

KOHL'S

Minimum Construction Standards

基本的结构标准

Footwear/Slippers/Flip Flops

Minimum quality and construction standards for footwear/slippers/flip flops

鞋类/拖鞋/人字拖鞋品质以及结构标准

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Introduction 简介

Kohl's is committed to providing our customers with quality product. Building a strong foundation of Kohl's 致力于提供高品质的产品给客户。

minimum construction standards establishes the benchmark in which Kohl's products are made. 建立最低结构标准来确立 KOHL'S 产品的基准。

As a vendor partner, the acceptance of an order placed by Kohl's for Private and Exclusive Branded product requires that these standards, in combination with applicable laws and regulations, are strictly followed.

作为供应商合作伙伴，需要接受 Kohl's 针对自己的品牌和其他非 KOHL'S 品牌的产品要求，须严格遵守这些标准所适用的法律和法规。

General Guidelines, Workmanship, & Appearance

总则，工艺&外观

First quality materials must be used – no seconds. The lot must be cut from only one shade of material – matching pieces must all be the same shade.

必须使用一级材料，不可用次品。同一材料必须为同一色系，配色材料也必须同色系

Your samples are a reflection of your reputation as a vendor partner – samples should always represent the level of craftsmanship you want to be known for.

作为供应商合作伙伴，您的样品反映的是您的信誉 - 样品代表的是您的技术水平。

Samples must always be clean and free from: 样品须整洁，要避免如下瑕疵：

- Defects including excessive glue, dirt, flaws, oil, raw/unfinished edges, repair marks, shade differences, stains, mismatched sizing/heights within a pair
包括过多的胶水，污垢，缺陷，油污，未修剪边缘，标记号，色差，污渍，一双鞋子乱码或者高度不一
- Mold and chemical odors (use anti-mold sheets or box stickers)
发霉和化学气味（须使用防霉片或者防霉纸）

- Irregularities in coloration/pigmentation or surface irregularities that are not inherent to the product
产品颜色以及色泽不规则或者表面纹路不规则。

For more details on defects, please see [Defect Classification List on K-link](#).

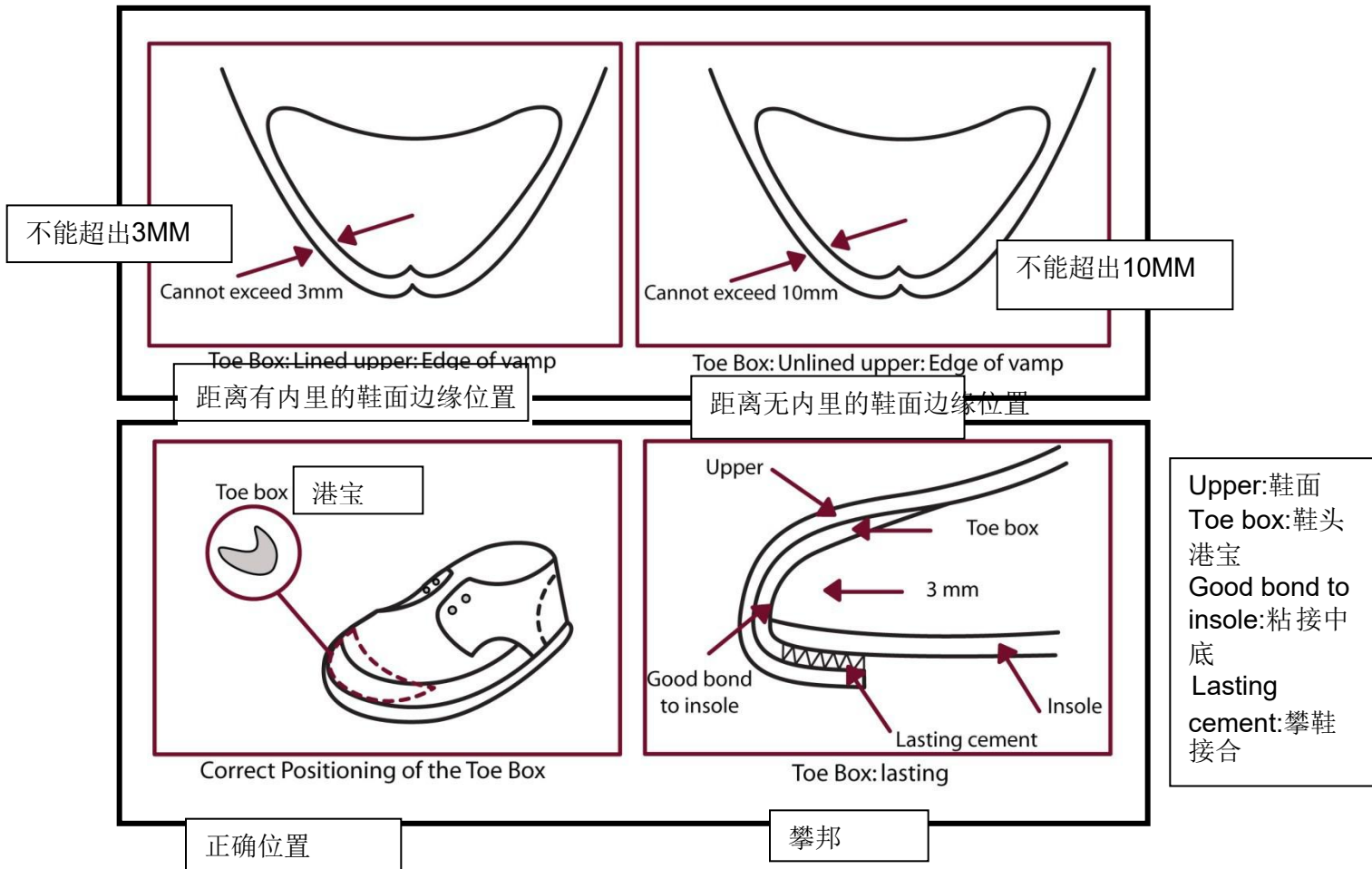
有关瑕疵的更多详细信息，请参阅 K-link 上的缺陷分类列表。

Internal Components 内部组件

- Toe Boxes 前港宝
- Heel Counters 后套
- Insole Boards 中底板
- Composite Midsoles 组合中底
- Molded Midsoles 射出中底
- Heels 鞋跟

Toe Boxes 前港宝

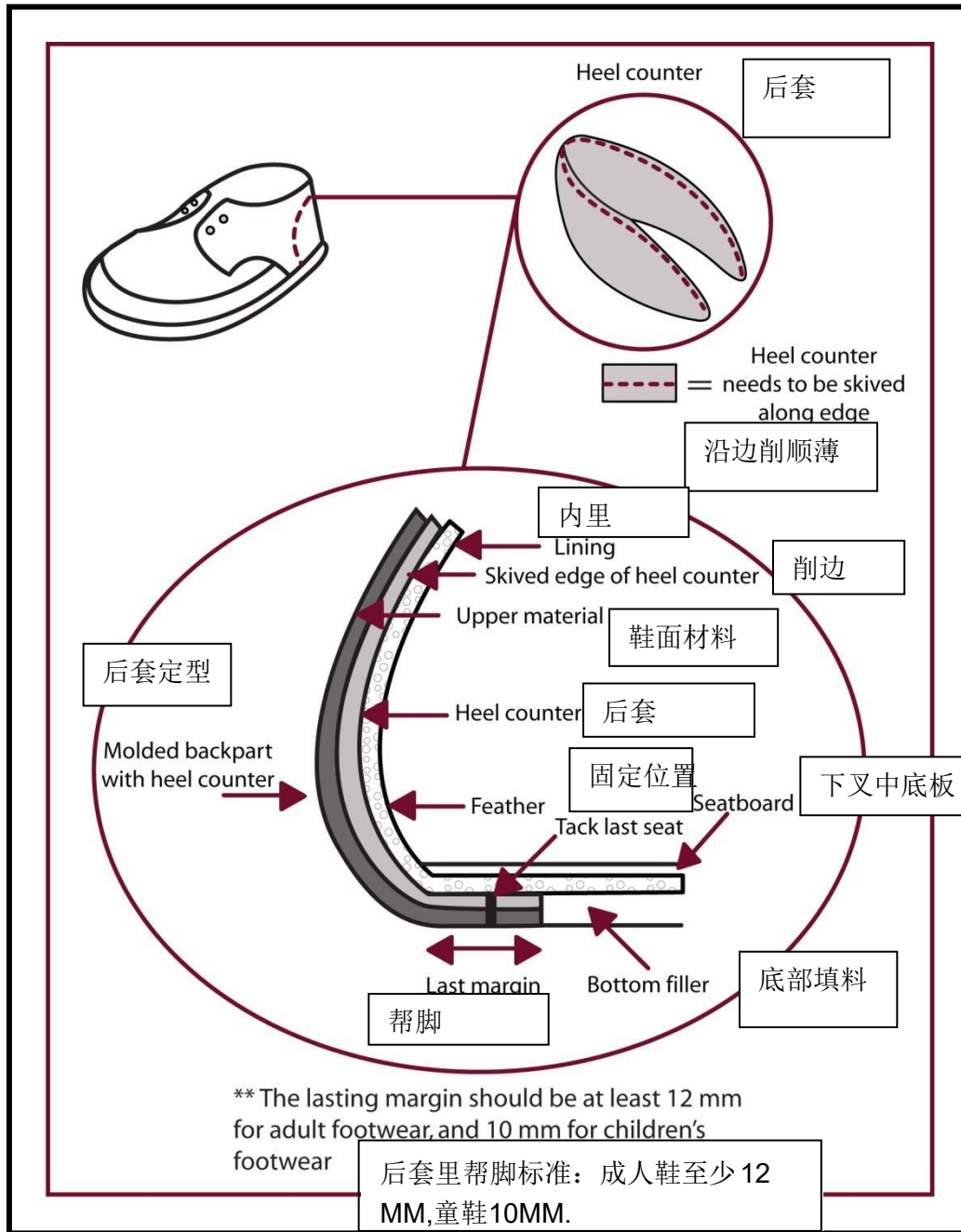
The 'toe box' is typically a firmer material, such as thermoplastic, inserted between the upper and lining to help the toe maintain shape. “港宝”通常是坚固的材料，例如热熔胶，放入鞋面和内里之间以帮助鞋头保持形状。



Heel Counters 后套

- Thermoplastic 热熔胶
 - 1 full shoe size per cut counter size 每一后套码数对应一个鞋子的整码
 - Upper edge needs to be skived, should not be full thickness 面料边缘要顺薄。
 - Counter should extend ~13mm beyond each side of heel breast 后套港宝每侧延伸~13MM
 - Lasting margin: counter must be lasted under insole at least 6mm 帮脚: 后套港宝至少攀在中底下面6MM以上 - Counter must be securely adhered to heel pocked without wrinkles 后套不能发角, 须牢固地粘附在跟面上 -
- Minimum Thickness 最低厚度要求
- o Men's, Young Men's 男鞋: 1.5mm

o Women's 女鞋: 1.0 – 1.2mm



Insole Boards 中底板

Insole boards for Kohl's Private Label footwear is **required** to be ordered from our Preferred Suppliers – Bontex or Texon. Kohl's 自有品牌鞋子的中底板要去 KOHL'S 推荐的供应商 Bontex or Texon 采购

Recommended Insole Board Thickness 中底板厚度推荐

	Cellulose 纤维素	Non-woven 不织布
Wms Athletics w/EVA or Filon Midsole 带有EVA或者FILON中底的女运动鞋	1.00 mm	1.00 mm
Wms Pumps & Casuals / Youth / Toddler / Infant 女装密鞋/休闲/大童/小童/婴童	1.25 mm	1.25 mm
Wms Athletic & Service 女运动鞋/服务鞋	1.25 mm	1.25 mm
Mens Athletics w/EVA or Filon Midsole 带有EVA或者FILON中底的男运动鞋	1.25 mm	1.25 mm
Mens Athletic, Dress & Casual 男运动鞋, 时装/休闲鞋	1.50 mm	1.50 mm
Mens Boots (welt, work, sport & hiker) 男靴 (沿条, 工作, 运动/登山靴)	2.00 mm	1.50 mm

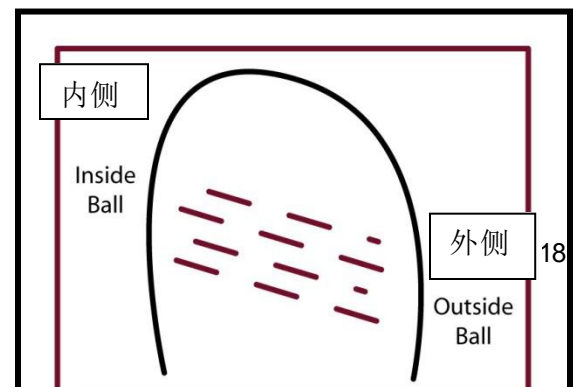
Pre-Approved Qualities from our Preferred Suppliers
推荐供应商的中底有预先确认品质

Shoe Type 鞋型	Texon	Bontex
Wmns Heels 女鞋跟高 >40mm	T507	347FF
Wmns Heels 女鞋跟高 <39mm	T516	347FF
Flat Wmns, Mens, Childrens 男/女/童鞋平底	ECO100	Te

Scored Insole Board 中底板前掌切刀

- Rows of scoring across the insole board from inside to outside ball for flexibility

从内侧到外侧打出中底板的切刀以达到柔韧效果



- Scored rows need to be offset (see diagram).切刀排列要求
 - o Mns男鞋 = 5 rows 排
 - o Wms & Youth 女鞋/大童 = 4 rows排
 - o Toddler & Infant 小童/婴童 = 3 rows排
- Insole bottom filler must be used when board lasting thick uppers to prevent concave soles.

将厚的鞋面攀到中底帮脚时，需要加中底填充物避免凹陷

Steel Shanks 钢芯

- 3.25 mm suggested minimum rivet holes diameter (actual variance is 3.17-3.25 mm) 建议最小铆钉孔直径为3.25 mm (实际为3.17-3.25mm)
- The attachment positions of the rivet holes should be as close as possible to the front & back edges.

铆钉孔的连接位置应尽可能靠近前后边缘。 -

The full height of the flutes should extend as close to the eyelet holes as possible, without interfering with the shank attachment.

在不影响钢芯附着的前提下，凹槽的总长应尽可能延伸靠近孔眼，

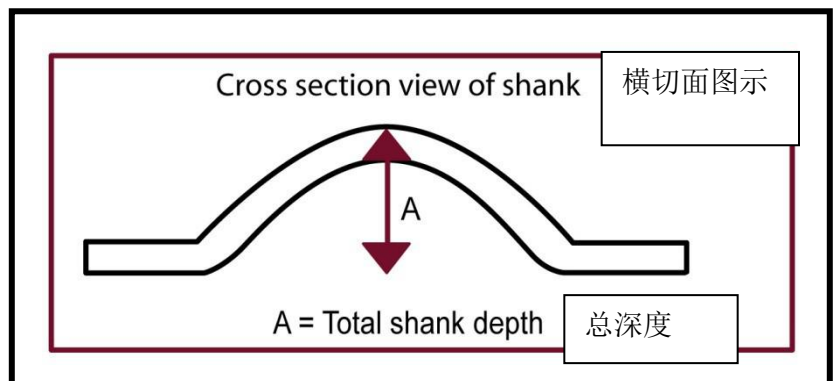
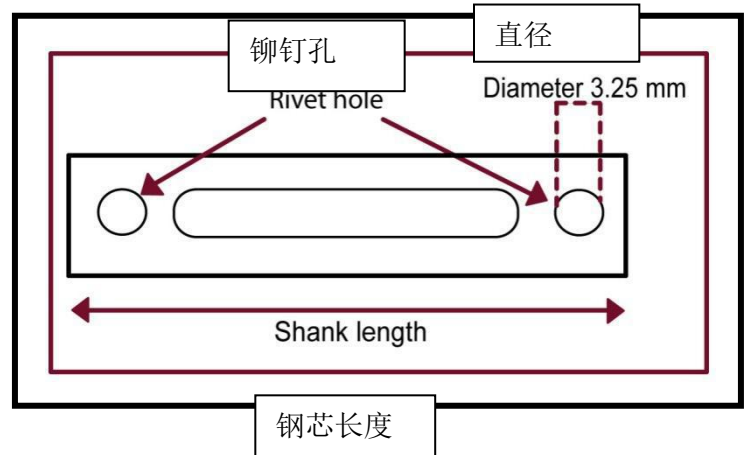
- Measurements of the total shank depth

are normally made 32 mm from the back end of the shank.

钢芯槽总深度通常是从钢芯的背部制成3.2毫米。

- The flat edges of either side of the shank should be as flat as possible 钢芯两侧的边应尽可能平
- There should be no abrupt reduction in width, more than 10 mm from the front & back ends of the shank. 宽度应在前后尾端超过10MM处逐渐减小，不应突然减小
- Be cautious about using flat or slightly fluted shanks with heels > 70 mm high and underset < 15 mm, due to potentially low back rigidity. - 跟高 > 70 mm, < 15mm 的鞋子在使用扁平

或略带凹槽的钢芯时要注意硬度



- Shank length is dictated by the need to position the front & back ends relative to specific parts of the shoe to ensure proper support.
- 钢芯的长度由不同鞋型前端和尾端的位置来决定，以确保适当的支撑。
- Prongs or holes with ragged edges for temporary attachment to buried shank insoles are acceptable if they are within 10 mm of the end of the shank. 为了暂时将钢芯埋置于中底上，在尾端10MM以内采用边缘粗糙的叉或孔是可以接受的。

Shank Dimensions 钢芯尺寸 – Men’s 男鞋 & Women’s 女鞋

- The table below gives recommendations for fluted shank depth based on their width. Based on 1.2 mm thick, tempered steel shanks (46-53 degrees C Rockwell C hardness). 基于1.2 mm厚的钢芯 (46 - 53°C 罗克韦尔 C 硬度) ，下表基于钢芯宽度给予钢芯沟槽深度的建议。
- The heel height referred to in the table is measured vertically at the back of the footwear. (Refer to diagram). 表中提到的鞋跟高度是垂直于鞋子后部测量的。（参见图表）。

Heel Height (mm) 更高	Minimum total shank depths (mm) for shank widths 最低的钢芯深度所对应宽度		
	12 mm wide 宽	14 mm wide 宽	16 mm wide 宽
> 100	Not recommended 不建议	3.76	3.45
75-99	3.40*	3.12	2.82
50-74	2.82	2.49	2.18
< 50	2.18	1.85	1.22

* Some manufacturers cannot guarantee achieving a total shank depth of 3.40 mm for shanks 9.5 mm wide. In these instances, for heel heights of 75-99 mm, a wider shank is recommended.

* 有些供应商无法保证9.5 mm 宽钢芯总的深度为3.40 mm。在这些情况下，对于75-99 mm的鞋跟高度，建议使用更宽的钢芯。

Be cautious about using flat or slightly fluted shanks with heels >70 mm high and underset < less than 15 mm, due to potentially low back rigidity.

跟高 > 70 mm， <15 mm的鞋子在使用 扁平或略带凹槽的钢芯时要注意硬度

- Shank length is dictated by the need to position the front & back ends relative to specific parts of the shoe to ensure proper support. 钢芯的长度由不同鞋型前端和尾端的位置来决定，以确保适当的支撑。
- 10mm shank must always be flat, not fluted, and only used on heel heights <25mm
10毫米钢芯必须始终是平的，没有凹槽，只用于鞋跟高度<25mm的鞋子。

Shank Attachment 钢芯放置

via Insole Board 通过中底板

- Steel shanks should be attached to the insole using a rivet at each end of the shank.
- 钢芯应在两端用铆钉固定在中底上。
- The eyelets size should no more than 0.13 mm smaller than the hole diameter in the shank.
- 铆钉尺寸应小于钢芯孔直径的0.13毫米。
- The barrel diameter of the rivet would be 3.12 mm for a shank hole diameter of 3.25 mm. - 对于3.25毫米的钢芯孔直径，铆钉的筒直径为3.12毫米。

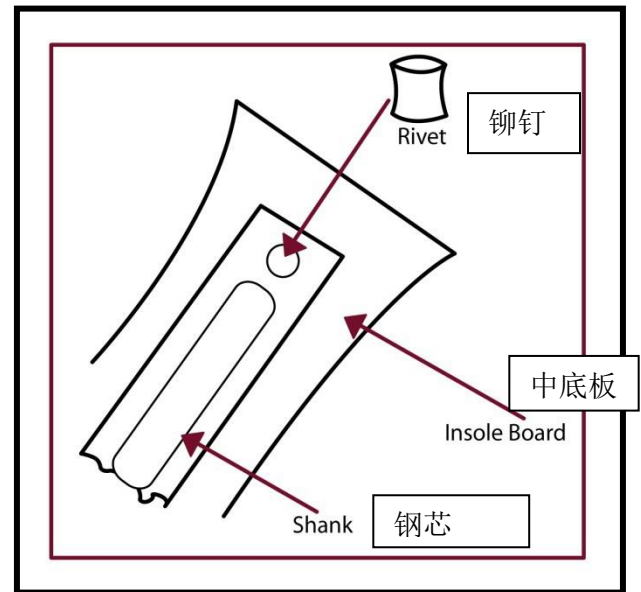
Rivet barrel diameter can vary from 3.05-3.12 mm, depending on the shank hole diameter. 铆钉筒直径可以在3.05-3.12mm的范围内变化，这取决于钢芯孔直径。

- When inserted and clenched, the rivet should expand to fill out the hole in the shank.

当打入时，铆钉应膨胀扩展以填满到钢芯孔。 -

The rivet barrel should be 1.5 mm longer than the combined thickness of the shank and insole board it passes through, to ensure proper clench on the insole side.

- 铆钉筒应比其穿过的钢芯和中底板的组合厚度长1.5毫米，以确保能完全钉牢在中底边。

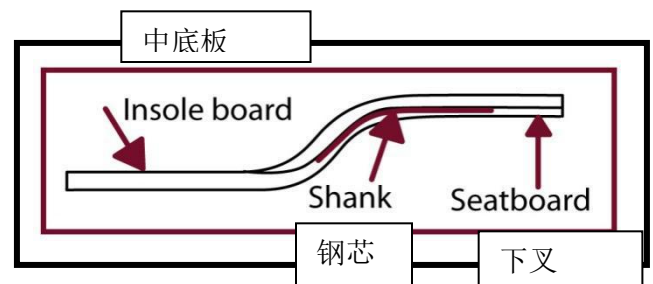


via Combination Board 通过组合中底板

- It is only necessary to attach the shank at one end (to hold it in position while the insole is combined) as long as there is a good bond between the 2 insole boards to keep it in position. A back rivet, or adhesive attachment should be satisfactory. A front attachment rivet may be necessary for heel heights of >100.

- 只要两个中底板之间有良好的胶着力，则只须固定钢芯的一端(在组合中底时钢芯位置要对)，背面铆钉或粘合剂固定都要符合要求。鞋跟高度>100MM的鞋子的前端可能仍需用铆钉固定

- Temporary attachment by means of prongs or ragged holes punched into the shank is satisfactory (see illustration for positioning).



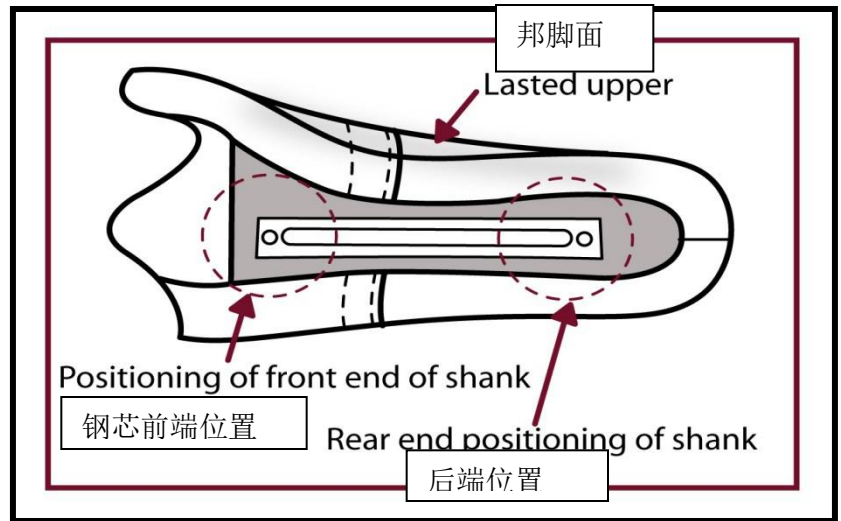
Minimum Construction Standards – Footwear/Slippers/Flip Flops

- 为了暂时将钢芯埋置于中底上，采用边缘粗糙的叉或孔是可以的。(参见定位说明)。
- **FOR WMNS FOOTWEAR WITH HEEL HEIGHTS 50 MM, permanent attachment of the shank is not critical. Hot melt or a similar technique may be sufficient.**

对于鞋跟高度为50毫米的女鞋，钢芯永久附着的技术要求不是很严格，热熔或类似的技术可能足够了。

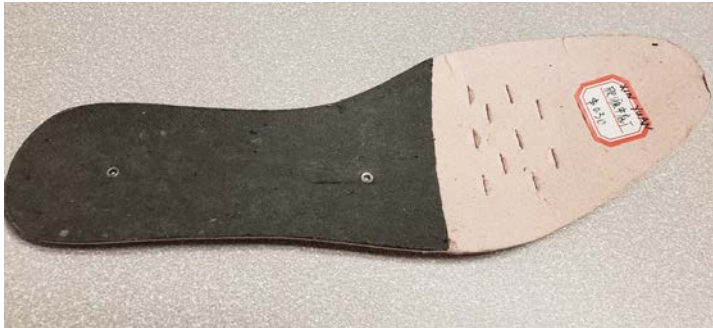
Positioning 位置

- Women's 女鞋: The back end of the shank should normally be 12-20 mm from the back edge of the footwear.
- 钢芯的后端通常应距鞋子后部边缘12~20mm处。
- Men's 男鞋: The back end of the shank should extend at least 25 mm behind the heel breast. 钢芯后端距离跟面至少延伸25毫米。



Composite Midsoles

These traditional midsoles are comprised of the insole board, tuck board, and shank combined into one package. Composite midsoles can be used for most footwear categories and genders.



Molded Midsoles 射出中底

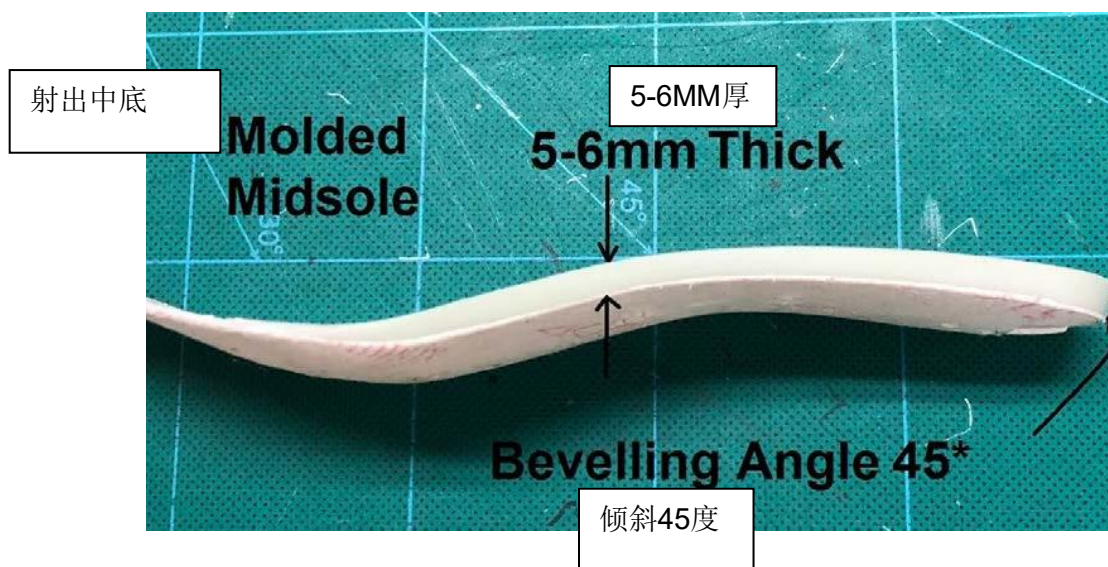
With large order quantities, molded midsoles can be an efficient alternative to traditional midsoles. This method combines the insole board and shank via injection mold to create the midsole.

如果订单数量多，射出中底则有效的取代了传统中底。

该方法将中底板和铁心通过射出模具进行组合，形成射出中底。

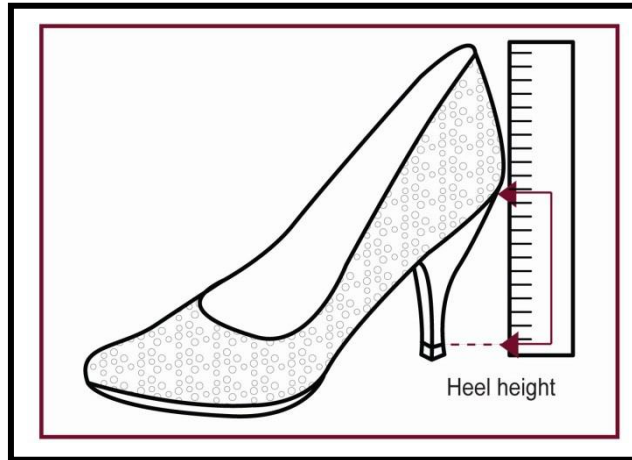
- 3.0 – 6.0mm thickness 厚度
- Includes steel shank 含钢芯, 12 – 16mm wide 宽度, 1.2mm thickness 厚度
- Edges of heel area of midsole should be beveled around 45° and match the heel
- 中底鞋跟区域的边缘应倾斜约45°，与鞋跟相匹配。
- **For heel attachment, see page 18 for screw length minimums. Screw length must be an additional 6-8mm long to clear the thickness of the molded midsole.**

-鞋跟固定，请参阅第18页的螺钉长度最小值。螺钉长度必须要超出中底6至8毫米，不包括射出中底的厚度。



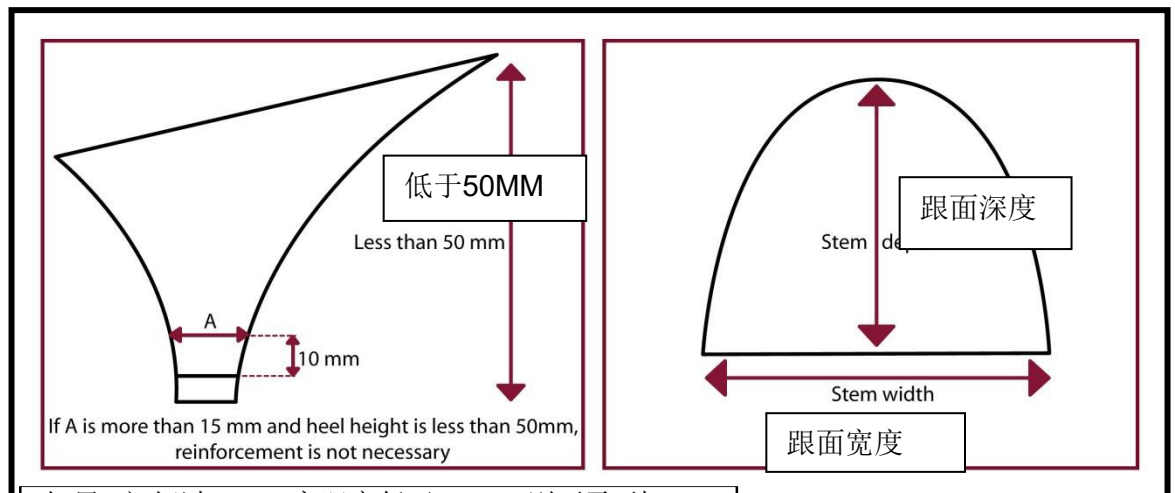
Heels 跟

Heel Height Point of Measure (POM)
鞋跟高度测量点



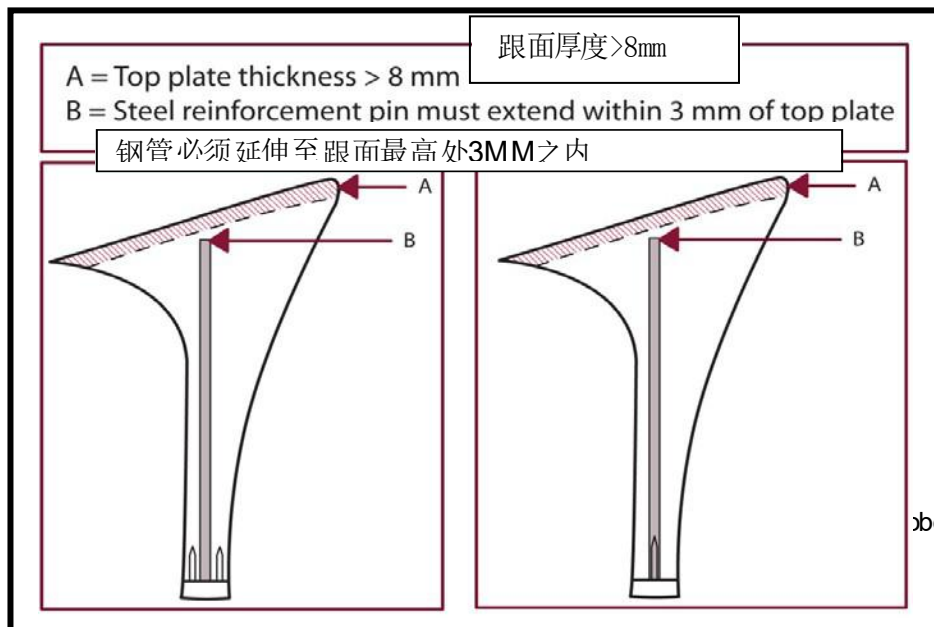
Heel Height & Shaft Diameter Points of Measure

鞋跟高度和轴直径测量点



如果A部超过15MM宽跟高低于50MM,则不需要加固跟

Heel Reinforcement
鞋跟加固



Heel Attachment will be checked both in fit evaluation and intermittently via inspections.
 鞋跟拉力在试穿样品时会检查，也会在大货验货时抽查
 Confirmation samples, fit samples, and production samples should all match in heel attachment.
 确认样品，fit样品及大货样品的鞋跟拉力要一致

3 Screw Method 锁螺丝钉方法

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

KOHL'S 自有品牌推荐锁三颗螺丝钉，这样做跟的强度和完整性都很出色。如果工厂有更好的方式请联络KOHL'S TD。



4 Nail + 1 Center Screw Method 4颗牙钉+中心一颗锁钉

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

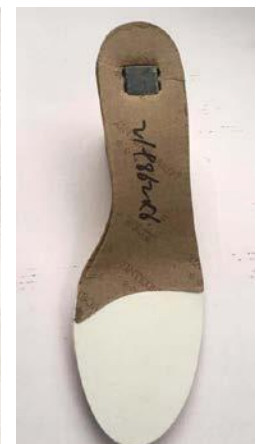
在得到KOHL'S 确认的前提下，某些特定款式可以用4颗牙钉+中心一颗锁钉的方式，虽然牢固度稍逊色，但这种锁钉方式对这些款式会更有效，这种情况下，跟的强度和完整性可以让步于跟的结构，但仍必须提交测试通过的报告。











Ultrasonic Plate 四角钉

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

在得到KOHL'S 确认的前提下，跟高<50mm 的低跟/粗跟或者坡跟/有防水台的鞋子推荐用四角钉，但须提交测试通过的报告



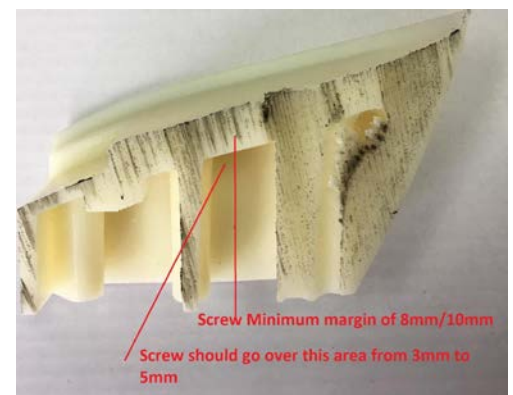
Recommended Heel Attachment by Heel Type

SKETCH	HEEL TYPE	3*SCREWS	4*NAILS+1*SCREW	1 SCREW
	STILETTO	≥65MM	<65MM	N/A
	CONE HEEL	≥65MM	<65MM	N/A
	KITTEN HEEL	≥65MM	<65MM	N/A
	SPOOL HEEL	≥65MM	<65MM	N/A
	LOUIS HEEL	≥65MM	<65MM	N/A
	WEDGE	NO NEED	NO NEED	If it's extra sock lining or heel seat design, then can put 1 screw, otherwise, only cement
	BLOCK	NO NEED	YES	N/A
	CHUNKY HEEL	NO NEED	YES	N/A

Recommended Screw Length Minimums

Heel Height	Minimum Screw Size
< 50mm	19mm length + 6mm head diameter
50 – 74mm	21mm length + 6mm head diameter
75 – 99mm	23mm length + 6mm head diameter
100mm+	25mm length + 6mm head diameter

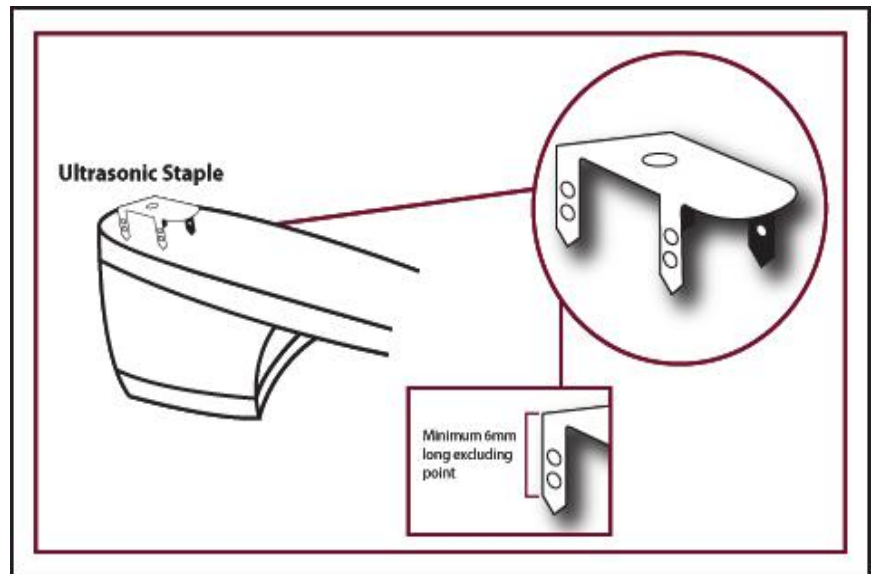
- Screws must be of high quality metals to promote strong integrity, and resistance to cracking
- Screws or staples must go into heel at least **8 mm**
- 30-35mm screws are typically only used on high platform constructions, to attach the insole to the platform



Ultrasonic Staples – for lower, chunky heels <50mm 四角钉适应于跟高<50mm低跟/大粗跟

Choose largest staple, but ensure that the legs do not damage the sides of the heel. 选择最大的钉，但要确保钉脚不会损伤鞋跟的两侧。

- The main point of attachment should be taken as the point where the center line of the front legs pass through the insole. 主要连接点应为钉的前脚中心线穿过中底的点。
- Staples must go at least 6mm into heel, not including pointed end. 钉必须至少要入跟6毫米，不包括钉的尖点。
- Do not use staples with TPR unit outsoles. 不要使用订书针连接TPR一体底。
- Cover the head of all staples with a thin piece of rubber or upper material on the insole. 在中底上用一块橡胶片或者鞋面材料覆盖所有钉头。

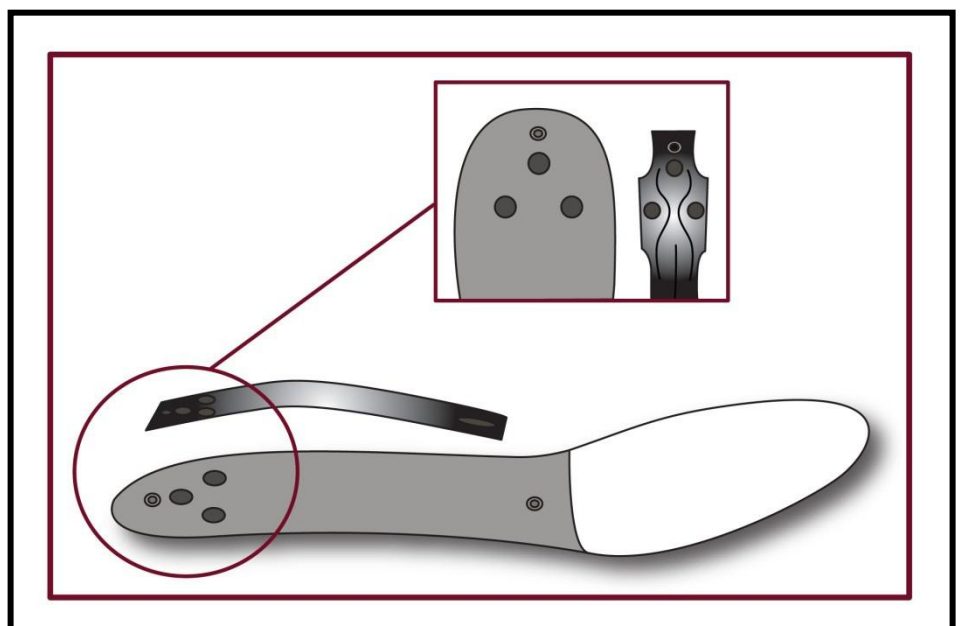


Shanks 钢芯 & Screws 锁钉

Specialized Shank & Screws

特制钢芯 & 锁钉

- If the heel silhouette is so too small/shallow to attach with nails, then a shank with a special back part is required. The back part of the shank, and the heel seat board it is riveted to, is made with holes



positioned so that 2 heel attachment screws can be driven in side by side.

如果鞋跟轮廓太小/太浅而不能用钉子固定，则需要带有特殊背面的钢芯。钢芯的后部和中底跟坐需要采用定位孔，使得2个后跟连接螺钉可以并排钉入。

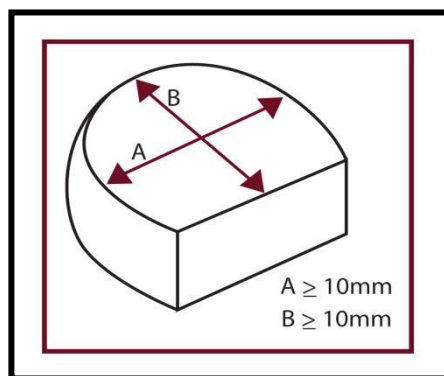
Toplift 天皮

		天皮厚度 Thickness of Toplift			
		男鞋/童鞋 Men's and Children's		Women's 女鞋最低厚度 Recommended minimum thickness (mm)	
天皮类型 Type of Toplift	超过 Over 25mm wide 宽	Over 25mm wide	Over 25mm wide	15-25mm wide	Less than 低于 15mm wide 宽
整片型 Sheet		6	4.5	6	Not Recommended 不建议
模压型 Molded (Autoloc type)		6	4.5	6	Not Recommended
模压型 (带金属套管) Molded (With metal spigot)		N/A	4.5	6	6

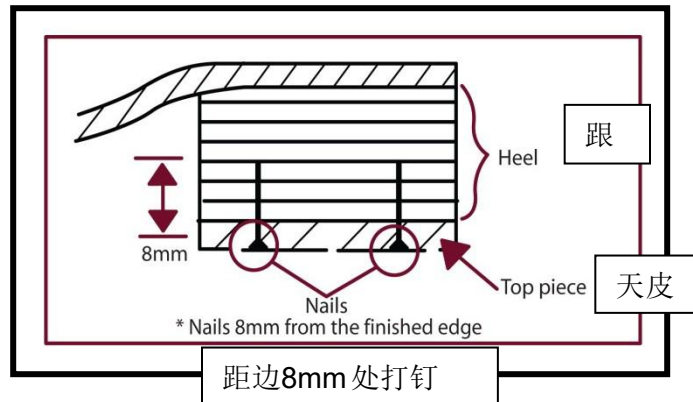
must be at least 10mm in any direction
天皮任何方向都必须至少10mm

*Toplift

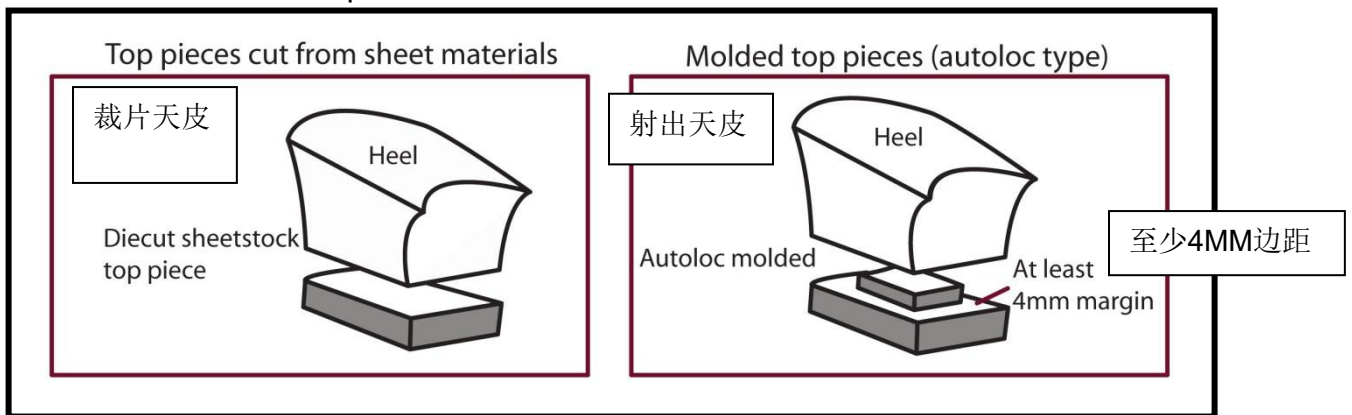
Toplift Diameter 天皮直径



Toplift Nailed 天皮钉

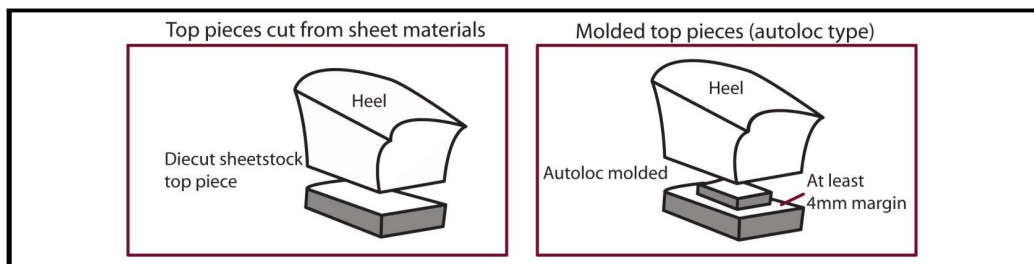


Sheet Material and Molded Toplifts 裁片与射出天皮



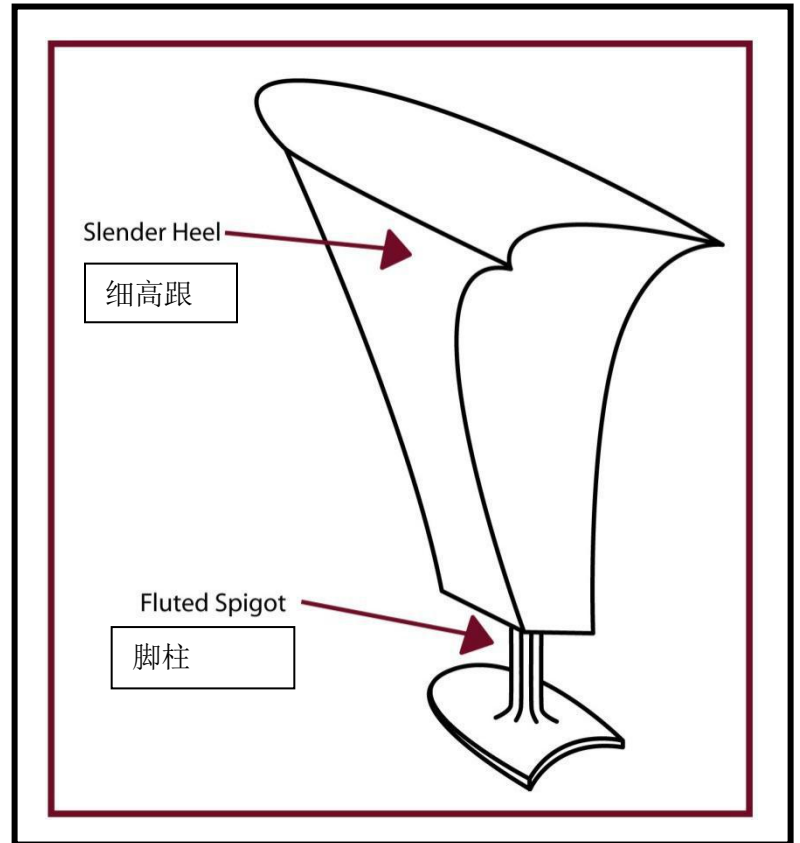
Autoloc Toplift Illustrations AUTOLOC天皮说明

- The heel cavity is designed to give an interference fit with a plastic extension molded onto the Toplift.跟内部要有龙骨增加天皮的黏着
- The cross section of the plastic spigot (extension) should be non-circular to prevent the Toplift from turning in the heel cavity.天皮脚柱（延伸）的横截面应为非圆形，以防止天皮在跟腔中翻转。
- The heel wall must be thick enough to prevent the high stresses at Toplift insertion from cracking the heel plastic and should be at least 4mm thick.跟墙至少要4MM厚以防止天皮嵌入产生的高压而裂。
- There should be no sharp corners in the cavity.在跟内部中不应该有尖角。
- Slender heels less than 15mm across in either direction at the top will not normally provide a thick enough wall section to be used with an autoloc type Toplift.跟的底面任意方向直径小于15mm的细高跟鞋通常剖面不够厚，不能使用AUTOLOC射出天皮



Molded Toplift with Spigot

带脚柱的射出天皮



External Components 外部组件

- Outsoles 大底
- Toplines 鞋口
- Toe Posts
夹脚鼻梁

Outsoles大底

Soling Materials for All Footwear (including hanging)

所有鞋类的大底材料（包括挂钩装的鞋子）

Compounds Containing Recycled Materials - the recycled material content of outsole compounds cannot exceed **35%**. The results of using more than 35% recycled materials in an outsole compound are low abrasion, poor slip resistance, and strong chemical odors.

含有回收材料的化合物-大底化合物的再生材料含量不能超过**35%**。在大底化合物中使用超过**35%**的回收材料的结果是低磨损、低抗滑性和强烈的化学气味。

Outsole Unit Design大底设计

- The width of the bonding margin should be at least 10 mm.大底贴胶面应至少为10毫米宽。 - There should be no lettering molded into the surface of the molding margin.

在模具边缘的表面不能刻字。

- The angle of the undercutting of the margin should be at least 45 degrees.

角度应至少为45度。

- The thickness of the material before undercutting must be at least 3.2 mm.

大底厚度至少为3.2毫米（不含底花）。

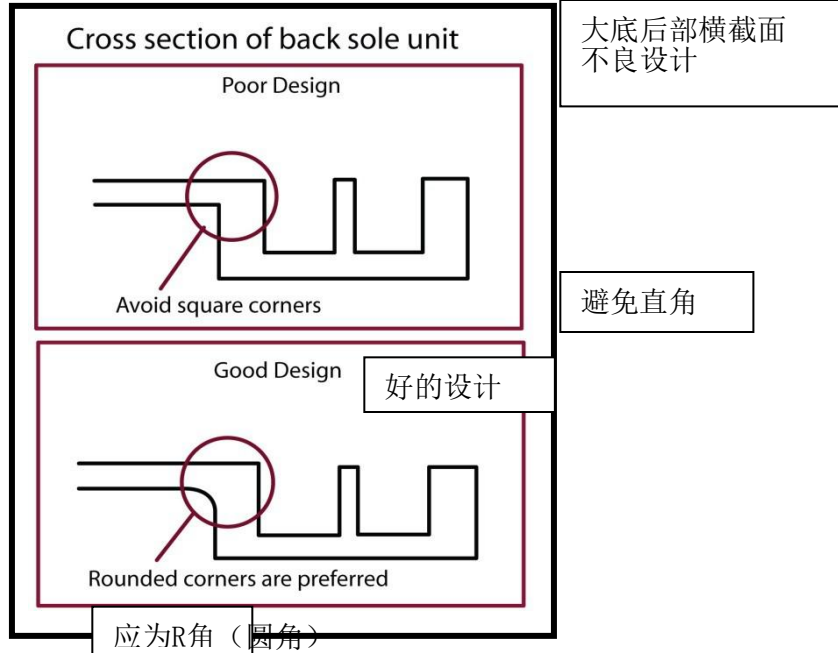
- The thickness of the sidewall should be at least 7 mm.边墙的厚度至少要7毫米.

- Rounded internal corners in patterns are recommended to help reduce stress points caused by the pattern design.建议采用圆形内角，以减少底花设计引起的压力点。

- A curve with a radius of one third of the channel width is recommended.

建议弧度为半径的3/1。

Heel Breast Design
跟腰设计



Patterned Sole Design 大底底花设计

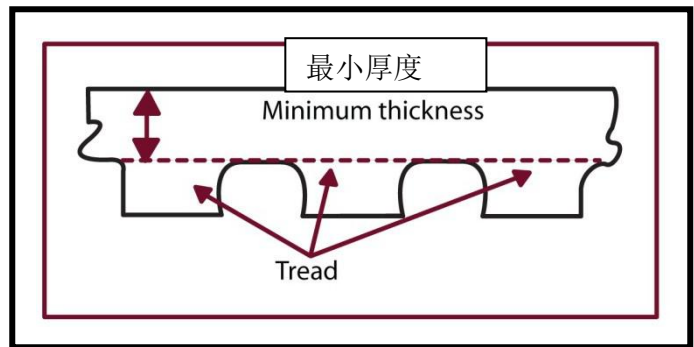
Outsole thickness prior to patterning: 大底厚度优先于底花设计

- 2 mm for hard materials 2MM硬底 (不含底花厚度)
- 4 mm for soft materials 4MM软底 (不含底花厚度)
- It is recommended that patterns are not cored out. 建议不要用凹下去的底花

Unit Sole Cross Section 大底横截面

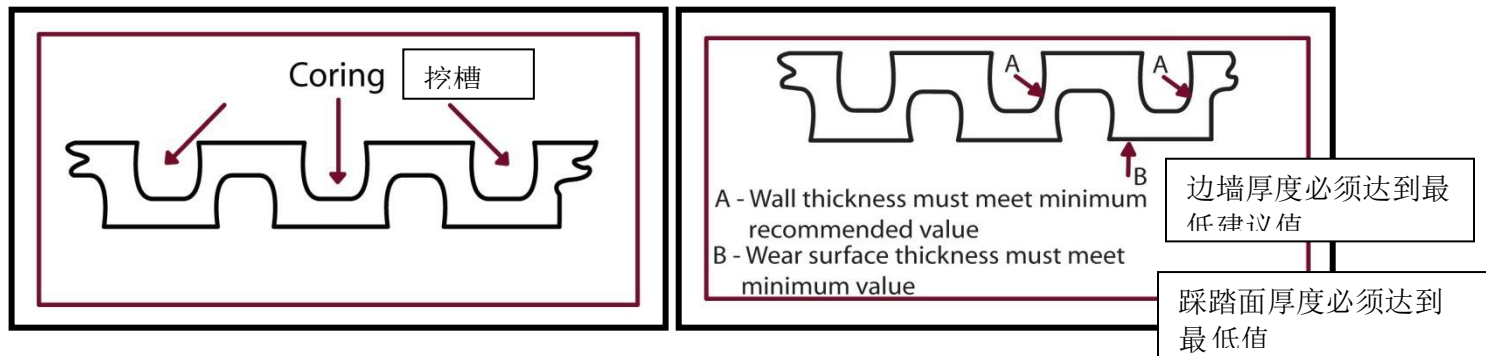
- If the pattern is cored out, the wall thickness should not be less than the wearing surface thickness.

如果底花是凹下去的，则边墙厚度不应小于踩踏面的厚度。

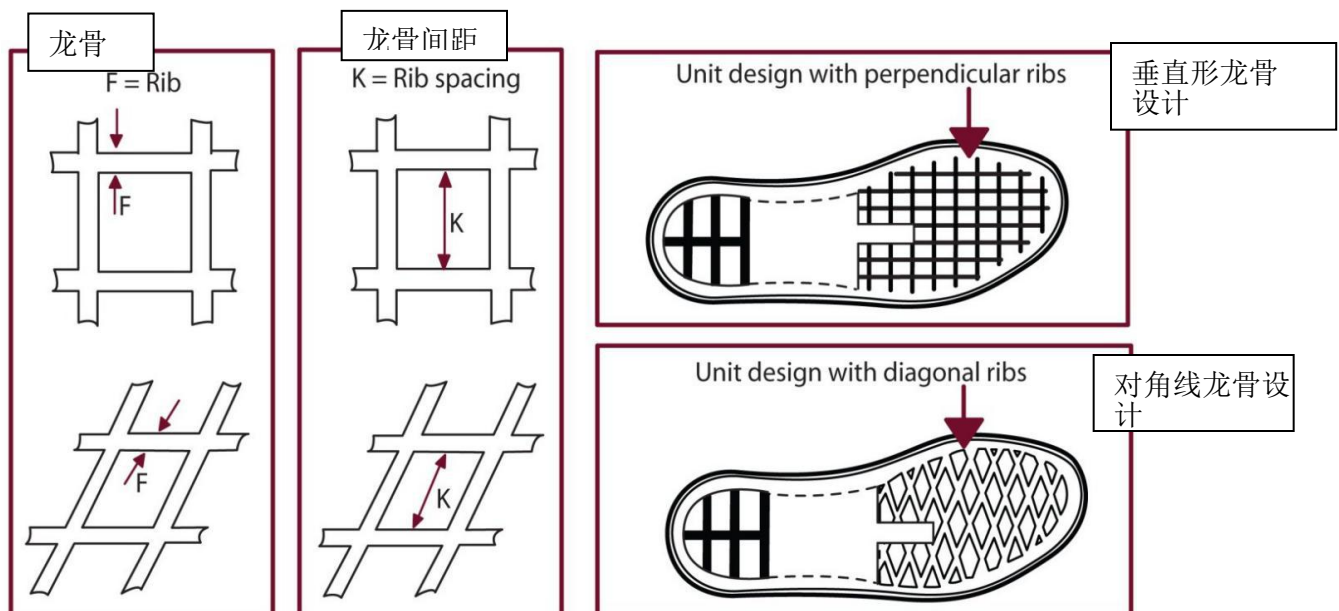
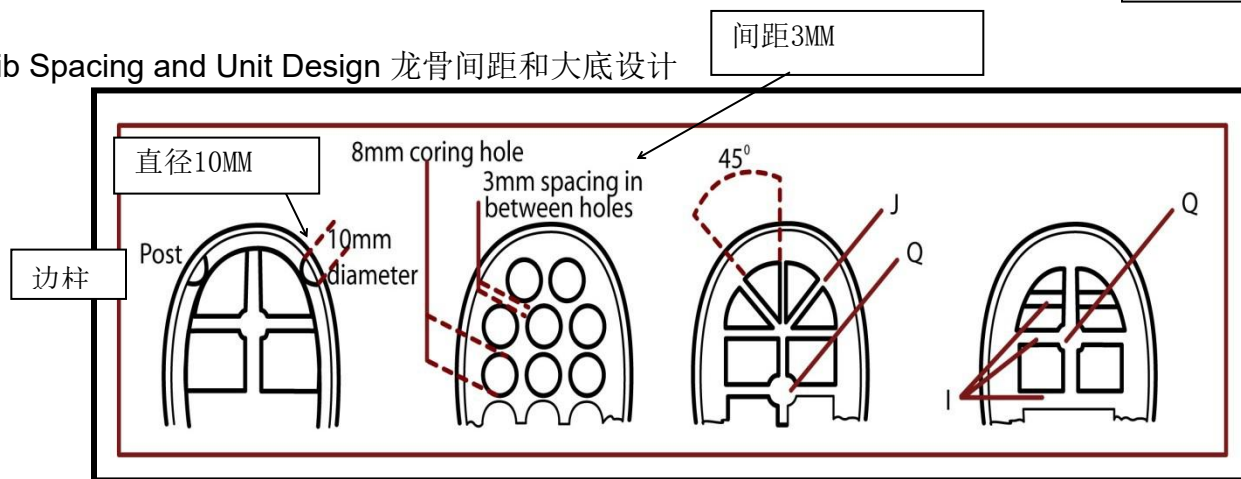


Cored Unit Cross Section 凹槽横截面

- Where a dual density sole is used, coring of the pattern is acceptable if the coring is filled with an infill material. 如有使用双密度大底，只要凹槽有材料填充，则底花的凹槽是可接受的



Rib Spacing and Unit Design 龙骨间距和大底设计



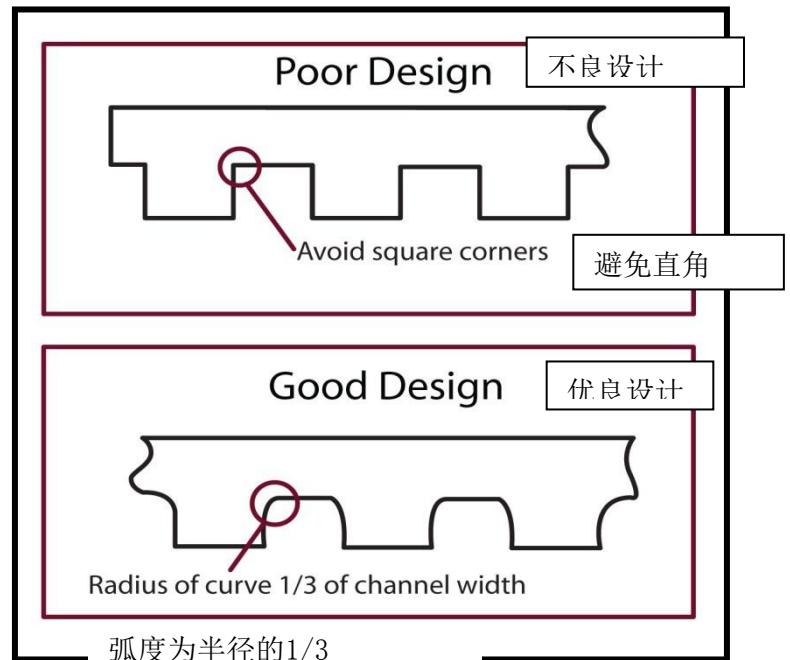
Poor & Good Sole Designs 不良 & 良好的大底设计

- The more leading edges in the sole pattern, the better the frictional properties.

底花越多，摩擦力越好

For soles where the pattern runs transversely across the sole, the compound type must be chosen carefully since these types of patterns are more prone to cracking.

对于横向穿过鞋底的底花，必须慎用复合底花，因为这种类型的底花更容易开裂



Internal Flex Grooves 内部弹性凹槽

- Horizontal grooves in the top of the unit, at the forefoot of the shoe designed to promote flexion 大底顶部的水平凹槽，位于鞋的前掌，意在促进弯曲
- Recommended indentation around 1.5mm 建议压痕约1.5mm



Soling Materials 底料– Minimum Thickness最小厚度

Soling Material底料	Recommended Thickness (mm) 建议厚度	
	Utility 运动底& Hikers登山底	Casual休闲底& Dress时装底
Resin Rubber 美耐底	4.3	2.7
Vulcanized Rubber硫化底	5.0	4.0
Microcellular Rubber -low density* 微孔橡胶 - 低密度	8.0	6.0
Microcellular EVA – low density* 微孔EVA - 低密度	8.0	6.0
Microcellular EVA – high density微孔EVA - 高密度	4.3	2.7
TPR Unit 单底– hard grade硬等级	6.0	5.0
TPR Unit 单底– soft grade软等级	5.0	3.0
Polyurethane – single density聚氨酯 - 单密度	5.0	3.0
Polyurethane – dual density – outsole - midsole聚氨酯 - 双重密度 - 大底 - 中底	2.0 4.0	2.0 3.0
Crepe Rubber生胶底	6.0	5.0
Leather皮底 - cemented 皮底-冷粘	3.5	3.0
Leather 皮底– welted沿条 & machine stitched车线	4.0	3.5

* Not recommended for children’s footwear 不建议使用于童鞋

Soling Materials底料 – Stitched Sole 缝合大底

Thicknesses Stitching through the bottom of the sole:粗线穿过底部

- The thickness of the soling material under the stitch should be at least 3 mm.
车线下方大底厚度至少要3MM.
- The stitching groove in the bottom of the sole should be 1 mm deep.
大底底部的缝合槽应为1毫米深

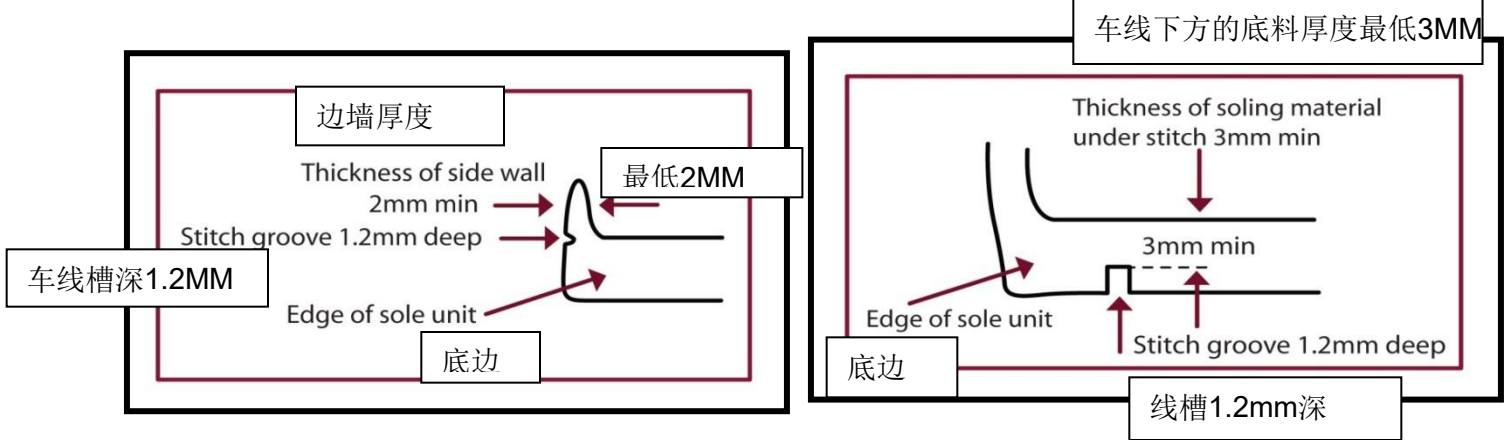
Stitching through the sidewall of the sole:

缝合大底的边墙

- The thickness of the sidewall should be at least 2 mm.边墙的厚度至少2MM
- It is recommended that the sidewall have a shallow stitching groove.
建议边墙有一个浅的缝合槽

Bottom Stitch 底线

Sidewall Stitch 边墙车线

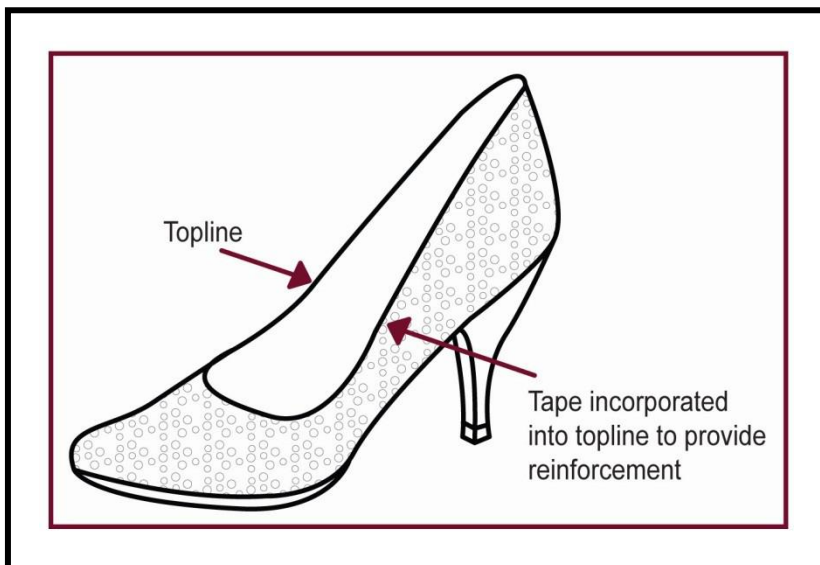


Toplines 鞋口

It is important to add Reinforcement Tape along the topline to cover any raw edges and prevent fraying. 沿着鞋口添加补强以覆盖任何毛边并防止磨损。

Upper Material 鞋面材料	Minimum Tape Width (mm) 补强最小宽度
Synthetics 合成革 0.8 mm or thicker 更厚	1.6 mm
Synthetics 合成革 thinner than 0.8 mm 比 0.8MM 薄	2.4 mm
Synthetics, stretch 弹力合成革	2.4 mm
Leathers thicker than 1.2 mm 皮料厚于 1.2MM	1.6 mm
Leathers 1.2 mm or thinner 皮料 1.2 或者 薄于 1.2	2.4 mm
Leathers, stretchy 弹力皮	2.4 mm
Leather, patent 镜面皮	2.4 mm
Textile 布类	2.4 mm

Topline Reinforcement 鞋口补强

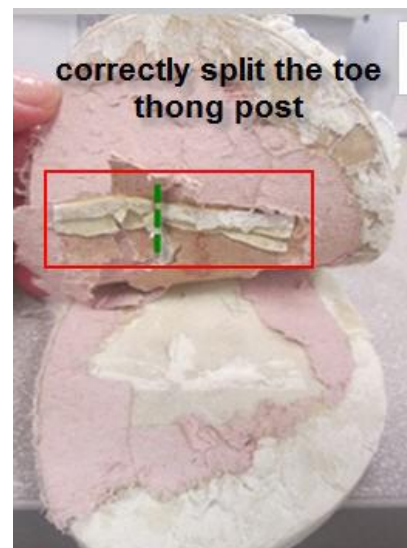
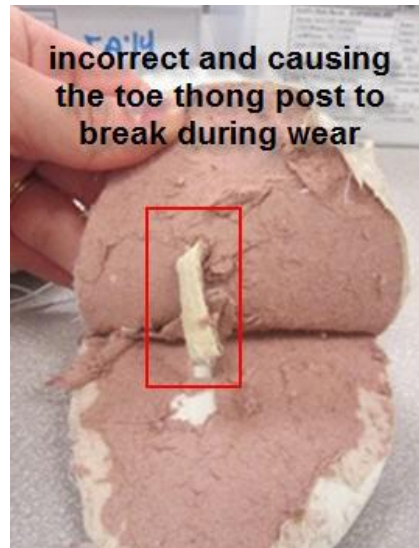


鞋口补强带组合

Toe Post Construction Standards 夹角鼻梁结构标准

The base of the toe thong must be split a minimum of 2-3 times under the footbed to ensure it does not pull through during wear. 夹脚鼻梁的底部必须在脚床下分开，以确保在穿着时不会拉脱。

错误的方式导致夹脚带拉脱



正确分开夹脚鼻梁

Toe post must stand vertically – **not** angled/pulled back, as this holds the foot back.

夹脚鼻梁必须垂直-不可倾斜/回扯



Minimum Toe Post Length 夹脚鼻梁最小长度

Women's 女鞋	
5-6 or S	25.4 mm
7-8 or M	25.4 mm
9-10 or L	28.6 mm
11-12 or XL	28.6 mm

Men's 男鞋	
6-7 or S	28.6 mm
8-9 or M	28.6 mm
10-11 or L	31.8 mm
12-13 or XL	31.8 mm

Boys Accessories 男孩	
12-13 or XS	25.4 mm
1-2 or S	25.4 mm
3-4 or M	25.4 mm
5-6 or L	25.4 mm
7-8 or XL	28.6 mm

Youth 大童	
10-11 or S	22.2 mm
12-13 or M	22.2 mm
1-2 or L	25.4 mm
3-4 or XL	25.4 mm

Toddler 婴童	
1-2 yrs or 4/5	19 mm
3-4 yrs or 6/7	19 mm
4-5 yrs or 8/9	19 mm

Trims 配件

- Thread 车线
- Elastic & Goring 松紧
- Other Trims
其他配件

Thread车线

Preferred Suppliers include American & Efird, Inc. (A&E) and Coats – please refer to Kohl's Required Footwear Suppliers on [K-Link](#). 首选供应商包括美国&EFRD公司（A&E）和 COATS-请在K-Link上参阅Kohl所需的鞋类供应商。

Thread Size Reference 车线规格参考

	Children童鞋/Slippers拖鞋 /Casual休闲鞋		Sports运动/Hiking 登 山鞋Shoes		Hiking登山/Work Shoes工作鞋	
Operation运用	Thread Size 车线规 格	Fiber Type 纤维类型	Thread Size车 线规格	Fiber Type纤 维类型	Thread Size车 线规格	Fiber Type纤 维类型
Upper Stitching鞋面车线						
Needle Thread面 线	M40	Nylon尼龙 6.6	M30	Nylon 6.6	M20	Nylon 6.6
Bobbin Thread底 线	M41	Nylon 6.6	M31	Nylon 6.6	M21	Nylon 6.6
Water Repellent防水面						
Needle Thread面 线	M40	Nylon 6.6	M30	Nylon 6.6	M20	Nylon 6.6
Bobbin Thread底 线	M40	Nylon 6.6	M30	Nylon 6.6	M20	Nylon 6.6
Embroidery电绣						
Needle Thread面 线	M120	Trilobal Polyester 三叶形涤 纶短纤维	M120	Trilobal Polyester	M120	Trilobal Polyester
Bobbin Thread底 线	M160	Spun Polyester短 纤维涤纶	M160	Spun Polyester	M160	Spun Polyester
Mocassin手工缝线鞋						
Hand Stitching 手缝线	1.0mm	Braided Polyester, Waxed for pile/brushed fabrics编织 涤纶	1.2mm	Braided Polyester, Waxed for pile/brushed fabrics	1.2mm	Braided Polyester, Waxed for pile/brushed fabrics
Welt Outsole 沿条大底						
Needle/Awl针/锥	M9	Continuous Fiber Polyester连 续纤维聚酯	M7	Continuous Fiber Polyester	M7	Continuous Fiber Polyester

Minimum Construction Standards – Footwear/Slippers/Flip Flops

Bobbin Thread底 线	1.0mm	Braided Polyester 编织涤纶	1.0mm	Braided Polyester	1.0mm	Braided Polyester
Bobbin Thread底 线	1.0mm	Braided Polyester 编织涤纶	1.2mm	Braided Polyester	1.2mm	Braided Polyester
Welt/Inseaming 沿条/内接缝						
Needle Thread面 线	M5	Continuous Fiber Polyester 连续纤维聚酯	M5	Continuous Fiber Polyester	M5	Continuous Fiber Polyester
Bobbin Thread底 线	M4	Monocord Polyester 莫诺考涤纶	M4	Monocord Polyester	M4	Monocord Polyester
Cupsole外底/Sidewall 边墙						
Needle Thread面 线	M10	Nylon 6.6		Nylon 6.6		Nylon 6.6
Bobbin Thread底 线		Nylon 6.6		Nylon 6.6		Nylon 6.6

Thread Definitions 车线定义

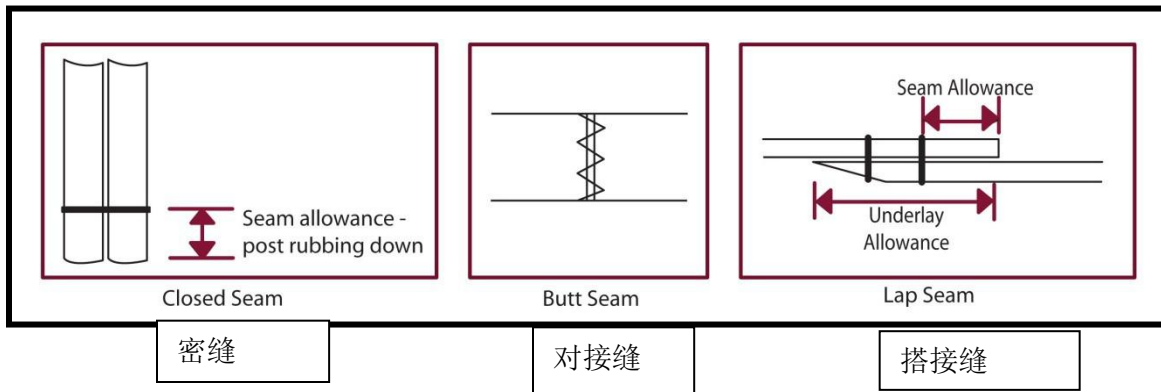
- Nylon 6.6 (Polyamide) – High tenacity nylon continuous filament yarn, bonded by resin and finished by special heat-setting 尼龙6.6（聚酰胺）-高强度尼龙连续长丝，用树脂粘接且用特殊热定型制成
- Trilobal Polyester – Multiple filament, twisted, high-sheen continuous fiber thread. Triangular shaped fibers reflect more light, resulting in high sheen 三叶形涤纶复丝、绞纱、高光泽连续纤维丝。三角形的纤维反射更多的光，从而产生高光泽。
- Spun (or Staple) Polyester – Individual fibers are rarely longer than a few centimeters and thread strength depends on the degree of twist when the fibers are spun into yarns. 短纤维涤纶—单纤维长度很少超过几厘米，车线强度取决于纤维纺成纱线时的扭曲度
- Braided Polyester – 3 or more yarns braided together. Less likely to untwist. 编织涤纶- 3种或多种纱线编织在一起。不太可能会拆开。
- Continuous Fiber Polyester – The individual fibers are many miles long. Bundles of fibers are spun together to form yarns, and the yarns combine to form thread. 连续纤维聚酯—单个纤维长很多英里。纤维束被纺成纱线，纱线结合在一起形成线。
- Monocord Polyester – bonded monocord polyester, displaying a flat, ribbon-like cross section for low-profile stitches. Excellent seam strength, very good colorfastness, and good overall sewing performance. 莫诺考尼龙单丝线，有优良的接缝强力，非常好的色牢度和缝纫性能。

Seam Allowance Guidelines 缝份规则

Minimum Seam Allowance 最低缝份				
	Closed Seam 密缝	Lap Seam 搭接合缝		
		Underlay 下垫层	Seam Allowance 缝份允许值	Distance Between Rows 行距
Patent Leather 镜面皮	2mm	9mm	1.5mm	1.5mm
Other Leathers, 其他皮类包括反毛皮 Including Suede	2-3mm	9mm	1.5-2.0mm	1.5mm
Coated Textiles & Poromerics 涂层纺织品 & 透气人造革	3mm	9mm	3mm	2mm
Textiles 布类	4mm	9mm	3mm	2mm
Meshes 网布	3mm*	11mm*	3mm*	3mm*
Moccasin Plug Seam 马克线	4mm			

*Distance must exceed the width of the openings in the mesh pattern. 距离必须超过网状图案中开口的宽度

Seam Illustrations 接缝示例



Functional Seams: Needle Types & Maximum Stitch Density 功能性接缝：针型和最大车线密度

Material材料	Preferred Needle Type 推荐针类**	Recommend Stitch Density 建议车线密度 (stitches per inch 每英寸针车数)
Patent leather 镜面皮	Narrow or extra narrow wedge 箭尾针或者超细箭尾针	10 - 12 SPI *
All other leathers 其他皮	Narrow wedge or any needle with cutting point precise type 箭尾针或者其他有切割针尖的针	10 - 12 SPI *
Coated textiles 涂料布 & Poromerics 透气人造革 (Breathable 透气料)	Round or Tri-R point (Tri-R is a round point needle w/triangular tip) * 圆头或三角型针尖 (TRI-R就是带有三角形针尖的圆头针) *	8 - 10 SPI *
Mesh Knits 网眼编织	Smallest round point needle (do not exceed #14 needle size) 最小圆头针 (不超过14针大小)	8 - 10 SPI *
Textiles 布类 (Uncoated 没有涂层)	Round (Ball) or Tri-R point (Tri-R is a round point needle w/triangular tip) * 圆头或三角型针尖 (TRI-R就是带有三角形针尖的圆头针) *	8 - 10 SPI *
<p>* An extra narrow wedge may be used for a neater seam appearance. ** Needle size should match the thread size. 为使接缝外观更整洁，可能要使用超细箭尾针 **针号应与车线尺寸匹配。</p>		

Average SPI (based on application) 每英寸平均针车数 (基于实用性)

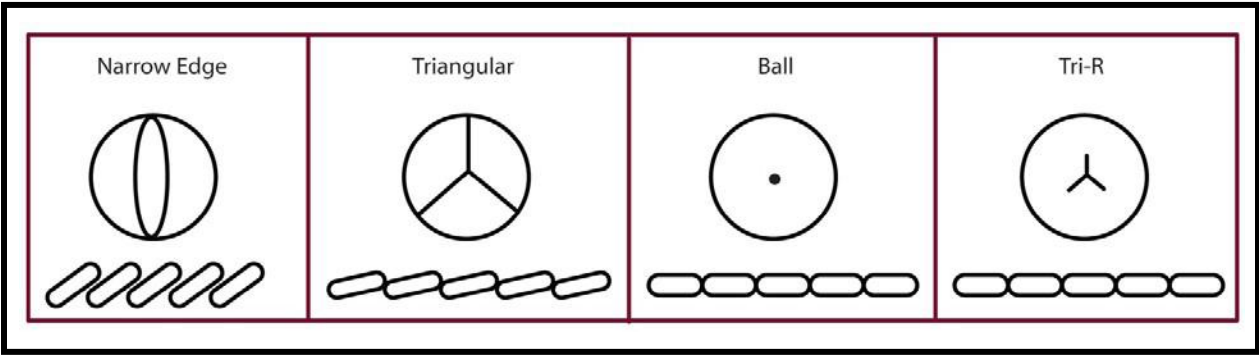
- 3.5-4 SPI for Opanka stitching Opanka OPANKA 车线为3.5-4针
- 4 SPI for hand whipped, hand laced plug
 - 5 SPI for handsewn plug (genuine or prepunched)
- 5 SPI for machine sewn laid on welt 车线接缝在沿条上则为5针
- 5 SPI for Littleway sole attachment Littleway 鞋底固定
- 8-13 SPI for machine sewn upper (varies by style, casual vs. dress 机器缝制鞋面：8-13针

Needle Type Illustrations 针型示例

剑形

三角形

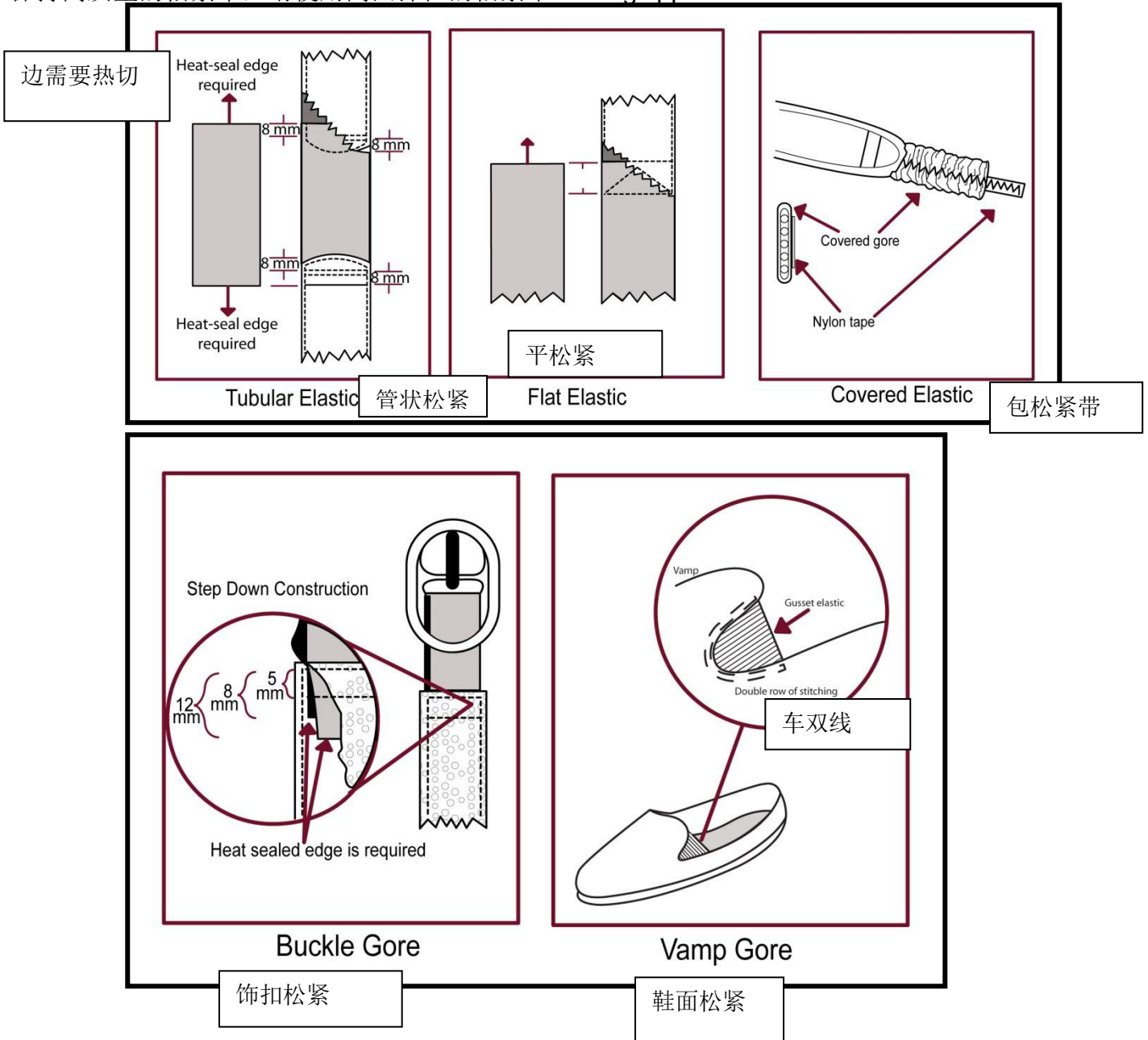
球形



Elastic & Goring 松紧带

To maintain high quality goring, please use a high recovery, knit elastic.为

保持高质量的松紧带，请使用高回弹性的松紧带 Goring Applications



Gore covers must be completely split to function fully. 松紧覆盖处必须完全剪开松紧带才能完全起作用。



Elastic with a stretch ratio of 1:1.5 is required in order to maintain the shape of an upper pattern while providing stretch (see below for example) 松紧带的弹性要求：拉伸比为1：1.5，以便在提供拉伸的同时保持鞋面版型（例如，见下文）

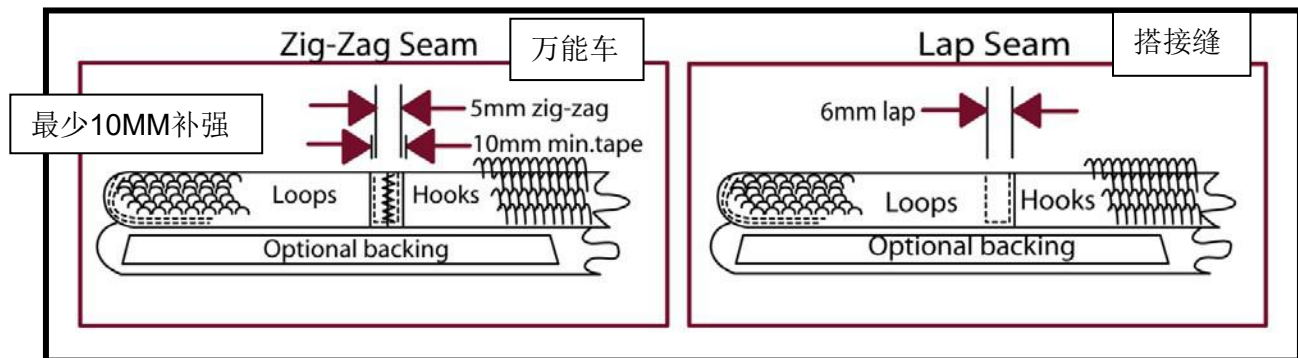


Other Trims 其他修饰物

- Metal/metallic components must be free from any corrosion 金属/金属部件必须没有任何腐蚀
- Must pass care label instructions and not crack, chip, discolor, rust, or melt 必须通过护理标签说明，不能有裂缝，缺口，不可变色，生锈或溶解
- Must be securely fastened with no sharp or rough edges, reinforced, and colorfast 必须牢固地固定，没有锋利或粗糙的边缘，不可褪色
- Nickel cannot be used for surface plating. 镍不能用于表面电镀
- Plastic buckle assemblies should be made using ABS (acrylonitrile butadiene styrene) plastic or nylon 6. 塑料饰扣组件应使用ABS（丙烯腈丁二烯苯乙烯）塑料或尼龙6制成。
- Single ply fabric or leather must have a reinforcement backing for eyelet attachment. 单层布料或皮革必须具有背面补强，用于鞋眼附着。

Hook & Loop Fasteners 挂钩&环紧固件

For children’s product only, use rounded corners for hook & loop closures to prevent sharp edges.



仅限儿童用品，使用圆角钩环扣以避免锋利的边缘。

Strength Standards 强度标准

Property 属性	Test Method 测试方法	Number of Samples 样品数量	Requirement 需求
Shear Strength 剪切强度	SATRA TM123	1 sample for each direction 1个样板 每个方向	- Lengthwise (original) 纵向（原始）: 10 lbs./in sqrd - Lengthwise (after 1000 cycles 100圈后) > 50% of the original (Mod.) - Widthwise (original) 宽度（原始）: 5.5 lbs./in sqrd - Widthwise (after 1000 cycles 100圈

Minimum Construction Standards – Footwear/Slippers/Flip Flops

			后) > 50% of the original (Mod.)
Peel Strength 剥离强度	SATRA TM123	1 Sample 1个样板	- Original 原始: 0.4 lb/in. - After 1000 cycles 1000圈后: 0.3 lbs/in. (mod.)

Zippers 拉链

- Please refer to the preferred suppliers list under general information on K-Link. Zipper guidelines for footwear are found under “Preferred Suppliers Guidelines- Apparel.”
请参阅K-Link一般信息下的首选供应商列表。鞋类拉链指南可在“首选供应商指南 - 服装”中找到。
- All zippers need to have a zipper guard. Exceptions would have to be considered on a style by style basis and approved by both the Product Manager and Technical Design.
所有拉链都需要拉链挡片。例外情况必须按照样式进行考虑，并经产品经理和技术设计部门批准。
- Recommended 2mm zipper tape allowance between zipper teeth and upper
拉链齿和鞋面之间要有2mm的间距



Rivets 铆钉

- When using a rivet to attach an ornament to an upper, the rivet should NOT come in contact with the foot. This includes rivets used for decorative purpose. 当使用铆钉将装饰物连接到鞋面时，铆钉不应与脚接触。这包括用于装饰目的的铆钉。
- On molded uppers, a recess should be molded into the upper for the rivet to be set into (see example below). 在模压鞋面上，应在鞋面压一个凹槽，以便将铆钉固定（如下例图）
- On non-molded uppers (PU, leather, textile etc.), the rivet should lay flush with the lining/ inside of strap to not cause irritation to the foot. 在非模压鞋面（PU，皮革，纺织品等）上，铆钉应与衬里/衬带内侧齐平，以免打脚。
- Example: The sample on the left is incorrect. The rivet sits on top of the upper and comes in contact with the foot. The sample on the right is correct. The rivet is recessed into the upper and does not come in contact with the foot.

示例：左侧的示例不正确。铆钉位于鞋面的顶部并与脚接触。右边的样本是正确的。铆钉凹入鞋面并且不与脚接触。

