sonoma Goods For Life](#)
★★★★★ 4.6 (4627) [Write a review](#) [Ask a question](#)



Filter Reviews

Search topics and reviews

Rating Age

1 - 8 of 4627 Reviews

JackieH
Verified Purchaser
St. Louis, MO
Age Over 65

★★★★★
Slip on Canvas Shoe
4 hours ago
I have 5 pairs in different colors. Love them. Very comfortable.
Length of Ownership 1 month
Yes, I recommend this product.
Helpful? (0) (0) [Report](#)

Be sure to sort by most recent

Sort by Most Recent

- Most Relevant
- Most Helpful
- Highest to Lowest Rating
- Lowest to Highest Rating
- Most Recent

Fit

Runs Small

Quality

Poor Excellent

Comfort

Not at all Comfortable Very Comfortable

Durability

Not Durable Very Durable

Value

Poor Value Great Value

Style

Not Stylish Very Stylish

**Vendor Owned
Tech Pack to PLM**



Vendor Owned Tech Pack to PLM

Tech Pack Requirements

- Front, Back, & Detail images
 - Final approved version only
- Construction Details including:
 - Construction type: cemented, strobel, molded, etc
 - Outsole flocking
 - Upper stitching & attachment
- Sizing Information (Points of Measure, sizing names if applicable (ie S 5/6, M 7/8, etc))
- BOM – including all materials, trims, and hardware
 - [Template available here](#)

Vendor Owned Tech Pack to PLM - How to Upload

Access the style via style search:

KOHL'S Style Global Search

DESIGN CENTER Style: LIST

DESIGN CENTER DASHBOARD

Style

Advanced Search: Style

Style Search

Style No Request No

Description Development Stage

Season Commodity

Brand Division

Customer Product Type

Buy Program Product Category

Style Status Merchandise Code

Base Request No Created By

Dept

Actors

Product Manager Associate Product Manager

Product Coordinator Product Specialist

Designer Assoc/Asst Designer

Technical Designer Classification Contact

Operational Search

Field	Operation	Value
<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>

Change Tracking Search

Changes Since

BOM Component Search

Supplier Ref # Material Name

Vendor Owned Tech Pack to PLM - How to Upload

Alternatively, you can search more broadly by setting one or more search parameters.

In this example, the search results will only return styles assigned to you in SP25 under the Vera brand:

KOHL'S Style ▾ Quick Search Go Global Search

DESIGN CENTER < Style: LIST

DESIGN CENTER DASHBOARD

▸ Style

▼ Advanced Search: Style

Style Search

Style No	Request No	Product Manager	Associate Product Manager	Field	Operation	Value
<input type="text"/>	<input type="text"/>	<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> ▾	<input type="text"/> ▾	<input type="text"/>
Description	Development Stage	Product Coordinator	Product Specialist	<input type="text"/> ▾	<input type="text"/> ▾	<input type="text"/>
<input type="text"/>	<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> ▾	<input type="text"/> ▾	<input type="text"/>
Season	Commodity	Designer	Assoc/Asst Designer	Change Tracking Search		
<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> 🔍	Changes Since		
Brand	Division	Technical Designer	Classification Contact	--Select-- ▾		
<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> 🔍	<input type="text"/> 🔍			
Customer	Product Type	BOM Component Search				
<input type="text"/> 🔍	<input type="text"/> 🔍	Supplier Ref #				
Buy Program	Product Category	<input type="text"/> 🔍				
<input type="text"/> 🔍	<input type="text"/> 🔍	Material Name				
Style Status	Merchandise Code	<input type="text"/> 🔍				
<input type="text"/> 🔍	<input type="text"/>					
Base Request No	Created By					
<input type="text"/> 🔍	<input type="text"/>					
Dept						
<input type="text"/> 🔍						

Clear Fields Cancel Save **3** Search

Vendor Owned Tech Pack to PLM

Be sure to select the correct season - in this example SP25:

Style: LIST

Advanced Search: Style

Style List < 1 >

Mass Style Handoff Report Tech Spec All Report Tech Spec-Fit Active Report

<input type="checkbox"/>		Style No	Description	Development Stage	Request No	Base Request No	Style Status	Season	Commodity	Brand	Division
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	FIT APPROVED	00623685		CONFIRMED	SP21	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	FIT APPROVED	00632030		CONFIRMED	FA21	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	FIT APPROVED	00648531		CONFIRMED	SP22	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	FIT APPROVED	00661451		CONFIRMED	FA22	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	FIT APPROVED	00673146		CONFIRMED	SP23	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	NEW	00682055		CONFIRMED	FA23	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	CANCELLED	00692626		CONFIRMED	SP24	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	NEW	00711192		CONFIRMED	FA24	HOME	SONOMA	HOM
<input type="checkbox"/>		L <u>11SNBBPBS</u>	SN BOXPLEAT BEDSKIRT	DEVELOPMENT	00725752		NEW	SP25	HOME	SONOMA	HOM

Vendor Owned Tech Pack to PLM

Once in the style shell - navigate to the 'Attachments' tab:

Style: 11SNBBPBS

Overview Design Intent Constructions Instructions POM Samples BOM **Attachments** Indicators Events >>


▼ Style Overview

Smart Copy Request Sample Tech Spec All Tech Spec/Fit Active Style Handoff Report Refresh

► Style Status & Actors

▼ Style Information

Edit Image Large Image



[+]Add Image [-]Remove Image

Style Information

Style No	Style Description	Development Stage	TD Style Development Handoff
11SNBBPBS	SN BOXPLEAT BEDSKIRT	DEVELOPMENT	08/04/2024
TD Dev Location	Technical Designer	Base Request No	Design Handoff Date
MILWAUKEE	KATE ANDERSON		
Design Definition	Gender		

Tech Design Notes

Hierarchy Information

Fiscal Season	Commodity	Brand	Division
SP25	HOME	SONOMA	HOME-SOFT
Product Type			
BEDDING			

Apparel Attributes

Sourcing Type	Level of Newness	Hang/Fold	Multipack
POLYESTER			1

Vendor Owned Tech Pack to PLM

Navigate to an open line item on the "Attachments" tab.

Select "C" for the File Upload window to appear.

Add your file - be sure to add a description to help Kohl's identify the file.

Once added, you must select 'Save'.

Style: 115NBPPBS

Overview Design Intent Constructions Instructions POM Samples BOM Attachments Indicators Events >>

More Actions... Save

Attachments

Attachments Report Download files

Sort	Attachment No	Attachment Type	Description	Vendor	Attached By	Date
<input type="checkbox"/>	1	IMAGE	--Select--			SUSAN MORATH 20
<input type="checkbox"/>		IMG1	--Select--			MORATH 20
<input type="checkbox"/>			--Select--			
<input type="checkbox"/>			--Select--			

<input type="checkbox"/>	3	IMG2	--Select--		VENDOR TECH PACK ABC123	
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THANK YOU

Questions/Support:

Tech Design Training & Standards Team

angela.caruso@kohls.com

