Color Review Process & Evaluation Requirements

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Color Evaluation Guidelines
-
Getting Started

Color Lab Requirements, Color Standards,

Color Lab Requirements

Maintaining the proper environment for consistent color evaluation

- Lighting and Illuminants
- Conditioning Requirements
- Spectrophotometer Specifications

Color Lab Requirements

Lighting and Illuminants

Visual assessments should be performed in a light controlled room or a darkened environment with a standardized light box

- Lightbox needs to be away from exterior lighting (i.e. windows or other light fixtures)
- Lightbox needs to be free of papers or other submits

Kohl's Primary light source is SPX35 (3500)
Kohl's Secondary light source is Daylight (D65)

We encourage you to check your lightbulbs to ensure the correct output

- **GTI Graphic Technology** is our Preferred Light Bulb Supplier
  - Light bulbs can be purchased at http://www.GTIlite.com
  - For additional assistance, contact sales@gtilite.com or 845-562-7066(US)

Color Lab Requirements

Conditioning Requirements (Room or Cabinet)

Every sample and submit needs to be conditioned in a textile conditioning cabinet or conditioning room prior to color evaluation

- Samples that have not been conditioned will show color variance due to moisture and temperature (defined by ASTM)

Temperature	21°C +/- 2°
Relative Humidity (RH)	65% +/- 2%
Light Exposure	Required
Timing	• Conditioning Cabinet - 15 minutes • Conditioning Room - 4 hours minimum

Color Lab Requirements

Spectrophotometer Specifications

Instrument	Datacolor 800 *(or similar model)*
Software	Datacolor TOOLS PLUS version 2.0.1 *(or similar software)*
Profiling Software	Datacolor Maestro or Guardian *(or similar software)*
Color Difference	CMC (2:1)
Specular Component	Included (SCI)
UV Component	0% UV (Filter FL40)
Primary Illuminant	SPX35 (3500)
Secondary Illuminant	D65 (6500)
Observer	10 degree
Aperture:	LAV
Flashes:	2
Green Tile	Measured, checked, and stored to the green tile folder daily
Calibration Interval:	Every 8 hours

Kohl's Spectral Tolerance - Solids

- Lab dip: 0.8 CMC ΔE
- Bulk: 0.8 CMC ΔE

Annual Maintenance/Calibration is Required

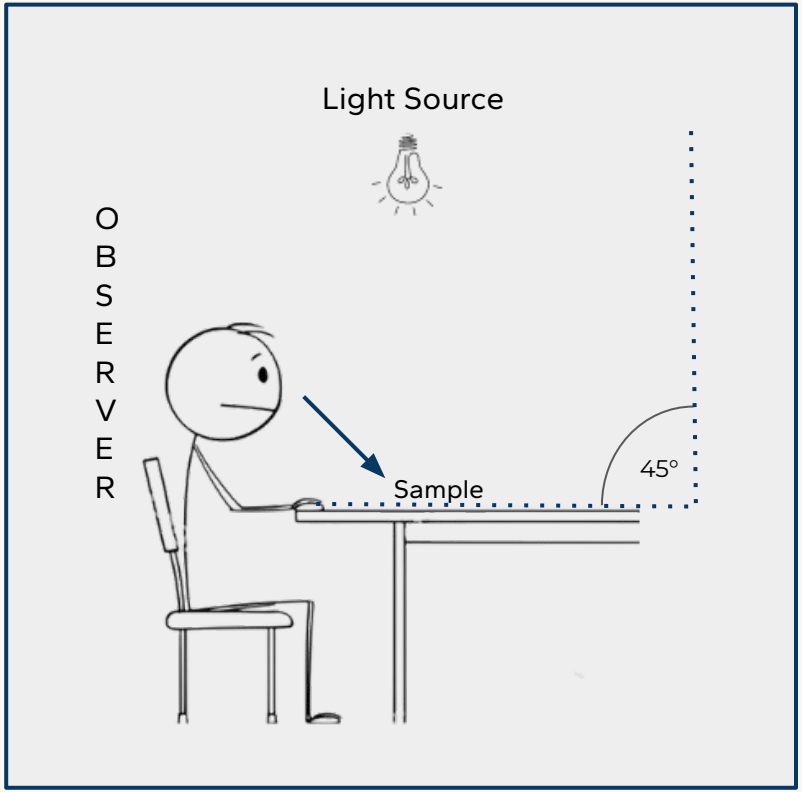
Color Lab Requirements

Viewing Angle

Viewing Angle

Just as controlled lighting is essential to viewing color, the angle at which a sample is viewed is just as important

- **Observer -** review the sample flat and at a **45° angle**
- **Light source** - **directly above** the sample



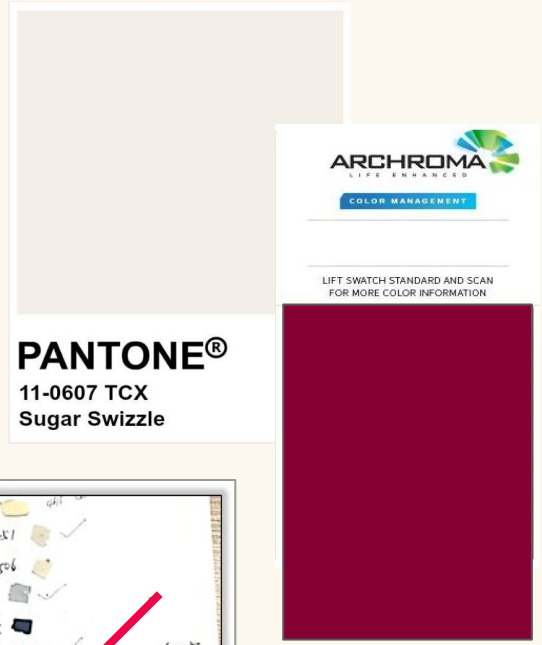
Color Standards

Maintaining color integrity

- Quality and Storage Requirements
- Service Providers

Color Standards

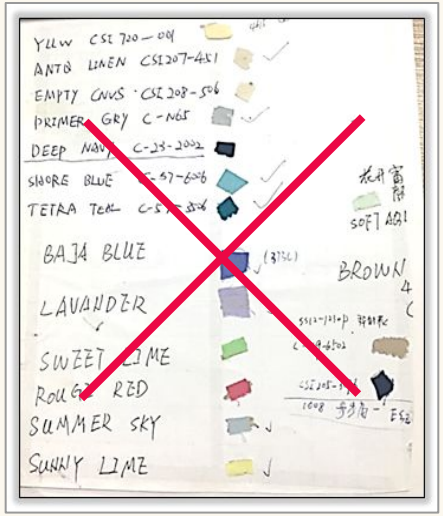
Quality and Storage Requirements



To maintain color integrity...

Color standards must:

- Maintain their original condition
  - Double layered, non-backed
  - Fully intact | **DO NOT CUT STANDARDS**
- Be stored in protected sheets or in a cabinet away from light and other contaminants



Light exposure and frequent use negatively impacts color validity.
To ensure quality and consistency:

- Standards should be **replaced seasonally**
- Catalogs and physical libraries should be **replaced every two years**

Kohl's Preferred Color Service Providers are:

- Archroma
- Pantone

Color Standards

Color Service Providers

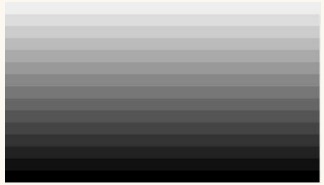
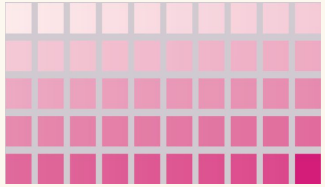
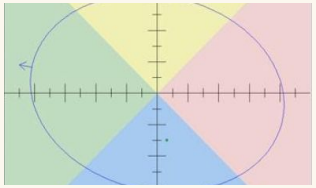
ARCHROMA LIFE ENHANCED	PANTONE®
4320 shades	2800 shades
Delivery within 3 Business Days	Delivery within 7 Business Days
Provides Dye Recipes for Cross Substrate Consistency	Globally Available Dyes
Master Digital Standard (QTX File) Provided with Each Color Standard Order	Master Digital Standard (QTX File) is Available to Purchase
Engineered Textile Color Standards	
Digital Color Resources and Color Match Technology	
Global Support	
Cotton Library	
Polyester Library	
Nylon Library	

Color Communication

Kohl's Global Color Language

Color Submit Review

How to Communicate Differences

Identify Differences	Determine Level of Difference	Examples
Value - Lighter or Darker 	Match	
	Slight	Color is slightly too **Dark**
Chroma - Brighter or Duller 	Moderate	
	Much	Color is slightly too **Bright**
Hue - Red | Green Blue | Yellow 	Off Shade	Color is slightly too **Red**

Comment on what you **SEE** - not how to fix it

**Do not communicate color changes in percentages, i.e. 10% lighter, etc., as this is subjective to the individual.*

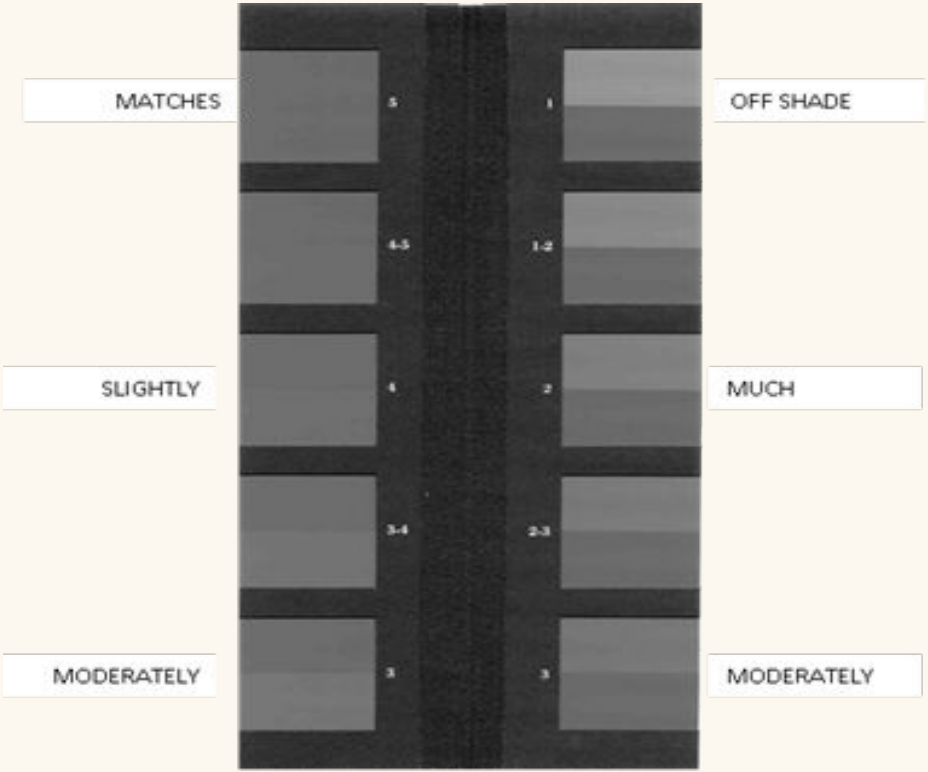
Color Submit Review

How to Communicate Differences | Magnitude

Determine
Level/Magnitude of Difference

Magnitude of difference is based on the AATCC Gray Scale for Color Change.

This can be purchased online from http://www.aatcc.org



Color Submit Review Process

Digital & Visual Review

Color Submit Review

Digital | Visual

Certified Colorists may choose to review digitally with a spectrophotometer or visually in a certified lab

Digital

- Spectral data is used to guide comments and make approvals, increases 1st round approval rates
- Improves development and cycle time between rounds
- Creates a digital color library
- Only applicable for solid, flat surfaced, and non-shiny fabrics
- Requires software maintenance and updates

Visual

- Visual assessment is done against textile color standards
- Cost efficient and managed by Certified Colorist
- Applicable to all fabrications, materials, and construction

Digital Color Review

A Step by Step Guide

Color Submit Review

Digital | Spectrophotometer

Certified Colorists have the authority to approve solid lab dips/bulk on Kohl's behalf based on spectral tolerance

Fabrics **must be solid and flat surfaced** (non-shiny)!

- Ex: interlock, jersey, rib, etc.

To Perform a Sample Reading:

1. Calibrate machine
2. Remove any obstructing items from samples *(i.e. labels and backing)*
3. Fold sample until opaque *(no light shining through)*
4. Lay sample so the front/face of the fabric is facing the aperture port
5. Ensure the sample is -
   a. Completely covering the aperture
   b. Flat without tension
   c. Not protruding into the sphere

Utilizes **Master Digital Standards** (QTX files) provided by Color Service Providers

Set tolerances of **0.8 cmc DE** in Primary Lightsource (SPX35) and **1.2 cmc DE** in Secondary (D65)

Ensures the **metamerism index is less than 1.0**

The below **cannot create accurate spectral data & cannot be approved digitally**!

- Colors: heathers, whites, neons
- Fabrications: velour, corduroy, french terry, bulky sweater knits, high shine fabrics
- Trims: both contrast and DTM

Color Submit Review | Process Recap | Not Color Certified

Digital | Spectrophotometer

Digital Lab Dip Approval Process

Color Palette Receipt & Ordering

Vendor/Mill receives color palette from Kohl's and orders color standards. The Master Digital Standard (MDS) is available as a QTX file immediately upon order placement

Lab Dipping

Mill creates lab dip

Spectral Read & Prescreening

Vendor/mill conducts a spectral measurement of the lab dip against the MDS. Based on Kohl's defined spectral tolerance, a preliminary pass/fail determination is made

1st Round Submission

The mill should submit 4–6 lab dips that fall within Kohl's spectral tolerance range for review by a Kohl's Certified Colorist

- If the mill is not certified, the lab dips must be sent to a Vendor Certified Colorist for evaluation.
- If the vendor is not certified, the lab dips must be submitted directly to Kohl's for approval

2nd Round Submission

If rejected, Kohl's Certified Colorist will enter comments in onePLM. Mill will reference comments to redye another set of 4-6 lab dips

BCD Request

If a second round is rejected and the vendor cannot achieve color consistency, they will send both rounds to Kohl's as a BCD request with an explanation/reasoning for the request

Digital Solid Bulk Approval Process

Bulk Creation

Vendor/Mill uses the spectral data from the approved lab dip to create bulk. This becomes the new Master Digital Standard (MDS)

Spectral Read & Prescreening

A vendor/mill colorist spectrally measures the bulk submit against the MDS (of approved lab dip)

1st Round Submission

If within spectral tolerance, bulk submit is sent to the Kohls Certified Vendor Colorist (if applicable) or Kohl's for approval

2nd Round Submission

If outside of spectral tolerance or rejected by Kohl's, vendor/mill must redye and resubmit up to two rounds

BCD Request

If second round is rejected or color consistency is unachievable, vendor will send Kohl's a BCD request with explanation/reasoning of request

Bulk Production

Once Kohl's formally approves bulk submit, mill may begin bulk production

Color Submit Review | Process Recap | Color Certified

Certified | Digital | Spectrophotometer

Digital Lab Dip Approval Process - Certified

Color Palette Receipt & Ordering

Vendor/Mill receives color palette from Kohl's and orders color standards. The Master Digital Standard (MDS) is available as a QTX file immediately upon order placement

Lab Dipping

Mill creates lab dip

Spectral Read & Approval

The Kohl's Certified Colorist performs a spectral measurement and compares the results to the MDS. Approval or rejection is determined using the CMC ΔE value within Kohl's established spectral tolerance.

Send Approval

Once lab dip is approved, a copy (attached to the proper submit form) should be sent to Kohl's for reference

BCD Request

If the Certified Colorist has rejected 8-12 lab dips (2 complete submit rounds) and the mill cannot achieve the intended color, all lab dip attempts should be sent to Kohl's for BCD consideration

Digital Solid Bulk Approval Process - Certified

Bulk Creation

Vendor/Mill uses the spectral data from the approved lab dip to create bulk. This becomes the new Master Digital Standard (MDS)

Spectral Read & Prescreening

A vendor/mill colorist spectrally measures the bulk submit against the MDS (of approved lab dip)

2nd Round Submission

If outside of spectral tolerance or visually rejected, bulk should be immediately re-dyed and evaluated again

BCD Request

If second round is rejected or color consistency is unachievable, vendor should send Kohl's a BCD request with the approved lab dip attached for reference and an explanation/reasoning of request

Bulk Production

Once approved by Kohl's Certified Colorist or Kohl's Color Team, mill may begin production

Visual Color Review

A Step by Step Guide

Solids

A Step by Step Guide

Color Submit Review | Process Recap | Not Color Certified

Visual | Solids

Visual Lab Dip Approval Process

Color Palette Receipt & Ordering

Vendor/Mill receives color palette from Kohl's and orders color standards. The Master Digital Standard (MDS) is available as a QTX file immediately upon order placement

Lab Dipping

Mill creates lab dip

Prescreening

Vendor/mill reviews lab dip against textile color standard and makes pass/fail decision. If the lab dip is visually close to standard, it can be submitted. If the lab dip does not match standard, it should be internally rejected

1st Round Submission

4-6 lab dips that match the textile color standard should be attached to a onePLM form and sent to a Kohl's Certified Colorist for approval.

- If the vendor is not certified, the lab dips must be submitted directly to Kohl's

If rejected, Kohl's will enter comments in onePLM based on what they see

2nd Round | BCD Request

Mill should reference comments from Certified Colorist and redye another set of 4-6 lab dips
If second round is rejected or color consistency is unachievable, vendor will send Kohl's a BCD request with an explanation/reasoning of request

Approval

Once lab dip is approved in onePLM, the vendor may begin the bulk submit process

Visual Solid Bulk Approval Process

Bulk Creation

Vendor/Mill uses the approved lab dip to create bulk

Prescreening

Mill partner compares bulk submit against the approved lab dip. If there is variation between the two, bulk should be internally rejected and re dyed

1st Round Submission

If bulk submit matches the approved lab dip, the bulk submit is sent to the Kohl's Certified Vendor Colorist (if applicable) or Kohls for approval.

2nd Round | BCD Request

Vendor/mill should reference comments in OnePLM to redye another bulk submit
If second round is rejected or color consistency is unachievable, vendor will send Kohl's a BCD request with explanation/reasoning of request

Bulk Production

Once Kohl's formally approves bulk submit, mill may begin production

Color Submit Review | Process Recap | Color Certified

Certified | Visual | Solids

Visual Lab Dip Approval Process - Certified

Color Palette Receipt & Ordering

Vendor/Mill receives color palette from Kohl's and orders color standards. The Master Digital Standard (MDS) is available as a QTX file immediately upon order placement

Lab Dipping

Mill creates lab dip

Colorist Review

The Kohl's Certified Colorist will review lab dip options against a textile color standard, using spectral data for reference.

Approve/Reject

If lab dip is rejected, the Certified Colorist will enter comments in onePLM for the Mill to improve and resubmit

Once approved, a copy is sent to Kohl's on a onePLM form and marked as "For Reference Only"

BCD Request

If a second round is rejected and the vendor cannot achieve color consistency, they will send it clearly marked to Kohl's as a BCD request with an explanation/reasoning for the request

Proceed to Bulk

Once lab dip is approved in onePLM, the vendor may begin the bulk submit process

Visual Solid Bulk Approval Process - Certified

Bulk Creation

Vendor/Mill uses the approved lab dip to create bulk

Colorist Review

The Kohl's Certified Colorist will compare bulk submit against the approved lab dip

Approve/Reject

If rejected, the Certified Colorist will enter comments in onePLM for the Mill to improve and resubmit

BCD Request

If second round is rejected or color consistency is unachievable, vendor should send Kohl's a BCD request with the approved lab dip attached for reference and an explanation/reasoning of request

Approval

Once approved by a Kohl's Certified Colorist or BCD approved by Kohl's, a copy is sent to Kohl's on a onePLM form and marked as "For Reference Only"

Bulk Production

Once onePLM reflects bulk approval, mill may begin production

Color Submit Review

Visual Color Evaluation | Pre-screening Lab Dips

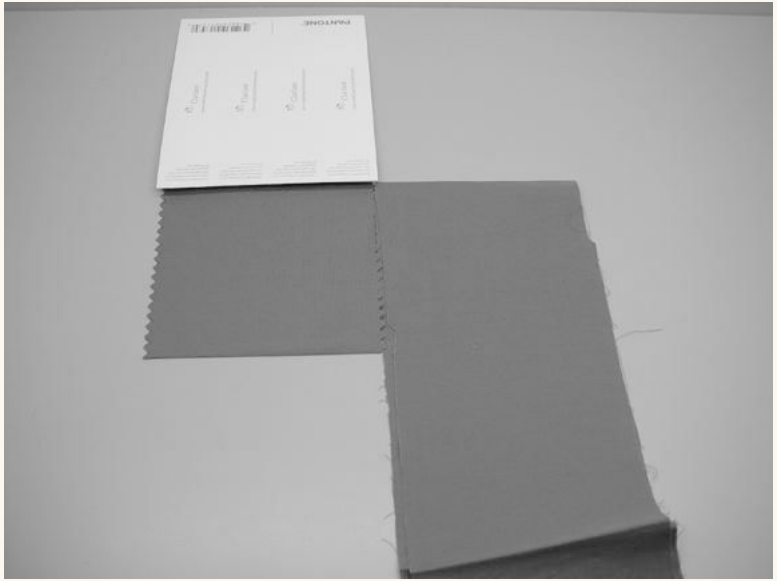
AREA PREP -

Before reviewing a submit, be sure to:

1. Pull all correlating/style history, color standards, and artwork, if applicable
2. Clear viewing area of all other samples/submits

SUBMIT REVIEW -

1. **Remove** each lab dip from the form one at a time. Lay the color standard and the fabric swatch flat on the viewing surface, **edge to edge, not overlapping**.
2. Place the color standard on the left side and the lab dip on the right.
3. The lab dip and standard must be double-folded and reviewed face side up (sheer fabrics must be folded in 4 layers to ensure opacity).
4. **Repeat** this with each lab dip to determine which is the **closest** to the color standard (you may also reference the spectral report to assist in this)
5. Determine if the lab dip is within tolerance and either...
    a. If Kohl's color certified - approve or reject and reference Kohl's Global Color Language to guide the mill in redyeing
    b. If not Kohl's color certified - send to Kohl's for color review



Color Submit Review

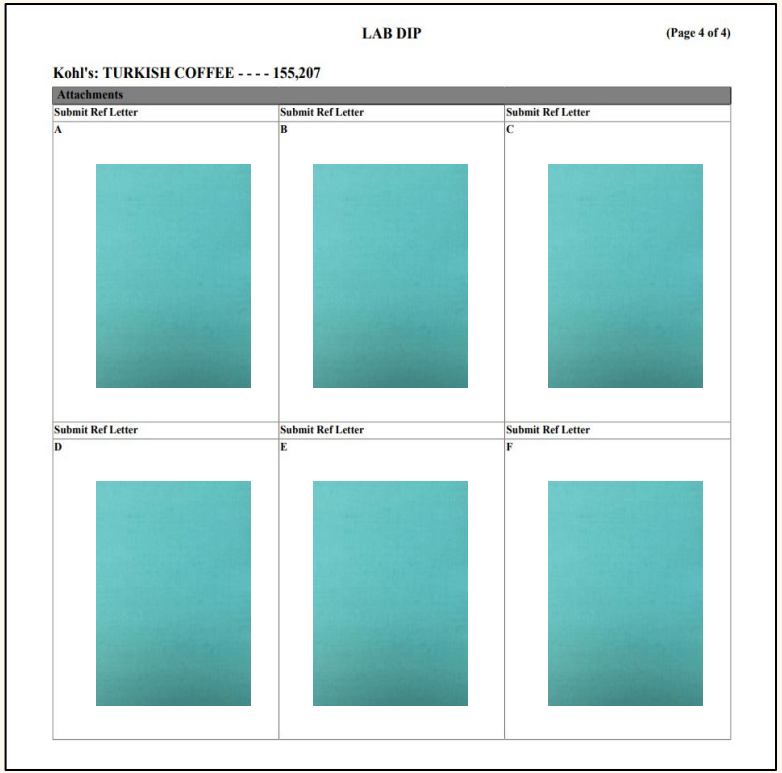
Visual Color Evaluation | Lab Dips

LAB DIP SUBMITS MUST -

- Be created in onePLM
- Sent on a complete and accurate onePLM form
- Fall within ΔE requirements
- Have a copy of spectral reading attached (if applicable)
- Be the correct swatch size
    - **Lab dip** - 8cm x 8cm with 6 options labeled A-F (subsequent round should be labeled G-K etc)
    - **Bulk** - 30cm x 30cm

ONCE APPROVED IN ONEPLM, MILL MAY PROCEED TO BULK

★ **If lab dip is part of a mixed media style, submit details for correlating fabrications should be noted on the front page for easy reference**



LAB DIP (Page 4 of 4)

Kohl's: TURKISH COFFEE - - - - 155,207

Attachments		
Submit Ref Letter	Submit Ref Letter	Submit Ref Letter
A	B	C
Submit Ref Letter	Submit Ref Letter	Submit Ref Letter
D	E	F

Color Submit Review

Visual Color Evaluation | Pre-screening Bulk

BULK SUBMIT REVIEW -

1. Remove bulk submission from the form. **Bulk is always reviewed against the approved lab dip, NOT the textile color standard**. Both should be flat on the viewing surface, edge to edge, not overlapping.

2. Place the approved lab dip on the left side and the bulk on the right.

3. The approved lab dip and bulk swatch must be double-folded and reviewed face-side up (sheer fabrics should be folded in 4 layers to ensure opacity).

4. Determine if the bulk is within tolerance and...

    a. If Kohl's color certified - approve or reject and reference Kohl's Global Color Language to guide the mill in redyeing
    b. If not Kohl's color certified - send to Kohl's for color review

*** Approved Lab dip ***

Bulk Submit

Color Submit Review

Visual Color Evaluation | Solid Bulk

SOLID BULK SUBMITS MUST -

- Be created in onePLM
- Sent on a complete and accurate onePLM form
- Fall within ΔE requirements
- Have a copy of spectral reading attached (if applicable)
- Be the correct swatch size
    - **Bulk** - 30cm x 30cm

★ **If bulk is part of a mixed media style, submit details for correlating fabrications should be noted on the front page for easy reference**

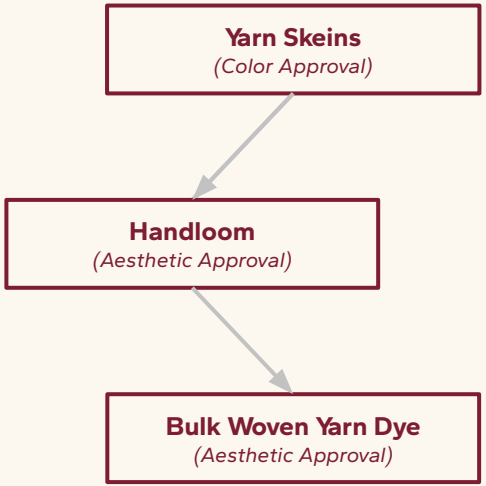
Wovens

A Step by Step Guide

Color Submit Review

Woven Process | Yarn Skeins | Handlooms | Bulk Woven Yarn Dyes

Colors are first individually reviewed as a yarn skein for all woven development



YARN SKEIN SUBMITS -

- Each color within the pattern should be submitted individually on its own onePLM “Yarn Skein” form
- Each skein should be at least 10cm long and 2cm wide
- 3-4 options per color/ per round are required

HANDLOOM -

- Submitted using approved yarn skeins on a "Handloom" onePLM form
- Kohl's Designer will review color aesthetically. If the overall aesthetic is rejected, the Designer may select new color standard(s), and a new handloom (and yarn skein) is required
- Minimum swatch size is 15cm x 15cm with a full pattern repeat

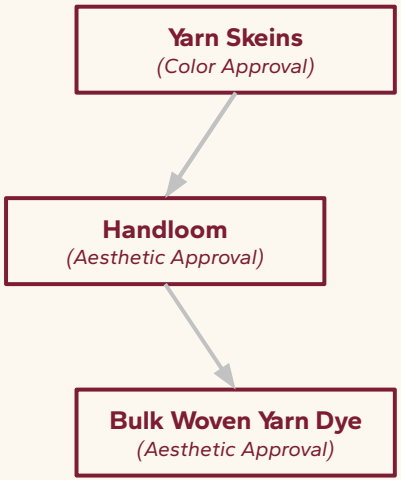
BULK WOVEN YARN-DYES -

- Submitted using approved yarn skeins to match the approved ‘Handloom’
- Sent on a ‘Woven Yarn Dye Bulk’ submit form
- Based on the approved handloom
- Minimum swatch size is 15cm x 15cm with a full pattern repeat

Color Submit Review | Wovens Process Recap

Yarn Skeins | Handlooms | Bulk Woven Yarn Dyes

Colors are first individually reviewed as a yarn skein for all woven development



Yarn Skein Approval Process

Color Palette Receipt & Ordering

Vendor/Mill receives color palette from Kohl's and orders color standards. The Master Digital Standard (MDS) is available as a QTX file immediately upon order placement

Yarn Skeins

Mill creates 3-6 yarn skeins for each color within a pattern.

Colorist Review

Kohl's Certified Colorist (or Kohl's) reviews individual yarn skeins against the textile color standard.

If yarn skein color is rejected, the Certified Colorist will enter comments in onePLM for the Mill to improve and resubmit

BCD Request

If a second round is rejected and the vendor cannot achieve color consistency, they will send it clearly marked to Kohl's as a BCD request with an explanation/reasoning for the request

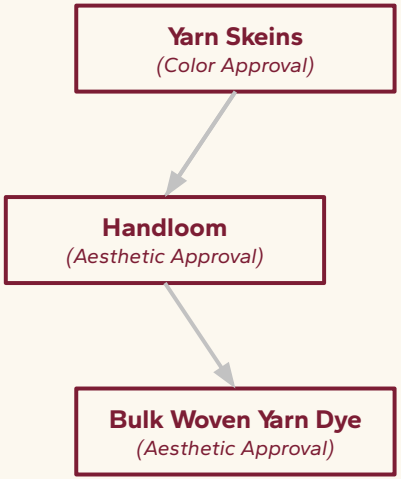
Once approved, a copy is sent to Kohl's on a onePLM form and marked as "For Reference Only"

Proceed to Handloom

Once all yarn skeins are approved in onePLM, the vendor may begin handloom creation

Color Submit Review | Wovens Process Recap

Yarn Skeins | Handlooms | Bulk Woven Yarn Dyes



Handloom Approval Process

Handloom

Vendor/mill uses color approved yarn skeins to make the handloom and sends it to the Kohl's design team for aesthetic approval.

Approval | BCD Request

Once the handloom is approved in onePLM, Bulk Woven Yarn Dye creation may begin

Bulk Woven Yarn Dye Approval Process

Bulk Creation

Vendor/Mill uses color approved yarn skeins to create a bulk woven yarn dye submit and sends to Kohl's for approval

Colorist Review

Kohl's Colorist reviews the bulk woven yarn dye against the handloom and approves or rejects color. If rejected, vendor needs to resubmit based on comments in onePLM

BCD Request

If second round is rejected or color consistency is unachievable, vendor will send Kohl's a clearly marked BCD request with an explanation/reasoning of request

Bulk Production

Once Kohl's formally approves in onePLM, mill may begin production

Prints & Knitdowns

Allover | Placement | Knitdowns

A Step by Step Guide

Color Submit Review

Prints & Knitdowns

ALLOVER PRINTS | PLACEMENT PRINTS | KNITDOWNS -

★ **If the print matches to another solid/print/pattern, all coordinating submits must be viewed together to ensure color matching**

Print & Knit Down Approval Process

Prescreening

Vendor prescreens the strike off/knitdown to ensure colors are within tolerance of textile color standards. Once achieved, vendor sends to Kohl's* for approval

Colorist Review

Kohl's* Colorist reviews strike off/knitdown for color and either approves or rejects and enters comments in onePLM

Rejected/BCD Request

If rejected, vendor must correct and re-submit. If after 2 rounds the color is still rejected, send to Kohl's as a BCD request

Approval

Once Kohl's formally approves in onePLM, vendor may proceed to the bulk submit process.

Visual Solid Bulk Approval Process

Bulk Creation

Vendor/Mill uses the approved strike off/knitdown to create bulk

Prescreening

Vendor partner compares bulk submit against the approved strike off/knitdown. If there is variation between the two, bulk should be internally rejected and re dyed

1st Round Submission

If bulk submit matches the approved strike off/knit down, the bulk submit is sent to the Kohl's Certified Vendor Colorist (if applicable) or Kohls for approval.

2nd Round | BCD Request

If rejected, vendor/mill should reference comments in OnePLM to redye another bulk submit
If second round is rejected or color consistency is unachievable, vendor will send Kohl's a BCD request with explanation/reasoning of request

Bulk Production

Once Kohl's formally approves bulk submit, mill may begin production

★ **All print & knitdown approvals are owned by Kohl's or a specially appointed vendor certified colorist**

Color Submit Review

Prints & Knitdowns

GRAPHIC/PLACEMENT PRINTS | ALLOVER PRINTS | KNITDOWNS

How to correctly send a graphic/placement print, allover print, or knitdown strike off to Kohl's -

- Must reflect accurate fiber content, fabric weight, and construction
- Every color within the print/pattern must be represented
- If the print coordinates with a solid or other print/pattern, all coordinating submits must be noted on the front submit page and included in the review process to ensure color consistency
- A minimum of 15cm x 15cm in size
  - Includes one full pattern repeat that's clearly marked (if the repeat is larger than 15cm)
- **All over prints:** ground color is included in strike off review and must be correct
- **Graphic/placement prints (strike offs):** must be sent on the correct ground fabrication that has been approved separately via lab dip OR, if the ground color is not yet approved, the submit should be sent on the closest available fabric and noted as "available" on the submit form
  - *Please note that the Color Team may reject reviewing color if the available fabric used is too different from design intent*
- C.I.P. (Correct in Production) approval status is never accepted

How to correctly send bulk prints and knit-yarn dye bulks to Kohl's -

- For placement prints, bulk must be sent on the actual fabric and approved ground color
- Bulk submit approval and Best Can Do requests are owned by the Kohl's Color and Design Teams

MILL/VENDOR PRESCREENING -

- Prior to submitting **strike-off/knitdown submits:** the vendor should review each color within the print against the textile color standard to ensure its within tolerance
- Prior to submitting **bulk prints and bulk knitdown submits**: the vendor should review the ground and each color within the print against the approved strike off or knitdown
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.

Specialty Yarns

Single Dye | Cross Dye

A Step by Step Guide

Color Submit Review

Specialty Yarns

SINGLE DYE | CROSS DYE PROCESS

Specialty Yarn Lab Dip Approval Process

Prescreening

Mill/vendor creates lab dips and reviews each option against the textile color standard to make a pass/fail decision. If the lab dip is close to standard, it can be sent to Kohl's. If the lab dip does not match standard, it should be internally rejected

Colorist Review

4-6 lab dips that match the color standard should be attached to a onePLM form and sent to Kohl's (or specially appointed certified vendor) for approval.

If rejected, Certified Colorist will enter comments in onePLM based on what they see

Rejected/BCD Request

If rejected, the mill must redye another set of 4-6 lab dips based on the comments in onePLM. If after 2 rounds the color is still rejected, send to Kohl's as a BCD request

Approval

Once lab dip is approved in onePLM, the vendor may begin the bulk process

Specialty Yarn Bulk Approval Process

Bulk Creation

Mill uses the approved lab dip to create bulk

Prescreening

Vendor/mill partner compares bulk submit against the approved lab dip. If they visually match, bulk can be sent to Kohl's for approval. If there is variation between the two, bulk should be internally rejected and re dyed

1st Round Submission

Bulk should be sent to Kohl's for final approval

If rejected, Kohl's will enter comments in onePLM based on what they see

2nd Round Submission

Vendor/mill should reference comments from Kohl's to redye another bulk submit

BCD Request

If second round is rejected or color consistency is unachievable, vendor will send Kohl's a BCD request with explanation/reasoning of request

Bulk Production

Once Kohl's formally approves bulk submit, mill may begin production

Color Submit Review

Specialty Yarns

SINGLE DYES | CROSS DYES

How to correctly send single dye or cross dye lab dips to Kohl's -

- Lab dips must be:
  - Submitted in the correct color, fiber content, construction, and weight
  - 8 cm x 8 cm each with 4 – 6 options attached, labeled A,B,C,D,E, and F. The second round submission, if required, should follow the same sequence and be labeled G, H, I, J, K, and L and so on

How to correctly send single dye or cross dye bulk to Kohl's -

- Bulk Submits must be:
  - 30 cm x 30 cm
  - Matched to the approved lab dip

MILL/VENDOR PRESCREENING -

- Prior to submitting **single dye/cross dye lab dips** to Kohl's, the mill and vendor should review each color against the textile color standard to ensure its within tolerance
- Prior to submitting **single dye/cross dye bulk submits**, the vendor should reference the approved lab dip to ensure bulk is within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

★ **All single dye and cross dye approvals are owned by Kohl's or a specially appointed vendor certified colorist**

Heathers

A Step by Step Guide

Color Submit Review | Process Recap | Preferred Yarn Supplier

Heathers

HEATHER SUBMIT PROCESS - PREFERRED YARN SUPPLIER

Kohl's Preferred Heather Yarn Suppliers
• Bro's • Danx

Heather Lab Dip Approval Process - Preferred Heather Yarn Supplier

Bulk Request

Vendor may proceed directly to bulk if yarns are ordered from a Preferred Heather Yarn Supplier.

Color Review

Kohl's or Kohl's Certified Colorist reviews bulk against the textile color standard and approves or rejects.

2nd Round Submission

If rejected, vendor/mill should reference comments from the Certified Colorist to redye another bulk submit

BCD Request

If a second round is rejected and the vendor cannot achieve color consistency, they will send it to Kohl's clearly marked as a BCD request with an explanation/reasoning of request

Approval

Once Kohl's formally approves bulk submit, mill may begin production

Color Submit Review | Process Recap | Not Preferred Yarn Supplier

Heathers

HEATHER SUBMIT PROCESS

Heather Lab Dip Approval Process

Prescreening

Mill/vendor creates lab dips and reviews each option against the textile color standard to make a pass/fail decision.If the lab dip does not visually match standard, it should be internally rejected

Colorist Review

4-6 lab dips that match the color standard should be attached to a onePLM form and sent to Kohl's (or Kohl's Certified Colorist) for approval.

If rejected, comments will be entered in onePLM based on what is seen

Rejected/BCD Request

If rejected, the mill must redye another set of 4-6 lab dips based on the comments in onePLM. If after 2 rounds the color is still rejected, send to Kohl's as a BCD request

Approval

Once lab dip is approved in onePLM, the vendor may begin the bulk submit process.

If approved by a Kohl's Certified Colorist, a "For Reference" copy must be sent to Kohl's to have on file.

Heather Bulk Approval Process

Bulk Creation

Mill references the approved lab dip to create a bulk submit

Prescreening

Vendor/mill partner compares bulk submit against the approved lab dip. If they visually match, bulk can be sent to Kohl's or Kohl's Certified Colorist for approval. If there is variation between the two, bulk should be internally rejected and re dyed

Colorist Review

Bulk should be sent to Kohl's or Kohl's Certified Colorist for final approval

If rejected, comments will be entered in onePLM based on what is seen

2nd Round Submission

If rejected, vendor/mill should reference comments in OnePLM to redye another bulk submit

BCD Request

If second round is rejected and color consistency is unachievable, vendor will send Kohl's a BCD request with explanation/reasoning of request

Bulk Production

Once Kohl's formally approves bulk submit, mill may begin production

Color Submit Review

Heathers

HEATHER LAB DIPS & BULK COLOR PROCESS

Kohl's Preferred Heather Yarn Suppliers
• Bro's • Danx

How to correctly send heather lab dips to Kohl's -

- Lab dips must be:
  - Submitted in the correct color, fiber content, construction, and weight
  - 8 cm x 8 cm each with 4 – 6 options attached, per round, labeled A,B,C,D,E, and F. *(the second round submission, if required, should follow the same sequence and be labeled G, H, I, J, K, and L and so on)*

How to correctly send heather bulk to Kohl's -

- Bulk Submits must be:
  - 30 cm x 30 cm
  - Matched to the approved lab dip

PREFERRED HEATHER YARN SUPPLIERS

- Yarns ordered directly through a preferred heather supplier can skip lab dipping and proceed directly to bulk submit development
- All other yarn suppliers are required to submit lab dips for their heather yarns

MILL/VENDOR PRESCREENING -

- Prior to submitting **heather lab dips** to Kohl's, the mill and vendor should review each option against the textile color standard to ensure its within tolerance
- Prior to submitting **heather bulk submits**, the mill and vendor should reference the approved lab dip to ensure bulk is within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

Embroidery/Applique

A Step by Step Guide

Color Submit Review | Process Recap

Embroidery/Applique

Embroidery/Applique Color Submit Process

Prescreening

Mill/vendor creates embroidery/applique submit and reviews each color against the textile color standard to ensure color matching. If colors are within tolerance, submit can be sent to Kohl's, otherwise the submit should be internally rejected

Colorist Review

Kohl's reviews the submit against textile color standards and approves or rejects color

Rejected/BCD Request

If rejected, the mill must reference comments in onePLM and resubmit.

If a second round is rejected and the vendor cannot achieve color consistency, they should send it to Kohl's clearly marked as a BCD request with an explanation/reasoning of request

Approval

Once the embroidery/applique submit is approved in onePLM, the vendor may begin production

Color Submit Review

Embroidery/Applique

How to correctly send embroidery/applique submits to Kohl's -

- Embroidery/appliques must be sent on the correct ground fabrication that has been approved separately via lab dip/raw material confirmation form
  - *If the ground color is not yet approved, the submit should use the closest available fabric and noted as "available" on the submit form.*
  - *Please note that the Color Team may reject reviewing color if the available fabric used is too different from design intent*
- Entire embroidery/applique pattern must be represented for proper color evaluation
- If the embroidery color/applique coordinates with a solid or other print/pattern, all coordinating submits must be noted on the front submit page and included in the review process to ensure color consistency

BULK EMBROIDERY/APPLIQUE - Kohl's does not require a bulk submit for embroidery and appliques

MILL/VENDOR PRESCREENING -

- Prior to submitting an embroidery/applique submit to Kohl's, the mill and vendor should review each color against the textile color standard to ensure its within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

★ **All embroidery/applique approvals are owned by Kohl's**

Trims

Contrast | Dyed to Match

A Step by Step Guide

Color Submit Review | Process Recap

Trims | Contrast & Dyed to Match (DTM)

Trim Color Submit Process

Prescreening

The mill/vendor creates the trim and prescreens it against the textile color standard and approved body fabric (if applicable) to ensure color matching before sending it to Kohl's

Colorist Review

Kohl's or Kohl's Certified Colorist reviews the trim approves or rejects color

Rejected/BCD Request

If rejected, the mill must reference comments in onePLM and resubmit.

If a second round is rejected and the vendor cannot achieve color consistency, they should send it to Kohl's clearly marked as a BCD request with an explanation/reasoning of request

Approval

Once the trim submit is approved in onePLM, the vendor may begin production

Color Submit Review

Trims | Contrast & Dyed to Match (DTM)

How to correctly send contrast and DTM trim submits to Kohl's -

- Contrast and DTM trims must be submitted in the correct construction or ornamentation for proper evaluation
- Approved body/garment fabric details (ideally bulk) should be noted for easy reference and included in the review process to ensure color consistency

BULK TRIM & FINDINGS - Kohl's does not require a bulk submit for trims

MILL/VENDOR PRESCREENING -

- Prior to submitting a trim submit to Kohl's, the mill and vendor should review against the textile color standard to ensure its within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

PREFERRED TRIM SUPPLIERS

The below trims must be sourced from a Preferred Trim Supplier. Please see our most updated matrix on KLINK

- Buttons & Metal Hardware
- Thread
- Elastic
- Interlining
- Zippers

Sweaters

Solids | Knitdown

A Step by Step Guide

Color Submit Review

Sweaters

SOLIDS

How to correctly send <u>sweater lab dips</u> to Kohl's -

- Lab dips must be:
  - Submitted in the correct yarns in a jersey stitch for color approval
    (If lab dip (or bulk) is submitted for color review in a different/available stitch, it must be indicated in the "comments" section in onePLM)
  - 8 cm x 8 cm each with 4 – 6 options attached, labeled A,B,C,D,E, and F. The second round submission, if required, should follow the same sequence and be labeled G, H, I, J, K, and L and so on

How to correctly send <u>sweater bulk</u> to Kohl's -

- Bulk Submits must be:
  - Sent in a jersey stitch
  - 30 cm x 30 cm
  - Matched to the approved lab dip
- Once approved for color, a "For Reference" submit must be sent in the actual yarn quality, size, gauge, and stitch for record keeping. Each stitch must be represented. If a style has multiple stitches, each stitch should be sent together as "for reference"

MILL/VENDOR PRESCREENING -

- Prior to submitting **sweater lab dips** to Kohl's, the mill/vendor should review each color against the textile color standard to ensure its within tolerance
- Prior to submitting **sweater bulk submits**, the mill/vendor should reference the approved lab dip to ensure bulk is within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl's if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

Color Submit Review

Sweaters

KNITDOWNS

How to correctly submit a sweater knitdown:

- If a knitdown is being sent for a sweater:
  - All main and accent colors within the knitdown must be represented
  - Once a yarn is color approved, it can be used for multiple patterns and styles.
    - Clearly mark the submit form if a color has been previously approved within another pattern
    - Use a chart to track color approvals for both solids and knitdowns (example below)

- All knitdowns need to be sent on a onePLM “knitdown” submit form.
  - Top Dye
    - Solid Effect - follow the solid color approval process
    - Heather Effect - must be submitted as a lab dip or a knitdown. Follow solid color approval process.
  - Melange
    - If using a preferred heather yarn supplier, a knitdown is not required. A bulk submit can be sent directly to a Certified Vendor Colorist for final color approval
- Counter samples sent for Design/Production reference or Milestone Meetings cannot be used as a substitute for submit approval. A knitdown submit is always required, despite sample status!
- Bulk Knitdowns and Best Can Do requests are owned by the Kohl’s Color and Design Teams

COLOR NAME	COLOR CODE	REFERENCE #	ARTWORK #	PATTERN NAME	1st Round Knitdown	2nd Round Knitdown	Including Pattern No.	COMMENTS
		EXAMPLE						
1. Evening Blue	19-3815 TCX	17,111	FA4SNM385A	NVY BLU TN	8/15 rejected submit #78,569, make mod. Less red, and deeper	9/5 approved submit 78,569	HY4SNM390A - RED CRM HB HY4SNM394B - NVY GRN HB	

Color Submit Review

Sweaters

BULK KNITDOWNS

How to correctly submit a sweater bulk knitdown :

- Bulk Submits must be:
  - Sent in a jersey stitch
  - 30 cm x 30 cm
  - Matched to the approved lab dip
- Once approved for color, a “For Reference” submit must be sent in the actual yarn quality, size, gauge, and stitch for record keeping. Each stitch must be represented. If a style has multiple stitches, each stitch should be sent together as “for reference”

Kohl’s Approval:

- Any Bulk Knitdown, that does not meet visual requirements and cannot be approved by a Certified Vendor colorist must be sent to Kohl’s as a BCD (Best Can Do)

MILL/VENDOR PRESCREENING -

- Prior to submitting **sweater lab dips**, the mill and vendor should review each color against the textile color standard to ensure its within tolerance
- Prior to submitting **sweater bulk submits**, the vendor should reference the approved lab dip to ensure bulk is within tolerance
- The vendor has authority (and is encouraged) to internally reject submits that do not match color standards
- Submits should only be sent to Kohl’s if all colors are approvable based on visual evaluation.
- C.I.P. (Correct in Production) approval status is never accepted

OnePLM and Submit Forms

How to ensure the correct submit forms are used

Submit Types
&
OnePLM Forms

Color Submit Review

ONEPLM COLOR SUBMIT MODULE - Submit Types and Correlating OnePLM Form Guide

To determine the correct submit form, identify your submit type in the far left column *("SUBMIT/TYPE")* and reference the initial and bulk form listed within that row.

SUBMIT / TYPE	INITIAL SUBMIT FORM →	BULK SUBMIT FORM
SOLID	LAB DIP	SOLID BULK
SINGLE DYE	SINGLE DYE LAB DIP	SINGLE DYE BULK
CROSS DYE	CROSS DYE LAB DIP	CROSS DYE BULK
HEATHER	HEATHER LAB DIP	HEATHER BULK
SPACE DYE	SPACE DYE LAB DIP	SPACE DYE BULK
GRAPHIC/ALL OVER PRINT	STRIKE OFF	PRINT BULK
WOVEN	1. YARN SKEIN - COLOR APPROVAL 2. HANDLOOM - AESTHETIC APPROVAL BY DESIGN	WOVEN YARN DYE BULK
HEAVY WASHED WOVEN	1. YARN SKEIN - COLOR APPROVAL 2. HANDLOOM - WITH BEFORE WASH/AFTER WASH - AESTHETIC APPROVAL BY DESIGN	1. WOVEN YARN DYE BULK 2. WASHED SHADEBAND
KNIT YARN DYE	KNITDOWN	KNIT YARN DYE BULK
TRIMS	TRIM & FINDINGS	N/A
***APPROVED/CARRY OVER LAB DIP FROM A PREVIOUS SEASON**	BULK (FOR REFERENCE)	N/A
EMBROIDERY/APPLIQUE	EMBROIDERY/APPLIQUE	N/A

Submits in OnePLM

OnePLM | Submit Module Overview

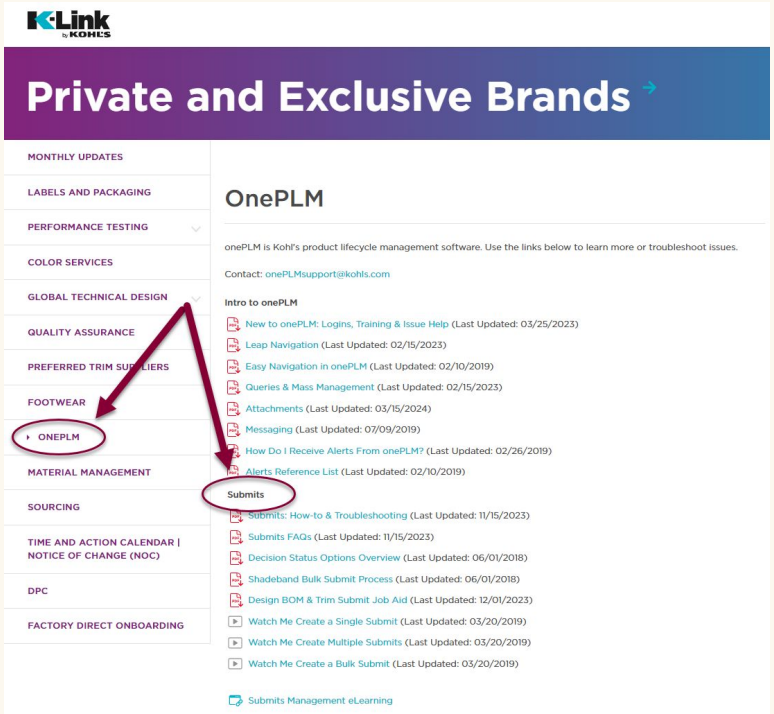
HOW TO GUIDES

Using onePLM for submit creation is essential - it links all components through the development, costing, and production process

Once Kohl's creates a style in onePLM, the **vendor initiates submit creation within the BOM tab**

Before sending to Kohl's...

- Vendor must manually check off what needs to be reviewed within the submit (Color, Quality, or Pattern/Layout)
- Color names and color codes should be listed either within onePLM or manually written on form
- Correct stamps must be used to indicate:
  - For Reference
  - Best Can Do Request
  - Mill/Vendor Approval/Rejection
  - Digital Approval
  - Certified Colorists Name/Signature



SUBMIT CREATION

Training on submit creation and usage can be found on KLink

K-LINK → RESOURCES → PRIVATE AND EXCLUSIVE BRANDS → ONEPLM → SUBMITS

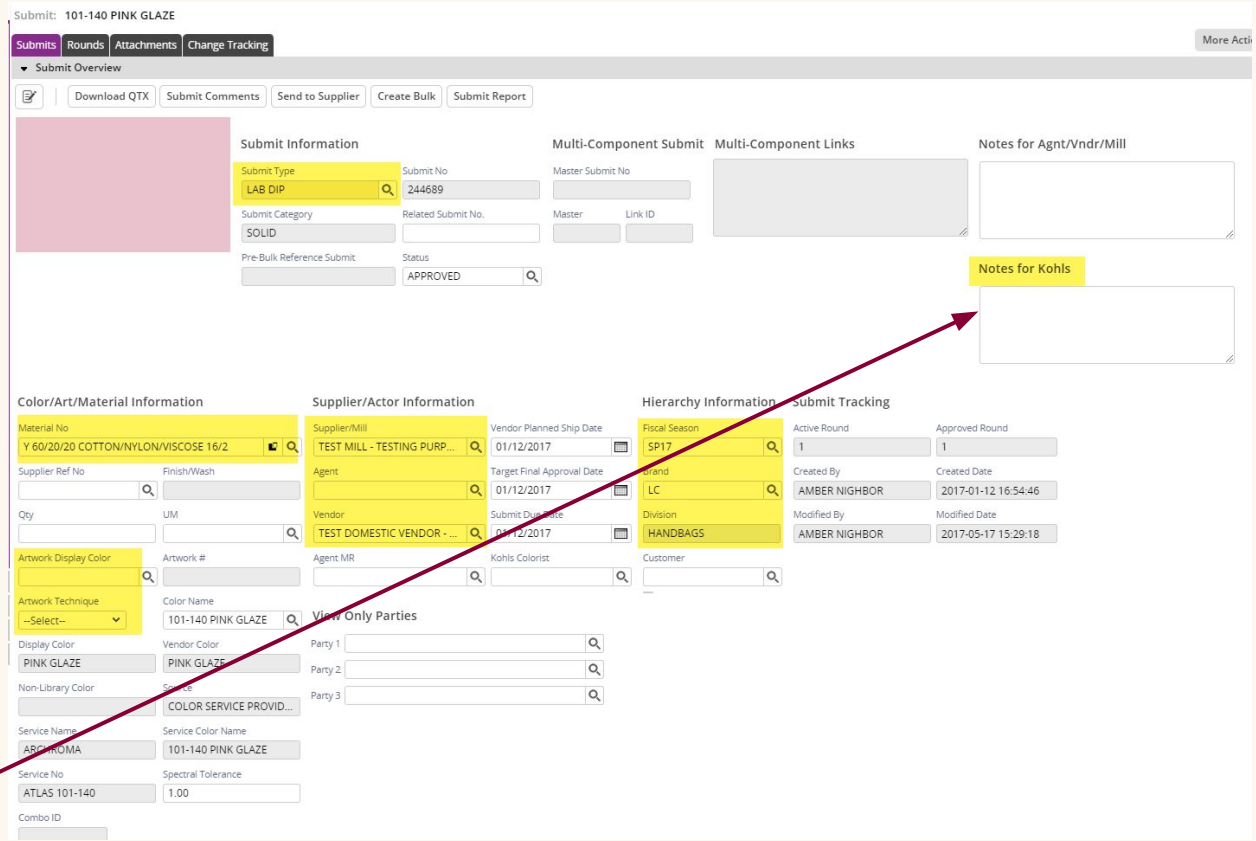
OnePLM | Submit Module Requirements

REQUIRED FIELDS TO COMPLETE IN ONEPLM

Required Fields

- Submit Type
- Material Number
- Color Name
- Artwork Number (if applicable)
- Artwork Technique (if applicable)
- Supplier/Mill
- Agent (if applicable)
- Vendor
- Fiscal Season
- Brand
- Division

Good place to callout colors within artwork or any coordinating/mixed media submits that should be referenced

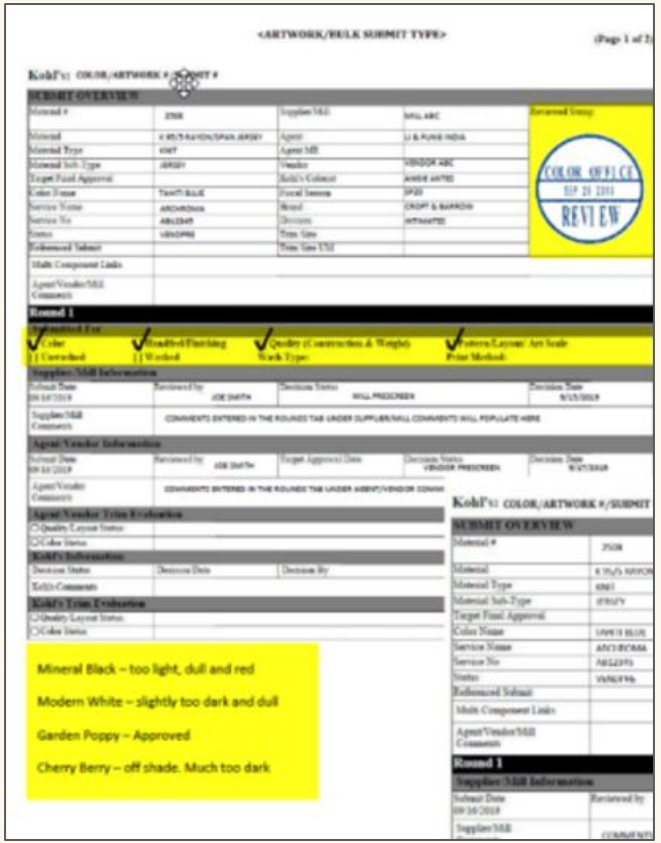


OnePLM | Final Submit Checklist

QUESTIONS TO ASK BEFORE SENDING SUBMITS

Submit Form

- Is the attached submit within spectral tolerance (solids)?
- Does the attached submit match the textile color standard(s)?
- Is the submit form completely and correctly filled out?
- Are the checkboxes marked to reflect what needs to be reviewed?
- Are there any trims or other fabrications that should be reviewed alongside this submit?
    - If so, are those submit numbers noted on the form?
- Is a copy of the artwork attached? Or are the color names listed on the submit form?



Color Certification Program

The **Kohl's Color Certification Program** is designed to promote agility, global best practices, and a higher level of color proficiency with our vendor and mill partners.

Color Certification Program

Introduction

WHAT IS IT?

The Kohl's Color Team has worked to certify colorists around the world. Each participant has gone through an extensive training and correlation process to earn their title and the ability to make color comments and approvals on Kohl's behalf. These colorists should be used as much as possible.

It is important to note that **certification is based the individual, not company**. It is possible that a mill or vendor loses their approval authority if their Certified Colorist leaves.

WHAT TYPE OF SUBMIT CAN A CERTIFIED COLORIST REVIEW?

Based on each Colorist's experience/training, we recently developed an additional tier of certification that expands approval authority. Please see the individual Colorist's certificate for details on their scope of ownership.

PARTICIPATION

At this time, participation in Kohl's Color Certification Program **is by invitation only.**

We strategically work with our sourcing team to select vendor and mill partners aligning with our global sourcing strategy.

REQUIREMENTS TO BECOME CERTIFIED

01 Qualified Colorist Nomination

02 Color Lab/ Darkened Environment

03 Conditioning Room or Cabinet

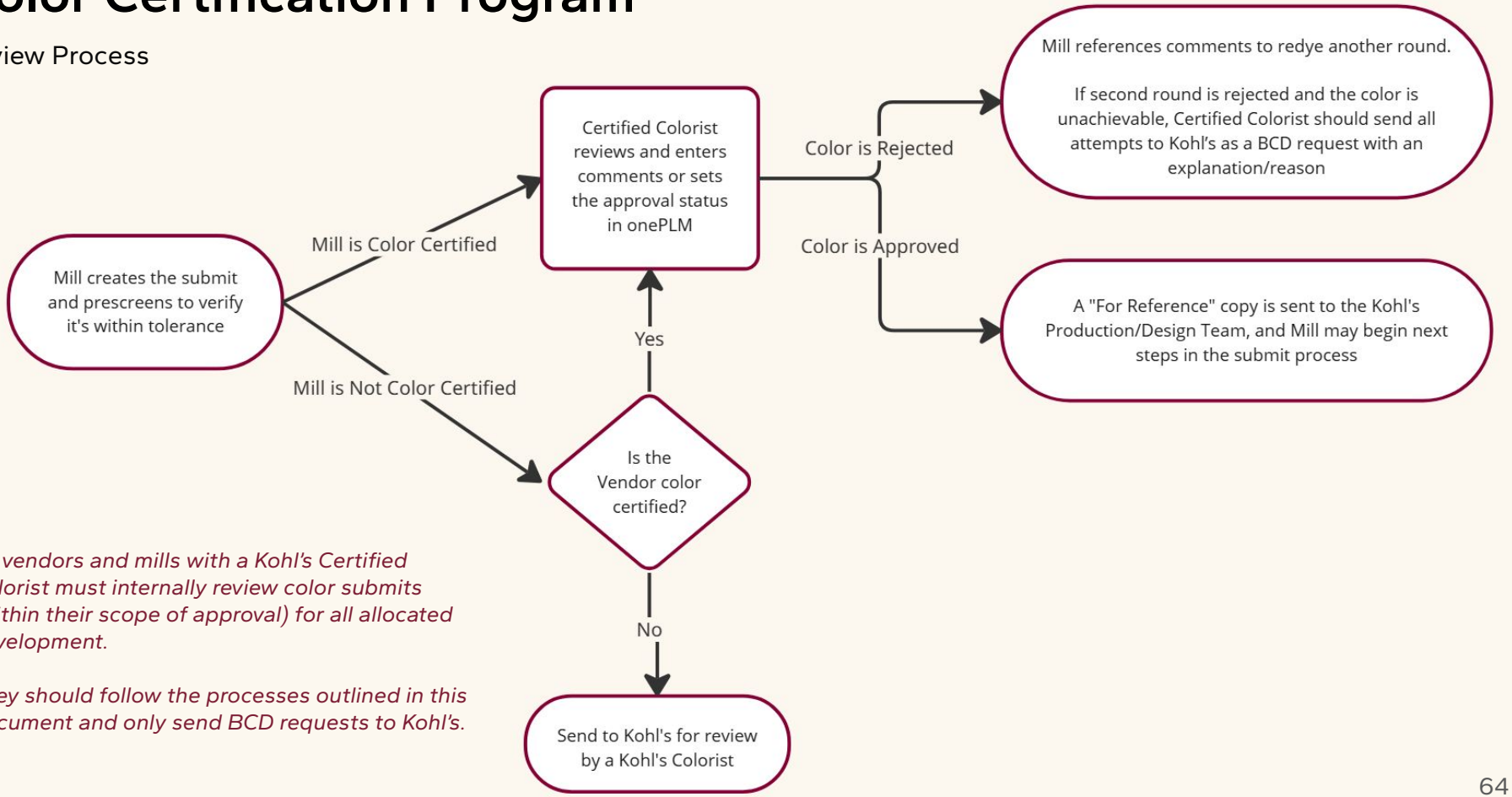
04 Light Box & Light Bulb Log

05 Spectrophotometer QC Software Profiling Software

06 Certified Color Standards

Color Certification Program

Review Process



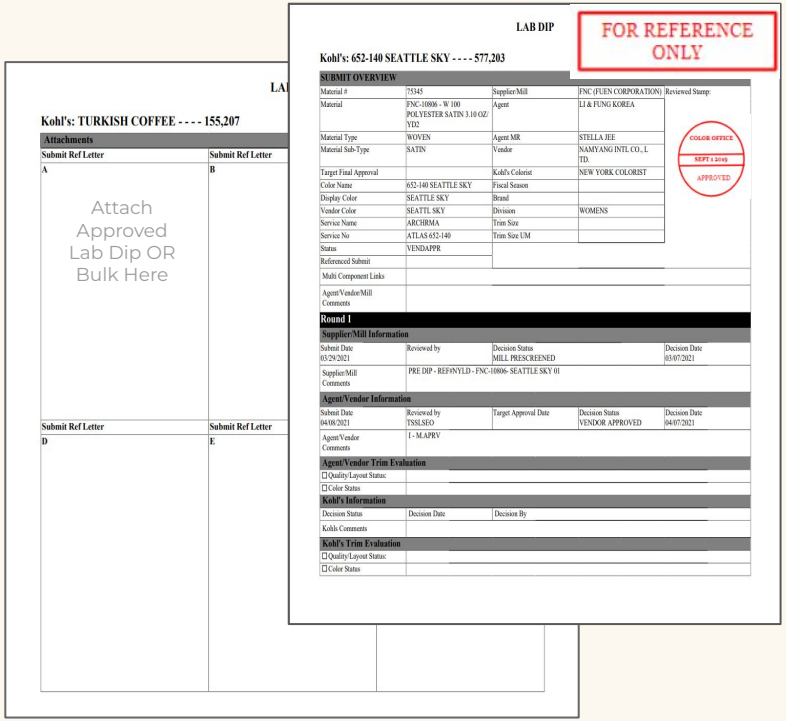
All vendors and mills with a Kohl's Certified Colorist must internally review color submits (within their scope of approval) for all allocated development.

They should follow the processes outlined in this document and only send BCD requests to Kohl's.

Color Certification Program

Sending Approved Submits to Kohl's

Once approved, all submits reviewed by a Kohl's Certified Colorist should be sent to Kohl's for reference and record keeping.
These should be clearly marked as "FOR REFERENCE ONLY".



To send Kohl's an approved submit for reference, it must meet the specified requirements below:

- Be within approval tolerance
- Be created in onePLM
- Submitted on onePLM form
- Have all required fields filled out
- Have copy of the spectral reading included
- Be 8cm x 8cm in size for lab dip and 30cm x 30cm in size for bulk
- Be stamped to indicate the approval

Mills/Vendors should maintain a 'Kohl's Approval Library' consisting of a physical swatch and dye recipe for future reference.
An approval can be applied to more than one style/brand if the mill/fabrication/color is the same
(This does not include BCD approvals)

Best Can Do (BCD) Submits

Requirements for Requesting BCD Approval

*A **best can do (BCD) approval** is requested when an acceptable color match is not possible due to technical and/or time limitations*

To send Kohl's a BCD Request -

- Show at least 2 rounds have been attempted
  - All rounds should be included for reference
- Each submit must be stamped as 'Rejected' and either 'BCD Technical' or 'BCD Timing'
- Include an explanation as to why the color cannot be achieved
- Check marks must be added to indicate what the submit was sent for (Color, Handfeel, Quality etc)

SOLID BULK

BCD REQUEST

(Page 2 of 3)

Kohl's: PURPLE WINE - - - - 123,456

SUBMIT OVERVIEW				
Material #	15308	Supplier/Mill	H.C.T.TEXTILE LTD.	Reviewed Stamp:
Material	W 100 POLYESTER GEORGETTE 3.3 OZ/YD2	Agent	LI & FUNG KOREA	
Material Type	WOVEN	Agent MR	MORGAN LEE	
Material Sub-Type	GEORGETTE	Vendor	GG INTERNATIONAL MANUFACTURING.CO.LTD	
Target Final Approval		Kohl's Colorist	JENNIFER DELA CRUZ	
Color Name	PURPLE WINE	Fiscal Season		
Display Color	PURPLE WINE	Brand		
Vendor Color	PURPL WINE	Division	WOMENS	
Service Name	PANTONE	Trim Size		
Service No	18-2929 TCX	Trim Size UM		
Status	APPROVED			
Referenced Submit				
Multi Component Links				
Agent/Vendor/Mill Comments	WAPR151015RE2			

COLOR OFFICE
SEPT 1 2019
REJECTED

Round 1

Submitted For

[✓] Color **[✓] Handfeel/Finishing** **[✓] Quality (Construction & Weight)**

[ ] Unwashed **[ ] Washed** **Wash Type:**

Only the internal Kohl's Color or Design Team can approve BCDs!

Color Submit Review

Key Reminders

CARRY OVER APPROVALS-

(this does not apply to bcd approvals!)

If a mill and fabrication are maintained, approved lab dip and bulk submits...

- Can be used across multiple styles/brands
- Can be referenced in the next season
  (however the mill must create and send Kohl's a new correlating bulk submit for reference)

KOHL'S COLOR LIBRARY

(this does not apply to bcd approvals!)

Vendors and mills should maintain a 'Kohl's Approval Library' that contains a physical swatch and dye recipe of approved submits for future reference

CORRECT IN PRODUCTION/BULK -

This process/approval condition is never accepted for Kohl's submits. If a Best Can Do (BCD) request is outside the internal Kohl's Color Team tolerance, the vendor may request aesthetic approval from the design team

OVERALL OWNERSHIP -

The vendor is ultimately responsible for the color integrity of the product shipped to Kohl's

Submit Process | Frequently Asked Questions

Where do I send submits that need color comments?	All submits should be sent to the correlating production office
Who do I send color submits to?	All submit packages should be addressed to the production coordinator
How many copies of each submit do I send?	For organizational purposes within Kohl's - please only send 1 copy of each submit! There is an internal process within Color and Design to review accordingly
What is the turnaround time to receive Kohl's color comments?	The Kohl's Color Team is in the office Monday - Thursday. We review all submits within 24 hours of receiving submit in Color Office*. *Note, tracking numbers only confirm arrival to our corporate mailroom. Please give our mail team time to sort and deliver packages to individual offices
What form should I attach the submit to?	All submits should be created in onePLM and sent on the corresponding submit form. Please reference *'Submit Types & Correlating onePLM Form Guide'*
How many rounds per submit are required prior to a BCD request?	Kohl's requires at least 2 rounds before requesting a BCD approval
Once a lab dip or bulk is approved, how many seasons is the approval valid?	**Lab dips** are approved infinitely as long as the color, mill, and fabrication are the same. **Bulk** needs to be resubmitted seasonally. MILL is responsible for maintaining the Kohl's approved dye recipe for future bulks of the same color, fabric, and mill within a Kohl's approval library. This does not include BCD approvals - **ALL BCD's MUST BE RESUBMITTED**

Shade Band Process

Outline of our wash / shade band process to provide a clear understanding of approval responsibility, expectations and ownership across all of Kohl's brands and divisions.

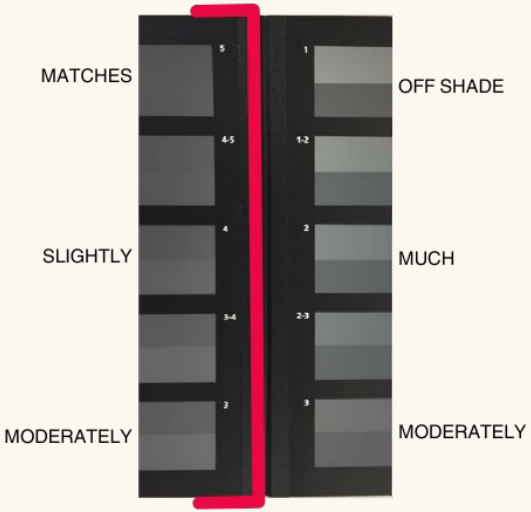
Shade Bands | Kohl's Color Evaluation

Step 1
Visual Evaluation

Kohl's colorist or Designer will review all submits in the proper viewing condition and light source.

Step 2
Tolerance Evaluation

Determine **tolerance**. Ensure submits are within a visual range of a **3-5** compared to the grayscale.



Step 3
Evaluation Guidelines

- Review each submit/sample against the original standard and compared to the other samples within the same shade band/lot.
- Ensure the hue of each submit/sample is within the same family of color (red/blue/yellow/green)
- Value (lightness/darkness) and Chroma (brightness/dullness) should also be considered.
- Select and approve a minimum of 4 shades.

Scenario #1 | **New Program**

New program | New colors | No previous approvals

Lab Dips
based on color standard

***Fabric cuttings should not be used as a standard!**

Unwashed & Washed Bulk
based on the approved lab dip

A washed bulk submit is required prior to the vendor submitting shade bands

Shade Band
based on the approved bulk

Scenario #2 | **Repeat Program / Replenishment**

Same program | Same vendor | **SAME** MILL | Same fabric and color

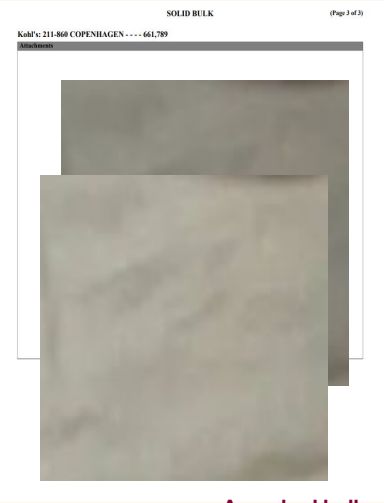
Lab Dips
based on color standard

❌

- **Mill will reference the previously approved unwashed-bulk dye recipe**
- **Lab dips are not required by Kohl's, but the Mill can choose to submit if they prefer to do so**
- **Mill must have a color standard on hand for dyeing/record-keeping purposes and to ensure consistency**

Unwashed & Washed Bulk
based on the previous seasons dye recipe

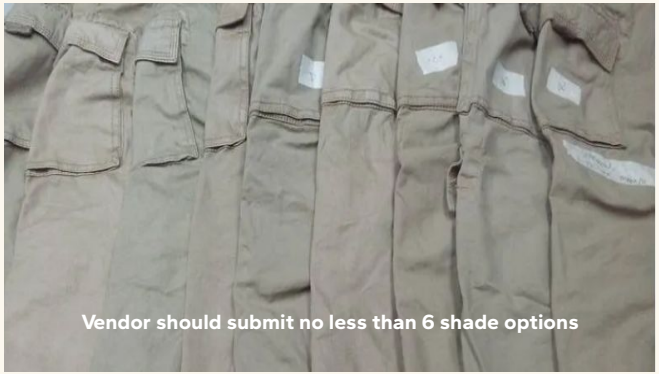
✅



A washed bulk submit is required prior to the vendor submitting shade bands.

Shade Band
based on the approved bulk

✅



Scenario #3 | **Repeat Program / Replenishment**

Same program | Same vendor | **DIFFERENT** MILL | Same fabric and color

Lab Dips
based on color standard

***Fabric cuttings should not be used as a standard!**

Unwashed & Washed Bulk
based on the approved lab dip

A washed bulk submit is required prior to the vendor submitting shade bands

Shade Band
based on the approved bulk

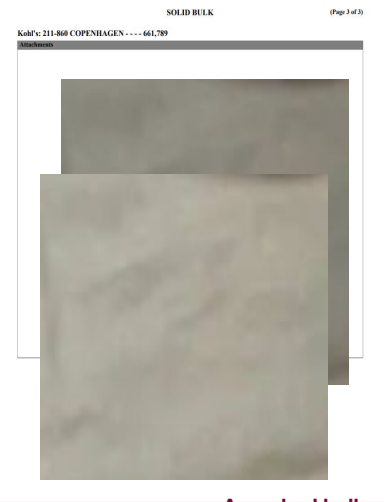
Scenario #3 | **Repeat Program / Replenishment**

Same program | **NEW** VENDOR | **SAME** MILL | Same fabric and color

Lab Dips
based on color standard

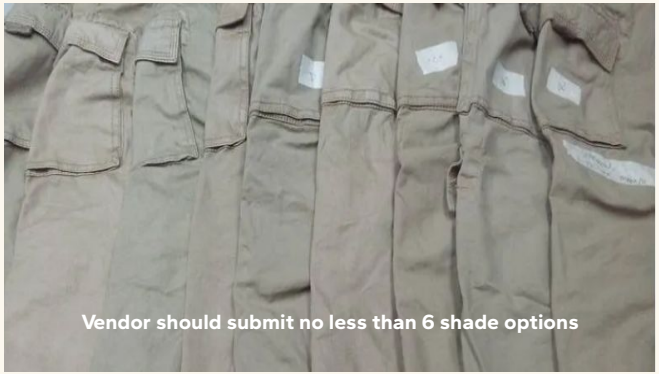
- **Mill will reference the previously approved unwashed-bulk dye recipe**
- **Lab dips are not required by Kohl's, but the Mill can choose to submit if they prefer to do so**
- **Mill must have a color standard on hand for dyeing/record-keeping purposes and to ensure consistency**

Unwashed & Washed Bulk
based on the previous seasons dye recipe



A washed bulk submit is required prior to the vendor submitting shade bands.

Shade Band
based on the approved bulk



*Kohl's and Mill will provide new vendor with the previously approved washed bulk for reference to maintain color consistency.

Garment Wash Process

Garment Wash - Scenario #1 | New Program

New program | New colors | No previous approvals

Lab Dips

- Lab dips are not required by Kohl's, but the Mill can choose to submit if they prefer to do so
- Mill must have a color standard on hand for dyeing/record-keeping purposes and to ensure consistency

*Fabric cuttings should not be used as a standard!

Garment Sample

A washed garment sample is sent to Kohl's for color approval. Once approved the vendor submits a range of shade bands for final approval.

Shade Band

Vendor should submit no less than 6 shade options

Garment Wash - Scenario #2 | **Repeat Program/Replenishment**

Same program | **NEW** VENDOR | **SAME** MILL | Same fabric and colors

Lab Dips

- Mill will reference the previously approved dye recipe to replicate the color of the garment wash sample
- Lab dips are not required by Kohl's, but the Mill can choose to submit if they prefer to do so
- Mill must have a color standard on hand for dyeing/record-keeping purposes and to ensure consistency

***Fabric cuttings should not be used as a standard!**

Garment Sample

A washed garment sample is sent to Kohl's for color approval. Once approved the vendor submits a range of shade bands for final approval.

Shade Band

Vendor should submit no less than 6 shade options

Shade Bands | Approval Ownership

NON-DENIM WASHED SUBMIT OWNERSHIP				
SUBMIT TYPES	**CERTIFIED COLORIST**	**KOHL'S COLORIST**	**KOHL'S DESIGNER**	**KOHL'S DESIGNATED WASH TECHNICIAN**
Unwashed Lab Dip	x	x		
Unwashed Bulk	x	x		
Washed Bulk		x	x	
Washed Shade Bands		x	x	
Subsequent Shade Bands				x
Garment Dye Sample			x	
Garment Dye Shade Bands			x	
Subsequent Garment Dye Shade Bands				x
BCDs		x	x	

Shade Bands | **Commonly Asked Questions**

Questions	Answers
Can Kohl's use a previously approved sample or cutting as a standard?	No. While the sample or cutting can be used as a "reference" it should not be used as the official standard. The mill should use the approved dye recipe based on the original color standard (Archroma/Pantone).
We use the same color in many fabrications. How can we help to control color consistency?	1. Use a controlled standard (Archroma/Pantone). Don't use a cutting. 2. When reviewing color try to pick shades that are in the same hue "family" first. Then consider the lightness/darkness and brightness/dullness. 3. Utilize the color rooms and color team.
What are some reason for color variances in unwashed bulks?	While the mill takes all necessary precautions some variables may take place due to different dye stuff, water and temperature variables? The quality of the fabric itself can also cause color differences.
How many rounds of shade bands can we have?	Generally, 2 rounds of shade bands can be planned for where at least 6 options per round are expected.
How does the vendor pick the shades they send to us for approval?	They create a "blanket". What that means is they will take a 4x4 size cutting of fabric from each roll of fabric they receive from the mill and stitch the together. They then wash the blanket by following the same wash recipe of KOHLS approved “WASHED BULK” submit. They then select options that are close in color (hue, lightness, brightness/dullness). They will then send those dye lots as the shade bands to be reviewed.
After Kohl's approved the shade bands, how is color controlled in production or subsequent shade bands?	Previously the Vendor QA team would review and control the color. However, we've just identified individuals within the vendor's wash facility to be a "Certified Wash Technician." These are the experts and have the proper tools to review.
How was the designated wash technician selected?	The vendor selected their washed technician based on criteria we presented and their experience.
Does the wash facility have a color room?	Yes. The washed facilities have a light controlled area/room and Kohl's designated light sources.
What should we do if we need to make an exception to the process?	Before communicating any direction outside of the process guidelines, please talk with the Kohl's color team.
Should we be using onePLM for wash submits/shadeband submits?	Yes. Please let us know if you or your vendors need help navigating submit creation.
On replenishment programs, how does the vendor know to use the approved dye recipe rather than the color standard?	3 ways: 1. In most cases all the vendors/mills we spoke with are already doing it. 2. We will be rounding back will all the vendors/mills we've met with to re-align on the process and our expectations. 3. Your support and communication. If you experience a mill/vendor deviating from the process please involve the color team.

Questions?

Please reach out to mr-colorist@kohls.com