



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS HOME

COOKWARE / BAKEWARE / FOOD PREP

All Private and Exclusive brands must follow Minimum requirements unless otherwise specified in the TP.



MINIMUM CONSTRUCTION STANDARDS COOKWARE / BAKEWARE/ FOOD PREP

Kohl's Cookware/Bakeware/Food Prep Minimum Construction Standards Overview

The acceptance of an order placed by Kohl's for Private and Exclusive Brand products indicates that as a vendor, you are aware of the technical and quality standards required by Kohl's, in addition to any applicable laws or regulations existing for this product category. It is your responsibility to supply product to Kohl's that meets those standards. Any variation from Kohl's established standards must be agreed upon in writing by Kohl's and the manufacturer.

Section I. Defect Zones

- Maps locations on the products for imperfection accept/reject assignments.

Section II. Classification of Defects (color, dirt/soils, material, contamination, construction/assembly and packaging)

- Outlines defects that could pose safety liabilities, performance limitations, or be visually unacceptable to the consumer.
- The list identifies general defects and is a starting point. Vendor should work with the Technical Designer to develop specific standards, where necessary, per product.

Section III. Construction and Assembly Requirements:

- Outlines performance requirements and other requirements pertaining to performance and materials.
- Labeling / Packaging Requirements: Outlines Kohl's requirements for product protection and accuracy.

Section IV. Measurement Tolerances

- Lists measurement points and assigned tolerances per product type.

Section IV. Glossary

- Defines common terms that help align basic understanding of common cookware terms.

Section VI. Sources


- Lists associations or websites referenced for creating this document.

Defect Zones:


Product mapping identifying areas of product where questionable material imperfections and dirt/soils may or may not exist.

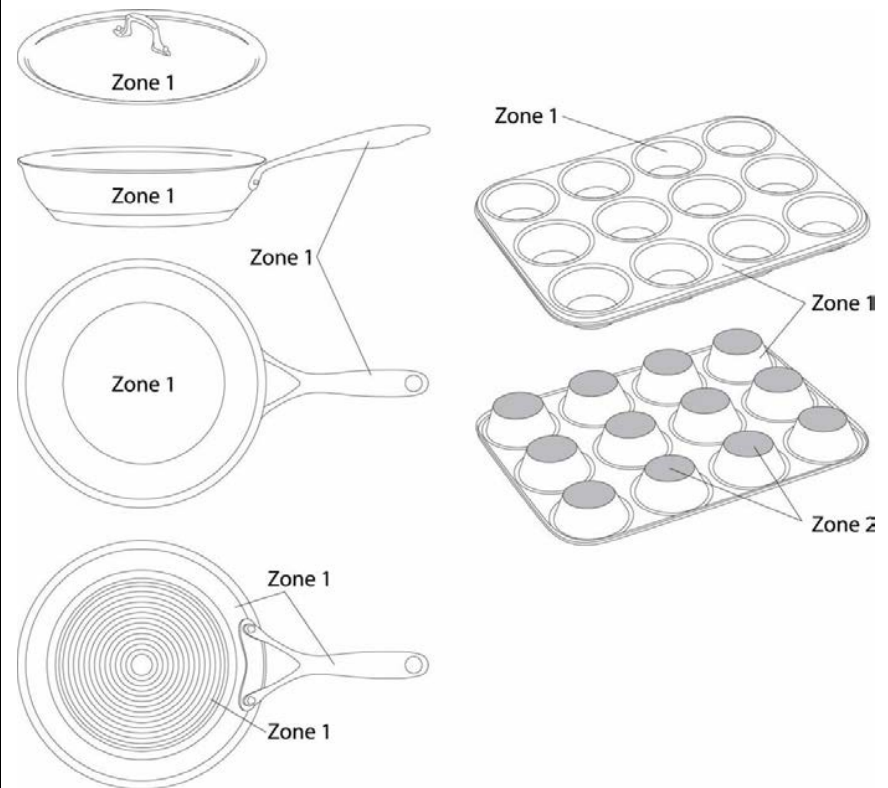
Defect Zones:

Zone 1: Focal points which are highly visible.

 = Zone 1

Zone 2: Areas of product not readily visible when in use.

 = Zone 2





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Classification of Defects: Visual and/or performance imperfections that may cause safety concerns, product failure, affect the usability of the product for its intended purpose or, be unacceptable to the customer. (Cosmetic variations viewed at arms length in normal room lighting. All products must match standards unless otherwise specified.)		Zone 1	Zone 2
Visual Defects	Sharp, rough, uneven or unfinished edges/rim.	not acceptable	
	Severe scratches, scuff marks, or blemishes that score the surface	not acceptable	
	Slight scratches, scuff marks, or blemishes that don't break the surface	not acceptable	acceptable
	Chips, cracks, spalling or broken surface	not acceptable	
	Wrinkling in side wall	not acceptable	
	Cracking of the base metal or flaking of the coating	not acceptable	
	Absent pre-seasoning (when specified)	not acceptable	acceptable
	Rust	not acceptable	
	Gloss or level of sheen not as specified	not acceptable	
	Blisters in coatings	not acceptable	
	Crevices or seams causing difficulty for cleaning.	not acceptable	
	Orange peel, peeling, or dry spray	not acceptable	
	Any defect detracting from the appearance of the unit	not acceptable	
	Mold lines severe enough to break or disrupt the surface	not acceptable	
	Partial injection of mold	not acceptable	
	Camber or the deviation of a side edge from a straight line	± 0.8 mm per 1000 mm	
Out of square sides, handles or design elements	± 0.8 mm per 1200 mm		

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CONSTRUCTION AND ASSEMBLY REQUIREMENTS:

These requirements apply to all products regardless of brand or price. These standards are set to promote function, longevity, and safety. Additional standards may be required on a case by case basis.

Function	
	All products must pass Kohl's testing requirements
	Stability - All products must sit flat and upright when empty.
	All cookware / bakeware construction must permit easy cleaning
	For pans with braised bottoms, there must be no gap between the braised cap and the vessel.
	Gasket material must be used between metal-to-glass connections.
	Openings must be fully functional and not drip. (Teapot or pitcher spout, etc.)
	Products must be clean and free of dust, grease, dirt or other unwanted contamination
Materials	
	All products must meet Minimum Performance Standards for its product type.
	Product must be made from materials as specified in the BOM.
	Product must be made from the gauge as specified in the BOM.
	Materials must match Durometer measurement (when specified.)
	All materials, finishes and coatings must match Rockwell Hardness Scale (when specified.)
	All materials used must be durable for both the specified design and function of the product.
	All materials, coatings and surfaces must comply with state, federal, or FDA regulations where applicable.
Lids	
	Lids must fit snugly but also allow easy removal.
	Glass lids must be in minimum thickness of 4 mm.

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CONSTRUCTION AND ASSEMBLY REQUIREMENTS (Cont.)

Handles

Handles which are riveted for attachment must not deform the pan. The shape of the pan must remain smooth and even.

Stick handles, side handles or knobs attached with screws must have three (3) full turns of screw into and/or through the mating part before handle comes detached.

Handles secured by screw must be non-corrosive and utilize a lock washer device.

All metal hardware used in the construction or attachment of handles must be stainless steel unless otherwise specified.

All non-cast metal handles must have crested construction for strength.

Handles created from molded plastic must be heat resistant to 350°C unless otherwise specified.

Shanks must have a minimum length of 40 mm when used in handle construction.

Welded handles must be free of sharp edges or splatter. They must be durable and pass testing for strength, etc.

Handles must be positioned above the center of gravity when filled to capacity with water.

A. Stick Handles - There must be a minimum clearance of 30 mm from a horizontal projection of the base to the lowest point at the halfway mark of a stick handle. (See Diagram for Handle Height below)

B. Side Handles - There must be a minimum clearance of 30 mm from a horizontal projection of the base to the lowest point of a side handle where normally grasped. (See Diagram for Handle Height below)

Diagram for Handle Height

A.



Stick Handles

B.



Side Handles



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CONSTRUCTION AND ASSEMBLY REQUIREMENTS (Cont.)

Finish / Coatings	Nonstick coatings must be smooth and continuous to the top edge of the pan.	
	All materials, coatings and surfaces must comply with state, federal, or FDA regulations where applicable.	
	Nonstick coatings must not be manufactured using PFOA.	
	All materials, coatings and surfaces must be tested by a third party for food safety.	
	All materials, coatings and surfaces must be formulated with ingredients known to be safe for use in contact with food and that are appropriate for the intended conditions of use.	
	Coatings must have the correct number of layers and application method as specified.	
	Unnecessary thicknesses / thinness of anodized finishes are unacceptable.	
Porcelain Enamel	Inconsistent thickness / thinness of porcelain enamel coatings are unacceptable.	
	Porcelain enamel must be free of contamination, pits, bumps or breaks in the surface.	
Cast Iron	Cast iron must be shot – blasted, rattled, and/or ground.	
	Minimum wall thickness of cast iron.	3.2 mm
	Dimensional tolerance of cast iron for design elements other than inside dimensions and capacity.	± 0.8 mm
	Evenness of the bottom of cast iron (must not wobble)	± 0.4 mm
	Bottoms of cast iron may be stepped, formed or machine grooved.	

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CONSTRUCTION AND ASSEMBLY REQUIREMENTS (Cont.)

Labeling / Packaging

Products must comply with all advertised and labeled claims (i.e. microwave safe, dishwasher safe, oven safe, freezer safe, etc.)

Must have special food use warnings when applicable.

Must have temperature limitations when applicable.

Missing, incorrect or misspelled use instruction or care information is not acceptable.

Retail packaging must be sufficient size or strength to support and protect product as required by testing.

Shipping carton and shipping material must be sufficient size or strength to protect product in transit

All markings must be conspicuously and durably marked

All brand markings must be applied in the correct size, technique and with visual clarity.

Back stamps must be centered on the product, and placed squarely to any straight angles.

Back stamps created in relief must be clean and free of debris.

Measurement information must be listed using the correct format. (See Kohl's Packaging Style Guide for more details.) For example:

XX.X in. x XX.X in. (XX.X cm x XX.X cm)



XX.X in. x XX.X in.
(XX.X cm x XX.X cm)

Can be presented
as 1 or 2 lines



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MEASUREMENTS:

Controlling product dimensions, capacities, and set component variations is imperative. Tolerances only allow for reasonable manufacturing error. The measurements of products must be consistent with any product claims and is federally regulated by the FPLA and NIST. A product can be rejected when:

- One or more critical measurement is outside of tolerance. (Applies to length, width, depth, or capacity)
- Several detail measurement points are out of tolerance and effect aesthetics or function.
- Component variation within a set or between items normally purchased as a set is outside of set tolerance.
- Measurements do not match packaging / labeling claims.
- Product does not match the Technical Drawing.

(Note: Refer to tolerances for specific information by product type. Listed characteristics are *minimum* construction standards unless otherwise specified.)

MEASUREMENT TYPE	Intended Measurement / Claim (Listed in US / Metric)	Actual Measurement	
		Minimum	Maximum
CAPACITY: All Cookware, Bakeware, and Food Prep items with a claimed / intended capacity. (Other than Measuring devices) Tolerance = -0% / +3% Measurements are listed as level full capacity or fill line.	1 pt. / 16 oz. / 473.18 mL	473.18 mL	487.37 mL
	1 qt. / 32 oz. / 946.35 mL	946.35 mL	974.74 mL
	1.5 qt. / 48 oz. / 1.42 L / 1419.53 mL	1419.53 mL	1462.11 mL
	2 qt. / 64 oz. / 1.89 L / 1892.71 mL	1892.71 mL	1949.48 mL
	3 qt. / 96 oz. / 2.84 L / 2839.06 mL	2839.06 mL	2924.23 mL
	1 gal. / 4 qt. / 3.79 L / 3785.41 mL	3785.41 mL	3898.97 mL
	1.25 gal. / 5 qt. / 4.73 L / 4731.76 mL	4731.76 mL	4873.71 mL
	1.5 gal. / 6 qt. / 5.69 L / 5678.12 mL	5678.12 mL	5848.46 mL
	2 gal. / 8 qt. / 7.57 L / 7570.82 mL	7570.82 mL	7797.94 mL
2.5 gal. / 10 qt. / 9.46 L / 9463.53 mL	9463.53 mL	9747.43 mL	

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MEASUREMENTS (Cont.)

MEASUREMENT TYPE	Intended Measurement / Claim (Listed in US / Metric)	Actual Measurement	
		Minimum	Maximum
<p>DIMENSIONS: All Cookware, Bakeware, and Food Prep items with a claimed / intended dimension. (Other than Measuring devices)</p> <p>Tolerance = -0% / +3%</p> <p>Length and Width Measurements are listed as top inside dimensions.</p> <p>Depth Measurement is listed as a vertical dimension perpendicular to the inside bottom surface.</p>	1 in. / 2.54 cm / 25.4 mm	25.4 mm	26.162 mm
	5 in. / 12.7 cm / 127 mm	127 mm	130.81 mm
	6 in. / 15.2 cm / 152.4 mm	152.4 mm	156.97 mm
	8 in. / 20.3 cm / 203.2 mm	203.2 mm	209.29 mm
	9 in. / 22.9 cm / 228.6 mm	228.6 mm	235.48 mm
	10 in. / 25.4 cm / 254 mm	254 mm	261.62 mm
	11 in. / 27.9 cm / 279.4 mm	279.4 mm	287.78 mm
	1 ft. / 12 in. / 30.5 cm / 304.8 mm	304.8 mm	313.94 mm
	13 in. / 33 cm / 330.2 mm	330.2 mm	340.10 mm
	14 in. / 35.6 cm / 355.6 mm	355.6 mm	366.26 mm
	15 in. / 38.1 cm / 381 mm	381 mm	392.43 mm
	16 in. / 40.6 cm / 406.4 mm	406.4 mm	418.59 mm
	17 in. / 43.2 cm / 431.8 mm	431.8 mm	444.75 mm
	1.5 ft. / 18 in. / 45.7 cm / 457.2 mm	457.2 mm	470.91 mm

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MEASUREMENTS (Cont.)

MEASUREMENT TYPE	Intended Measurement / Claim (Listed in US / Metric)	Actual Measurement	
		Minimum	Maximum
MEASURING DEVICES: Measuring Cups, Measuring Spoons, Pastry Measuring Mats, etc including all Cookware with incremental measurement markings. (These items must match the claim exactly.) Tolerance = -0% / +0%	¼ tsp. / 1.23 mL	1.23 mL	1.23 mL
	½ tsp. / 2.46 mL	2.46 mL	2.46 mL
	1 tsp. / 0.17 oz. / 4.93 mL	4.93 mL	4.93 mL
	1 Tbsp. / 0.5 oz. / 14.77 mL	14.77 mL	14.77 mL
	¼ c. / 2 oz. / 59.15 mL	59.15 mL	59.15 mL
	⅓ c. / 2.67 oz. / 78.86 mL	78.86 mL	78.86 mL
	½ c. / 4 oz. / 118.29 mL	118.29 mL	118.29 mL
	1 c. / 8 oz. / 236.59 mL	236.59 mL	236.59 mL
	1 in. / 25.4 mm	25.4 mm	25.4 mm
	1 ft. / 12 in. / 304.8 mm	304.8 mm	304.8 mm
	Components not relating to claimed capacity or dimensions (such as rims or handle length) must be within tolerance of intended dimension.		
DESIGN ELEMENTS	Components not relating to claimed capacity or dimensions (such as rims or handle length) must be within tolerance of intended dimension	± 1% of specified dimension	

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COOKWARE GLOSSARY

PRODUCT TYPES:

Angel / Tube Cake Pan	Usually a circular pan with slightly tapered high sides, with tubular insert for angel food cakes, chiffon cakes, etc.
Bakeware (Non-electric)	Products used for cooking foods by absorbing heat from the surrounding indirect heat as produced in an oven.
Barbeque Cookware	Cookware items specifically manufactured for use on either gas, electric or charcoal grills. These items typically have surface finishes that can withstand higher temperatures than traditional cookware or bakeware.
Blancher / Steam Cooker	A covered utensil similar to a saucepan but with a perforated insert so that the food placed in the insert is raised above a small amount of water in the pot and is cooked by steam.
Brazier / Sauteuse	Shallow wide vessel with two side handles and a lid.
Bread / Loaf Pan	A deep and narrow rectangular vessel with slightly flared sides, designed for oven use.
Broiling Pan	A large two piece flat pan with perforated top that allows fat to drip to pan below. Used for broiling steaks, chops, etc.
Cake Mold	A cake mold is a utensil with a central tube and a "carved" design in the side wall. It is designed for cakes, gelatin salads and desserts.
Cake Pans	Utensil available in round, square, or oblong shapes with slightly tapered sides used for baking cakes.
Canner	A covered cooking vessel similar to a stockpot with a wire insert rack for jars that permits convenient handling. Generally used for canning fresh meats and vegetables. Must have 2 to 3" (5 to 8 cm) of headroom above the jar lid.
Casserole	A vessel in which food may be baked and served. It may have one or two handles. Some models may not have a cover.
Chefs Pan	A medium depth pan that generally has flared or rounded sides. It has a flat bottom and wide mouth, which accelerates the evaporation of liquids.

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GLOSSARY (cont.)

PRODUCT TYPES (cont.):

Chicken Fryer	A deep, covered fry pan or skillet.
Cookie Sheet	A flat rectangular pan which may be open on one, two or three sides. It is especially designed for baking cookies and biscuits.
Covered Roasting Pan	A large, covered oblong, oval or round pan. Generally used for roasting meats and poultry.
Custard Cup / Ramekin	A round, individually sized vessel with deep sides especially designed for oven use.
Double Boiler	A saucepan with a detachable upper component which is heated by boiling water in the lower saucepan. The upper pan-like component should sit securely on top of the lower saucepan. Used to melt or heat foods with less danger of scorching.
Dutch Oven	Similar to saucepot. Usually comes with a dome cover. Sometimes is heavier gauge material. Used for braising and slow cooking of meats.
French Fryer / Chicken Fryer	A French fryer is an uncovered basket, mesh, perforated, or sieve-like insert basket with one long handle.
Griddle	Shallow side wall pan with a wide bottom and one long handle, two side handles, or possibly no handles. Ideal for pancakes, hamburgers, etc.
Jelly Roll Pan / Baking Sheet	A shallow rectangular utensil with low sides.
Lasagna Pan	A lasagna pan is an open, rectangular baking pan with two side handles.
Muffin / Cupcake Pan	A tray-like series of individual cups which are formed from the tray metal (seamless) or are lock-seamed to the tray.
Novelty	Trending sizes or shapes that may change seasonally.



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GLOSSARY (cont.)

PRODUCT TYPES (cont.):

Open Roasting Pan	A large rectangular pan especially designed for roasting meats and poultry.
Pie Pan / Pie Plate	A round pan with open flared sides made from metal, glass or ceramic.
Pizza Pan	A round shallow or flat pan used for making pizza. May be solid or perforated.
Pressure Cooker	Similar to a stockpot but with an air-tight locking cover that permits steam pressure of 5 to 15 pounds. Ideal for reducing cooking time for vegetables, soups, meats, etc. A pressure release valve is built in for safety.
Saucepan	Utensil with one long handle. Some also have a side handle, which is commonly called a "side assist handle", or "helper handle." Generally used for cooking vegetables, cereals, puddings, sauces, etc. Saucepans are available with or without cover.
Sauté Pan	A low, uncovered pan with straight sides and having one long handle. Larger sizes may also include a helper handle.
Skillet / Fry Pan / Omelet Pan	Vessel with one long handle, possibly a side handle, and a wide bottom and low sides. Skillets or fry pans are available with and without cover. Used for frying meats, eggs, pancakes, etc.
Soup Pot / Stockpot	Large deep vessel with two side handles. Generally used for same foods as a saucepan but in larger capacities. A sauce pot is generally wider in diameter than a stock pot of equivalent capacity.
Springform Pan	A deep round pan used primarily to make cheesecakes. The side section is equipped with a clamp or lock so it can be completely released and removed to release the cake. It may have a flat or tubed bottom interchangeable use.
Teakettle	A teakettle is a covered utensil having one handle and equipped with a spout or pouring lip.
Top-of-Range Metal Cookware (Non-electric)	Those products used for foods which cook by direct contact with the heat source (direct heat). Family needs and common household usage determine cookware sizes. For best cooking results and efficient use of energy, the base dimension should relate to the diameter of the heating element or burner of household ranges.

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GLOSSARY (Cont.)

CONSTRUCTION:	
Blanking	A punch and die are used to remove a section, or blank, from the sheet metal that will be used for the forming of the product.
Brake Forming	The bending of metal
Brazing	The joining of two metals by using a third lower melting temperature filler metal.
Bulging	The creation of a form where the metal is stretched into a concave form rather than compressed into a die.
Camber	The deviation of a side edge from a straight line
Cladding	The bonding of dissimilar thin sheets, or plies, of metals by rolling together under high pressure. The combined performance features of the different metals create a product that is better than its individual components.
Die Casting	Process that uses hardened steel molds to receive molten metal under pressure such as iron or aluminum.
Impact Bonding	Joining of two metals together using heat and pressure. First, the parts are heated almost to the softening point of aluminum. The parts are transferred into a press and bonded together.
Piercing	The opposite of blanking where the punched piece is discarded as scrap and the remaining is used to form the product.
Sand Casting	Process that uses a mold made from compressed sand and a binder to receive molten metal such as iron or aluminum.
Shearing	Process which cuts metal stock without forming chips or melting the metal through the use of a moving blade pushing the material against a fixed blade. Also known as die cutting.
Sheet Metal Drawing	Process which uses tensile forces to stretch the metal by forcing it through a die.
Spinning	Forming of a symmetrical product by rotation on a lathe.
Stamping	Encompasses many sheet-metal forming manufacturing processes including blanking, embossing, punching, bending, and flanging. Also called pressing.
Trimming	Cuts away excess or unwanted irregular features from the work piece.
Wrinkling	A defect in the surface of the metal due to incorrect pressure or lubrication during drawing.

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GLOSSARY (Cont.)

MATERIALS:

Aluminum	Beneficial qualities of aluminum include: lightweight, resistance to corrosion, design flexibility, and high thermal or heat transfer.
Cast Iron	Excellent heat retention properties. Seasoning is often used to protect bare cast iron from rust and to create a non-stick surface.
Copper	Excellent heat-conducting metal and heat-distribution. Often used as a core material or lined with stainless steel.
Stainless Steel	Beneficial qualities of stainless steel include: excellent resistance to corrosion, continued retention of a high lustrous surface, reflectivity, non-reactivity in food contact and the added feature of high strength. Ferrous alloys that contain a minimum of 12% chromium.
Types of Finishes / Coatings / Decorations	Acrylic Finish Alykd Finish Anodized Finish Chrome Plate Finish Decalomania Epoxy Finish Hard Coat Anodized Finish Nonstick Fluorocarbon Finish Nonstick High Temperature Resin Finish Nonstick Silicone Finish Pad Printed – Porcelain Polyamide Finish Porcelain Enamel on Aluminum or Stainless Steel Porcelain Enamel on Steel or Cast Iron Porcelain Enamel on Porcelain or Pottery Polyurethane Finish Silicone Polyester Silk Screen – Porcelain Silk Screen – Acrylic Silk-screened PTFE decoration

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SOURCES: Associations or websites referenced for creating this document

ASTM	ASTM International, formerly known as the American Society for Testing and Materials (http://www.astm.org/)
CESA	Catering Equipment Suppliers' Association (http://www.cesa.org.uk/)
CMA	Cookware Manufacturers Association (http://www.cookware.org/)
CPSC	U.S. Consumer Product Safety Commission
FDA	U.S. Food and Drug Administration (http://www.fda.gov/)
FPLA	The Fair Packaging and Labeling Act (http://www.ftc.gov/)
NIST	National Institute of Standards and Technology (http://www.nist.gov/)
NSF	National Sanitation Foundation (http://www.nsf.org/)