



# MINIMUM CONSTRUCTION STANDARDS

**PRIVATE & EXCLUSIVE BRANDS HOME**

## TOWELS

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



# MINIMUM CONSTRUCTION STANDARDS TOWELS

## 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 Technical Product Specification.

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

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

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

Section IV. [Measurement Tolerances](#)

Section V. [Product Labeling](#)



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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>	1 way cut: Cut all products in the same direction within an entire program	2 way cut: Cut all pieces within a single unit and multiple components within a set in the same direction but it may be different between units/sets.



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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. 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>Needle &amp; Bobbin Thread: Poly-wrap/Poly-core OR Cotton-wrap/Poly-core</p> <p>Decorative thread as specified</p>	<p>Needle &amp; Bobbin Thread: Spun Polyester</p> <p>Decorative thread as specified</p>
Needle/Bobbin:	Looper:													
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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		
<b>Fasteners (buttons, grippers, snaps, eyelets, grommets)</b> <ul style="list-style-type: none"> <li>• Must be secured through two layers of fabric. Fasteners on a single ply fabric must be supported with non-woven/non-fusible discs - with approval only</li> <li>• Metal components must be plated, lacquered, or enameled to be corrosion resistant. Corrosion proof as specified</li> <li>• Must be evenly spaced and centered on width of panel, or as specified</li> <li>• <b>Children's Products:</b> <ul style="list-style-type: none"> <li>• Functional buttons must be 4-hole and sewn with locking cross stitch, with a minimum of 16 stitches</li> <li>• Decorative buttons can be 2-hole button, sewn with a minimum of 8 stitches</li> </ul> </li> <li>• Buttons must be sewn with shank height suitable for fabric thickness</li> <li>• Covered buttons must be made from a 'kit' and be securely assembled</li> </ul>	Recommended: Sew 4-hole buttons with locking cross stitch  Buttons must have a thread wrapped shank	Allowed: Sew 4-hole buttons with parallel stitch (excluding children's products)
<b>Embroideries</b> <ul style="list-style-type: none"> <li>• Must have suitable tear-away or dissolveable 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> <ul style="list-style-type: none"> <li>• floats no longer than 3/8"</li> </ul> </li> </ul>		
<b>Bead/Sequin</b> <ul style="list-style-type: none"> <li>• <b>No monofilament thread</b></li> <li>• Refer to '<a href="#">Bead &amp; Sequin Attachment Guide</a>' on K-link</li> <li>• Suitable stabilizer must be used with lightweight fabrics</li> <li>• Thread must be knotted off sufficiently throughout to prevent excessive beads/sequins from falling off</li> </ul>		



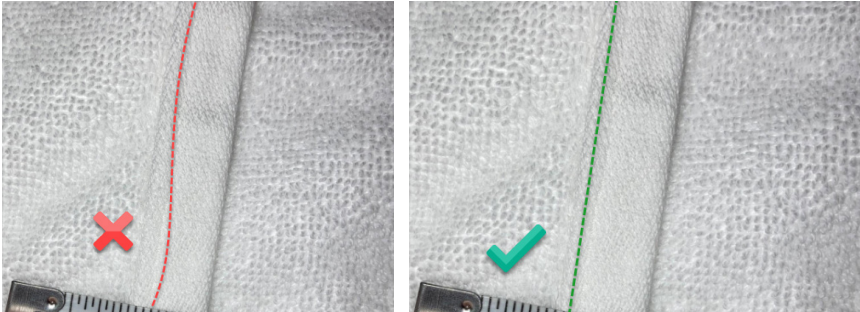
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REQUIREMENTS	Where QUALITY is the Major Consideration	Where PRICE is the Major Consideration
<b>Section II. Trims and Findings Requirements (cont'd)</b>		
Trims/Findings in children's products must meet CPSIA requirements		
<b>Binding</b> <ul style="list-style-type: 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
<b>Ruffles</b> <ul style="list-style-type: none"><li>• Single ply or Double ply as specified</li></ul>	Gather ratio: 1.75:1 - 2:1	Gather ratio: 1.5:1 minimum





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<b>Section III. Sewing and Construction Requirements</b>		
Seams must meet Kohl's seam slippage and strength requirements		
<b>Terry Towels - Side Hems</b> <ul style="list-style-type: none"> <li>Side hems sewn first, as specified and approved. Refer to the Kohl's Tech Pack for additional information</li> </ul>	<i>Recommended:</i> SN LS, reinforced  <i>Allowed:</i> SN CS with Schmale backtacking chainstitch machine head OR 2N CS, Stacking stitches (25-30 SPI) for 1". Tightly chained thread tails - 10mm length maximum	<i>Recommended:</i> SN LS, reinforced  <i>Allowed:</i> SN CS with Schmale backtacking chainstitch machine head OR 2N CS, Stacking stitches (25-30 SPI) for 1". Tightly chained thread tails - 10mm length maximum
<b>Terry Towels - End Hems</b> <ul style="list-style-type: none"> <li>End hems (top and bottom) sewn second, crossing side hem stitching</li> <li>End hems (top and bottom) 3/4" or wider - stitch sides of end hems closed</li> </ul>	<b>Required</b> SN LS, reinforced	<i>Recommended</i> SN LS, reinforced  <i>Allowed:</i> SN CS with Schmale backtacking chainstitch machine head OR SN or 2N CS, Stacking stitches (25-30 SPI) for 1". Tightly chained thread tails - 10mm length maximum
<b>Finishing: Clean Finished Hems</b>		
<ul style="list-style-type: none"> <li>Hem stitching must be applied evenly along hem opening, no more than 1/16" - 1/8" away from edge</li> </ul>		
		

Revised Date: 4/23/2024





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<p><b>Section IV. Measurement Tolerances</b></p> <p>All measurements as specified in the Kohl's Tech Pack. Tolerances apply to finished product dimensions only.</p>		
<p>Component Variation Within A Set</p> <ul style="list-style-type: none"> <li>Component variation must not exceed individual measurement tolerances as specified               <ul style="list-style-type: none"> <li>Length (at center)      +/-1/2"</li> <li>Width (at center)      +/-1/2"</li> </ul> </li> </ul>		
<p style="text-align: center;"><b>REQUIREMENTS</b></p>		
<p><b>Section V. Product Labeling</b></p> <p>For a full details regarding labeling, please refer to the Kohl's <a href="#">Labeling Guidelines for Home Textiles</a>, on K-link:  <i>Resources &gt; Private and Exclusive Brands &gt; Performance Testing &gt; Soft Home - Home Textiles &gt; "Labeling Guidelines" under Regulatory Compliance &amp; Safety subheading</i></p>		
<p>Label Placement</p> <ul style="list-style-type: none"> <li>Follow instructions as specified in the Kohl's Tech Pack</li> <li>For a complete list of label placements, reference the below guides available on K-link:               <ul style="list-style-type: none"> <li><i>Resources &gt; Private and Exclusive Brands &gt; Global Technical Design &gt; Home &gt; Label Placement Guides subheading</i></li> <li><a href="#">Label Placement - Bath and Beach</a></li> </ul> </li> </ul>		