



# MINIMUM CONSTRUCTION STANDARDS

## PRIVATE & EXCLUSIVE BRANDS HOME

# RUGS

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



# MINIMUM CONSTRUCTION STANDARDS RUGS

## 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 and documented in the Kohl's Tech Pack.

Section I. [Fabric Layout and Cutting Requirements](#)

Section II. [Trims and Findings Requirements](#)

Section III. [Sewing and Construction Requirements](#)

Section IV. [Product Labeling](#)



# MINIMUM CONSTRUCTION STANDARDS RUGS

REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section I. Fabric Layout and Cutting Requirements</b>		
All fabrics as specified, including but not limited to - content, yarn type, weave, weight, dye class & process, finish, etc		
<ul style="list-style-type: none"><li>• All parts of finished products must be compatible with prescribed care instructions</li><li>• Combined fabrications must have compatible shrinkage</li><li>• Cut product pieces on grain unless otherwise specified (length on warp)</li><li>• No selvage edges allowed as hems</li><li>• Heavily napped fabrics, brushed fabrics and one-way prints - all product pieces cut in the same direction within a unit</li><li>• Pattern Matching: Pattern/Plaid/Stripe match must be submitted to Design/Production/Technical Design for approval before final costing acceptance</li><li>• No exposed drill holes, punch holes, or notches</li><li>• Corners must be 90 degrees</li></ul>		



# MINIMUM CONSTRUCTION STANDARDS RUGS

REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration												
<p><b>Section II. Trims and Findings Requirements</b></p> <p>Trims/Findings in children's products must meet CPSIA requirements</p>														
<p>Thread: Must source thread with <a href="#">Kohl's Preferred Supplier</a></p> <ul style="list-style-type: none"> <li>• <b>No monofilament thread.</b> Multi-filament is acceptable for specific uses</li> </ul> <p>Embroidery Thread:</p> <ul style="list-style-type: none"> <li>• Preference - Polyester - from <a href="#">Kohl's Preferred Supplier</a></li> <li>• Allowed - Polyester from a non-Preferred Supplier, contingent upon passing specific thread testing protocols</li> <li>• Allowed - Rayon - from a <a href="#">Kohl's Preferred Supplier</a></li> </ul> <p>Bead/Sequin attachment thread. Very specific thread requirements</p> <ul style="list-style-type: none"> <li>• Refer to '<a href="#">Bead &amp; Sequin Attachment Guide</a>' on K-link</li> </ul> <p>Thread Color</p> <ul style="list-style-type: none"> <li>• Must match fabric ground unless otherwise specified. Bedskirt thread color to match skirt/drop, not platform. When in doubt, check with Design team.</li> <li>• All operations must use same color thread within internal seams</li> </ul> <p>NOTE: Thread types/sizes may vary based on fabric characteristics and weight, and are subject to approval by TD. Seams must meet Kohl's strength and appearance requirements.</p> <p><b>Thread Size Chart by Fabrication:</b></p> <table border="0"> <tr> <td>Needle/Bobbin:</td> <td>Looper:</td> </tr> <tr> <td>• 2 - 4oz = Tex 18-21</td> <td>Tex 18</td> </tr> <tr> <td>• 4 - 6oz = Tex 21(spun) - 24(core)</td> <td>Tex 27</td> </tr> <tr> <td>• 6 - 8oz = Tex 27(spun) - 30(core)</td> <td>Tex 30</td> </tr> <tr> <td>• 8 - 10oz = Tex 40</td> <td>Tex 27-30 or 35 (textured poly)</td> </tr> <tr> <td>• 10 - 14oz = Tex 60</td> <td>Tex 40</td> </tr> </table> <p>Looper Thread: Spun Polyester or Textured Polyester</p> <ul style="list-style-type: none"> <li>• Tex size of looper thread must be comparable with tex size of needle thread</li> </ul>	Needle/Bobbin:	Looper:	• 2 - 4oz = Tex 18-21	Tex 18	• 4 - 6oz = Tex 21(spun) - 24(core)	Tex 27	• 6 - 8oz = Tex 27(spun) - 30(core)	Tex 30	• 8 - 10oz = Tex 40	Tex 27-30 or 35 (textured poly)	• 10 - 14oz = Tex 60	Tex 40	<p>Decorative thread as specified</p>	<p>Decorative thread as specified</p>
Needle/Bobbin:	Looper:													
• 2 - 4oz = Tex 18-21	Tex 18													
• 4 - 6oz = Tex 21(spun) - 24(core)	Tex 27													
• 6 - 8oz = Tex 27(spun) - 30(core)	Tex 30													
• 8 - 10oz = Tex 40	Tex 27-30 or 35 (textured poly)													
• 10 - 14oz = Tex 60	Tex 40													



# MINIMUM CONSTRUCTION STANDARDS RUGS

REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section II. Trims and Findings Requirements (cont'd)</b> Trims/Findings in children's products must meet CPSIA requirements		
Embroideries <ul style="list-style-type: none"> <li>• Must have suitable tear-away or dissolvable backing that must be removed after application</li> <li>• Stitching must be secured by stacking stitches with increased SPI (minimum 25-30), knotting, back-stitch (minimum 3 stitches), or bar-tack</li> <li>• Stitching must be knotted/secured every 3/4" with thread floats no longer than 3/4"</li> <li>• <b>Children's Products:</b></li> <li>• floats no longer than 3/8"</li> </ul>		
Binding <ul style="list-style-type: none"> <li>• Lockstitch zigzag (ISO 304) all layers together before applying binding</li> <li>• Raw edges of binding must be folded in and securely sewn into binding</li> <li>• If self-bound (hemmed) - clean finished, double turned, single need lockstitch</li> <li>• Minimal number of splices - directly proportional to the size of the product</li> </ul>	Preferred bias cut unless otherwise specified	May be straight cut for straight edges, must be bias cut for curved/shaped edges
Ruffles, Crochet Edging, Fringe Tape, Tassels, Pom poms, etc <ul style="list-style-type: none"> <li>• Lockstitch zigzag (ISO 304) all layers together before applying trims</li> <li>• Ruggles single ply or double ply as specified</li> </ul>	Gather ratio: 1.75:1 - 2:1	Gather ratio: 1.5:1 minimum



# MINIMUM CONSTRUCTION STANDARDS RUGS

REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section III. Sewing and Construction Requirements</b>  Seams must meet Kohl's seam slippage and strength requirements		
<ul style="list-style-type: none"> <li>• Stitches per inch (SPI) of hem, seams and topstitching as specified by tech pack</li> <li>• Reinforcement Stitching: Stitching must be secured at start and stop;               <ul style="list-style-type: none"> <li>- Back-stitch (minimum 3 stitches), lockstitch thread tails trimmed closeor using Schmale backtacking chainstitch sewing machine head</li> <li>- Bar-tack</li> <li>- Latchback</li> <li>- Ends of stitching crossed by another seam or line of stitching</li> <li>- Stack stitches by increasing SPI for 1" (minimum 25-30 SPI)</li> <li>- Knotted ends (on running stitch only)</li> </ul> </li> <li>• No exposed raw or pinked edges.</li> <li>• No inconsistent pile height, missing tufts/loops, bare spots, cut holes</li> <li>• Decorative whipstitch (over machine stitched hems only): Must be secured at start and stop by back-tack (minimum 3 stitches)</li> <li>• <b>Children's Products:</b></li> <li>• Overlock stitch is required underneath any blanketstitch or whipstitch detail</li> <li>• All blanketstitching or whipstitching must be cut in 8" lengths and tacked or knotted at the end of each length</li> <li>• Line tack is to be perpendicular (non-parallel) to the edge of the product</li> <li>• Knotting is to be done on the backside of the product</li> </ul>	SPI (binding or hemming): 8 - 10	SPI (binding or hemming): 6 - 8
Lid Covers <ul style="list-style-type: none"> <li>• Woven elastic type as specified. Must source the specified elastic model # from the assigned supplier only</li> <li>• Elastic stretch ratio: 1:2.5 minimum.</li> <li>• Elastic applied as binding over edge of lid cover, approx. 1/2" inside and outside.</li> <li>• Elastic is sewn using SN chainstitch, chain on inside - knife removed.</li> <li>• Minimum 1 1/2" flat overlap reinforcement at elastic start/stop. Maximum chain-off 1"</li> </ul>		
Rugs - Knit <ul style="list-style-type: none"> <li>• Circular knit, split, usually laminated to polyurethane foam or backing for stability</li> </ul>		
Rugs - Braided (Flat, Rag) <ul style="list-style-type: none"> <li>• Sew braids together with Zig Zag LS (ISO 304) 2.5 - 3 SPI</li> </ul>		

Revised Date: 2/20/2024



# MINIMUM CONSTRUCTION STANDARDS RUGS

REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<p><b>Section III. Sewing and Construction Requirements (cont'd)</b></p> <p>Seams must meet Kohl's seam slippage and strength requirements</p>		
<p>Rugs - Machine Made - Tufted / Hooked / Needle Punched</p> <ul style="list-style-type: none"> <li>• Reversible:               <ul style="list-style-type: none"> <li>- Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face and back of rug.</li> </ul> </li> <li>• One Sided:               <ul style="list-style-type: none"> <li>- Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face only</li> <li>- Secondary Backing (if applicable) – woven – adhered over primary backing using natural, synthetic, or blended rubber latex (must identify)</li> </ul> </li> <li>• Non-Skid:               <ul style="list-style-type: none"> <li>- Primary Backing or Base – woven or non-woven or mesh – foundation for tufts or hooks. Pile yarn creates cut/loop design on face only</li> <li>- Secondary Backing – Natural, synthetic, or blended rubber latex (must identify secures pile yarns on back of rug. Latex is not covered with fabric. Latex may be sprayed on, or, padded on with no design or with embossed design</li> <li>- No latex that is uncured/soured/odorous, cracking/crumbling/powdered, holes, delaminated/peeling, or over-sprayed</li> </ul> </li> <li>• All rug edges must be finished - bound, serged, hemmed or fringed</li> <li>• Rug must lie flat, without rolling or curling along the edges</li> <li>• Hem long sides first; then hem short ends, crossing long side hem stitching SN LS TS (ISO301) or SN CS (ISO 401) or 2N Bottom Coverstitch (ISO 406)</li> <li>• Binding ends – specific to tech pack – turn to face or to back – as specified</li> <li>• Refer to Construction Details page in Technical Product Specification</li> <li>• Oval or Round rugs: Position overlap of edgefinish (binding or serging) at an inconspicuous location. Full overlap – binding: 1"minimum / 1 1/2" maximum; overlock: 1 1/2" minimum / 2" maximum. No excessive thread chain-off tails (max 1")</li> </ul>	<p><b>Secondary Backing:</b> Cotton canvas backing</p> <p>Hooked rugs must have latex adhesive coating to secure yarns.</p> <p>Double turn hems</p> <p>CS-chain on face or as specified 2N Coverstitch: needles on face</p>	<p><b>Secondary Backing:</b> Cotton canvas backing. Jute burlap backing with approval</p> <p>Overlock raw edge, single turn hem (only with approval)</p> <p>CS-chain on face or as specified 2N Coverstitch: needles on face</p>
<p>Rugs - Hand Woven / Knotted Rugs (Dhurrie, Kilim, etc)</p> <ul style="list-style-type: none"> <li>• Double turn hems to back, SN LS TS (ISO 301)</li> <li>• Knotted fringe (warp ends). No loose cut warp ends without reinforcement stitching on last weft insertion</li> </ul>		

Revised Date: 2/20/2024



# MINIMUM CONSTRUCTION STANDARDS RUGS

## REQUIREMENTS

### Section IV. Product Labeling

For a full details regarding labeling, please refer to the Kohl's [Labeling Guidelines for Home Textiles](#), on K-link:

*Resources > Private and Exclusive Brands > Performance Testing > Soft Home - Home Textiles > "Labeling Guidelines" under Regulatory Compliance & Safety subheading*

#### Label Placement

- Follow instructions as specified in Kohl's Tech Pack
- For a complete list of label placements, reference the below guides available on K-link:
  - *Resources > Private and Exclusive Brands > Global Technical Design > Home > Label Placement Guides subheading*
  - [Label Placement - Rugs](#)