

Kids 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.

All products must meet the requirements of the Child Safety Protection Act.

All trims must be in compliance with the Consumer Product Safety Improvement Act of 2008.

Vendor must specify when placing an order that trim is intended for a children's garment.

Bon-Ton private brand will only allow woven labels on children's garments. All labels must be approved by Product Manager except when specified otherwise.

CPSIA label must be incorporated into garment. Stacked under care label.
LABEL - COATED POLY in dimensions of 19mm x 35mm (plus seam allowance)
Arial Font - size 6/7

To insure no needles are left undetected all garments must be scanned with a needle detection device before shipping.

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”

Must use 4-hole buttons with cross-stitched – “X” - 2 hole buttons are not acceptable for sizes 0 – 6X.

Logo buttons are to be all sewn in the same direction

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

Hook and Loop must have rounded corner and stitched down around all edges.

Products that are washed with pumice stone or similar abrasives must have all pockets basted closed before the stone washing process to prevent stones from entering the pockets. Basting stitched must be removed after stone washing.

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

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 and 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 & removed from garment

Shank buttons can not be used on sizes 0 - 6X upper garments

Snaps must have long prongs and machine set

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.

Trims such as beads, rhinestones, and sequins must be sewn on and not pinned or glued onto garments

Beads must be knotted off every 3rd bead

Metal zippers that come in contact with the skin must have a zipper guard behind the zipper (facing the body) to prevent injury

Open ended zippers must have safety stops

Sizes 0 - 5T for Tops must be plastic zippers with plastic stoppers on top/bottom.

Full drawstring must be secured at Center Back for sizes 2T - 20. NO drawstring is acceptable on garment for size 0 – 24 month

Waist and bottom drawstring, the ends must not exceed 3 inches in length outside the channel when the garment is expanded to its full width.

Drawstring and tie ends must be permanently clean finished – no toggles, caps or knots

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

Pre-tied bow – tie length can not exceed 3” for 0 - 24 months

Non-function tie can not exceed 3” for sizes 0 - 24 months and 8” for sizes 2T - 20

Definitions:

Drawstring = is a string, cord, tape or ribbon inserted into a hem or casing and intended to be drawn to close a bag or control fullness of garment.

Tie = a string, cord, tape or ribbon used for fastening or uniting. Tie is not capable of controlling fullness of a garment

Decorative Tie / Bow = a string cord, tape or ribbon that is stitched in the middle to create a permanent non-functional pre-tied bow or tie