



Colony[®]
BRANDS, INC.

Minimum Construction
Standards for Apparel
服装结构基本标准



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

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PAGE: 1

Contents 内容

目录

1. -- <u>Wovens and Knits – Minimum Construction Standards</u>	2
梭织&针织—结构基本标准	
1A. Components 部件	2
1B. Cutting 裁剪	4
1C. Pattern Matching (Print, Stripes & Plaids) 对条对格（印花，条子&格子）	4
1D. Seams & Stitching 缝份与车缝	5
1E. Finishing (pressing & trimming) 后整理（熨烫&修剪）	10
2. --<u>Sweaters – Minimum Construction Standards</u>	10
毛衫—结构基本标准	
2A. Yarn / Garments 纱线/ 成衣	10
2B. Components 部件	10
2C. Knitting 针织	11
2D. Seams & Stitching 缝子& 车缝	11
2E. Finishing (pressing & trimming) 后整理 & 熨烫	13



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 2

1. Wovens and Knits – Minimum Construction Standards

梭织&针织—结构基本标准

1A. Components 部件

- Decorative 装饰
 - Embroidery must have reinforced backing: 绣花背面必须加背衬：
 - Lightweight tear away or dissolvable backing left on finished garment must be minimal. 衣服完成后，撕掉和清理干净成衣背面的衬纸。
 - Ribbons, bows, and other decorative trims must be securely stitched and properly centered/placed. 缎带，蝴蝶结和装饰辅料必须车缝牢固位置正确。
 - Pleated panels must hemmed before pleating. 活褶部分必须先卷边再安装。
 - Smocking panels must have finished ends secured. 斯玛特成衣片子两头橡筋必须车缝加固。
- Elastic 橡筋
 - All tunneled waist elastic must be non-roll and/or secured into center back seam, side seam, or waist seam. 腰内橡筋不能起扭和转动，橡筋接头必须牢固，侧缝，后中心缝需暗针固定。
 - Exposed trim elastics must be dyed to match base fabric unless otherwise specified. 外露装饰性橡筋除特殊规定外**必须**与面布配色。
 - Internal elastic colors must be white for light colors and black for dark colors. 内嵌橡筋**必须**根据面料颜色的深浅选配使用。
 - All elastic must be pre-shrunk. 所有橡筋**必须**先预先缩水。
 - Elastic constructed from monofilament yarns is not acceptable. 橡筋内的组织必须是高弹纤维丝。



TITLE: Minimum Construction Standards for Apparel


HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 3

- Fasteners & Closures 扣合件
 - Metal fasteners must be rust proof, corrosion resistant, and nickel free. 金属扣件必须是防锈，防腐蚀以及不能含镍。
 - Metal snaps can be prong or stud style. Prong or stud length will vary based on fabric weight and garments construction. 金属五爪扣的爪子长度必须根据不同面料的厚度和结构确定长度。
 - Outerwear and other bulky items must have exterior buttons reinforced with an inside button back. 衣服表面装饰性部件必须在背面增加扣子加固。
 - All zippers must be auto-lock unless otherwise specified. Prefer zippers to be purchased to correct length, not on a roll. Zippers must have stoppers at top edge. 所有拉链除特殊要求外必须是含有自动锁扣，拉链长度合适，拉链顶部和尾部必须要有挡赛，防止脱落。
 - Tack buttons: 摇头扣（撞钉）
 - Tack length must be appropriate for fabric weight and garment construction. 扣子钉脚长度必须根据面料厚度结构确定合适的长度。
 - Burrs: 大头钉
 - rivet length must be appropriate for fabric weight and garment construction. 铆钉的钉脚长度必须根据面料厚度结构确定合适的长度。
- Interlining 粘合衬
 - Interlining must be fully fused to avoid delaminating, and void of bubbling/puckering/lines. 粘合衬必须充分粘合牢固，不能有分层，起泡，起皱，起扭
 - White or off-white interlining should be used on light colors, black or grey interlining to be used on dark colors. 衬布必须根据面料颜色的深浅选配使用。（亮色的面料用白色衬&暗色的面料用黑色衬）

	TITLE: Minimum Construction Standards for Apparel	
	HOME: Technical Design/QA	
	DOC #: 1	REVISION #: 1

- Interlining must be compatible with the stretch, weight, fiber and care instructions. 衬布**必须**根据面料性能和厚薄选配使用。（弹力面料必须用弹力料）
- Lining Lining 里布
 - All lining colors must match shell unless otherwise specified. 所有里布的颜色必须与面布配色。（除特殊要求外）
- Trim 附件
 - Drawcord ends must be finished unless specified. 穿绳尾部**必须**做光。（除特殊要求外）

1B. Cutting 裁剪

- Directional prints must be cut in one direction. 定位印花裁剪时必须方向一致。
- Napped fabrics must be cut in one direction unless otherwise specified. Nap direction must match with a set. 有毛向的布料裁剪时必须毛向一致，上下套装也必须毛向一致。（除特殊要求外）
- No drill or punch holes. 裁剪时不能钻孔打洞。
- Garment must be cut on straight grain, unless otherwise specified. 裁片所有丝绉必须顺直。（除特殊规定外）

1C. Pattern Matching (Print, Stripes & Plaids) 对条对格（印花，条子&格子）

- All stripe & plaid patterns must match vertically and horizontally at center front and back unless specified. 所有对条对格前后中条纹必须顺直方正。（除特殊规定外）
- All stripe and plaid patterns must match at side seams unless specified. 所有条格款式侧缝必须对条对格。（除特殊规定外）
- 1/2" matching tolerance unless otherwise specified. 条格匹配误差需在1/2内。（除特殊规定外）
- Collars, cuffs and sleeves must be balanced and paired. 领子，克夫和袖子条格必须左右对称。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1


REVISION #: 1

PAGE: 5

- Pockets must match vertically and horizontally to body unless specified. 口袋竖条或者横条，必须同大身条格相匹配。（除特殊规定外）
- Dominant patterns or engineered stripes must be proportionally placed from size to size unless specified. 有特殊设计，特征的条格款，每个尺码位置必须一致成比例。（除特殊规定外）

1D. Seams & Stitching 缝份&车缝

- All stitching must be straight and even. 所有车缝必须顺直平服。
- Overall thread tension must be adjusted properly to avoid puckering. 所有线迹必须松紧适度避免有褶皱产生。
- All stitching must be secured. 所有车缝必须牢固开头与结尾必须要有来回针没有跳针断线现象。
- Coverstitching must enclose all raw edges, unless otherwise specified. 双针或者三针（绷缝），车缝接缝或者卷边时，反面的毛头必须缝进里面，不可外漏。（除特殊规定外）
- Sharp point needles must be used on all production of woven garments unless ballpoint needles are more appropriate for fabric type. 所有梭织产品必须用要使用圆头针，合适的尖针车缝。（除特殊规定外）
- Ballpoint needles must be used on all production of knit garments. 针织产品必须使用圆头针。
- Needle size must be compatible with fabric, trim, thread size and construction application. 针和线的大小粗细必须根据面辅料特性选配使用。
- Needle usage must be monitored and replaced as needed to prevent fabric damage. 针的使用和放置必须预防损害面料。
- Stitch Selection should be appropriate to fabrication.
Example: chain stitch on knit or stretch. 必须根据面辅料特性选配合适的车缝线。
例如：链条机使用在针织和弹力面料上。

	TITLE: Minimum Construction Standards for Apparel	
	HOME: Technical Design/QA	
	DOC #: 1	REVISION #: 1

- *Wovens 梭织*
 - Internal seam construction: 内缝结构：
 - 10 to 12 stitches per inch (will vary with fabric weight). 10—12针每英寸（根据不同的面料克重）。
 - Minimum of ¼” seam allowance, unless otherwise specified. 缝份最小 1/4，除非有特殊规定外。
 - Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic). 明线 8—10针每英寸（根据不同面料克重和款式需要）。

- *Woven Tops and Jackets 梭织上装和夹克*
 - Internal seam construction: 内部缝份结构：
 - 12 to 14 stitches per inch (will vary with fabric weight). 12—14针每英寸（根据不同的面料克重）。
 - Minimum of ¼” seam allowance, unless otherwise specified. 缝份最小 1/4，除非有特殊规定外。
 - Topstitch 12-14 stitches per inch (will vary with fabric weight and desired aesthetic). 明线 12—14针每英寸（根据不同面料克重和款式需要）。

- *Knits 针织*
 - Internal seam construction: 内缝结构：
 - 10 to 12 stitches per inch (based on fabric weight) 每英寸10~12针（基于面料客重）。
 - Minimum of ¼” seam allowance, unless otherwise specified. 最小1/4”缝份，特别要求除外。
 - Topstitch 12-14 stitches per inch (unless specified with desired aesthetic). 面线每英寸12~14针（根据款式有特殊要求除外）。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 7

- *Denim* 牛仔
 - Internal seam construction: 内缝结构:
 - 10 to 12 stitches per inch for safety stitch and overlock with a minimum 3/8" seam allowance. 四线拷边每英寸10~12针，最小缝份宽度为3/8"。
 - Topstitch 8-10 stitches per inch (will vary with fabric weight and desired aesthetic). 面线每英寸8-10针（根据面料重量和衣服风格会有不同）。
- Staystitching must not be visible on finished garment. 拷边线成衣后不能外漏。
- Thread 缝合线
 - Thread size and composition must be compatible to base fabric, components and application. 缝合线的粗细和成份必须跟面料的成份和功能相匹配。
 - Polycore or spun texturized polyester threads must be used for basic seaming. 涤线，短纤，弹力涤线只能使用在普通缝份里。
 - Monofilament thread is not acceptable. 不接受单丝线。
- Belt Loops must be securely fastened. 马王祥要缝合牢固。
- Buttonholes 纽眼
 - Buttonhole size must be appropriate for button size and fabric type. Size must allow easy buttoning and security when closed. 纽眼大小必须根据纽扣大小和面料属性调整，要开合自如。
 - Must be lockstitched and be fully covered without exposed fabric edges. 纽眼锁眼保持较密，避免面料毛边外露。
 - Buttonholes must be sewn through a minimum of 2 ply fabrics with interlining reinforcement. 纽眼门襟至少两层面料，且要加粘衬。
 - Must be cleanly cut. 纽眼要清理干净。
 - Gimp thread must be used for keyhole buttonholes. 圆头眼时里面要放一根粗线。
 - Bound buttonholes must be interlined. Facing opening must align with buttonhole. 嵌条纽眼要用粘衬。正反面开口要放正。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 8

- **Center Front Openings 前中门襟&开口**
 - Left over right – Men’s & Boys closure. 左盖右——男装&男童服装。
 - Right over left – Women’s & Girls closure unless specified. 右盖左——女装 & 女童服装（特别要求除外）。

- **Hems 下摆**
 - Blindstitch hems must be secured with overlock stitch or tape and not visible on the outside. 下摆暗针撬边，反面的毛边必须用拷边或者滚边做光，并且撬边线不可过紧，正面针脚不可外露或者起皱。

- **Lining 里布**
 - Lining fabric must have stretch for stretch garments. 衣服的面料有弹性，里布必须要有弹性。
 - Adequate ease must be present at sleeve and bottom hems. 成衣后袖口和下摆处，里布要有一定的松量。
 - Adequate ease must be present at across back location. 后中要放足够的松量。
 - Closed lining must be secured at shoulder seam, underarm and bottom hem. 肩缝，袖笼底和下摆处的里布缝份要牢固。
 - Lining ease must not be excessive in length, to avoid being visible on outside of garment. 里布松量不能超过衣长，避免里布外露。

- **Pockets 口袋**
 - Facing on pocket openings must be deep enough so pocketing is not visible. 口袋贴边不能太小，避免口袋里布外露。
 - Pocket bags must be overlocked, unless otherwise specified. 口袋在没有特别要求的情况下必须拷边。
 - When specified, baste pockets closed for shipment. Maximum 4-6 SPI on baste stitch. 如有要求，大货袋口要用手针封口，针距为最大4-6SPI。
 - No back-tacking on ends of baste stitch. 口袋封口时，手针不能用套结加固，以免顾客能打开袋口。
 - Baste stitch should be centered on opening of pocket. 手针必须在袋口中心位置。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 9

- Necklines for Knits 针织领圈
 - 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. 罗文和本身面料缝制到领围时，接缝要在穿着左肩高点往后 $\frac{3}{4}$ ~1"处，包边领圈接缝要在左肩缝位置，缝份朝后，单针车缝领圈。
 - Extended neck opening must meet minimum stretch requirements without cracking stitches. 领圈必须在不断线的情况下能拉到最小拉量尺寸。
 - Neckline finish must be taped, coverstitched, or clean finished as specified for each style. 领圈的后道工艺必须要有滚边，绷缝或按每款特殊要求。

- Reinforcements 加固
 - Drawstrings must be tacked at center back if circular. 拉绳在后中要固定。
 - Tunnel elastic must be secured with single needle chainstitch at side seams or sewn into seams or center back. 腰里橡筋在要用单针链条线迹在侧缝或后中加固，或用链条车车进腰缝。
 - Hook and eye at waistbands must be reinforced with interlining. 要口钩扣要跟粘衬缝在一起。
 - Zippers set on bias must have seam reinforced with tape or interlining. 斜纹面料上装拉链要用衬条加固，防止拉伸。
 - All openings must be reinforced, unless otherwise specified. 所有开口都必须加固，除非有特别要求。
 - All pocket openings must be reinforced with one of the following, rivets and burrs, bartack, triangular, rectangular stitching or triple backtack. 所有口袋开口要用以下一种方式加固:铆钉，套结，三角针或来回针。
 - Zipper fly "J" stitch must be bartacked (inside or outside) and backstitched. 裤子门襟"J"型线迹，必须内外轮廓线加套结和来回针。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1


REVISION #: 1

PAGE: 10

- Knit shoulder seams must be reinforced with clear plastic tape unless otherwise specified. Stable fabrics may be reinforced with woven tape as specified (white on light colors, black on dark colors). 针织面料肩缝要用透明橡筋加固，除非特别要求，弹性不大的面料有特别要求时可能要用梭织条加固（白的用于浅色，黑的用于深色）。
- Vents 开衩
 - Side vents must be cleaned finished (double fold with single needle topstitch) unless otherwise specified. 侧衩必须光边（对折后单针线迹缝制，特殊要求除外）。
 - Side vents must be square cut at vent top, not straight cut side seams with tapered vent. 侧衩上口要方形不能是锥型。
 - Bar tack at stress point unless otherwise specified. 衩上口要用套结加固，特别要求除外（根据面料判别能否用套结）。
 - Garment must be bottom hemmed before vent is sewn. 下摆工艺必须在缝制衣衩之前。
 - Center back vents should be basted closed with X-stitch when specified.
 - 前后衩要用“X”型手针缝和。
- Waistband 腰头
 - Waistband must be sewn with chainstitch unless specified. 腰头要用链条车线迹，特别要求除外。

1E. Finishing (pressing & trimming)后整（整烫和修剪）

- Threads must be trimmed and removed from garment. 衣服上线头要清理干净。
- Products must be sufficiently pressed, but not hard pressed or over pressed. Avoid shine marks and creases. 产品整烫平整，但不能过分熨烫避免烫痕和死痕。
- Products must not be moist when sealed in plastic bags. 产品进包装袋前要确保干燥。

	TITLE: Minimum Construction Standards for Apparel	
	HOME: Technical Design/QA	
	DOC #: 1	REVISION #: 1

1. Sweaters – Minimum Construction Standards

毛衫-基本结构标准


2A. Yarn/Garments 纱线/成衣

- All yarns/garments must adhere to physical specifications:所有纱线/成衣必须根到技术要求：
 - Garment weight 克重
 - Gauge 针数
 - Stitch type (jersey, full needle, etc.)针型（平整，收花等）

2B. Components 成份

****For all Components other than Thread/Yarn, refer to Knits and Wovens. 针梭织面料成份*

- Thread/Yarn
 - Thread/yarn size and composition must be compatible to base yarn, components and application. 车缝线的粗细和成分要跟服装的面料成分和功能吻合。
 - Polycore threads must be used to basic seaming on cut and sew sweaters. 缝制毛衫时要用苞芯线。
 - For linking, self-yarn must be used unless otherwise specified. 套口线用大身纱线，特殊要求除外。
 - All thread/yarn must be dyed to match unless otherwise specified. 所有的车缝线必须跟大身配色，特殊要求除外。
 - Monofilament thread is not acceptable . 不接受单丝线。

	TITLE: Minimum Construction Standards for Apparel	
	HOME: Technical Design/QA	
	DOC #: 1	REVISION #: 1

2C. Knitting 针织

- Yarn must be knitted to the specified stitch type. 拼缝线要用规定或者指定的纱线。
- Yarn must be knitted to the specified gauge and tension. 对针数和线迹张力有特殊要求。
- There must be the proper spinning, twisting or plying of yarns. 针织衫必须用弹力线。
- There must be no conspicuous thin ends or dropped needles. 不能有明显的小线头货落针现象。
- Tied ends of yarn must be knotted off to 1/2" on technical back of garment, causing no distortion on technical face of garment. 衣服反面打结1/2"左右，衣服表面不能有变形。

2D. Seams & Stitching 缝份和线迹

- Cut and sew and full fashion 梭织裁剪和缝制，毛衫
 - Shoulder seams are minimum 1/4" 4-thread mock safety with stretchable shoulder tape (as specified). 肩缝必须用至少宽度为1/4"的四线拷贝并加有弹力肩带（肩带要求见具体说明）。
- Cut and Sew 裁剪和缝制
 - 10-12 stitches per inch (9-12 gauge sweaters). 每英寸10-12针（毛衫9-12针）。
 - 6-8 stitches per inch (3-7 gauge sweaters). 每英寸6-8针（毛衫3-7针）。
 - Minimum of 1/4" seam allowance, unless otherwise specified. 至少1/4"的缝份宽，特殊要求除外。
 - Ballpoint needles must be used on all production. 所有大货都必须要用圆头针。
 - No raw edges are acceptable, unless otherwise specified. 特殊要求除外，所有毛边都不能接受。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 13

- Full Fashion收花
 - All internal side seams & armhole seams must be linked. 所有内侧缝合袖笼缝必须套口。
 - Appropriate tension of linking must be used for the gauge/yarn. 套口的张力必须根据针数和纱线来调整。
 - Armholes are fully fashioned.袖笼要收花。
 - Fully fashioned shoulder seam that fall to the back of the garment must be linked.收花肩缝内缝要向后身倒，并且要用套口线迹。

- Linings里布
 - Adequate ease must be present at sleeve and bottom hems. 里布在袖口和下摆处要放适当松量。
 - Adequate ease must be present at across back location. 后背要放适当松量。
 - Closed lining must be secured at shoulder seam, underarm and bottom hem. 肩缝，袖底缝和下摆处的里布缝份要牢固，不能散口。

- Necklines 领圈
 - Ribbed/tubular necklines to be closed at wearer's left shoulder set to the back $\frac{3}{4}$ ".罗文/管状领圈要在穿着者左肩缝往后 $\frac{3}{4}$ "处缝合。
 - Extended neck opening must meet minimum stretch requirements without cracking stitches.领圈要拉伸达到最小拉量尺寸而不能断线。

- Reinforcements 加固
 - Tunnel elastic must be secured with a single needle lockstitch at side seams. 有细橡筋的款，在橡筋两头一定要用单针线加固。
 - All openings must be reinforced and stress points must be secure. 所有开衩末端要加固（比如裙子后开衩，袖开衩等）。
 - Separating zippers must be triple back-tacked at zipper base. 拉链底不要用三角针加固。
 - Shoulder seams must be reinforced with DTM stretchable twill tape, stretch mesh, clear elastic tap or self-knitted tape with $\frac{1}{4}$ " width maximum overhang. 肩缝要用配色的弹力斜纹织带，弹力网布，透明橡筋或者本身纱线织的编织带（最宽 $\frac{1}{4}$ "）加固。



TITLE: Minimum Construction Standards for Apparel

HOME: Technical Design/QA

DOC #: 1

REVISION #: 1

PAGE: 14

- Zippers must be clean finished with inside full needle facing (unless otherwise specified). 拉链带边要跟大身面料固定，不能外翻（特殊要求除外）。
- Vents 开衩
 - Must be clean finished (tubular, rib or self-start). 所有开衩要做光（管状折边，罗文或本身布）。

2E. Finishing (pressing & trimming) 后整（整烫和后整）

- Garments must be blocked and properly dried to avoid excessive stretching. 衣服包装时袋口要封紧，要确保衣服干燥，避免受潮，变型。
- Threads and yarn must be trimmed within 1/8" and removed from garment. 衣服上的线头要清理干净，最长只能留1/8"。