Kohl's
Non-Denim Wash Color Process
(Garments)

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.
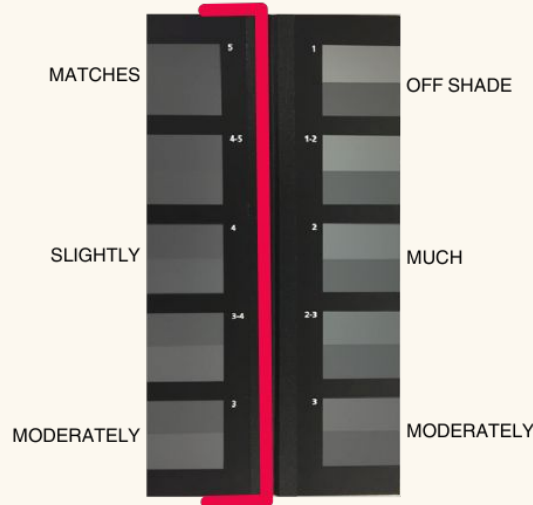
Shade Bands | Kohl's Color Evaluation

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**
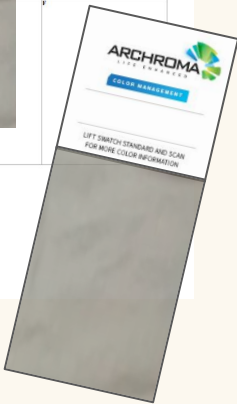
New program | New colors | No previous approvals

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

Vendor should submit no less than 6 shade options

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

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

Lab Dips *based on color standard*	**Unwashed & Washed Bulk** *based on the previous seasons dye recipe*	**Shade Band** *based on the approved bulk*

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❖ **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**
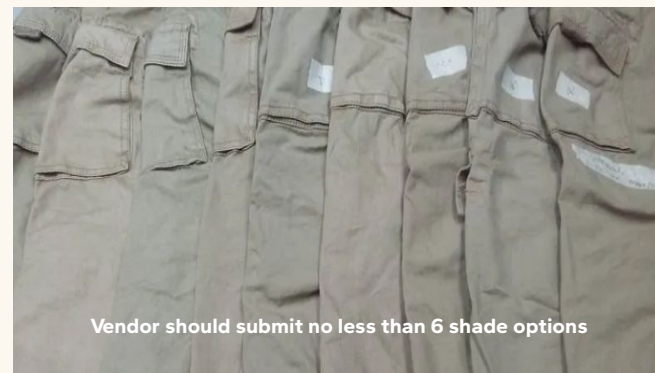

SOLID BULK (Page 3 of 3)

Kohl's: 211-860 COPENHAGEN - - - - 661,789

Attachments

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

Vendor should submit no less than 6 shade options

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

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

Lab Dips
based on color standard

Unwashed & Washed Bulk
based on the approved lab dip

Shade Band
based on the approved bulk

Fabric cuttings should not be used as a standard!

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

Vendor should submit no less than 6 shade options

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

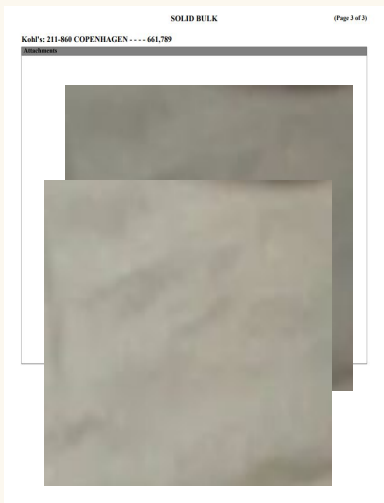Same program | **NEW** VENDOR | **SAME** MILL | Same fabric and color

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**

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

Unwashed & Washed Bulk
based on the previous seasons dye recipe

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SOLID BULK   (Page 3 of 3)

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Attachments

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

Shade Band
based on the approved bulk

✓

Vendor should submit no less than 6 shade options

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**

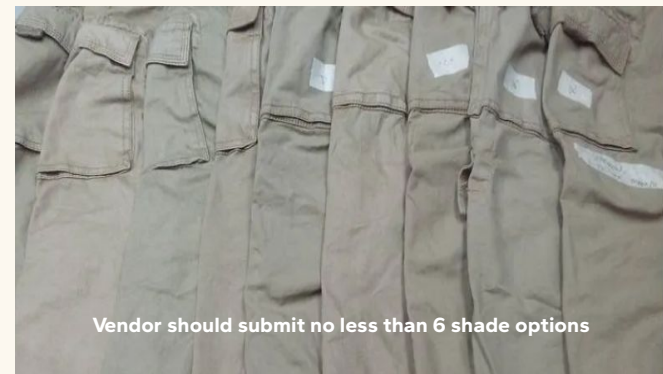- ❖ **Mill must have a color standard on hand for dyeing/record-keeping purposes and to ensure consistency**

*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
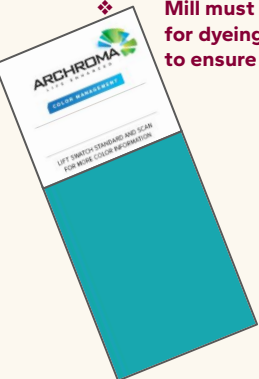

Vendor should submit no less than 6 shade options

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