

Adult Woven-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

Fabric should be relaxed a minimum of 24 hours after spreading

Accuracy of grain line (markers must be made with zero tilt tolerance).

All garment pieces cut on grain, unless specified

Garment pieces cut in same direction within a garment

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

Stripes and plaids must be pinned or blocked

Stripes and plaids must match at Center Front, Center Back and side seams unless specified otherwise by Bon-Ton Private Brand

Sleeves, lapels and cuffs must be paired

Collar must be balanced

No print repairs on roller prints

No drill or punch holes

No exposed notches

Sewing

3/8" minimum seam allowance unless specified otherwise in specific areas of the garment

Use a #516 – 5 thread safety stitch except when specified otherwise

Use French seam for sheer fabric except when specified otherwise

Internal seams 10-12 stitches per inch

Top-stitching 8-10 stitches per inch for heavy weight fabrics

Top-stitching 10-12 stitches per inch for medium and light weight fabrics

Stitching must be secure at start and stop (back-tacks or bar-tacks at ends of stitching when not caught in another seam)

Chain stitch ends must be secured

Buttonhole stitch to be locked

Gimp on all keyhole buttonholes

Stitching on a seam must be continuous

Rises must have continuous seam

Shoulder seam must be pressed towards the back

Armhole seam must be pressed towards the sleeve when no top stitching

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.

Sleeve cuffs, necks and banded bottoms must be circular set

Bound necks closed at left shoulder 1” towards the back on figure except when specified otherwise.

Underarm seam allowance must be tacked at sleeve hem on seam allowance over 3/16”

All pocket opening corners must be reinforced

Patch pocket hems must be clean finished

Patch pocket must have mitered seam allowance

Pocket bags are to be clean finished with French seams except when specified otherwise.

Tunnel elastic must be secured

Full drawstring must be secured at Center Back

Circular bottom hems (except vented and split styles)

All blind-stitched hems must be machine blind-stitched

Blind-stitch hems must have no excessive stitch show through

Lining hem must be clean finished and cover top of shell hem

Hems must lay flat, no roping or puckering

Waistbands must be interfaced except when specified otherwise

Contour waistbands should be interfaced on both the inside of the waistband & inside of the facing.

Inside of waistband must be clean finished, taped, or serged

No raw edges on plackets, vents or facings

Placket styles must have clean finished sides except when specified otherwise

Placket must be framed-stitched or edge stitched

Side vents must have clean finished sides except when specified otherwise

Lining body seams must be safety-stitched

Lining seam must be 1/2" from bottom of invisible zipper stop when zipper is fully open

No dimples at end of darts

Belt loops must be uniform and neatly trimmed to within 1/4" of tack

Bar tack at the intersection of the crotch seams

No raw or pinked edges

Trims

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

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

All trims must meet safety and performance standards

No monofilament thread

Thread color to match fabric ground unless specified otherwise

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

Button thread color to match the button unless specified otherwise

All threads must be trimmed and removed from garment

Buttons on single ply of fabric must be reinforced

Fasteners (grippers, snaps, eyelets, buttons and buttonholes, etc.) must go through a minimum of two ply of fabric with interlining reinforcement and set on even thickness

Elastic must meet recovery standards before and after washing / care

Elastic must meet or exceed test requirements.

Draw cord ends must be permanently tipped or knotted

Continuous tape zipper must have secure stop

Ends of satin bows must be heat sealed

Embroideries must have reinforcement backing, lightweight tear-away or dissolvable with tricot (over the back) backing as requested on the garment

Beads must be knotted off every 5th bead