

Managing Style Complexity Multiple Sizes, Fabrics, Vendors, & Factories in OnePLM

*Global Technical Design
Apparel Resource Tools
9-2022*

KOHL'S

Style Complexity Overview

SILHOUETTE Base Style ID



Base Style ID :
Initial tech pack is created with the core base size.

***Related Styles:** Some silhouettes share the same fit with a variation in sleeve length or inseam length or a regular version vs adaptive version, or market/climate version under a separate base style ID #.

SIZE EXTENSION MULTIPLIER POM Page Size Indicator



Size Extensions: Additional sizes that are fit separately from the base size.

These may include Plus, Big Man

***Size Conversion:** Additional sizes that are fit separately from the base size. These are built with a conversion table from the base size.

These may be further broken down into Petite Curvy, Plus Curvy, Plus Straight, ect.

***Grade Extension:** Sizes turned on within the base size grade table. These sizes are not fit separately.

Examples: Girls 7-16 Plus, Junior Plus, Kids Slim & Husky, Men's Tall, Women's Reg Tall/Short/Long, Missy Petite, Plus Petite/Plus Tall.

FABRIC MULTIPLIER Material Drop Down



Core Fabric: Base fabric that counter sample is fit in. May include multiple fabrics with the same properties, such as solid, print, heather, graphic. All applicable fabrics will be included on the same POM page.

Additional Fabrics are broken out when the fabric properties are not the same as the base fabric.

Differences in fabric construction, fiber content, weight, drape, or stretch

The POM page includes the material ID for each fabrication.

VENDOR MULTIPLIER Multiple COP/Factories

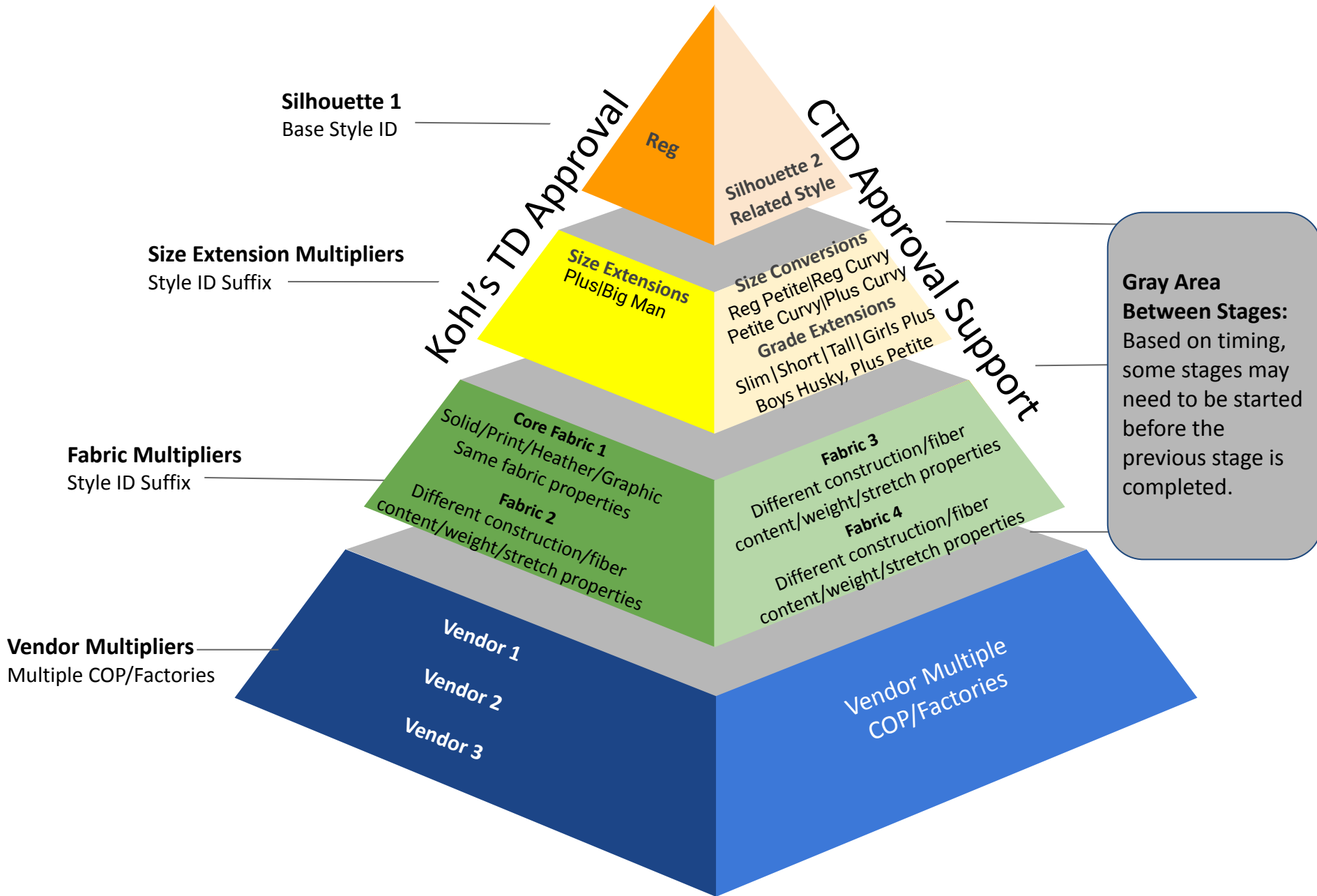


Vendor: One vendor name is used per fit eval, however multiple vendors may share the same POM page.

If the vendor is producing at multiple factories, or the factory has changed, the additional fit eval for the additional factory will be created at PP Stage.

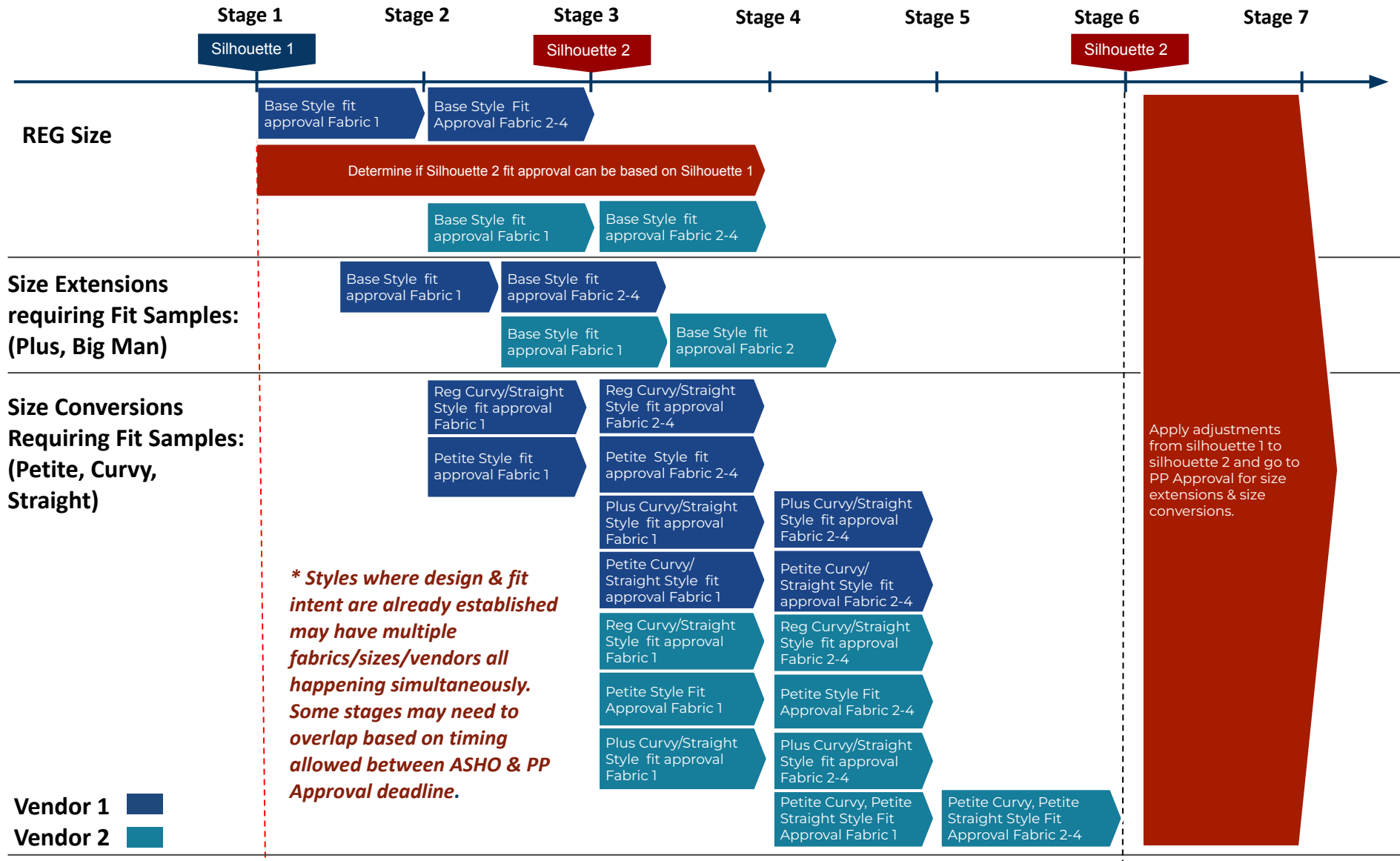
***Note** it is important that fit and construction details are align across all vendors. The customer should not see a difference in the product.

Style Complexity Overview



Planning for Style Complexity

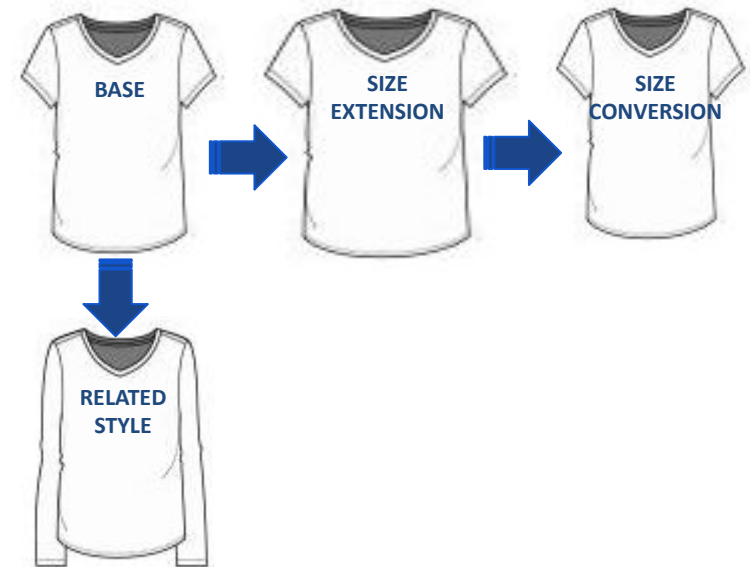
Fit Submit Workflow - New Style*



Planning for Style Complexity

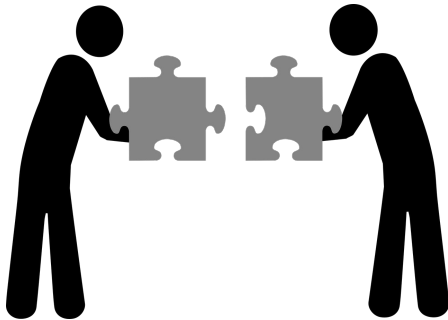
Why is a Style Workflow Important?

1. Information from the previous sample can be applied to the next sample round.
2. Avoids bottlenecking the sample room, the CTD, and the KTD.
3. Avoids unnecessary sample rejections/not approved samples.



What if there is not time to allow for previous stage to be approved before reviewing next stage?

Partner with the KTD to understand and prioritize together to ensure an efficient workflow;

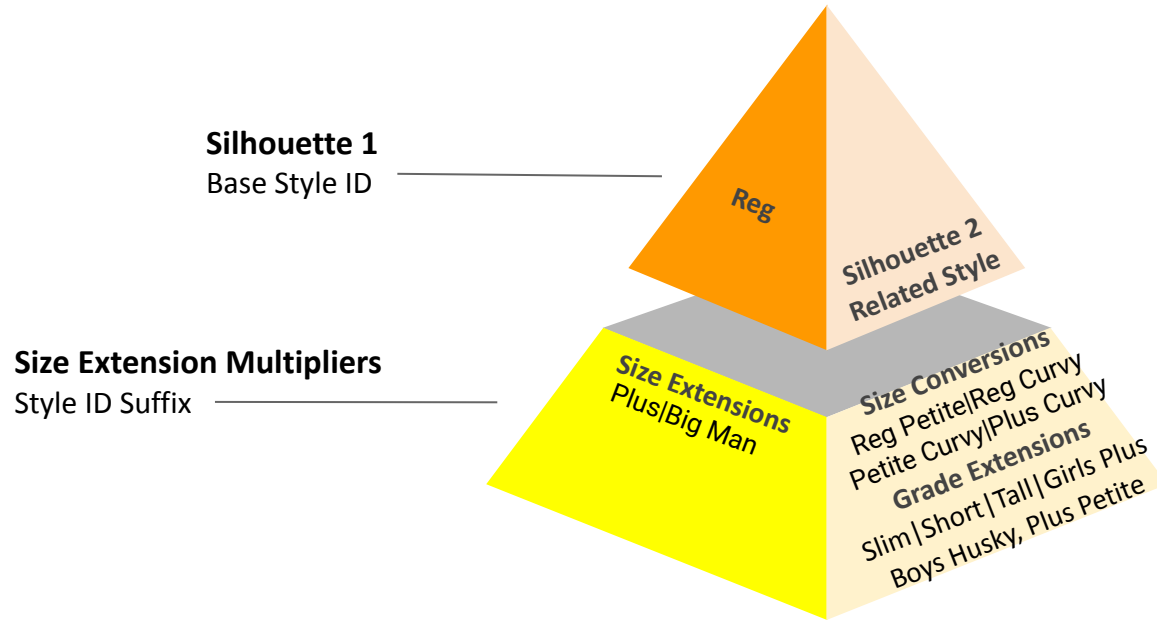


- Review which fabrics need to be fit/evaluated vs. which do not.
- How can we strategize together to ensure production can begin on time?
- Are there other options that can be used?
- Is 3D an option to evaluate some of the extended sizes?

The Role of the CTD: CTD Level 2 & 3 are critical to the success of this process!















Without the CTD support in approvals of multiple fabrics, sizes, and PP samples the approval process can take much longer. Kohl's is dependent on our vendor partners to build a strong CTD support system to ensure we can stay on time for the approval of the subsequent fabric/size variations after the initial sample is approved.

Managing Size Extensions



Size Extension Sample Requirements

- * KTD may request Fit samples to verify conversions with new vendors, exaggerated styling, new unknown fabrications.
- * Extended sizes only need to be verified with Designer for aesthetic intent if styling is exclusive, or if additional seaming, darting or styling details need to be added to accommodate the extended size marker that alters the design aesthetic.

Category	Size	Fit Sample	PP Sample	Procedure
Women's	Petite (Same styling as Reg w/o exaggerated style details) Petite Curvy		 submit converted pattern comparison to reg pattern to KTD or CTD Level 3  Vendors w/ only CTD Level 1 may be required to submit PP sample on select style after converted pattern is approved.	See Women's Extended Size Process
	Petite w/ exaggerated style details	 Submit to confirm if conversion adjustment is needed by KTD or CTD Level 3		
	Plus (Same styling as Reg)			
	Curvy/Straight (Reg & Plus)	 submit converted pattern comparison to reg pattern to KTD  New unknown fabrics: Fit sample may be required		
	Short/Long/Tall			
	Petite/Plus Exclusive	 Fit w/ Design team		

Size Extension Sample Requirements

Category	Size	Fit Sample	PP Sample	Procedure
Young Women's	Plus / Slim (Same styling as Reg) Short/Long/Tall	⊘	⊘	Pattern is mathematically converted from Approved Reg. pattern.
	Plus w/ exaggerated style details	✓ to confirm if conversion adjustment is needed	✓	Plus pattern is mathematically converted from Approved Reg. pattern. New silhouettes with exaggerated styling details may be verified by KTD or CTD.
	Curvy (Reg & Plus)	⊘ submit converted pattern comparison to reg pattern to KTD ✓ New unknown fabrics: Fit sample may be required	✓	Curvy pattern is mathematically converted from Approved Reg. pattern and the converted pattern is verified at fit stage before proceeding to PP sample.
Boy's 8/20 Girls 7/16	Plus/Husky/Slim Short/Long/Tall	⊘	⊘	Pattern is mathematically converted from Approved Reg. pattern.
Men's	Big Man (Same styling as Reg)	✓	✓	
	Short/Long/Tall	⊘	⊘	Pattern is mathematically converted from Approved Reg. pattern.
Little Kid's	Base size 6	✓	✓	Little Kid size 6 fit first if Toddler size does not ship before Little Kid's sizing
	Slim/Husky	⊘	⊘	Pattern is mathematically converted from Approved Little Kid pattern.
Toddler	Size 3T (Same styling as Little Kid)	✓	✓	Pattern is mathematically converted from Approved Little Kid size 6 pattern and verified in fit.

Multiple Sizes Workflow- Women's

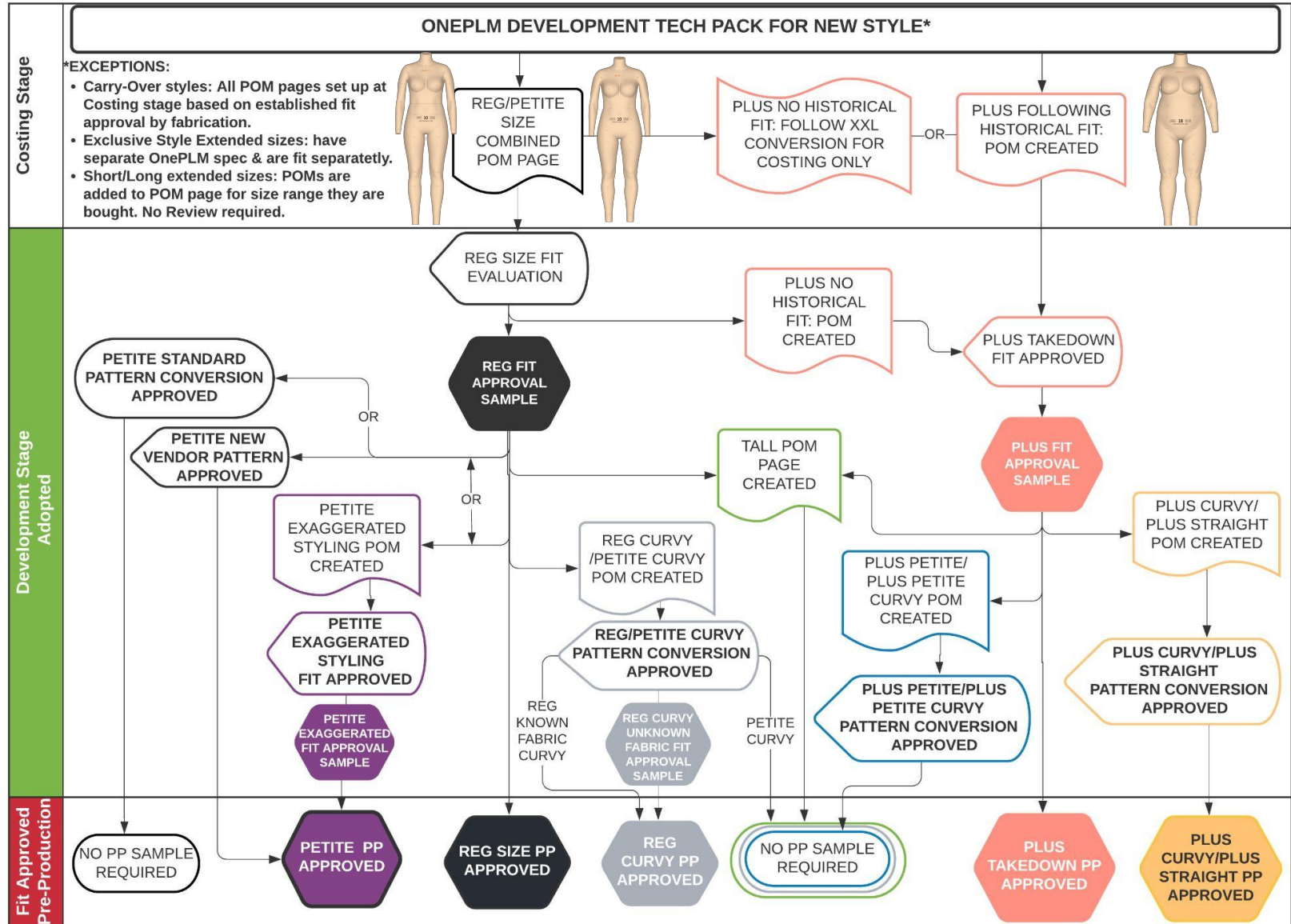
For more detail, click on link:

[Women's Extended Size Process](#)

Women's Fit Approval Workflow for Extended Sizes

Effective beginning SP22

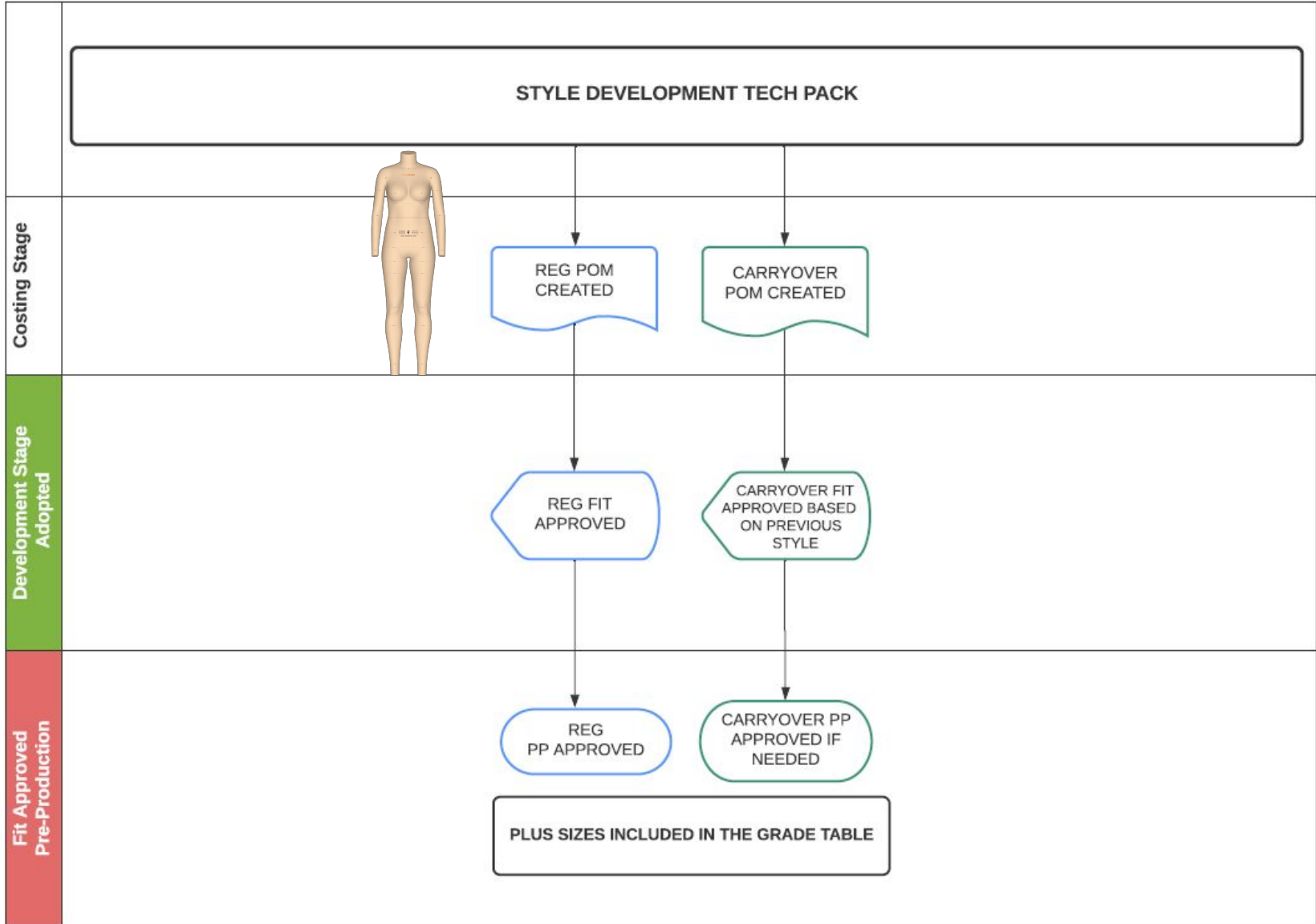
Technical Design



Multiple Sizes Workflow- Young Women's

Young Women's Approval Workflow for Extended Sizes

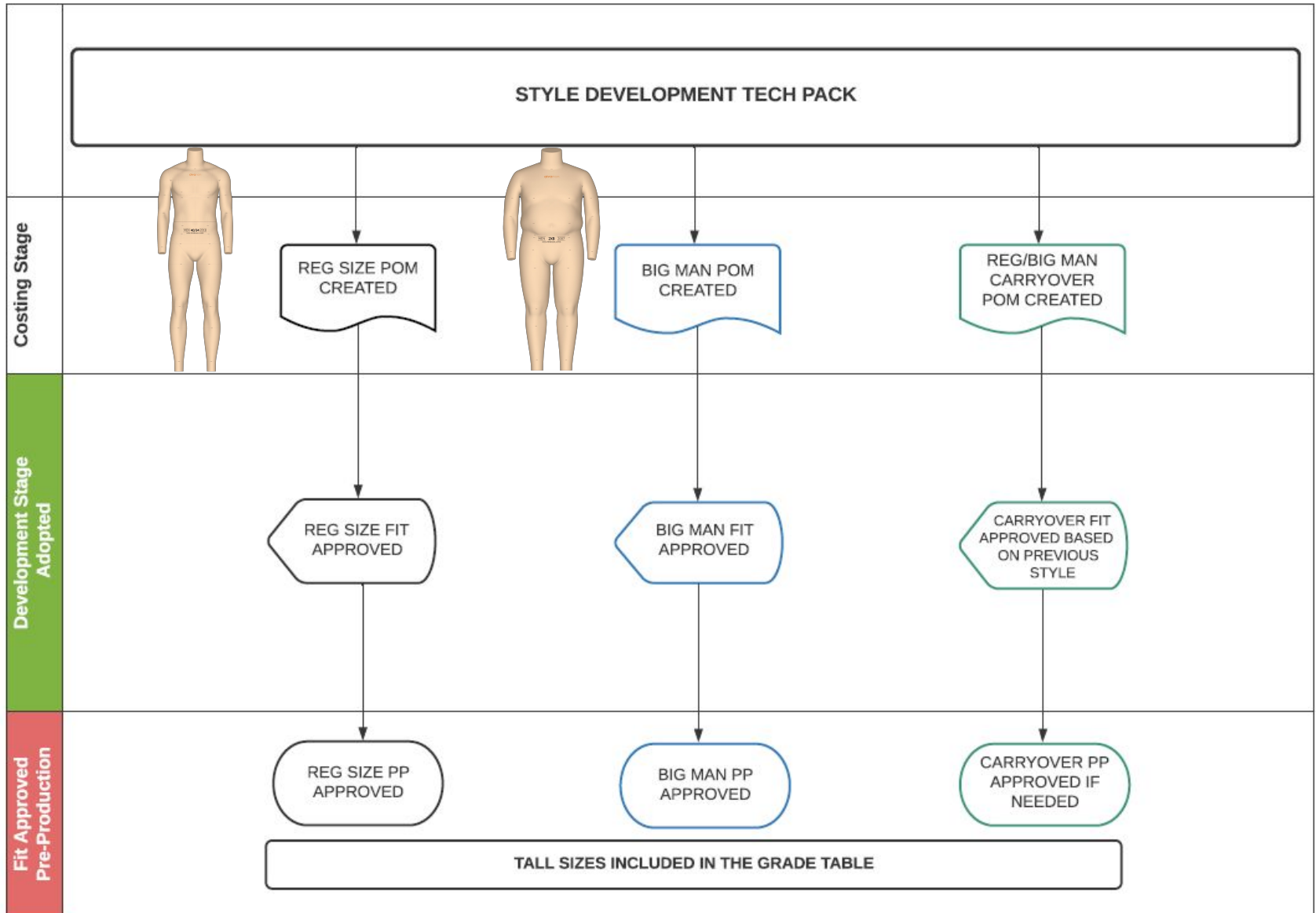
Technical Design



Multiple Sizes Workflow- Men's

Men's Fit Approval Workflow for Extended Sizes

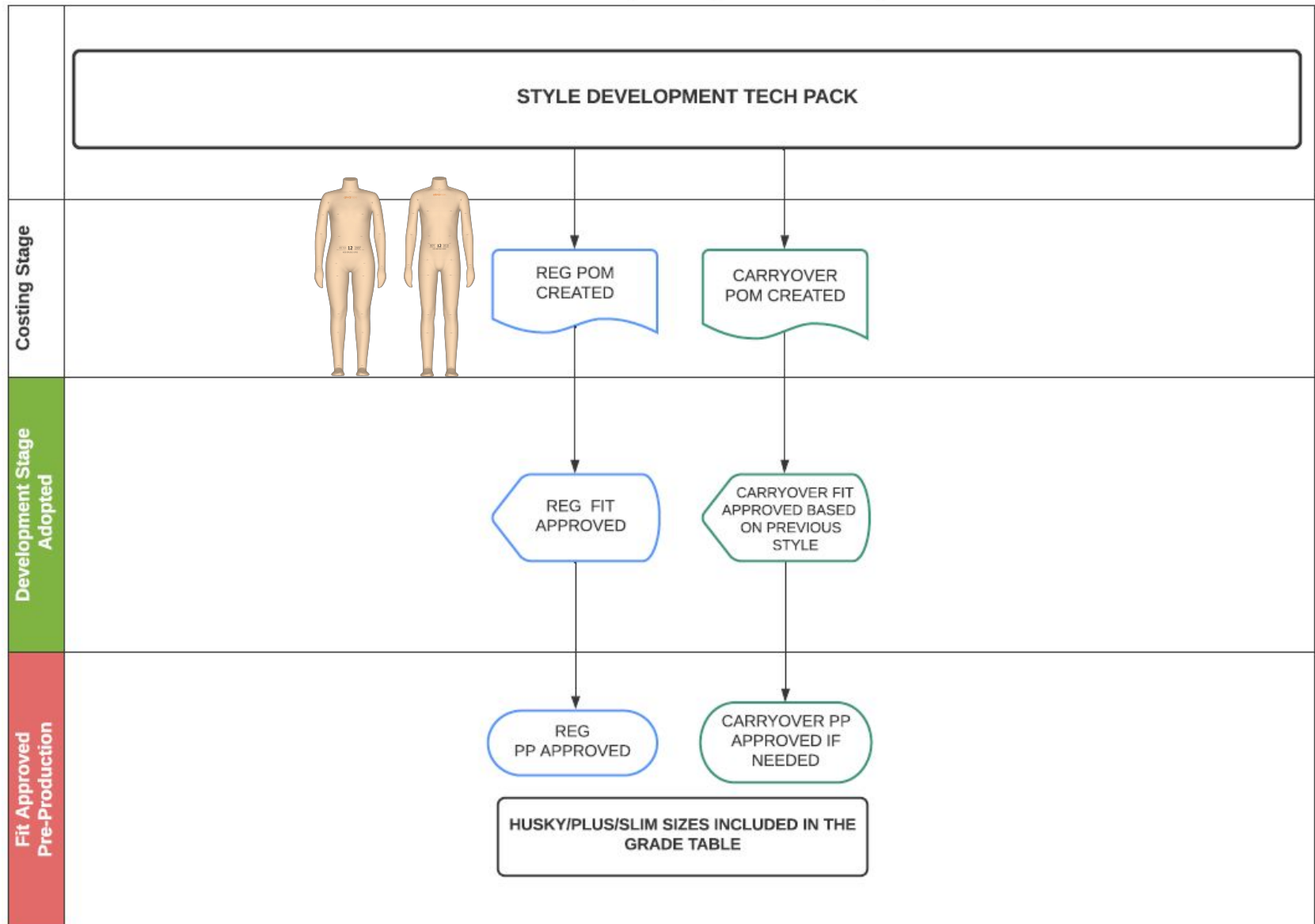
Technical Design



Multiple Sizes Workflow- Big Kids'

Big Kids' Fit Approval Workflow for Extended Sizes

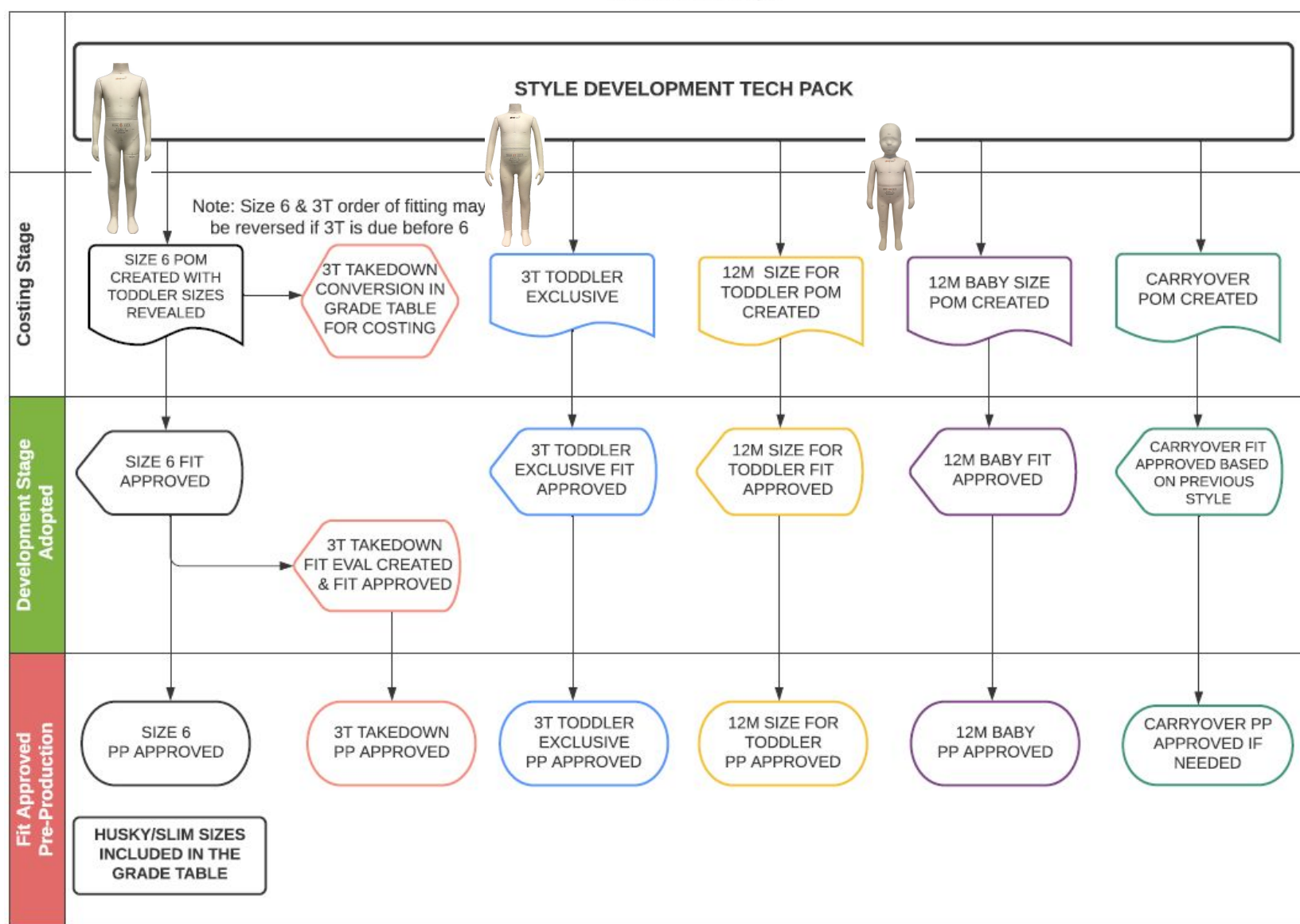
Girls 7-16, Boys 8-20 | Technical Design



Multiple Sizes Workflow- Little Kids'

Little Kids' Fit Approval Workflow for Multiple Size Ranges

Technical Design



OnePLM Example - Extended Size Fit Evaluation

Fit Evaluation: 94825

Overview Attachments Change Tracking 3

Petite Spec Fit Evaluation Example

Fit Sample	Size	Sample #	Sample Type	Fit Status
All	10			
Sample 4	10	918489	PRE-PRODUCTION SAMPLE	APPROVED 4
Sample 3	10	910797	FIT SAMPLE	APPROVED 3
Sample 2	10	908951	FIT SAMPLE	REJECTED 2
Sample 1	10		COUNTER SAMPLE	NOT EVALUATED 1

Evaluation Information

Agent: LI & FUNG TAIWAN Vendor: ECLAT TEXTILE CO., L... Factory: SON HA GARMENT J...
Adopted Style Handoff: 07/30/2019 PP Deadline: 10/01/2019 UM: IN
Number Format: Fraction POM Page Description: E.H/H1.100 POLY JERSEY.
Created On: 2019-09-02 02:58:03 Modified on: 2021-01-12 16:42:19 Fit Workflow Alert: 63

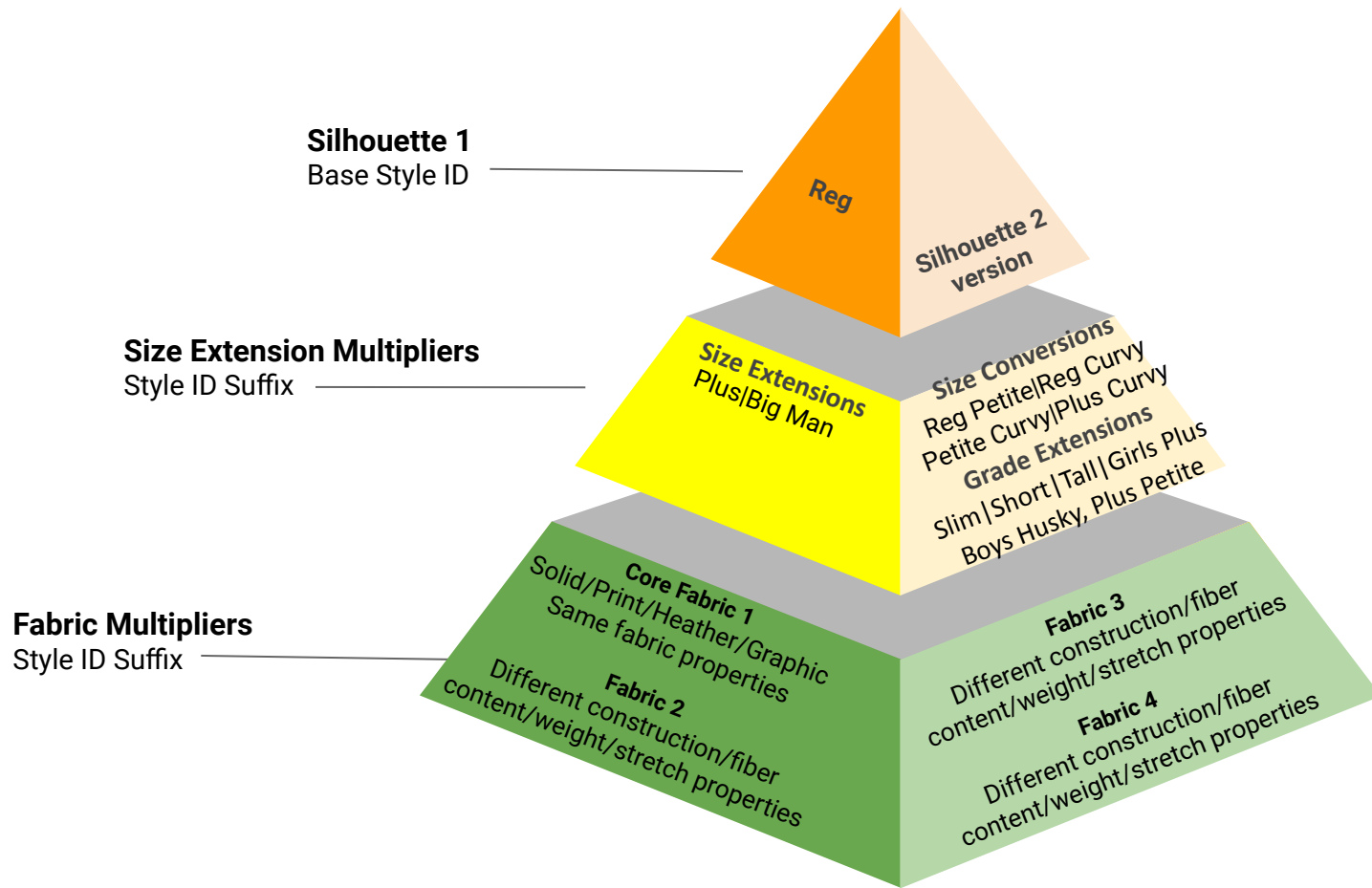
Sample Information

Fit Sample: Sample 4 Sample Type: PRE-PRODUCTION SA... Fit Status: APPROVED
Reason Code:
Date Received: 09/20/2019 Ownership: CTD Decision Date: 09/20/2019
Measurer 1: MICKIE WONG Measurer 2: Actual Fabric/Material: Yes
Actual Trim/Hardware: Yes Block/Last Used: Actual Outsole: --Select--
Date Fit: 09/20/2019 Fit With:

If CTD needs to create a fit evaluation to evaluate a new fabric or special size sample:

1. Confirm w/ KTD no Fit Evaluation already exists. (CTD cannot 'see' Fit Evaluation if the Agent and Vendor field are still blank in OnePLM).
2. Follow [Create Fit Eval](#) instructions in CTD OnePLM Manual.
3. On Sample 1; fill in Sample Type = COUNTER SAMPLE, and Fit Status = NOT EVALUATED (unless fit has previously been approved on a different Fit Evaluation (carry-over stye), then COUNTER SAMPLE status = APPROVED).
4. Adopted Style Handoff date is the day you were advised to create the style.
5. Update POM Page Description field with correct size/fabric information (see [POM Naming Convention](#))
6. Fill in all [Required Fields](#) on the Fit Evaluation
7. [Initiate Sample](#) round for Sample 2.

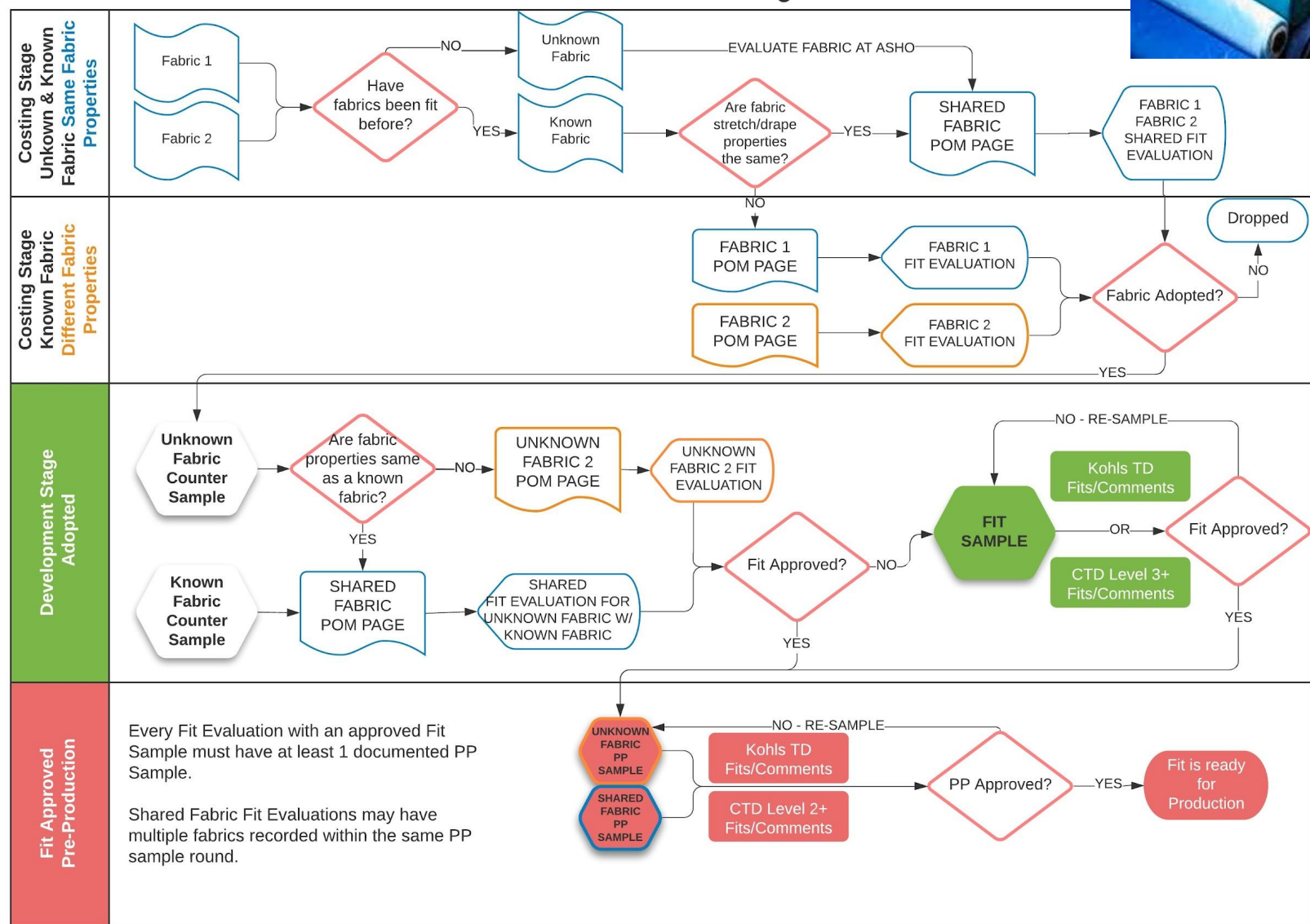
Managing Multiple Fabrics



Multiple Fabrication Workflow



Multiple Fabrics Fit Approval Workflow Kohls Technical Design



OnePLM Example - Multiple Fabrics on POM Page

Style: WT94A105

Overview Design Intent Constructions Instructions Standards **POM** Samples BOM Attachments Events >>

More Actions... Save

PLM Points of Measurement

View Fit Evals Create Fit Eval Add Points of Measure Copy POM Code(s) Change Size Range Change Tolerance Calculate Specification Multi Window POM Report Delete POM Code(s) Copy Grading

Points of Measurement < 1 2 3 4 > Go To R.H-H1-N-P-JERSEY.ECLAT R.H-H1-N-P-JERSEY ECLAT R.XH.XH1-MELANGE JERSEY-WILLBES E.H-H1-N-JERSEY.ECLAT E.XH-JERSEY.WILLBES

Base Style Information

Image L

Description PERFORMANCE TEE

Development Stage DEVELOPMENT Style Status CONFIRMED Technical Designer ASHLEY NUNEZ Designer JENNIFER CEPLUCH

Tolerance Information

Page Sort 1

POM Page Description R.H-H1-N-P-JERSEY.ECLAT

Tolerance Model LADIES TOPS ALPHA

Create Date 08/19/2020

Grading Information

Size Range LADIES (000-20) REG&PETITE Grading Size 10

Grading Method Cumulative UM IN

Grading Model Name LADIES Number Format Fraction

POM Material

Material 1	Material 2	Material 3	Material 4	Material 5	Material 6	Material 7	Material 8
68204 K 100 POLYESTER JERSEY 160 GM2	87469 K 100 POLYESTER INTERLOCK 145.00 GM2	79830 K 100 POLYESTER JERSEY 135.00 GM2					

See CTD OnePLM Manual: [POM Naming Convention](#) for more details on the POM page naming convention.

All fabrics with similar performance properties can share the same spec and are combined on the same POM page.

Fabrics that can share the same POM/spec are dependent on:

1. The amount of ease over body or if the fabric stretch properties are being used to fit the garment to the body.
2. The fabric drape and stretch properties (elongation & recovery).

When a new fabric is added to a style, always ask the Kohls TD to confirm the next steps in reviewing the fabric for fit.

*The Kohls TD may ask to see performance testing of the new fabric compared to current core fabric, or to see a fit or reference sample in the new fabric to help them make their decision.

OnePLM Example - Multiple Fabrics on Fit Eval pg

See CTD OnePLM Manual: [Navigating the Tech Spec Report](#) for the 'Report View' of fabric information in the printed tech spec.

When multiple fabrics share the same Fit Evaluation, which fabric should be used for making the fit sample?

1. The fabric that Kohls TD has requested in their fit comments.
2. If Kohls TD does not have a preference, it should be the fabrication with the largest number of units.
3. The Kohls TD may ask to sample the newest fabric if the other fabrications have been reviewed for fit previously.

Is it OK to have multiple Pre-Production samples on the same Fit Evaluation for multiple fabrics?

1. Only the fabrication that KTD requests for PP needs to be documented in the fit eval.
*This should be the fabric with the largest number of units, or the fabric evaluated in the previous fit rounds.
2. If vendor would like to document a CTD Internal PP sample of the other fabrications/suffix choices, see next slides.

Each Fit Evaluation represents a size, fabric, possibly vendor or factory combination that needs to be sampled and approved separately.

Every Fit Evaluation should have either a Counter or Fit sample round with an Approved status and Pre-Production sample round with an Approved status.

Fit Eval: LIST

Advanced Search: Fit Evaluation

Fit Evaluation List


<input type="checkbox"/>	Fit Eval Id	POM Page Description	Size	Fit Sample		Sample Type	Fit Status
<input type="checkbox"/>	107519	P.D1.SEAMLESS.ECLAT	18W	Sample 3		PRE-PRODUCTION SAMPLE	APPROVED
<input type="checkbox"/>	107519	P.D1.SEAMLESS.ECLAT	18W	Sample 1		COUNTER SAMPLE	NOT EVALUATED
<input type="checkbox"/>	107519	P.D1.SEAMLESS.ECLAT	18W	Sample 2		FIT SAMPLE	APPROVED
<input type="checkbox"/>	102735	R.E.D1 SEAMLESS.ECLAT	10	Sample 2		PRE-PRODUCTION SAMPLE	APPROVED
<input type="checkbox"/>	102735	R.E.D1 SEAMLESS.ECLAT	10	Sample 1		COUNTER SAMPLE	APPROVED
<input type="checkbox"/>	102734	R.N1.SPACE DYE.SEAMLESS.ECLAT	10	Sample 1		COUNTER SAMPLE	APPROVED
<input type="checkbox"/>	102734	R.N1.SPACE DYE.SEAMLESS.ECLAT	10	Sample 2		PRE-PRODUCTION SAMPLE	APPROVED

When should Multiple fabrics NOT share the same Fit Evaluation?

1. If the fabric properties are different (separate POM pages as well)
2. If the fabrics are new (unknown) and each fabric needs to be evaluated for fit. These will be documented with an individual fit approval and PP sample.
Example: performance leggings may require every fabric to be evaluated due fabric performance properties being used to fit the garment to the body. These small variations in performance may impact the fit.
3. Multiple vendors, with different fabrics for each vendor.
4. New vendors to Kohls may be asked to evaluate each fabric separately.

Optional PP Sample for Additional Fabrics: CTD Internal PP Sample

- ❑ If multiple fabrics are grouped together in one Fit Eval, only one PP sample is required.
- ❑ CTD Internal PP Samples for different variations (fabric, wash, dye effect, etc) can be made as determined by CTD.
- ❑ If CTD Internal PP Sample is entered into OnePLM, a new Fit Eval should *not* be created.
- ❑ Documentation should be attached in the existing Fit Eval without initiating a new sample round. The documentation will be uploaded to the attachment tab on the same round as the Required PP sample approval.
- ❑ CTD Internal PP Sample should *not* be sent to Kohl's TD for reference.



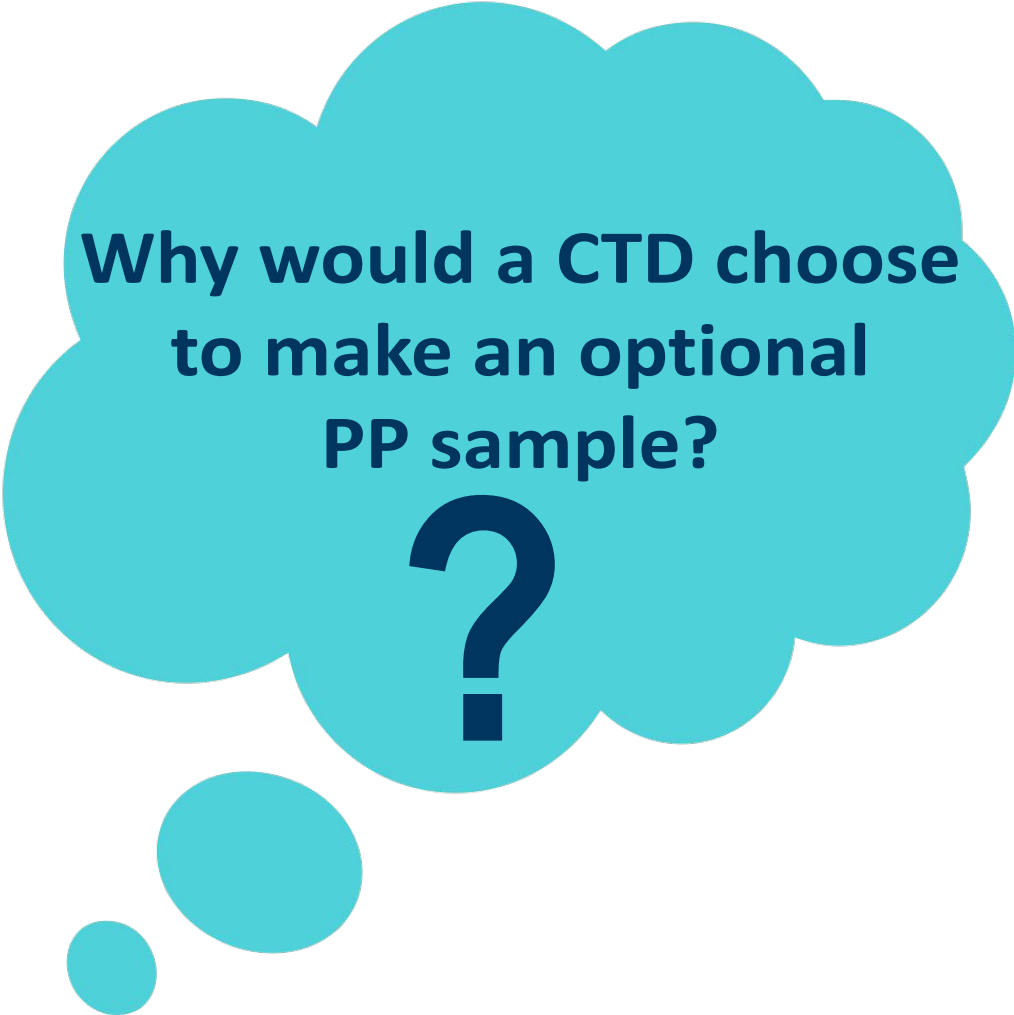
Why isn't a PP Sample required for each fabric?



A: When there are multiple fabric/washes/etc, KTD determines if the different variations can follow the same spec. If so, they can be grouped on to the same Fit Eval.

Kohl's requires a PP Sample for each Fit Eval, but does not require a PP sample for all of the different variations on the same Fit Eval.

If the fabrics/different variations are separated on to different Fit Evals, then a PP Sample must be made for each Fit Eval. Follow direction given by KTD.

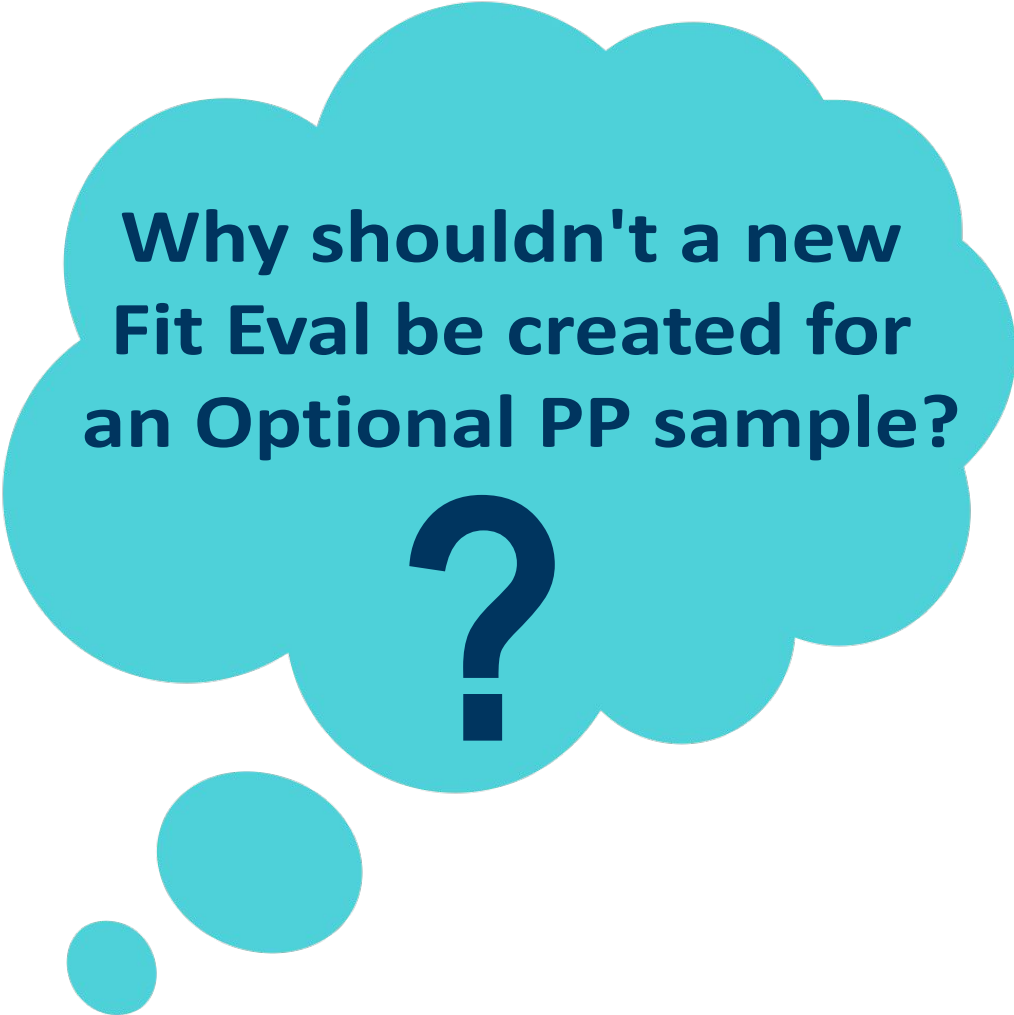


**Why would a CTD choose
to make an optional
PP sample?**



A: CTD may want to have a PP Sample in the different variations made as part of the internal process to prepare for production.

CTD Internal PP samples do *not* have to be documented in Oneplm, but they *can* be documented if desired.



**Why shouldn't a new
Fit Eval be created for
an Optional PP sample?**



A: Adding additional Fit Evaluations, or adding additional PP Sample rounds affects reporting generated by OnePLM.

Since CTD Internal PP Samples are not required and are not handled by KTD, a new Fit Eval/Sample round should not be created.

If there are questions, please ask the KTD.

Optional PP Samples: CTD Internal PP Sample


- ❑ Combine comments and photos onto one page using the template.

CTD Internal PP Sample

EXAMPLE

SP20 - MN01A002 –ABC Garments - 100% Polyester, 150g/m2

HPS Foldline @ dressform shoulder seam



12/30/2019 – John Doe (CTD Level 2) – PT. Hesed – Green seal # 0003344

GENERAL COMMENTS:
PP APPROVED based on initial pp sample approved on 1/05/2021 (Green seal#001234) by John (Associate CTD). Follow below comments for production.

*** FIT / CONSTRUCTION / WORKMANSHIP:**

1. Overall specs & fit/balance are okay same as fit & initial PP sample approved. Please maintain it for bulk production.
2. Fabric, trim, label placement, color, & quality are checked against standard.
3. Please pay attention to collar and placket; both collar points should be located at the same level. Collar point length/shape should be mirrored based on correct pattern. Upper placket should cover the under placket completely and placket opening edge should be straight.
4. Please ensure button & button hole should be set on correct placement as following correct spec. First button hole placement on current PPS looks far away from CF by 1/16". Please keep monitoring on this during bulk production.
5. Please ensure all the top stitches should be straight and even. Bottom cover stitch along hemline/ sleeve opening should not be too tight. Please maintain it as PPS.

Optional PP Samples

CTD Internal PP Sample

Season - Style # - Vendor - Fabric / Wash Information

Front
View

Side
View

Back
View

Date - CTD Name/Level - Factory Name - Green Seal#

GENERAL COMMENTS:

PP APPROVED- based on initial PP sample approved on _____ (Green seal # _____) by CTD Name
Follow Below Comments for Corrections. Once corrected, proceed to Production.


FIT/ CONSTRUCTION/ WORKMANSHIP:

- 1.
- 2.
- 3.
- 4.

Optional PP Samples

Optional PP Sample: CTD Internal PP Sample

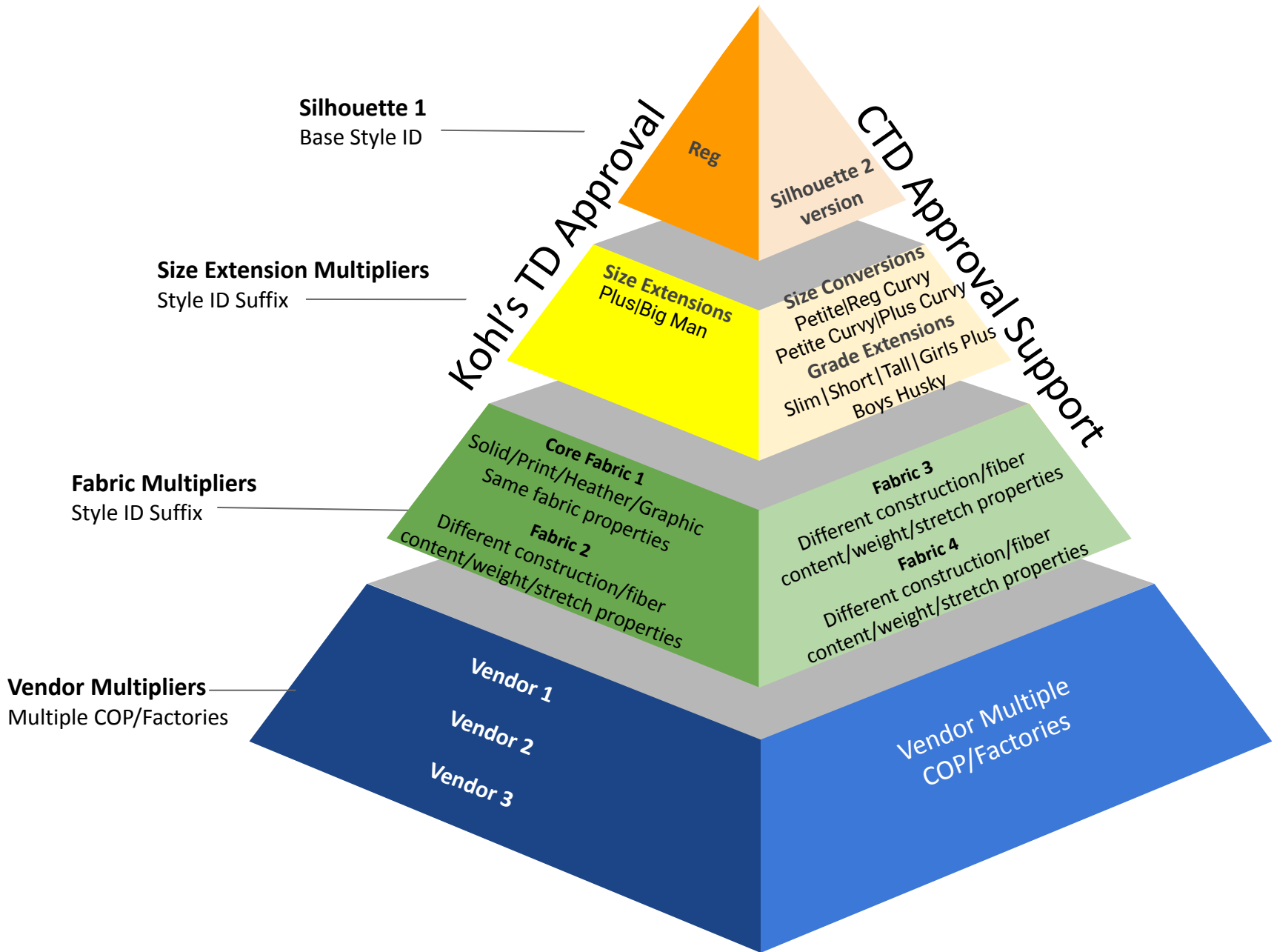
- Upload JPG attachment to the existing fit eval, on the same sample round as the Required PP Sample.
- Clearly label CTD Internal PP Sample in the Description field.

<input type="checkbox"/> Sort	Attachment No	Description
<input type="checkbox"/>	IMAGE	 P1-S21-R-MN01A002-JQD-HANSAE
<input type="checkbox"/>	IMAGE	CTD INTERNAL PP SAMPLE P1-S21-R-MN01A002-JSY-HANSAE (100 POLY, JQD, 140 GM2)

Photos of Required PP Sample

CTD Internal PP Sample JPG Attachment

Managing Multiple Factories



Required:

- ❑ One PP sample is required for each Fit Evaluation
- ❑ A PP sample is required from each production factory. If there are multiple factories, or the factory changes post PP sample approval, an additional PP sample must be made.
- ❑ Required PP Samples must be entered into OnePLM, and separate Fit Evaluation should be created by CTD level 2 or above.
- ❑ Required PP Sample must be sent to KTD for reference.

OnePLM Example - Additional Factories

Fit Evaluation: 105585

Overview Attachments Change Tracking 1

Development Stage DEVELOPMENT Style Status CONFIRMED Ecom Excl N

Technical Designer ANN MORROW Designer ERIN AUBREY

Sample Selection

Fit Sample	Size	Sample #	Sample Type	Fit Status
All	10			
Sample 2	10	996346	PRE-PRODUCTION SAMPLE	APPROVED
Sample 1	10		COUNTER SAMPLE	APPROVED

Evaluation Information

Agent: LI & FUNG KOREA Vendor: SAE-A TRADING CO., ... Factory: PT G- TEXPIA INTERN...
Adopted Style Handoff: 10/01/2019 PP Deadline: 03/03/2020 UM: IN
Number Format: Fraction POM Page Description: R.G.S.ST.60/40.JERSEY.TEXPIA1-SAE-A
Created On: 2020-02-21 01:33:05 Modified on: 2021-01-12 16:25:05 Fit WorkFlow Alert: 154

Sample Information

Fit Sample: Sample 2 Sample Type: PRE-PRODUCTION SA... Fit Status: APPROVED
Reason Code:
Date Received: 02/28/2020 Ownership: CTD Decision Date: 03/02/2020
Measurer 1: MARIELA ALVARADO ... Measurer 2:
Actual Trim/Hardware: Yes Block/Last Used: Yes Actual Outsole: --Select--
Date Fit: 02/28/2020 Fit With:

Original Factory Fit Evaluation:
You must add the Factory Name to the POM Page Description.

Additional Factory Steps:

1. Open original factory Fit Evaluation.
2. Add factory name to the end of the POM Page Description.

OnePLM Example - Additional Factories

Fit Evaluation: 105480

Overview Attachments Change Tracking 1

Development Stage DEVELOPMENT Style Status CONFIRMED Ecom Excl N

Technical Designer ANN MORROW Designer ERIN AUBREY

New Factory Fit Evaluation

Sample Selection

Fit Sample	Size	Sample #	Sample Type	Fit Status
All	10			
Sample 2	10	995467	PRE-PRODUCTION SAMPLE	APPROVED 2
Sample 1	10		COUNTER SAMPLE	APPROVED 1

Evaluation Information

Agent: LI & FUNG KOREA Vendor: SAE-A TRADING CO., ... Factory: CENTEXSA II

Adopted Style Handoff: 10/16/2019 PP Deadline: 02/21/2020 UM: IN

Number Format: Fraction POM Page Description: R.G.S.ST.60/40 JERSEY.CENTEXSA2-SAE-A

Created On: 2020-02-19 20:37:35 Modified on: 2021-01-12 16:16:00 Fit Workflow Alert: 128

Sample Information

Fit Sample: Sample 2 Sample Type: PRE-PRODUCTION SA... Fit Status: APPROVED

Reason Code:

Date Received: 02/20/2020 Ownership: CTD Decision Date: 02/20/2020

Measurer 1: MARIELA ALVARADO ... Measurer 2: Actual Fabric/Material: Yes

Actual Trim/Hardware: Yes Block/Last Used: Yes Actual Outsole: --Select--

Date Fit: 02/20/2020 Fit With:

Be sure Factory Name is included in POM Page Description on new Fit Eval.

Additional Factory Steps:

1. Follow [Create Fit Evaluation](#) instructions in CTD OnePLM Manual.
2. On Sample 1; fill in Sample Type = COUNTER SAMPLE, Fit Status = APPROVED
3. Adopted Style Handoff date is the day you were advised of the factory change.
4. Be sure to update POM Page Description field with new factory information (see [POM Naming Convention](#))
5. Fill in all [Required Fields](#) on the Fit Evaluation
6. [Initiate Sample](#) Pre-Production Sample round for Sample 2.

OnePLM Example - Additional Factories

Fit Evaluation List							
<input type="checkbox"/>	Fit Eval Id	POM Page Description	Size	Fit Sample		Sample Type	Fit Status
<input type="checkbox"/>	105585	R.G.S.ST.60/40.JERSEY.TEXPIA1-SAE-A	10	Sample 1		COUNTER SAMPLE	APPROVED
<input type="checkbox"/>	105585	R.G.S.ST.60/40.JERSEY.TEXPIA1-SAE-A	10	Sample 2		PRE-PRODUCTION SAMPLE	APPROVED
<input type="checkbox"/>	105480	R.G.S.ST.60/40 JERSEY.CENTEXSA2-SAE-A	10	Sample 1		COUNTER SAMPLE	APPROVED
<input type="checkbox"/>	105480	R.G.S.ST.60/40 JERSEY.CENTEXSA2-SAE-A	10	Sample 2		PRE-PRODUCTION SAMPLE	APPROVED

When searching by Fit Evaluation in OnePLM, you will see 2 Fit Evaluations:
One for each factory.

***Every Fit Evaluation should have either a Counter or Fit sample round with an Approved status and Pre-Production sample round with an Approved status.**

OnePLM Fit Evaluation Fields/Reject/Sample Options


KOHL'S

OnePLM Fit Evaluation Fields by CTD Level

REQUIRED FIELDS: See [REQUIRED FIELDS ON FIT EVALUATION](#) in CTD OnePLM Manual on K-Link. **“Owner”** is defined by Approval Ownership & scenario below.

FIT EVALUATION STATUS / NEXT STEPS: See chart in [KOHLS FIT COMMENT TEMPLATE](#)

FIT EVALUATION REASON CODES: See [REASON CODES](#) in CTD OnePLM Manual and Reason Code Explanation in [KOHLS FIT POLICY](#)

SAMPLE TYPE	APPROVAL OWNERSHIP	SCENARIO		MEASURER 1 FIELDS				MEASURER 2 FIELDS				CTD ASSESSMENT
				CTD NAME	MEASUREMENTS	MEAS. COMMENTS	FIT COMMENTS	KTD NAME	MEASUREMENTS	MEAS. COMMENTS	FIT COMMENTS	
COUNTER SAMPLE	CTD	NO SAMPLE	Factory change: NEW FIT EVAL FOR EACH FACTORY	CTD LEVEL 2-4				KTD IF ONLY CTD LEVEL 0-1				
			Vendor Assist or Special Size	CTD LEVEL 3-4				KTD				
	CTD OR KTD	Evaluation of Fittable Counter Sample by vendor before sending to Kohls ADD GREEN DOT STICKER TO SAMPLE TAG AFTER EVALUATION 	CTD LEVEL 0-4 (or trained sample room technician): FIT EVALUATION IN ONEPLM DOES NOT NEED TO BE FILLED OUT. Mark measurements on back of sample tag or attach print out of POM page with measurements to the counter sample tag.				KTD					
FIT / 3D SAMPLE	CTD	Fit sample approval authority has been passed to CTD	CTD LEVEL 0-2				CTD LEVEL 3-4					
			CTD LEVEL 2 WITH LEVEL 3 GAC, KTD oversight				KTD	Sample w/ CTD	KTD		KTD	
			CTD LEVEL 3-4				KTD may choose to review comments/photos if need to confirm updates w/ design. KTD will specify in next steps of previous sample					
	KTD	CTD reviews fit sample for accuracy of corrections before sending fit sample to KTD	CTD LEVEL 3-4	CTD LEVEL 0 W/ CTD LEVEL 3-4 OVERSIGHT: CTD LEVEL 0 enters comments & measurements 1st for CTD level 3-4 review. CTD level 3-4 adds their name to name field, reviews work in same fields and adds any additional comments next to CTD level 0 comments & adds CTD Level 0 assessment at the end of the comments.				KTD				CTD LEVEL 3-4
	3D FIT	CTD LEVEL 1-4	CTD does not need to enter measurements, but must upload image/file attachments on attachments tab		Note if actual fabric was scanned/used for 3D images		KTD	No physical sample		KTD	KTD for CTD Level 1-2	
PP SAMPLE	CTD	PP sample approval authority has been passed to CTD	CTD LEVEL 0-1				CTD LEVEL 3-4					
			CTD LEVEL 1 WITH LEVEL 2 GAC, KTD oversight				KTD	Sample w/ CTD	KTD		KTD	
	KTD	CTD reviews PP sample for accuracy of corrections before sending fit sample to KTD	CTD LEVEL 3-4	CTD LEVEL 0 W/ CTD LEVEL 3-4 OVERSIGHT: CTD LEVEL 0 enters comments & measurements 1st for CTD level 3-4 review. CTD level 3-4 adds their name to name field, reviews work in same fields and adds any additional comments next to CTD level 0 comments & adds CTD Level 0 assessment at the end of the comments.				KTD				CTD LEVEL 3-4
CTD LEVEL 1-4				KTD				KTD for CTD Level 1-2				

REJECTED SAMPLES FIT OR PP: CTDs at ANY level may internally reject a sample if they deem the sample is not approvable for fit and/or construction, even if KTD has not given authority to CTD for sample approval.

CTD Level 0-1: Mark sample status as 'rejected' with [reason code](#). Send email or threaded message to KTD initiate a new sample round:

CTD Level 2-4: Mark sample status as 'rejected' with [reason code](#). Initiate new sample round - send email or threaded message to KTD to alert KTD that CTD has internally rejected the sample and initiated a new sample round.

OnePLM Example - Internal Sample Rejection

Fit Evaluation: 94825

Overview Attachments Change Tracking 3

Fit Sample	Size	Sample #	Sample Type	Fit Status
All	10			
Sample 4	10	918489	PRE-PRODUCTION SAMPLE	APPROVED
Sample 3	10	910797	FIT SAMPLE	APPROVED 2
Sample 2	10	908951	FIT SAMPLE	REJECTED 1
Sample 1	10		COUNTER SAMPLE	NOT EVALU

Evaluation Information

Agent: LI & FUNG TAIWAN Vendor: ECLAT TEXTILE CO., L... Factory: SON HA GARMENT J...
Adopted Style Handoff: 07/30/2019 PP Deadline: 10/01/2019 UM: IN
Number Format: Fraction POM Page Description: E.H/H1.100 POLY JERSEY.
Created On: 2019-09-02 02:58:03 Modified on: 2021-01-12 16:42:19 Fit Workflow Alert: 63

Sample Information

Fit Sample: Sample 2 Sample Type: FIT SAMPLE Fit Status: REJECTED
Reason Code: POOR PATTERN EXECUTION/NOT BALANCED
Date Received: 08/14/2019 Ownership: CTD Decision Date: 08/14/2019
Measurer 1: MICKIE WONG Measurer 2: Actual Fabric/Material: Yes
Actual Trim/Hardware: Yes Block/Last Used: Yes Actual Outsole:
Date Fit: 08/14/2019 Fit With:
Fit Session Attendees:

When should a CTD reject a sample before submitting to Kohls?

1. When fit and construction corrections requested in previous sample round have not been made or did not improve the appearance of the sample.
2. Multiple Critical/Primary measurements are too far outside of tolerance to evaluate the fit/sample and should be brought back to spec.
3. Appearance of workmanship/sewing is so poor it is impacting the ability to accurately evaluate the fit of the sample.
4. See other reasons indicated in the onePLM [Reason Codes](#)

To Reject a sample:

1. Change Ownership field to 'CTD'
2. Fill in all [Required Fields](#) on the Fit Evaluation including [Reason Code](#) field
3. [Initiate Sample](#) next Sample round and fill in 'Ownership' field based on previous sample 'Ownership field'

OnePLM Example -Multiple Sample Options

Fit Evaluation: 62149

Overview Attachments Change Tracking 1

[View IMAGE](#) [Add](#) [Edit IMAGE](#) [View Versions](#)

Measurer 1 Fit Comments

2/12/2018 by Nari Kim
 OPTION 1 (Measurer 1)- Kohl's Requested
 OPTION 2 -(Measurer 1 comments) Revised Shoulder closed. We closed shoulder different to be more production friendly

Date: 2018/2/05
 Sample Type: 1ST FIT Sample
 Sample Color: HYPNOTIC BLUE (Sample Fabric Weight: 196G/M2)
 Vendor, CTD Name: Nari Kim [narikim@lee-co.co.kr]
 L&F TD: Jenna Lee (jennaLee@LF5ourcing.com)
 Factory: MODAS SHALOM
 COP: GUATEMALA
 UNITS: TBD

SAMPLE WASH INFO
 Non - Wash: Y [] N [V]
 Fabric Wash: Y [] N [V]
 Garment Wash: (list type of garment wash)

STYLE/FABRIC INFO
 Fabric 1: 95/5 RAYON/SPAN JSY, 200GR/M2 - TEXTILES COLOR REALS
 Thread: Needle: Tex21 Poly/Spun - A&E GUATEMALA
 Loooper: Tex18 Textured - A&E GUATEMALA
 Other: 1/4" Clear Stretch Tape - JCA
 Hanger Loop: 1/8" Satin Tape - dinamix
 Label Attachment: Main label: We use loop label & inset it at CBN of garment. And insert Size & Country of Production label 1/8" to right of main label.

Measurer 2 Fit Comments

Date: 2/9/2018
 Sample Type: 1st fit
 Sample Color: Hypnotic Blue
 By: Karen Koch & Assistant TD, to Kristin Myatt, TD

STATUS: FIT APPROVED by Kohl's TD- FOLLOW BELOW COMMENTS FOR CORRECTIONS. No further sample or documentation is required by Kohl's TD. CTD may need to review a sample in preparation for Production. Agent may advise to document PR in OnePLM or skip PR in limited cases. A QA Reference sample must be available before production begins.\

I HAVE ACCEPTED OPTION 2

For Options add your requested option in Measurer 1 Comments Box.

▼ Details 5013378

Points of Measure								Sample					
QA	P/S	Attachment	HTM	Code	POM Description	Tol(-)	Tol(+)	Sample 2(01/29/2018) 10(10)					
								Spec	Measurer 1 Actual	Measurer1 Delta	Measurer 1 Comments	Measurer 2 Actual	Measurer 2 Delta
<input type="checkbox"/>				A000	RAYON/SPANDEX JERSEY & NEP JERSEY						OPTION 2		
<input type="checkbox"/>	P			A001-LA000	LADIES ALPHA SIZES XXS(000-00) XS(0-2)								
<input checked="" type="checkbox"/>	P			A300	LEN HPS TO HEM	-1/2	1/2	26	26	0	26		
<input checked="" type="checkbox"/>	P			A100	NK WIDTH@SEAM	-1/4	1/4	7 3/4	7 3/8	-3/8	7 1/4		
<input checked="" type="checkbox"/>	S			A110	FRT NK DROP@SEAM	-1/8	1/8	8 1/2	8 3/8	-1/8	8 3/8		
<input checked="" type="checkbox"/>	S			A120	BK NK DROP@SEAM	-1/8	1/8	1 1/8	1	-1/8	1 1/8		

If you have option samples or alternate options for fit, pattern or construction changes.

Fill in the garment measurements for the Kohl's requested sample in the Measurer 1 Actual field and the measurements for the option sample in Measurer 1 Comments field.

Make sure Sample tag is clearly marked Option 1 vs Option 2