

Adult Sweater Minimum Construction Standards

NOTE

All construction standards will be followed except when specified otherwise

Must use Bon-Ton approved suppliers

Vendor must meet all applicable Bon-Ton Store, Inc. lab testing performance standards and applicable laws and regulations, both Federal and State.

Fabric / Cutting

All parts of finished garments must be compatible with prescribed care instructions

Combined fabrications must have compatible shrinkage

Knitting machines must be monitored for tension and relaxation

Tension & relaxation - minimum 24 hour relaxation period before cutting

Garment pieces cut in same direction within a garment

Heavy napped fabrics and one way prints – all garments pieces cut in same direction within a style

Stripe and plaids to match at Center Front, Center Back and side seam if specified

No drill or punch holes

Sewing

Only ball point needles should be used on sweater knits

Needle size must be compatible with gauge, fabric, trim, thread size and construction application.

Internal seams 10 -12 stitches per inch for 9-14 gauge sweaters

Internal seams 6 - 8 stitches per inch for 3–7 gauge sweaters

Top-stitching 8 - 10 stitches per inch for 3–7 gauge sweaters

Top-stitching 10 – 12 stitched per inch for 9-14 gauge sweaters

Stitching must be secure at start and stop

Linking/ stitching on a seam must be continuous

Float length should be no longer than 1"

Seams must stretch to maximum stretch of knit panels/ fabric without breaking

Buttons must be attached with lockstitch machine

Thread shank is required for all buttons that do not have a built in shank

Attach 4-hole buttons with cross-stitched – "X"

Logo buttons are to be all sewn in the same direction

Heavy fabric and outerwear should have a secure button except when specified otherwise.

Shoulder seams reinforced with tape as specified

Tunnel elastic must be secured

Full drawstring must be secured at Center Back

Side vents must have clean finished with tubular, rib stitch, hand crochet edge or self start

Beads must be knotted after every fifth bead

Belt loops must be uniform, clean finished and trimmed to within 1/4" of tack except when specified otherwise.

Full Fashion Seams:

All internal seams except for shoulder must be linked except when specified otherwise.

Linking tension should be same on all seams within a garment

Linked seams must stretch to maximum stretch of knit panels without breaking

Necklines:

Necklines with tubular or rib trim should have closing seam placed at HPS on wearer's left side

Necklines should meet minimum stretch requirements with breaking stitched

Sweater Starts:

Sweater starts on neck, sleeve, and bottom opening are ribbed, tubular, self start or self yarn crochet

Tighten tension 1/2" on all rib starts

Trims

Thread size & composition must be compatible to shell fabric except when specified otherwise

Linking yarn must be compatible to shell fabric, components and application

Interlining should be compatible with fabric type, color & corresponding components

All trims must meet safety & performance standards

No monofilament thread

Yarn/thread color to match fabric ground unless specified except when specified otherwise

All operations must use same color thread within internal seams except when specified otherwise

Button thread color to match the button except when specified otherwise

All threads must be trimmed & removed from garment

Buttons on single ply of fabric must be reinforced

All fasteners/ closures for fabric 12 oz and under must be applied through a minimum of two-ply fabric with interlining reinforcement

Metal fasteners must be appropriate length for fabric weight and garment construction as to attach properly and securely.

Elastic must meet recovery standards before & after washing / care

Elastic must meet or exceed test requirements.

Ends of satin bows must be heat sealed

Embroideries must have reinforcement backing; lightweight tear-away or dissolvable

Embroidery backing left on finished garments should have no visible edges

Draw cord ends must be permanently tipped or knotted

Continuous tape zipper must have secure stop

Beads must be knotted off every 5th bead