

Seventh Avenue Minimum Construction Standards

- 1) Quick Reference: Stitch details for all fabric
- 2) Special Occasion Garment Hang Tag
- 3) Woven
- 4) Woven with Spandex
- 5) Knits
- 6) Knits with Spandex
- 7) Denim
- 8) Sweater
- 9) Leather
- 10) Intimate

Quick Reference: Stitch details for all fabrics.

This should be used for a quick reference only. Please see individual sections for a more detailed description of stitches.

Wovens

- Internal seams construction:
 - 10 to 12 stitches per inch (will vary with fabric weight).
 - Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic)

Wovens with Spandex

- Internal seams construction:
 - 9 to 11 stitches per inch when 20% to 30% stretch.
 - 13 to 15 stitches per inch when more than 30% stretch.
 - Minimum of 3/8” seam allowance, unless otherwise specified.
- Topstitch 9 to 11 stitches per inch (will vary with fabric weight and desired aesthetic)

Knits

- Internal seams construction:
 - 10 to 12 stitches per inch (based on fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 8-10 stitches per inch (unless specified with desired aesthetic)

Knits with Spandex

- Internal seams construction:
 - 11 to 15 stitches per inch (adjustments must be made depending on stretch/fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 11-15 stitches per inch (unless specified with desired aesthetic)

Denim

- Internal seams construction:
 - 10 to 12 stitches per inch for safety stitch and overlock with a minimum 3/8” seam allowance.
- Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic)

Sweater

- Cut and sew and full fashion
 - Shoulder seams are minimum ¼” 4-thread mock safety with stretchable shoulder tape (as specified).
- Full Fashion
 - All internal side seams & armhole seams must be linked.
- Cut and Sew

- 10-12 stitches per inch (9-12 gauge sweaters)
- 6-8 stitches per inch (3-7 gauge sweaters)
- Minimum of ¼” seam allowance, unless otherwise specified.

Leather

- Internal seams construction:
 - 8 to 10 stitches per inch
 - 10 to 12 stitches per inch for lining
 - Minimum of ¼” seam allowance, unless otherwise specified
- Topstitch 8 stitches per inch (will vary with fabric weight and desired aesthetic)

Intimates

- Internal seams construction:
 - 10 to 12 stitches per inch (will vary with fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified
- Topstitch 8 – 10 stitches per inch for wovens.
- Topstitch 12 – 14 stitches per inch for knits.

Special Occasion Garment Hang Tag

The “Do Not Remove” hang tag should be included on all Special Occasion garments.
We recommend attaching the tag in the armpit seam.

100# white cover stock paper with some gloss
Hole punched

Tag Dimensions:

Width: 2.75 in

Height: 5.75 in

Inside rectangular Box:

Width: 2 in

Height: 4.9375 in

Rectangular stroke is 2 pt

[** Please see digital folder for PDF image of the hang tag.](#)

Wovens – Minimum Construction Standards

Fabric

- Fabric weight must be specified for all fabrics.
- Garments must meet legal requirements:
 - Care labeling
 - Fiber Content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- Garments must meet or exceed performance standards for components testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Ribbons, bows and other decorative trims must be securely stitched.
 - Pleated panels must be joined and hemmed before pleating.
 - Smocking panels must have finished ends secured.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of 2 ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.
- Interlining
 - White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.
 - Interlining must be compatible with the stretch, weight, fiber and care instructions.

- Lining
 - All lining colors must match shell unless otherwise specified.
- Reinforcements
 - All metal reinforcements must be rust proof, corrosion resistant and nickel free.
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Drawcord ends must be finished and follow safety standards.
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No drill or punch holes.
- Garment must be cut on straight grain, unless otherwise specified.

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front and back.
- 1/8" mismatch tolerance unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.
- Pockets must match vertically and horizontally to body.
- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Sharp point needs must be used on all production unless ballpoint needles are more appropriate for fabric type.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 10 to 12 stitches per inch (will vary with fabric weight).

- Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic)
- Staystitching must not be visible on finished garment.
- Belt Loops must be securely fastened.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement.
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
 - Must be cleanly cut.
 - Gimp thread must be used for keyhole buttonholes.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
- Hems
 - Blindstitch hems must be secured with overlock or tape and overrun.
 - Self-turn hems must be double turned and stitched.
 - Jackets and blouses with wide front facings, bottom edge must be clean finished prior to hemming.
- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.
- Necklines
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style.
- Reinforcements

- Drawstrings must be tacked at center back if circular.
- Tunnel elastic must be secured with single needle lockstitch at side seams.
- Hook and eye at waistbands must be reinforced with interlining.
- Zippers set on bias must have seam reinforced with tape or interlining.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Shirts with full length center front openings
 - 2” up from bottom edge of hem
 - On underside of wearer’s placket
 - Men’s & boys items on right side
 - Women’s & girls items on left side
 - Shirts without full length center front opening
 - 2” up from bottom hem or top of vent
 - On left (as worn) side seam
 - Pants / shorts / skirts
 - 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
 - Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- All formal wear garments must have “Do Not Remove” hang tag attached with Nylon fastener to the joint of underarm seam to side seam.
- Products must be pressed unbuttoned to avoid distorted edges.
- Products must be sufficiently pressed, but not hard pressed or over pressed.
- Products must not be moist when sealed in plastic bags.

Wovens with Spandex – Minimum Construction Standards

Fabric

- All fabric / garments must adhere to physical specifications:
 - Fabric weight
 - Percentage of stretch (minimum 20% stretch)
- All fabrics / garments must meet legal requirements:
 - Care labeling
 - Fiber content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- Dye and print methods used must be as specified (assumption reactive dyes are used unless otherwise specified).
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- All fabrics / garments must meet or exceed performance standards for components testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Ribbons, bows and other decorative trims must be securely stitched.
 - Pleated panels must be joined and hemmed before pleating.
 - Smocking panels must have finished ends secured.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.

- Interlining
 - White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.
 - Interlining must be compatible with the stretch, weight, fiber and care instructions.
- Lining
 - All lining colors must match shell unless otherwise specified.
- Reinforcements
 - All metal reinforcements must be rust proof, corrosion resistant and nickel free.
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No drill or punch holes.
- Garment must be cut on straight grain, unless otherwise specified.

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front & back.
- 1/8" mismatch tolerance unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.
- Pockets must match vertically and horizontally to body.
- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- Lycra ends must be secured in all stitching.
- All stitching must be secured.
- Raw edges are not acceptable, unless enclosed or otherwise specified.
- Ballpoint needles must be used on all production.

- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 5 thread overlock (safety stitch) or felled seam, unless otherwise specified.
 - Some seams enclosed by lining will be single needle lockstitch.
 - Seams with zipper set will be single needle lockstitch, open seam with overlock edging.
 - 9 to 11 stitches per inch when 20% to 30% stretch.
 - 13 to 15 stitches per inch when more than 30% stretch.
 - Minimum of 3/8" seam allowance, unless otherwise specified.
 - Adjustments must be made depending on stretch and weight.
- Topstitch 9 to 11 stitches per inch (will vary with fabric weight and desired aesthetic)
- All blindstitching should be done skip stitch, 4-5 stitches per inch.
- Staystitching must not be visible on finished garment.
- Belt Loops must be securely fastened.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement.
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
 - Must be cleanly cut.
 - Gimp thread must be used for keyhole buttonholes.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men's & boys closure
 - Right over left – women's & girls closure
- Hems
 - Blindstitch hems must be secured with overlock or tape and overrun.
 - Self-turn hems must be double turned and stitched.

- Jackets and blouses with wide front facings, bottom edge must be clean finished prior to hemming.
- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.
- Necklines
 - Must be taped, coverstitched, or clean finished as specified for each style.
- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - Hook and eye at waistbands must be reinforced with interlining.
 - Zippers set on bias must have seam reinforced with tape or interlining.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Shirts with full length center front openings
 - 2” up from bottom edge of hem
 - On underside of wearer’s placket
 - Men’s & boys items on right side
 - Women’s & girls items on left side
 - Shirts without full length center front opening
 - 2” up from bottom hem or top of vent
 - On left (as worn) side seam
 - Pants / shorts / skirts
 - 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
 - Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- All formal wear garments must have “Do Not Remove” hang tag attached with Nylon fastener to the joint of underarm seam to side seam.
- Products must be pressed unbuttoned to avoid distorted edges.
- Products must be sufficiently pressed, but not hard pressed or over pressed.
- Products must not be moist when sealed in plastic bags.

Knits – Minimum Construction Standards

Fabric

- Fabric weight must be specified for all fabrics
- Garments must meet legal requirements:
 - Care labeling
 - Fiber Content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- Garments must meet or exceed performance standards for components testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Ribbons, bows and other decorative trims must be securely stitched.
 - Pleated panels must be joined and hemmed before pleating.
 - Smocking panels must have finished ends secured.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.
- Interlining
 - White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.

- Interlining must be compatible with the stretch, weight, fiber and care instructions.
- Lining
 - All lining colors must match shell unless otherwise specified.
 - Lining must have compatible stretch.
- Reinforcements
 - Shoulder seams must be reinforced with clear plastic tape unless otherwise specified. Stable fabrics may be reinforced with woven tape (white on light colors, black on dark colors).
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Drawcord ends must be finished and follow safety standards.
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No garment parts are to be cut on fabric finishing fold line.
- Tubular bodies must be quarter turned (finishing lines will fall as side seams).
- No drill or punch holes.
- Fabric spreading and cutting must be monitored for:
 - Tension and relaxation.
 - Accuracy of grainlines.

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front and center back.
- All stripe and plaid patterns must match horizontally at side seams.
- 1/8" mismatch tolerance unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.
- Pockets must match vertically and horizontally to body.
- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Ballpoint needles must be used on all production.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 4 thread overlock (mock safety) for exposed seams.
 - 10 to 12 stitches per inch (based on fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 8-10 stitches per inch (unless specified with desired aesthetic)
- Staystitching must not be visible on finished garment.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement.
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:

(Ligne Size / Total Needle Drops in Buttonhole)

 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
 - Must be cleanly cut.
 - Gimp thread must be used for keyhole buttonholes.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
- Hems
 - Blindstitch hems must be stitched with lockstitch blindstitch.
 - 2 needle coverstitch hems must be undertrimmed with a maximum of 1/16” overhang.

- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.
- Necklines
 - Rib or self fabric attached necklines to be closed at wearer's left natural high point shoulder, set to the back ¾" to 1". Exceptions are bound necklines which will close at the left shoulder seam; seam allowance must be folded toward back and single needle lockstitched through seam allowance and binding.
 - Extended neck opening must meet minimum stretch requirements without cracking stitches.
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style.
- Pockets
 - Pocket bags must be overlocked, unless otherwise specified.
- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - All pocket openings must be reinforced with bartack, triangular or rectangular stitching, or triple bartack.
 - All openings must be reinforced.
 - Hook and eye at waistbands must be reinforced with interlining.
 - Zippers set on bias must have seam reinforced with tape or interlining.
 - Separating zippers must be bartacked or triple bartacked at the zipper base.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point and opening unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Shirts with full length center front openings
 - 2" up from bottom edge of hem
 - On underside of wearer's placket
 - Men's & boys items on right side
 - Women's & girls items on left side
 - Shirts without full length center front opening
 - 2" up from bottom hem or top of vent
 - On left (as worn) side seam
 - Pants / shorts / skirts

- 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
- Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- All formal wear garments must have “Do Not Remove” hang tag attached with Nylon fastener to the joint of underarm seam to side seam.
- Products must be pressed unbuttoned to avoid distorted edges.
- Products must be sufficiently pressed, but not hard pressed or over pressed.
- Products must not be moist when sealed in plastic bags.

Knits with Spandex – Minimum Construction Standards

Fabric

- All fabrics / garments must adhere to physical specifications:
 - Fabric weight
 - Percentage of stretch (minimum 20% stretch)
- Garments must meet legal requirements:
 - Care labeling
 - Fiber Content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- Garments must meet or exceed performance standards for components testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Ribbons, bows and other decorative trims must be securely stitched.
 - Pleated panels must be joined and hemmed before pleating.
 - Smocking panels must have finished ends secured.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.
- Interlining

- White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.
- Interlining must be compatible with the stretch, weight, fiber and care instructions.
- Lining
 - All lining colors must match shell unless otherwise specified.
 - Lining must have compatible stretch.
- Reinforcements
 - Shoulder seams must be reinforced with clear plastic tape unless otherwise specified.
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Drawcord ends must be finished and follow safety standards.
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No garment parts are to be cut on fabric finishing fold line.
- Tubular bodies must be quarter turned (finishing lines will fall as side seams).
- No drill or punch holes.
- Fabric spreading and cutting must be monitored for:
 - Tension and relaxation.
 - Accuracy of grainlines.

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front and center back.
- All stripe and plaid patterns must match horizontally at side seams.
- 1/8" mismatch tolerance unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.
- Pockets must match vertically and horizontally to body.
- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Ballpoint needles must be used on all production.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 4 thread overlock (mock safety) for exposed seams.
 - 11 to 15 stitches per inch (adjustments must be made depending on stretch/fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified.
- Topstitch 11-15 stitches per inch (unless specified with desired aesthetic)
- Staystitching must not be visible on finished garment.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
 - Must be cleanly cut.
 - Gimp thread must be used for keyhole buttonholes.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
- Hems
 - 2 needle coverstitch hems must be undertrimmed with a maximum of 1/16” overhang.

- Blindstitch hems must be stitched with lockstitch blindstitch.
- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.
- Necklines
 - Rib or self fabric attached necklines to be closed at wearer's left natural high point shoulder, set to the back $\frac{3}{4}$ " to 1". Exceptions are bound necklines which will close at the left shoulder seam; seam allowance must be folded toward back and single needle lockstitched through seam allowance and binding.
 - Extended neck opening must meet minimum stretch requirements without cracking stitches.
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style.
- Pockets
 - Pocket bags must be overlocked, unless otherwise specified.
- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - All pocket openings must be reinforced with bartack, triangular or rectangular stitching, or triple bartack.
 - All openings must be reinforced.
 - Hook and eye at waistbands must be reinforced with interlining.
 - Zippers set on bias must have seam reinforced with tape or interlining.
 - Separating zippers must be bartacked or triple bartacked at the zipper base.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point and opening unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Shirts with full length center front openings
 - 2" up from bottom edge of hem
 - On underside of wearer's placket
 - Men's & boys items on right side
 - Women's & girls items on left side
 - Shirts without full length center front opening
 - 2" up from bottom hem or top of vent
 - On left (as worn) side seam

- Pants / shorts / skirts
 - 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
- Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- All formal wear garments must have “Do Not Remove” hang tag attached with Nylon fastener to the joint of underarm seam to side seam.
- Products must be pressed unbuttoned to avoid distorted edges.
- Products must be sufficiently pressed, but not hard pressed or over pressed. Monitor pressing to avoid stretching, shrinkage, discoloration or glazing of the fabric.
- Products must not be moist when sealed in plastic bags.

Denim – Minimum Construction Standards

Fabric

- Fabric weight must be specified for all fabrics.
- Garments must meet legal requirements:
 - Care labeling
 - Fiber Content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- Garments must meet or exceed performance standards for components testing.
- Dye methods used must be as specified (vat dye will be assumed unless otherwise specified).
- Print methods used must be as specified (reactive dyes will be assumed unless otherwise specified).

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Ribbons, bows and other decorative trims must be securely stitched.
 - Smocking panels must have finished ends secured.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.

- Tack buttons: tack length must be appropriate for fabric weight and garment construction.
- Burrs: rivet length must be appropriate for fabric weight and garment construction, to assure rivets are securely and properly attached.
- Interlining
 - Internal colors must be white for all colors.
- Pocketing
 - For all basic jeans 10 oz and up, 65/35 poly/cotton 3.5 to 4 oz must be used.
 - For anything less than 10 oz, 70/30 poly/cotton 2.5 oz must be used.
- Reinforcements
 - All metal reinforcements must be rust proof, corrosion resistant and nickel free.
- Thread
 - All safety stitch or overlock under thread must be compatible to after wash color.
 - Felled seam underthread must match top thread.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No drill or punch holes.
- Fabric spreading and cutting must be monitored for:
 - Pattern adjustment: shrinkage for different wash & finish process must be calculated proportionally.
 - Fabric with different percent of shrinkage must be cut separately.
 - Tension and relaxation
 - Precision of cutting
 - Accuracy of grainlines

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front and center back.
- 1/8" mismatch tolerance unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.

- Pockets must match vertically and horizontally to body.
- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Sharp point needs must be used on all production unless ballpoint needles are more appropriate for fabric type.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 5 thread overlock, safetystitch or felled seam as specified.
 - Some seams enclosed by lining will be single needle lockstitch.
 - Seams with zipper set will be double needle lockstitch.
 - 10 to 12 stitches per inch for safetystitch and overlock with a minimum 3/8" seam allowance.
- Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic)
- Staystitching must not be visible on finished garment.
- Belt Loops:
 - Belt loops must be securely fastened.
 - Belt loops construction must include fused interlining with no raw edges.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
 - Must be cleanly cut.

- Gimp thread must be used for keyhole buttonholes.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Must be faced or clean finished unless otherwise specified.
 - Left over right – for all basic Jean closure.
- Hems
 - All hems must be in the round (circular, side seamed then hemmed).
 - Self-turn hems must be double turned and stitched.
 - Jackets and blouses with wide front facings, bottom edge must be clean finished prior to hemming.
- Necklines
 - Neckline must be clean finished unless otherwise specified.
- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.
- Necklines
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style.
- Pockets
 - Bags must be extended and stabilized into waist, hem or center front seams as specified to prevent pockets from flipping from front to back of garment.
 - Facing on pocket openings must be deep enough so pocketing is not visible.
- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Sideseam on basic jean must be topcorded no larger than 1/8” margin, with seam turned towards back.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - All safetystitched inseams must be bartacked on the inside of crotch join seam, parallel to inseam.
 - Hook and eye at waistbands must be reinforced with interlining.
 - All openings must be reinforced, unless otherwise specified.
 - All pocket openings must be reinforced with one of the following, rivets and burrs, bartack, triangular, rectangular stitching or triple bartack.
 - Zippers set on bias must have seam reinforced with tape or interlining.
 - Separating zippers must be bartacked or triple bartacked at the zipper base.
 - Zipper fly “J” stitch must be bartacked (inside or outside) and backstitched.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.
- Waistband
 - Waistband must be sewn with chainstitch

- Waistband ends must be enclosed with lockstitch

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Shirts with full length center front openings
 - 2” up from bottom edge of hem
 - On underside of wearer’s placket
 - Men’s & boys items on right side
 - Women’s & girls items on left side
 - Shirts without full length center front opening
 - 2” up from bottom hem or top of vent
 - On left (as worn) side seam
 - Pants / shorts / skirts
 - 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
 - Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- All formal wear garments must have “Do Not Remove” hang tag attached with Nylon fastener to the joint of underarm seam to side seam.
- Side seams must be pressed with seam turned towards the back panel.
- Jeans: side seams and inseam must be visually balanced within ½” when pressing.
- All stones must be removed from garment.
- Products must be sufficiently pressed, but not hard pressed or over pressed.
- Products must not be moist when sealed in plastic bags.

Sweaters – Minimum Construction Standards

Yarn / Garments

- All yarns / garments must adhere to physical specifications:
 - Garment weight
 - Gauge
 - Stitch type (jersey, full needle, etc)
- All garments must meet legal requirements
 - Fiber content
 - Care labeling
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All garments must meet or exceed performance standards to mandatory testing.
- All garments must meet or exceed performance standards for components testing.

Components & Findings

- Decorative
 - Embroidery must have reinforced backing. Backing left on finished garment must be minimal.
 - Hand embroidery ends must be tied off and secured to technical back garment.
 - Ribbons, bows and other decorative trims must be securely tacked/stitched.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.
- Reinforcements
 - Shoulder seams must be reinforced with DTM stretchable twill tape, stretch mesh, clear elastic tap or self knitted tape with ¼” width maximum overhang.

- Zippers must be clean finished with inside full needle facing (unless otherwise specified).
- Thread / Yarn
 - Thread / yarn size and composition must be compatible to base yarn, components and application.
 - Polycore threads must be used to basic seaming on cut and sew sweaters.
 - For linking, self-yarn must be used unless otherwise specified.
 - All thread / yarn must be dyed to match unless otherwise specified.
 - Monofilament thread is not acceptable.
- Trim
 - Exposed shoulder pads must be covered with jersey knit, unless otherwise specified.
 - Metal grommets must be rust proof, corrosion resistant and nickel free.

Knitting

- Yarn must be knitted to the specified stitch type.
- Yarn must be knitted to the specified gauge and tension.
- There must be the proper spinning, twisting or plying of yarns.
- There must be no conspicuous thin ends or dropped needles.
- Tied ends of yarn must be knotted off to ½” on technical back of garment, causing no distortion on technical face of garment.

Pattern Stripe Match (print, stripes)

- All stripe and plaid patterns must match horizontally at side seams.
- All stripe and plaid patterns must match vertically and horizontally at center front and center back.
- Pockets must match vertically and horizontally to body.
- 1/8” mismatch tolerance of the above, unless otherwise specified.
- Collars, cuffs and sleeves must be balanced and paired.
- Dominant patterns or engineered stripes must be as specified and proportionally placed from size to size.

Seams & Stitching

- Cut and sew and full fashion
 - Shoulder seams are minimum ¼” 4-thread mock safety with stretchable shoulder tape (as specified).
 - Ballpoint needles must be used on all production.
 - No raw edges are acceptable, unless otherwise specified.
- Full Fashion
 - All internal sideseams & armhole seams must be linked.
 - Appropriate tension of linking must be used for the gauge/yarn.
 - Armholes are fully fashioned
 - Fully fashioned shoulder seam that fall to the back of the garment must be linked.
- Cut and Sew
 - All internal seams must be 4 thread mock-safety.

- 10-12 stitches per inch (9-12 gauge sweaters)
- 6-8 stitches per inch (3-7 gauge sweaters)
- Minimum of ¼” seam allowance, unless otherwise specified.
- Buttons
 - Must meet standards for application as follows
 - 2 holes / minimum 10 stitch counts
 - 4 holes / minimum 16 stitch counts
 - Must be lockstitched.
 - Must be attached with thread.
 - Shank button must be attached with 6-8 loops and secured knot.
 - Spacer depth/tension of attachment must be appropriate for yarn thickness.
 - Thread shank must be used when specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and yarn type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed yarn edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150
 - Must be cleanly cut.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
 - Start / Hems – all starts at neck, sleeve, and bottom opening are ribbed, tubular, self-start or self-yarn crochet, linked on when applicable.
 - Cut & Sew – all starts must be clean finished, stitched on with 4 thread mock safety.
- Linings
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
- Necklines
 - Ribbed / tubular necklines to be closed at wearer’s left shoulder set to the back ¾”.
 - Extended neck opening must meet minimum stretch requirements without cracking stitches.
 - Ribbed / tubular V-necklines or square necklines must be mitered at the V point or side edges, where applicable.
- Reinforcements
 - Tunnel elastic must be secured with a single needle lockstitch at side seams.
 - All openings must be reinforced and stress points must be secure.
 - Separating zippers must be triple back-tacked at zipper base.
- Vents
 - Must be clean finished (tubular, rib or self-start)

Finishing (pressing & trimming)

- Garments must be blocked and properly dried to avoid excessive stretching.
- Threads and yarn must be trimmed within 1/8" and removed from garment.
- 1 extra button of each size must be sewn into wearer's left sideseam, 2" up from bottom hem, unless otherwise specified.
- Extra button is not required for garments with only one button.
- 32" extra yarn should be placed in bag, closed with cello tape. Bag is swift tagged to the care label.
- Products must not be moist when sealed in plastic bags.

Leather – Minimum Construction Standards

Leather

- Care label instructions must follow wording and format as specified.
- All leather / garments must adhere to physical specifications:
 - Hide type
 - Thickness / weight
 - Grade
 - Finish
 - No visible blemishes or holes
- All leather / garments must meet legal requirements:
 - Care labeling
 - Flammability
 - Country of Origin
- All leather / garments must meet or exceed performance standards for mandatory testing.
- All leather / garments must meet or exceed performance standards for component testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must meet specified recovery before and after washing.
 - All tunneled waist elastic must be non-roll.
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - All elastic must be pre-shrunk.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures
 - All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
 - All fasteners must be through a minimum of two ply of leather and reinforced with interlining (or 1 ply leather, 1 ply lining, and 1 ply interlining).
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free.
 - Metal snaps should stud style. Stud length should be based on leather weight and garments construction.
 - Metal snaps must be reinforced with clear plastic disks.
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back.
 - All zippers must be autolock unless otherwise specified.
 - Men's slider will be on wearer's right

- Women's slider will be on wearer's left
- Interlining
 - White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.
 - Interlining must be compatible with the leather and care instructions.
 - Outerwear and jackets must be stabilized at back neckline, armhole, front edge, and shoulder seam with tape or stripe of fusible interlining.
 - Interlining must be fused and must be bonded adequately to withstand cleaning.
- Lining
 - All lining colors must match shell unless otherwise specified.
- Reinforcements
 - All metal reinforcements must be rust proof, corrosion resistant and nickel free.
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Drawcord ends must be finished and follow safety standards.
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Metal grommets on swimwear, active wear and outerwear must be reinforced with plastic backs.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No drill or punch holes.
- Grains and grades must be balanced within a garment.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Tripoint or diamond point needles must be used. Must be compatible with type of skins.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 8 to 10 stitches per inch

- 10 to 12 stitches per inch for lining
- Minimum of ¼” seam allowance, unless otherwise specified
- Lockstitch or mock felled seam as specified.
- Seams with zippers are to be single needle lockstitch, open seam
- Seams are to be glued open & hammered unless otherwise specified.
- Topstitch 8 stitches per inch (will vary with fabric weight and desired aesthetic)
- Back flanges must be connected with elastic as specified.
- Staystitching must not be visible on finished garment.
- Belt Loops must be securely fastened.
- Belt loops construction must include fused interlining or must be glued.
- Darts on light weight leather, points of darts must be sewn through a strip of lining or broadcloth (unless garment is unlined).
- Shoulder pads
 - Enclosed should pads must be attached with lining strips at 3 points – 2 at armhole and 1 at shoulder seam near neck
 - Exposed shoulder pads must be covered with lining and tacked on shoulder seam allowance with 2 tacks ½” in from each edge, unless they are removable.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement.
 - Must be lockstitched.
 - Thread shank will be required as specified.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
- Hems
 - Seams must be joined before hemming.
 - Hems must be glued.
 - Glue must remain flexible, not visible from surface and compatible with leather type.
 - Garments with wide front facings, bottom edge must be clean finished prior to hemming.
- Lining
 - Adequate ease must be present at sleeve and bottom hems.
 - Adequate ease must be present at across back location.
 - Closed lining must be secured at shoulder seam, underarm and bottom hem.
 - Open lining must have thread chains joining to shell at bottom hem.

- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - Hook and eye at waistbands must be reinforced with interlining.
 - Zippers set on bias must have seam reinforced with tape or interlining.
 - Patch pocket openings must be reinforced with triangular or rectangular stitching, rivets or backstitching.
 - Separating zippers must be backstitched at zipper base.
 - Zipper fly “J” stitch must be backstitched.
- Zipper
 - Should be stitched no less than 1/8” from teeth.
 - Facing should not interfere with the function of the slider and must be topstitched.
- Side Vents
 - Must be cleaned finished (double fold with single needle topstitch) unless otherwise specified.
 - Must be square cut at vent top, not straight cut side seams with tapered vent.
 - Bar tack at stress point unless otherwise specified.
 - Garment must be bottom hemmed before vent is sewn.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified. General placement guidelines are as follows:
 - Pants / shorts / skirts
 - 1” down from waistband
 - On front pocket bag, left side (as worn)
 - On left side seam (as worn) for garments without pocket bags
 - Jackets / blazers
 - Inside front facing
 - Left side (as worn)
- Products must be sufficiently pressed using indirect method with paper, but not pressed or over pressed.
- Products must not be moist when sealed in plastic bags.
- Desiccant packets should be packed with each garment.
- Zipper tab and buttons must be covered with tissue prior to shipping.

Intimate – Minimum Construction Standards

Fabric

- Fabric weight must be specified for all fabrics.
- Garments must meet legal requirements:
 - Care labeling
 - Fiber Content
 - Flammability
 - Country of Origin
- Care label instructions must be based on wash care test.
- All fabrics / garments must meet or exceed performance standards for mandatory testing.
- Garments must meet or exceed performance standards for components testing.

Components & Findings

All components and findings must meet safety and performance standards.

- Decorative
 - Embroidery must have reinforced backing:
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal.
 - Cut away backing must be trimmed as close as possible to embroidery.
 - Raw edges of organza must be totally enclosed with embroidery, trim or stitching.
 - Ribbons, bows and other decorative trims must be securely stitched. Ends of satin bows must be heat sealed or laser cut.
 - Pleated panels must be joined and hemmed before pleating.
 - Smocking panels must have finished ends secured.
 - Lace applications:
 - All edges must be secured with stitching.
 - Appliqué lace edges must be trimmed to 1/8"
 - The joining of two lace pieces should be with a zig zag stitch 12 stitches per inch or joined together with 5 thread overlock (based on lace).
 - All inserted lace must be positioned and trimmed evenly on both sides.
 - Beading must be applied securely. Every 3rd bead is to be knotted (not necessarily cut, can be continuous). Ends are to be trimmed to 1/4", floats can be a maximum 3/4"
 - Ruffles must be Shirred evenly.
- Elastic
 - All elastic must have 100% (2:1) minimum stretch.
 - All elastic must be pre-shrunk.
 - All elastic must meet specified recovery before and after washing.
 - No exposed rubber. Woven, knitted or braided elastic to be used.
 - All tunneled waist elastic must be non-roll.
 - Internal elastic colors must be white for light colors and black for dark colors.
 - Elastic constructed from monofilament yarns is not acceptable.
- Fasteners & Closures

- All fasteners & closures must meet or exceed performance standards for care, durability, ease of use, and safety.
- All fasteners must be through a minimum of two ply of fabric and reinforced with interlining.
- Metal fasteners must be rust proof, corrosion resistant, and nickel free.
- Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction.
- All zippers must be autolock unless otherwise specified.
- Interlining
 - White or off-white interlining to be used on light colors, black or grey interlining to be used on dark colors.
 - Interlining must be compatible with the stretch, weight, fiber and care instructions.
- Lining
 - All lining colors must match shell unless otherwise specified.
- Reinforcements
 - All metal reinforcements must be rust proof, corrosion resistant and nickel free.
 - Shoulder seams for knits must be reinforced with clear elastic tape unless otherwise specified.
- Thread
 - All thread must match unless otherwise specified.
 - Thread size and composition must be compatible to base fabric, components and application.
 - Polycore or spun texturized polyester threads must be used for basic seaming.
 - 100% cotton thread is not acceptable for basic seaming.
 - Monofilament thread is not acceptable.
- Trim
 - Metal grommets must be rust proof, corrosion resistant and nickel free.
 - Exposed shoulder pads must be covered with fabric.
- Hook and Loop
 - Loop side must be placed on garment location, which faces toward the body.
 - Hook side must be placed on garment location, which faces away from the body.

Cutting

- Directional prints must be cut in one direction. Napped fabrics must be cut in one direction unless otherwise specified.
- No drill or punch holes.
- No knit garment parts are to be cut on fabric finished fold line.
- Garments made of tubular knit fabrics, creases must fall at side seams.

Pattern Design Match (print, stripes & plaids)

- All stripe & plaid patterns must match vertically and horizontally at center front and center back.
- 1/8" mismatch tolerance unless otherwise specified.
- Lace sections must be paired within garment.
- Collars, cuffs and sleeves must be balanced and paired.

- Dominant patterns or engineered stripes must be proportionally placed from size to size.

Seams & Stitching

- All stitching must be straight and even.
- Overall thread tension must be adjusted properly to avoid puckering.
- All stitching must be secured.
- The coverstitching must enclose all raw edges, unless otherwise specified.
- Sharp point needs must be used on all production for wovens, unless ballpoint needles are more appropriate for fabric type.
- Ballpoint needles to be used on production for knits must be used on all production.
- Needle size must be compatible with fabric, trim, thread size and construction application.
- Needle usage must be monitored and replaced as needed to prevent fabric damage.
- Internal seams construction:
 - 10 to 12 stitches per inch (will vary with fabric weight)
 - Minimum of ¼” seam allowance, unless otherwise specified
 - 5 thread overlock (safety stitch) or felled seam as specified for wovens.
 - Some seams enclosed by lining will be single needle lockstitch
 - Seams with zipper set will be single needle lockstitch, open seam with overlock edging.
 - 4 thread overlock (mock safety) for knits
- Topstitch 8 – 10 stitches per inch for wovens.
- Topstitch 12 – 14 stitches per inch for knits.
- Staystitching must not be visible on finished garment.
- Raw edges are not acceptable, unless otherwise specified.
- Belt Loops and locker loops must be securely fastened.
- Buttons
 - Must meet standards for application as follows:
 - 15 ligne button or smaller, minimum of 9 stitch counts
 - 16 ligne button or larger, minimum of 18 stitch counts
 - Buttons must be attached through a minimum of two ply fabric with interlining reinforcement
 - Must be lockstitched.
 - Spacer depth must be appropriate for fabric thickness.
 - Buttons must be spaced evenly, unless otherwise specified.
- Buttonholes
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed.
 - Must be lockstitched and be fully covered without exposed fabric edges. Stitching guidelines are as follows:
 - (Ligne Size / Total Needle Drops in Buttonhole)
 - 17 ligne & smaller / 90
 - 18 – 22 / 100
 - 24 – 27 / 120
 - 30 – 36 / 150

- Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement.
- Must be cleanly cut.
- Gimp thread must be used for keyhole buttonholes.
- Bound buttonholes must be interlined. Facing opening must align with buttonhole.
- Center Front Openings
 - Left over right – men’s & boys closure
 - Right over left – women’s & girls closure
- Hems
 - Blindstitch hems must be secured with overlock or tape and overrun.
 - Self-turn hems must be double turned and stitched.
 - Jackets and blouses with wide front facings, bottom edge must be clean finished prior to hemming.
- Necklines
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style.
 - Rib or self fabric attached necklines to be closed at wearer’s left natural high point shoulder, set to the back ¾” to 1”. Exceptions are bound necklines which will close at the left should seam; seam allowance must be folded toward back and single needle lockstitched through seam allowance and binding.
 - Extended neck openings must meet minimum stretch requirements without cracking stitches.
- Reinforcements
 - Drawstrings must be tacked at center back if circular.
 - Tunnel elastic must be secured with single needle lockstitch at side seams.
 - Hook and eye at waistbands must be reinforced with interlining.
 - All openings must be reinforced.
 - Pocket openings must be reinforced.
 - Zippers set on bias must have seam reinforced with tape or interlining.

Finishing (pressing & trimming)

- Threads must be trimmed and removed from garment.
- Extra button is not required for garments with only one button.
- 1 extra button of each size must be stitched directly to inside of garment, unless otherwise specified.
- Products must be pressed unbuttoned to avoid distorted edges.
- Products must be sufficiently pressed, but not hard pressed or over pressed.
- Products must not be moist when sealed in plastic bags.