



2024/1/9

1月BUY B組-2ND PR

莎美娜實業股份有限公司

SFC2400208



加工指導書

(SAB)台北總公司生產



2024/1/9

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(SAB)台北總公司生產



## 加工指導書

| SP25   | LuLulemon                  | 自編單號 | SP25 LW5GS2S P2 | 交貨日期 | 2024/1/22 | 製單 | 楊月霞 | 簽收 |  |
|--|----------------------------|------|-----------------|------|-----------|----|-----|----|--|
| 數量   | 5                          | 款號   | LW5GS2S         | 版號   | K5199     |    |     |    |  |
| 款式名稱   |                            |      |                 |      |           |    |     |    |  |
| YOGA ALIGN 25 CORE GRAPHIC (裁片印花)(Align Pant II)(大尺碼母款LW5FYCS-K2623)(襠底蓋大身)(Women Bottom)            |                            |      |                 |      |           |    |     |    |  |
| 搭配表  |                            |      |                 |      |           |    |     |    |  |
| #F7A5120-SEAMSOFT AS<br>Tex16/Tkt120 (5000M) 抗靜電-超細纖維特多龍蓬鬆線-腰圍接縫 - 拷克/腰圍接縫 + 下襠 - 三本爬網/腰頭內側口袋 - 窄針爬網 | C9760<br>(C9760-BLACK)(黑色) |      |                 |      |           |    |     |    |  |
| #03A3120-ELOFLEX AS<br>TEX27/TKT120 (3000M) 抗靜電-高彈性線-前/後襠 + 內長 - 併縫/腰圍接縫 + 下襠 - 三本爬網                 | C9760<br>(C9760-BLACK)(黑色) |      |                 |      |           |    |     |    |  |
| #2994180-EPIC<br>Tex18/Tkt180 (5000M)-包心線  | C9760<br>(C9760-BLACK)(黑色) |      |                 |      |           |    |     |    |  |
| #CC00001-CC00001-LLL-GARMENT 洗標成份+洗語-熱轉印尺寸標位置@穿者左側腰頭內貼口袋內垂直居中位置距袋口邊橫向2"處,量到標中間                       | (WHITE)                    |      |                 |      |           |    |     |    |  |

\*\* 熱轉印標位置:

1. 热轉印Logo標@後腰接片正中處;接片水平和垂直置中處,量到標中間.
2. 热轉印尺寸標@穿者左側腰頭內貼口袋內;垂直居中位置 & 距袋口邊橫向2"處,量到標中間.



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SP25 2024/1月BUY B組-2ND PR

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(SAB)台北總公司生產



|   |   |      |                 |      |           |    |     |    |  |
|---|---|------|-----------------|------|-----------|----|-----|----|--|
| 數量  | LuLulemon   | 自編單號 | SP25 LW5GS2S P2 | 交貨日期 | 2024/1/22 | 製單 | 楊月霞 | 簽收 |  |
|   | 5   | 款號   | LW5GS2S         | 版號   | K5199     |    |     |    |  |
| 款式名稱  |   |      |                 |      |           |    |     |    |  |
| YOGA ALIGN 25 CORE GRAPHIC (裁片印花)(Align Pant II)(大尺碼母款LW5FYCS-K2623)(襠底蓋大身)(Women Bottom) |   |      |                 |      |           |    |     |    |  |
| 布料名稱  |   |      |                 |      |           |    |     |    |  |
| 1   | 儒鴻#RT1904031/0001/81% NYLON 19% BLACK LYCRA@ ELASTANE -W:46" -WT:238g/Yd                      |      |                 |      |           |    |     |    |  |
| 2   | 儒鴻#RT1903050/0001/81% NYLON 19% BLACK LYCRA@ ELASTANE -W:46" -WT:238g/Yd                      |      |                 |      |           |    |     |    |  |
| 3   | 儒鴻#R20403099/0001/56% POLYESTER 33% COOLMAX@ POLYESTER 11% LYCRA@ ELASTANE -W:60" -WT:210g/Yd |      |                 |      |           |    |     |    |  |

## 副料

| 項目   | 單件用量    | 單位 | 總用量    | 供應商       |
|--|---------|----|--------|-----------|
| #E011303-透明板帶: 1/4" CLEAR MOBILON ELASTIC #0612 (1400Y/KG)// CLEAR                               | 0.220   | YD | 1.10   | 佶城        |
| #T00185N-反光銀LOGO標 LUF201408067-13MM SILVER REFLECTIVE LULU LOGO, HERO QUALITY- 13MM// SILVER     | 1.000   | PC | 5.00   | 登威(依田)    |
| #25HLUPBTK02-單件袋 條碼貼紙 (25HLUPBTK02) STK_POLYBAG_SKU FOR ADTP1 W:1.5" L:2" (1KIT=22000PC)// WHITE | 1.000   | PC | 5.00   | 艾利丹尼森     |
| #LU-POLY10-單件袋-Polybag 12"X10 (PB_12x10_APP_DS)// CLEAR  | 1.000   | PC | 5.00   | MAINETTI  |
| #MPPS-2525-防霉紙-LDPE 25CM X 25CM PE SHEET (1000PC PER UNIT)/                                      | 1.000   | PC | 5.00   | MICRO-PAK |
| #LHT-WWMT-001-吊牌 LHT - lululemon WWMT Hangtag - White (MOQ 50pc/Round up 50pc)// WHITE           | 1.000   | PC | 5.00   | 艾利丹尼森     |
| #RFID225-RFID 條碼貼紙 WWMT Barcode Sticker (4300PC/KIT)// WHITE                                     | 1.000   | PC | 5.00   | 艾利丹尼森     |
| #022209-1-2" 精距型細排釘 (10000PC/BOX)// WHITE  | 1.000   | PC | 5.00   | 千聲        |
| #2925180-EPIC Tex18/Tkt180 (2500M) 包心線// C9760   | 5.640   | M  | 28.20  | 高士台灣      |
| #5H43140-高蠟滌綸低彈蓬鬆線GRAMAX HL Tex21/Tkt140(5000M)// C9760  | 109.570 | M  | 547.85 | 上海高士      |
| #F7A5140-SEAMSOFT AS Tex24/Tkt140 (5000M) 抗靜電-超細纖維特多龍蓬鬆線// C9760                                 | 57.120  | M  | 285.60 | 高士台灣      |
| #F7A5120-SEAMSOFT AS Tex16/Tkt120 (5000M) 抗靜電-超細纖維特多龍蓬鬆線// C9760                                 | 54.670  | M  | 273.35 | 高士台灣      |
| #03A3120-ELOFLEX AS TEX27/TKT120 (3000M) 抗靜電-高彈性線// C9760  | 62.670  | M  | 313.35 | 高士台灣      |
| #2994180-EPIC Tex18/Tkt180 (5000M)-包心線// C9760   | 2.880   | M  | 14.40  | 高士台灣      |
| #CC00001-CC00001-LLL-GARMENT 洗標成份+洗語/  | 0.000   | PC | 0.00   | JMLT01    |



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(SAB)台北總公司生產

|      |           |      |                 |      |           |    |     |    |  |
|------|-----------|------|-----------------|------|-----------|----|-----|----|--|
| SP25 | LuLulemon | 自編單號 | SP25 LW5GS2S P2 | 交貨日期 | 2024/1/22 | 製單 | 楊月霞 | 簽收 |  |
| 數量   | 5         | 款號   | LW5GS2S         | 版號   | K5199     |    |     |    |  |

款式名稱

YOGA ALIGN 25 CORE GRAPHIC (裁片印花)(Align Pant II)(大尺碼母款LW5FYCS-K2623)(襠底蓋大身)(Women Bottom)

|               |   |   |   |   |   |    |    |    |    |    |    |    |
|---------------|---|---|---|---|---|----|----|----|----|----|----|----|
| 顏色/尺寸         | 0 | 2 | 4 | 6 | 8 | 10 | 12 | 14 | 16 | 18 | 20 | 數量 |
| #0001 0001\黑色 | 0 | 0 | 0 | 0 | 1 | 0  | 0  | 0  | 0  | 0  | 0  | 1  |

PO#LA SAMPLE 交期:2024/1/22

|               |   |   |   |   |   |   |   |   |   |   |   |   |
|---------------|---|---|---|---|---|---|---|---|---|---|---|---|
| #0001 0001\黑色 | 0 | 0 | 0 | 0 | 4 | 0 | 0 | 0 | 0 | 0 | 0 | 4 |
|---------------|---|---|---|---|---|---|---|---|---|---|---|---|

PO#P2 SAMPLE 交期:2024/1/22

| 商標  | 洗標內容  | 包裝方式   |
|---|-------|--|
| 1. 熱轉印LOGO標位置@後腰接片正中處<br>-接片水平和垂直置中處,量到標中間<br><br>2. CC LABLE洗標位置@車於穿者後中腰接縫左邊,<br>車單針回針固定上端。<br>(雙洗標:CC00026在下,CC0001在上)<br><br>3. 熱轉印尺寸標位置@穿者左側腰頭內貼口袋內<br>-垂直居中位置<br>-距袋口邊橫向2"處,量到標中間<br><br>4. 白色大吊卡:在吊卡背面貼一張WWMT+RFID電腦貼紙,用2"白色子彈釘在穿者左側腰接縫上.<br><br>5. 單件袋(POLY1)尺寸:<br>size 0-14:12" x 10"<br>size 16-20:12" x 12"<br>(包裝袋需加成品貼紙)<br><br>6. 每件需放一張防霉紙 25 x 25cm | ----- | 1. 單件入一單件袋(Poly Bag),規定件數入一大放水袋(24" x 32")再入外箱.<br><br>2. 除非另有說明,每個紙箱上均需註明"單品(SKU)"或"單色單碼".<br><br>3. 最後一個紙箱允許出現混合顏色和尺碼,且須在紙箱外表和裝箱單上註明有混合顏色和尺碼.<br><br>4. 紙箱規格為Standard Box 101 - B 200 - 24" x 15.5" x 13"的紙箱裝運. 紙箱的總重量不得超過23kg.<br><br>*注意有澳洲/e-Commerce訂單,不可短裝出貨.<br><br>*以下Channels通路,出口時須加上防盜鉗 - Australia Retail / US Retail / Canada Retail / US Exit / Canada Exit<br><br>*防盜鉗位置圖: 釘於穿者右側腰頭縫線處 |

| Measurement Report Proto 1 Physical 3D Sample - 1 Spring 2025 |  |  | SP25 Yoga Align Pant 25 In *CORE GRAPHIC   |  | lululemon                                    |  | Jan 08, 2024 |  |
|---|--|--|--|--|--|--|--------------|--|
| PDF-XChange<br>Editor<br>www.pdf-xchange.com                  | Season: Spring 2025<br>Style #: LW5GS2S<br>Style Desc: SP25 Yoga Align Pant 25 In *CORE GRAPHIC SLOT100862 LW5GS2S<br>Product Size Definition: W Bottoms--W Ext Sizes:0-26<br>Grade Rule Template: | Brand: lululemon<br>Division: lulu Womens<br>Class: Womens Pants<br>Pod: W Sweat | Style Status: Active<br>Generated Date: Jan 08, 2024<br>Measurement Template: W's_Tight_Bottoms_0-18 |  | PDF-XChange<br>Editor<br>www.pdf-xchange.com |  |              |  |

|                 |  |            |               |   |
|-----------------|--|------------|---------------|---|
| Request Name    | Proto 1 Physical 3D                    | P1 / 3D 標樣 | Sample        | Sample - 1 Physical (Proto 1 Physical 3D)                   |
| Type            | Product\Fit\Proto                      |            | Style         | SP25 Yoga Align Pant 25 In *CORE GRAPHIC SLOT100862 LW5GS2S |
| Source          | Sabrina Fashion Industrial Corporation |            | Specification | SPECIFICATION:001 - Sabrina Fashion Industrial Corporation  |
| Measurement Set | MEASUREMENTS:'EBS WI20 Onwards'        |            |               |   |

| General Attributes      |            |                         |                               |
|-------------------------|------------|-------------------------|-------------------------------|
| Sample Size             | 8          | Sample Description      | Proto 1                       |
| Sample Status           | Resubmit   | Sample Request Date     | 10/15/2023                    |
| Sample Request Due Date | 10/29/2023 | Sample Received Date    | 11/12/2023                    |
| Date Sample Approved    |            |                         |                               |
| Wash Tested             | No         | Wash Test Approved      |                               |
| Wear Tested             | No         | Wear Test Approved      |                               |
| QA Technician           |            | Product Developer       |                               |
| Fit Specialist          |            | Block Pattern Reference | BW555-ALG-FA18 Solid Nulu EBS |

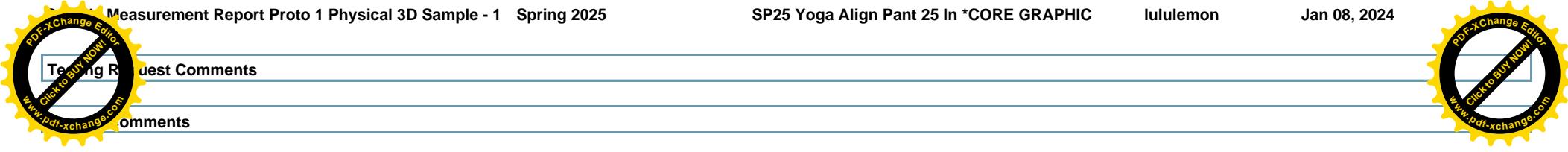
|                 |
|-----------------|
| Design Comments |
|-----------------|

|                       |
|-----------------------|
| Construction Comments |
|-----------------------|

|                           |  |
|---------------------------|--|
| Fit/Measurements Comments | 2024/01/05 1ST PROTO COMMENTS HY:<br><ul style="list-style-type: none"> <li>- Please refer to the updated TP for the updated sandwich colour and graphic placement.</li> <li>- Proceed with colourway 1a for full garment sample and submit strike offs for colourway 1b, 2 and 3 according to TP and BOM.</li> <li>- Keep graphic thickness consistent (see photo).</li> <li>- Improve the sandwich colour application to be shaper and cleaner to avoid colour bleeding on the fabric (see photo).</li> <li>- Back to spec on hip circ.</li> <li>- Logo is updated to silver reflective (LUF201408067).</li> </ul> |
|---------------------------|--|

|                      |   |
|----------------------|---|
| BOM Changes Comments | 2024/01/05 2ND PROTO STRIKE OFFS COMMENTS HY:<br><br>Colourway 1a - GROUND COLOR: BLACK(CSI)/ TOP COLOR: BLACK (19-0303 TCX)/ SANDWICH COLOR: TURKISH SEA (19-4053 TCX)<br>- submit in full garment sample<br><br>Colourway 1b - GROUND COLOR: BLACK(CSI)/ TOP COLOR: BLACK (19-0303 TCX)/ SANDWICH COLOR: LIME PUNCH (13-0550 TCX)<br>- submit in strike off ( submit only the right leg side artwork); 2PCS TOTAL<br><br>Colourway 2 - GROUND COLOR: GOODNIGHT PLUM(CSI)/ TOP COLOR: WINETASTING (19-2118 TCX)/ SANDWICH COLOR: LILAC ROSE (17-2227 TCX)<br>- submit in strike off ( submit only the right leg side artwork)<br><br>Colourway 3 - GROUND COLOR: RAINFOREST GREEN(CSI)/ TOP COLOR: ROSIN (19-0509 TCX)/ SANDWICH COLOR: STORMY SEA (18-4711 TCX)<br>- submit in strike off ( submit only the right leg side artwork) |
|----------------------|---|

|                            |   |
|----------------------------|---|
| Proto Status Comments      | 2024/01/05 2ND PROTO REQUEST HY:<br><ul style="list-style-type: none"> <li>- Please submit P2 3pcs of physical samples (1 for PD,1 for Merch, 1 for LA) and 4pcs strike offs (2pcs in colourway 1b, 1pc each in colourway 2 and 3) to SSC by Jan 26th.</li> <li>- Proceed PD+Merch+LA all in colourway 1a.</li> </ul> |
| Modified Date:Jan 08, 2024 | Confidential and Proprietary  |



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Request Comments

Comments

## Fit Session Attendance

FSA Product Developer Hailey Yoon - hyoon2

FSA Fit Specialist

FSA Fit Session Date 11/14/2023

FSA Designer

FSA Fit Model

Kiah Loewen

FSA QD Technician

## Quality

Testing and Compliance Comments

試穿/測量評語:

2024/01/05 P1評語 HY :

- 請參照更新的印花做工說明，以了解更新的厚版硅膠印顏色和圖形位置。
- P2樣需提供的完整樣品的色組:1a，並根據印花做工說明和BOM提交色組#1b、#2和#3 的部分縫印花供核可。
- 請保持厚版硅膠印厚度同P1樣一致（請見圖示）。
- 請改進厚版硅膠印顏色應用，為避免織物上滲色,使其更成形、及更乾淨(請見圖示)。
- 臀圍尺寸請更新回同測量表規格。
- LOGO標更新為銀色反光 (LUF201408067)。

BOM更新評語:

2024/01/05 P2-印花部份縫評語 HY:(請參照印花做工說明)

色組1a-大身色:黑色(CSI)/厚版硅膠印頂部顏色:黑色 (19-0303 TCX)/厚版硅膠印顏色:(19-4053 TCX)

-此色組需完整的P2樣品

色組1b-大身色:黑色(CSI)/厚版硅膠印頂部顏色:黑色 (19-0303 TCX)/厚版硅膠印顏色:(13-0550 TCX)

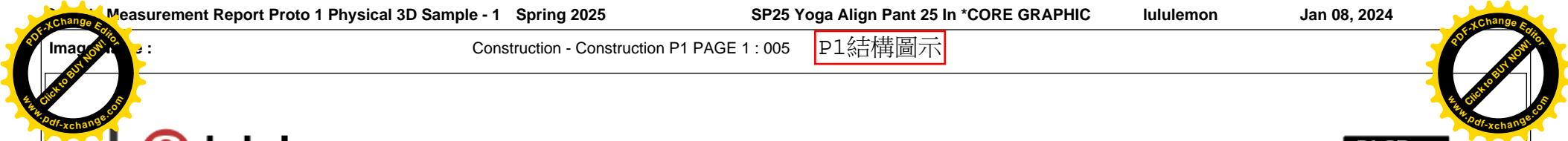
-此色組請提交裁片部分縫(僅需提交右腿側裁片 印花部分縫)

色組2-大身色:GOODNIGHT PLUM(CSI)/厚版硅膠印頂部顏色: (19-2118 TCX)/厚版硅膠印顏色:(17-2227 TCX)

-此色組請提交裁片 印花部分縫(僅需提交右腿側裁片 印花部分縫)

色組3-大身色:RAINFOREST GREEN(CSI)/厚版硅膠印頂部色:(19-0509 TCX)/厚版硅膠印顏色:(18-4711 TCX)

-此色組請提交(僅需提交右腿側裁片 印花部分縫)

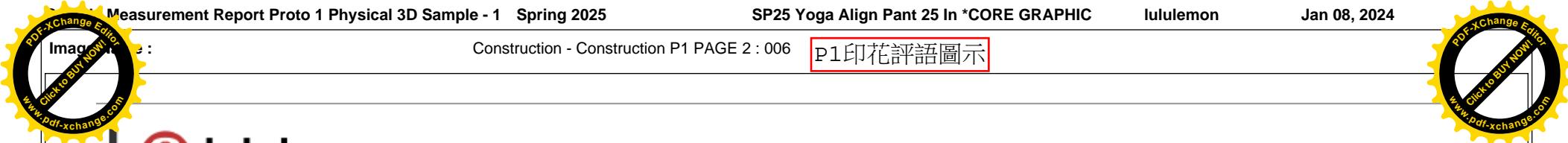


**lululemon** /FIT COMMENTS /LW5GS2S/ PROTO 1 /

PAGE 01



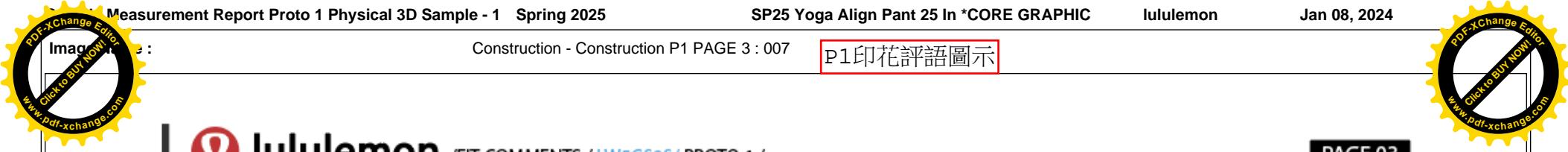
DESIGNER: Nicole Anson  
PRODUCT DEVELOPER: Hailey Yoon  
TECHNICAL DEVELOPER: Megan Leung



 lululemon /FIT COMMENTS /LW5GS2S/ PROTO 1 /

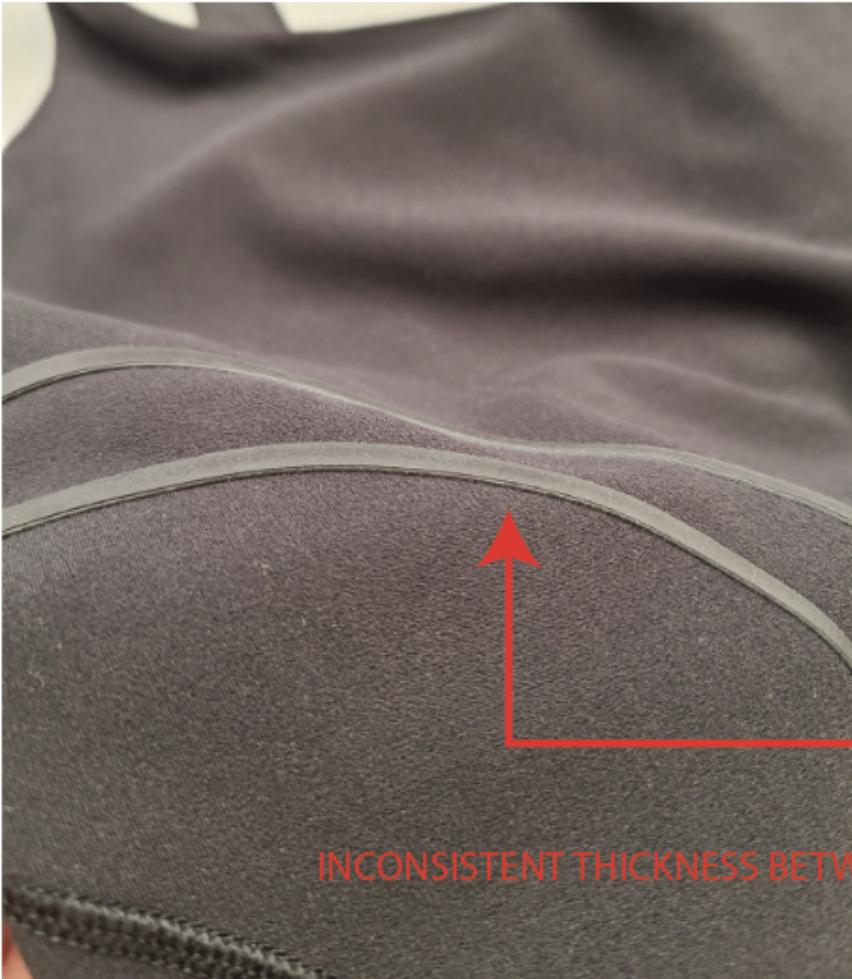
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**lululemon** /FIT COMMENTS /LW5GS2S/ PROTO 1 /

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INCONSISTENT THICKNESS BETWEEN TOP/BOTTOM SAMPLES

厚版硅膠印在頂部/底部之間的厚度不一致

| #        | Name                             | Criticality | Tol (-) | Tol (+) | HTM Instruction   | 0         | 2         | 4         | 6         | 8         | 10        | 12        | 14        | 16        | 18        |
|----------|----------------------------------|-------------|---------|---------|---|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| 146<br>6 | REF-RISE CATEGORY (HIGH RISE)    |             |         |         | Front waist edge sits 2-3/4" below true waist of a 5'-7" size 8 Lululemon model for all bottoms. This measurement is for the base size and for reference only.  |           |           |           |           |           |           |           |           |           |           |
| 163      | REF-OUTSEAM LENGTH               |             |         |         | Measure from top edge of waistband to bottom edge of hem along side seam. Note: This measurement is for the base size and for detail only.  |           |           |           |           | 33<br>1/4 |           |           |           |           |           |
| 253      | REF-TOTAL RISE                   |             | 1/2     | 1/2     | Measure along rise seam from CF top finished edge of waistband to center of gusset/crotch seam to CB top finished edge of waistband. Note: This measurement is for the base size and for detail only. | 21<br>1/4 | 22        | 22<br>3/4 | 23<br>1/2 | 24<br>1/4 | 25        | 25<br>3/4 | 26<br>1/2 | 27<br>1/4 | 28        |
| 21       | FRONT RISE to TOP WAIST EDGE     |             | 1/4     | 1/4     | Measure along front rise seam from inseam join to CF top finished waist edge.   | 8 1/2     | 8 7/8     | 9 1/4     | 9 5/8     | 10        | 10<br>3/8 | 10<br>3/4 | 11<br>1/8 | 11<br>1/2 | 11<br>7/8 |
| 22       | BACK RISE to TOP WAIST EDGE      |             | 1/4     | 1/4     | Measure along back rise seam from inseam join to CB top finished waist edge.  | 11<br>3/4 | 12<br>1/8 | 12<br>1/2 | 12<br>7/8 | 13<br>1/4 | 13<br>5/8 | 14        | 14<br>3/8 | 14<br>3/4 | 15<br>1/8 |
| 298      | GUSSET PANEL RISE                |             | 1/8     | 1/8     | Measure length of gusset panel along rise seam direction, from center of stitching at front rise to center of stitching at back rise.   | 1         | 1         | 1         | 1         | 1         | 1         | 1         | 1         | 1         | 1         |
| 14       | WAIST CIRC                       | Critical    | 1/2     | 1/2     | Measure along finished edge of waistband from fold edge of garment to fold edge of garment with waistband top edge aligned, multiply by 2.  | 17<br>3/4 | 19<br>1/4 | 21<br>1/4 | 23<br>1/4 | 25<br>1/4 | 27<br>1/4 | 29<br>1/4 | 31<br>1/4 | 33<br>1/4 | 35<br>1/4 |
| 16       | WAIST CIRC at SEAM               |             | 1/2     | 1/2     | Measure along waistband seam from fold edge of garment to fold edge of garment with waistband top edge aligned, multiply by 2.  | 22<br>1/4 | 23<br>3/4 | 25<br>3/4 | 27<br>3/4 | 29<br>3/4 | 31<br>3/4 | 33<br>3/4 | 35<br>3/4 | 37<br>3/4 | 39<br>3/4 |
| 213      | WAISTBAND HEIGHT at CF           |             | 1/8     | 1/8     | Measure from CF top of waistband edge straight down to waistband seam.  | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     | 4 3/4     |
| 307      | WAISTBAND HEIGHT at CB           |             | 1/8     | 1/8     | Measure from CB top of waistband edge straight down to waistband seam.  | 6         | 6         | 6         | 6         | 6         | 6         | 6         | 6         | 6         | 6         |
| 171      | HIP POSITION from TOP WAIST EDGE |             | 0       | 0       | Measure from top edge of waistband straight down to specified hip position.   | 6         | 6 1/4     | 6 1/2     | 6 3/4     | 7         | 7 1/4     | 7 1/2     | 7 3/4     | 8         | 8 1/4     |



| Element Set: Calculated     |                                  | Spring 2025   |         | SP25 Yoga Align Pant 25 In *CORE GRAPHIC |   |        | lululemon |   | Jan 08, 2024                              |  |
|-----------------------------|----------------------------------|---------------|---------|--|---|--------|-----------|---|---|--|
| #                           | Name                             | Criticality   | Tol (-) | Tol (+)                                  | HTM Instruction   | 8      | 20        | PDF-XChange Editor<br>www.pdf-xchange.com | PDF-XChange Editor<br>www.pdf-xchange.com |  |
| 1                           | REF-RISE CATEGORY (HIGH RISE)    |               |         |  | Front waist edge sits 2-3/4" below true waist of a 5-7" size 8 lululemon model for all bottoms. This measurement is for the base size and for reference only.   |        |           |   |   |  |
| 163                         | REF-OUTSEAM LENGTH               |               |         |  | Measure from top edge of waistband to bottom edge of hem along side seam. Note: This measurement is for the base size and for detail only.  | 33 1/4 |           |   |   |  |
| 253                         | REF-TOTAL RISE                   |               | 1/2     | 1/2                                      | Measure along rise seam from CF top finished edge of waistband to center of gusset/crotch seam to CB top finished edge of waistband. Note: This measurement is for the base size and for detail only. | 24 1/4 |           | 28 3/4                                    |   |  |
| 21                          | FRONT RISE to TOP WAIST EDGE     |               | 1/4     | 1/4                                      | Measure along front rise seam from inseam join to CF top finished waist edge.   | 10     |           | 12 1/4                                    |   |  |
| 22                          | BACK RISE to TOP WAIST EDGE      |               | 1/4     | 1/4                                      | Measure along back rise seam from inseam join to CB top finished waist edge.  | 13 1/4 |           | 15 1/2                                    |   |  |
| 298                         | GUSSET PANEL RISE                |               | 1/8     | 1/8                                      | Measure length of gusset panel along rise seam direction, from center of stitching at front rise to center of stitching at back rise.   | 1      |           | 1   |   |  |
| 14                          | WAIST CIRC                       | Critical      | 1/2     | 1/2                                      | Measure along finished edge of waistband from fold edge of garment to fold edge of garment with waistband top edge aligned, multiply by 2.  | 25 1/4 |           | 37 1/4                                    |   |  |
| 16                          | WAIST CIRC at SEAM               |               | 1/2     | 1/2                                      | Measure along waistband seam from fold edge of garment to fold edge of garment with waistband top edge aligned, multiply by 2.  | 29 3/4 |           | 41 3/4                                    |   |  |
| 213                         | WAISTBAND HEIGHT at CF           |               | 1/8     | 1/8                                      | Measure from CF top of waistband edge straight down to waistband seam.  | 4 3/4  |           | 4 3/4                                     |   |  |
| 307                         | WAISTBAND HEIGHT at CB           |               | 1/8     | 1/8                                      | Measure from CB top of waistband edge straight down to waistband seam.  | 6      |           | 6   |   |  |
| 171                         | HIP POSITION from TOP WAIST EDGE |               | 0       | 0  | Measure from top edge of waistband straight down to specified hip position.   | 7      |           | 8 1/2                                     |   |  |
| 158                         | HIP CIRC                         | Critical      | 1/2     | 1/2                                      | Measure from fold edge of garment to CF crotch seam to fold edge of garment, multiply by 2.<br>NOTE: Place garment flat in its natural state and ensure CF drop is correct.                           | 31     |           | 43  |   |  |
| 373                         | THIGH CIRC 1" BELOW RISE SEAM    | Critical      | 3/8     | 3/8                                      | At 1" below rise seam, measure straight across from inside leg fold edge to outer leg fold edge parallel to leg opening, multiply by 2.   | 19 1/2 |           | 27  |   |  |
| 304                         | KNEE CIRC - TIGHT                |               | 3/8     | 3/8                                      | Measure at specified knee position, from inner leg fold edge straight across to outer leg fold edge, multiply by 2.   | 11 3/4 |           | 15  |   |  |
| 256                         | KNEE POSITION from RISE SEAM     |               | 0       | 0  | Measure from rise seam or center of gusset to specified knee position.  | 14     |           | 13 3/4                                    |   |  |
| 344                         | CALF CIRC - TIGHT                |               | 1/4     | 1/4                                      | At specified calf position, measure straight across from Inside leg fold edge to outer leg fold edge, multiply by 2.  | 11 3/8 |           | 14 3/8                                    |   |  |
| 225                         | CALF POSITION from RISE SEAM     |               | 0       | 0  | Measure from rise seam along inseam down to specified calf position.  | 19     |           | 18 3/4                                    |   |  |
| 1724                        | HEM SWEEP-7/8 TIGHT              | Critical      | 1/4     | 1/4                                      | Measure from left fold edge to right fold edge straight across bottom edge of finished hem, multiply by 2. (For 7/8 Tight, 25" Inseam)  | 8 3/4  |           | 10 1/2                                    |   |  |
| 31                          | INSEAM                           | Critical      | 1/2     | 1/2                                      | Measure from center of gusset or crotch seam straight down to bottom edge of leg opening.   | 25     |           | 24 1/2                                    |   |  |
| 12                          | HEM HEIGHT                       |               | 1/8     | 1/8                                      | Measure from top of hem stitching line straight down to finished hem edge.  | 1      |           | 1   |   |  |
| Modified Date: Jan 08, 2024 |                                  | Page 23 of 24 |         |  | Confidential and Proprietary  |        |           |   |   |  |

| Element Set: Calculated |                          | Spring 2025 | SP25 Yoga Align Pant 25 In *CORE GRAPHIC |         |   | lululemon | Jan 08, 2024 |
|-------------------------|--------------------------|-------------|--|---------|---|-----------|--------------|
| #                       | Name                     | Criticality | Tol (-)                                  | Tol (+) | HTM Instruction   | 8         | 20           |
| 7                       | PKT1 OPENING on inner WB |             | 1/8                                      | 1/8     | Measure from finished edge to finished edge along pocket opening. | 2 3/4     | 2 1/4        |



|  |   |                                 |                                 |                            |
|--|---|---------------------------------|---------------------------------|----------------------------|
| lululemon  athletica | NAME : LW5GS2S - ALIGN PANT 25 IN GRAPHIC |                                 |                                 | SEASON : SP25              |
| DIVISION: WOMENS   | DATE CREATED : 26 OCT 2023                | DATE MODIFIED : 04 JANUARY 2024 | GRAPHIC DESIGNER : NICOLE ANSON | GARMENT SIZE : SIZE 8 ONLY |



正面  
FRONT

侧面  
SIDE

背面  
BACK

1

**APPLICATION:**

BI-COLOUR 'SANDWICH'  
SILICONE PRINT

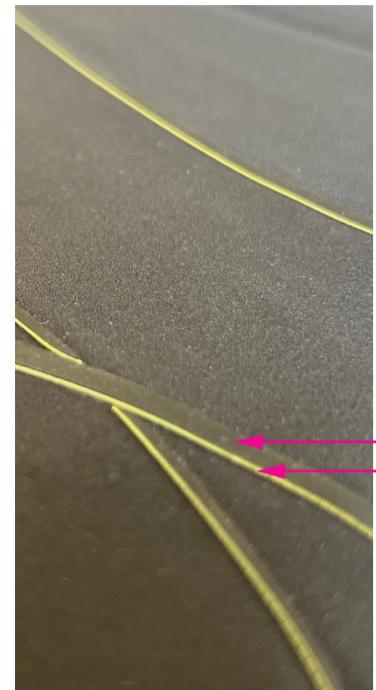
VENDOR: SABRINA

厚版硅膠印花

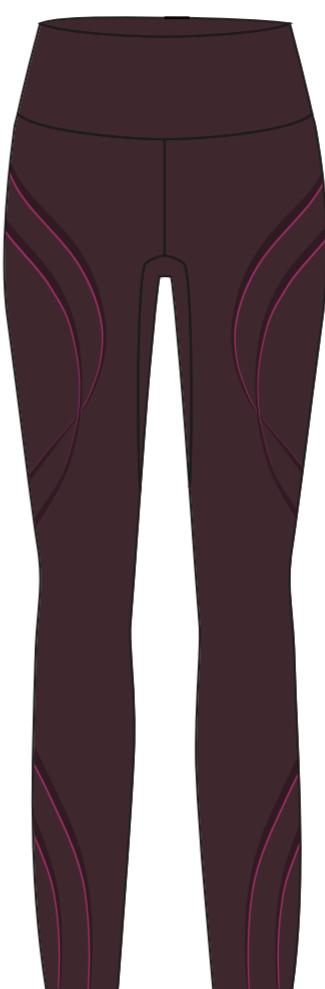
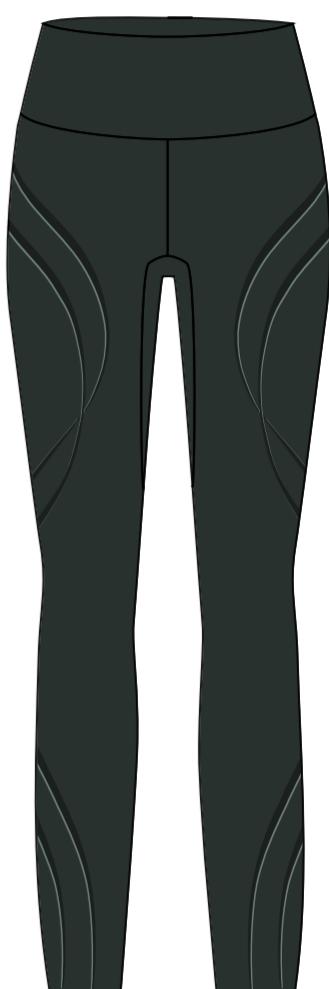


1



色組#1a  
Colourway 1a

TOP COLOUR  
漿料顏色  
  
'SANDWICH'  
COLOUR  
漿料顏色  


色組#1b  
Colourway 1b色組#2  
Colourway 2色組#3  
Colourway 3

GROUND:  
CSI: BLACK 大身色  


GROUND:  
CSI: BLACK 大身色  


GROUND: 大身色  
CSI: GOODNIGHT PLUM  


GROUND: 大身色  
CSI: RAINFOREST GREEN  


GRAPHIC:  
TOP COLOUR:  
BLACK 厚版硅膠印花漿料顏色  
19-0303 TCX  


GRAPHIC:  
TOP COLOUR:  
BLACK 厚版硅膠印花漿料顏色  
19-0303 TCX  


GRAPHIC:  
TOP COLOUR:  
WINETASTING  
19-2118 TCX 厚版硅膠印花漿料顏色  


GRAPHIC:  
TOP COLOUR:  
ROSIN 厚版硅膠印花漿料顏色  
19-0509 TCX  


'SANDWICH' COLOUR:  
BRANDIED APRICOT  
16-1610 TCX 厚版硅膠印花漿料顏色  


'SANDWICH' COLOUR:  
LIME PUNCH  
13-0550 TCX 厚版硅膠印花漿料顏色  


'SANDWICH' COLOUR:  
LILAC ROSE  
17-2227 TCX 厚版硅膠印花漿料顏色  



'SANDWICH' COLOUR:  
STORMY SEA  
18-4711 TCX 厚版硅膠印花漿料顏色  

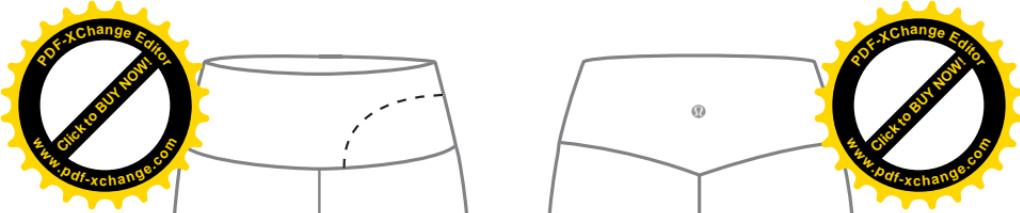

\*FULL SAMPLE\*  
P2樣裁片印花做此色組

\*STRIKE OFF\*  
提供印花部份縫

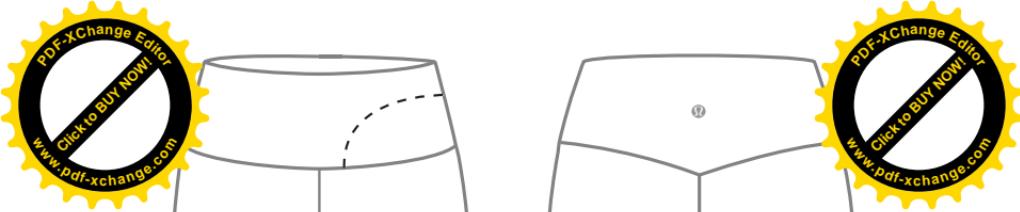
\*STRIKE OFF\*  
提供印花部份縫

\*STRIKE OFF\*  
提供印花部份縫





IGN PANT FU  
JLL LENGTH



FIT

High Rise, Tight, 28" Inseam

FABRIC

- (S) S-(BODY)
- (C1) C1-(WAISTBAND)
- (C2) C2-(GUSSET)

LINING

- (L1) L1- (POCKET BAG)

TRIMS

(logo) T00185N - Silver Reflective Lulu Logo, Hero Quality - 13mm (Effective SU15 and Onwards)

S=前腿接片/後腿接片

C1=前腰接片/後腰接片

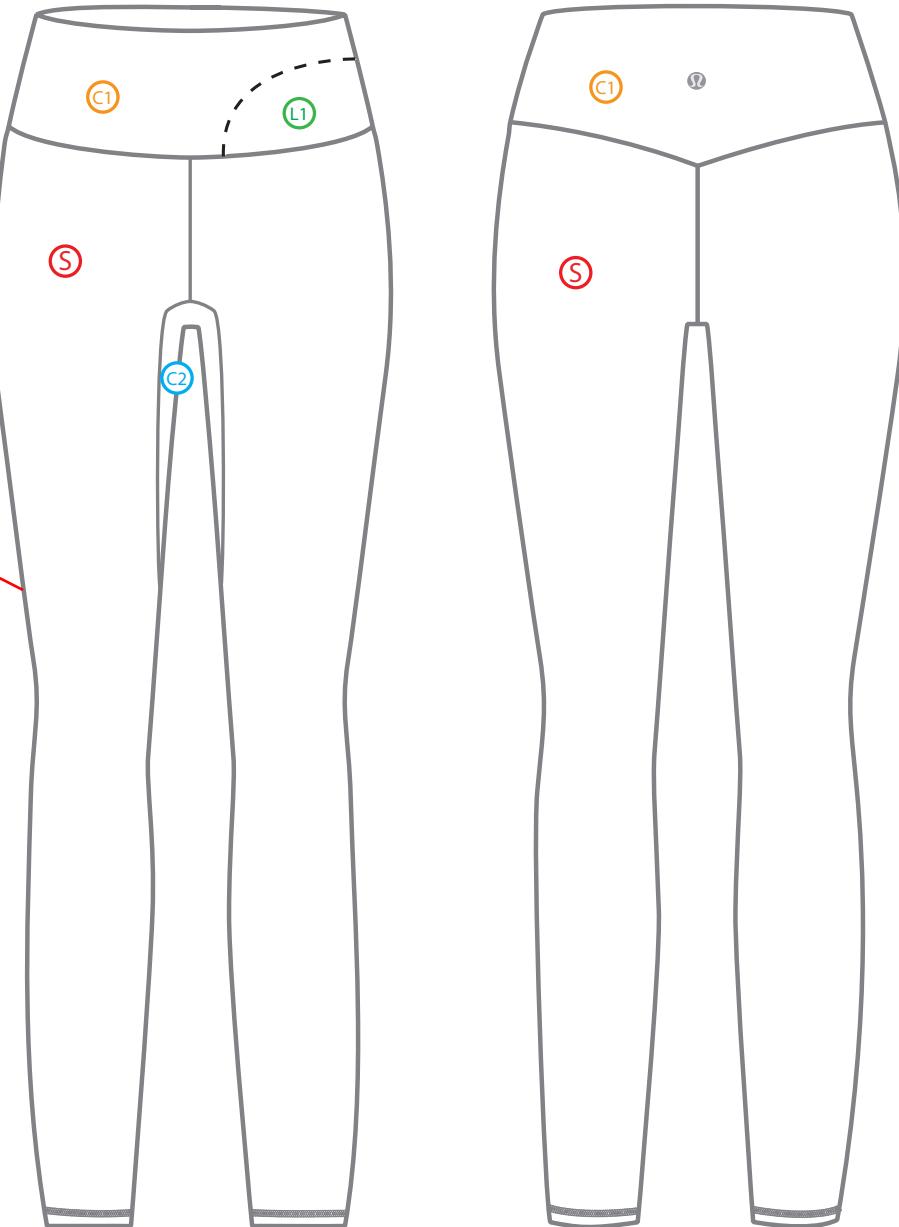
C2=襠底片

L1=前腰左側內貼口袋布 S=前腿接片/後腿接片

腰片折雙

前

後



TESTING

- add testing info

RISK LEVEL | Factory | IMU\_

DESIGNER:

D.A.:

DEVELOPER: MEGAN; FIT: LING

DATE: JULY 5TH 2019

腰片折双

Waistband on fold

- 1 (607)=四針六線併縫(SPI 18): 腰側縫/ 前後襠縫/ 內長/ 跨下接縫
  - 2 (514)=四線拷克(SPI 16): 腰圍接縫
  - 6 (605)=三針五線爬網(SPI 18): 腰圍接縫/褲口
  - 7 (602)=窄針爬網(SPI 18): 袋口
- \*襠底回針規定=回針位置統一回在併縫的第二道

STITCH LEGEND:

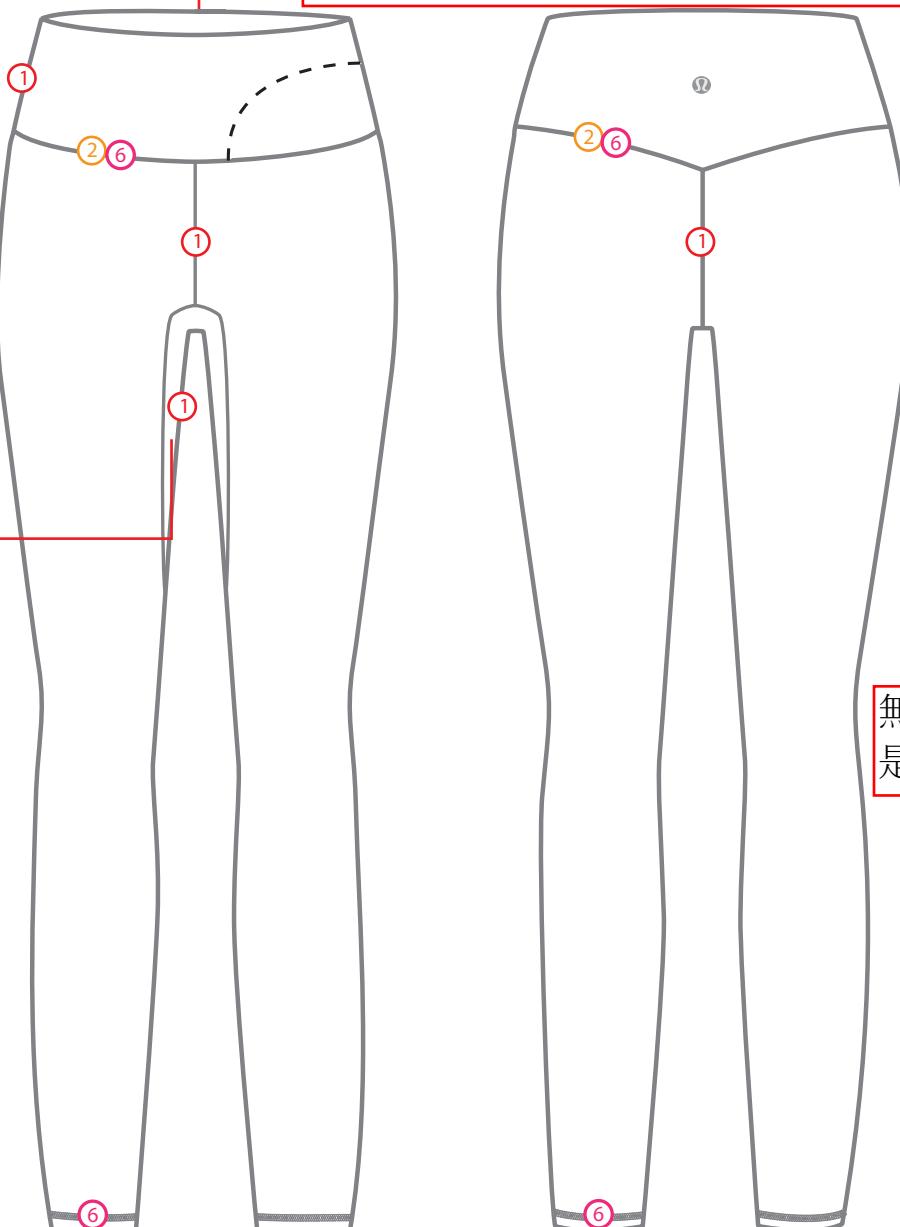
- ① (607): flatlock 4N6T
- ② (514): 4 thread serge (2N4T overedge)
- ③ (406): 2 needle bottom coverstitch 1/4"
- ④ (406): 2 needle bottom coverstitch 1/8"
- ⑤ (407): 3 needle bottom cover stitch
- ⑥ (605): 3 needle 5 thread coverstitch
- ⑦ 602): mini mock
- ⑧ (321): 3 step zig zag stitch 1/4"
- ⑨ (321): 3 step zig zag stitch 1/8"
- ⑩ (308): 2 step zig zag 1/8" (on bindings only)
- ⑪ (401): single needle chain stitch
- ⑫ (301): single needle lockstitch
- ⑬ (516): 5 thread serge w/ safety stitch
- ⑭ (504): 3 thread serge
- ⑮ 505): baby serge
- ⑯ (304): zig zag lockstitch (1 step zig zag) 1/8"
- ⑰ fall & winter 2016 scallop stitch
- ⑱ (605): 3 needle coverstitch with 4.8mm spacing  
'narrow coverstitch' with single lap construction
- ⑲ (607) 3needle flatlock

BONDING APPLICATION LEGEND:

- A Overlap seam
- B Fold over
- C Ultrasonic
- D Ultrasonic roller cut edge
- E Component bonding
- F Topical decorative
- G Multi Modulus
- H Bonded rib
- J Vivid edge

長條型襠底蓋大身

See updated  
PDF for Gusset  
Sequence of  
Construction

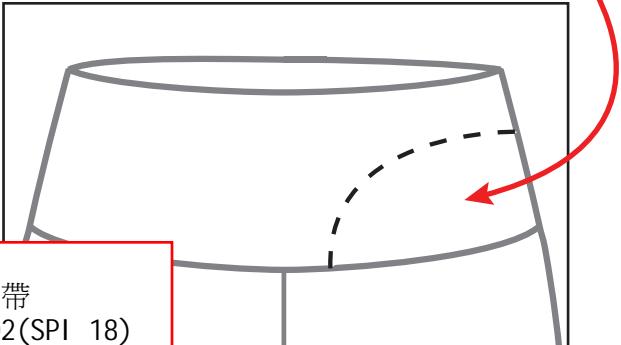


## INSIDE WAISTBAND POCKET CONSTRUCTION

### DETAILS:

內貼口袋(前腰頭左內側)

pocket (inside the WB)



INSIDE WAISTBAND POCKET CONSTRUCTION

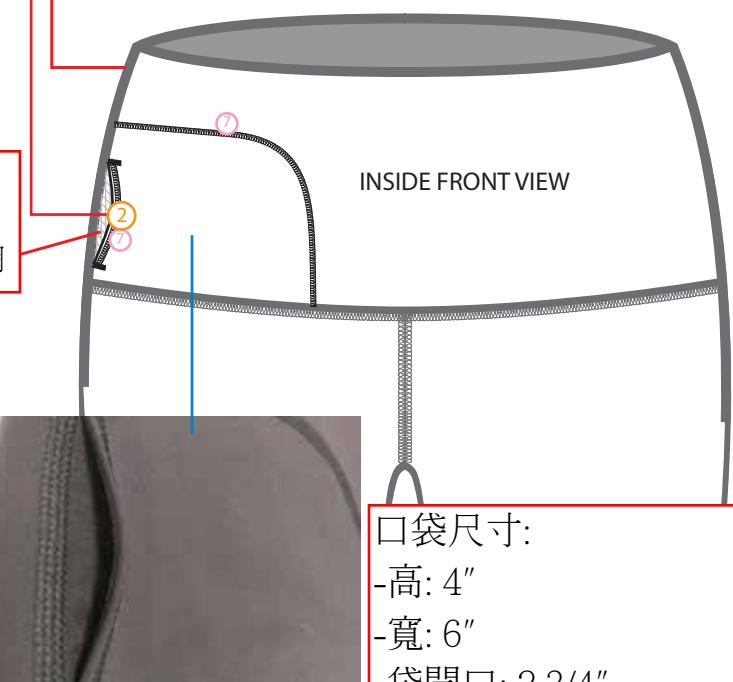
穿者左側內貼口袋開口:  
-袋口邊反折夾車透明版帶  
-袋口邊車四線拷克+#602(SPI 18)  
窄針爬網  
-袋口兩端車橫向1/4"打結穿透到內層口袋布和縫份

Inside Wearer's Left Pocket Opening:  
- Clip opening to turn back pocket hem.  
- Sandwich mobilon elastic between pocket hem  
- Edgestitch pocket hem with 602 minimock stitch  
1/4" from center of logo

穿者左側內貼口袋:  
-單層口袋布夾車到腰頭內貼接片，  
周圍壓縫# 602(SPI 18)窄針爬網

Inside Wearer's Left Pocket:  
- Single layer pocket bag attached to inside waistband panel with 1/8" 602 minimock stitch

Pocket size:  
Height: 4"  
Width: 6"  
Opening: 2 3/4"  
reference: FA15 LW5K63S

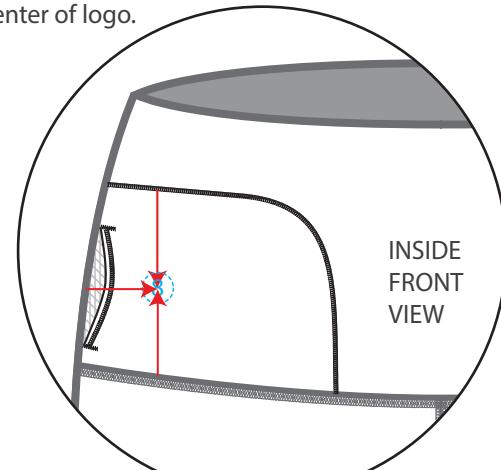


口袋尺寸:  
-高: 4"  
-寬: 6"  
-袋開口: 2 3/4"  
參考:FA15 LW5K63S

### SIZE LABEL PLACEMENT

Size label description: heat transfer

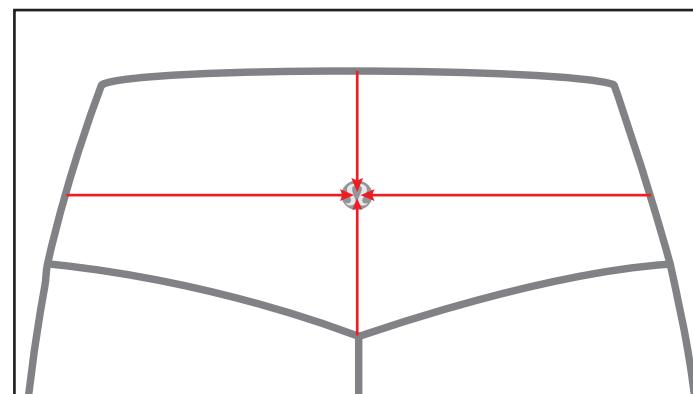
- Place at inside pocketbag
- Center vertically to center of logo
- Horizontally place 2" from pocket opening to center of logo.



熱轉印LOGO標位置@穿者的後腰中接片處  
-接片水平和垂直置中處,量到標中間

### Logo Placement:

- Center Vertically and Horizontally on waistband to center of logo

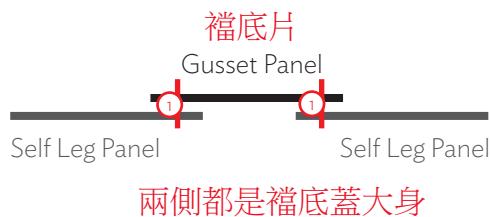


## STRAIGHT PANELLED GUSSET:



## 裁片擺放順序

## SEQUENCE OF CONSTRUCTION:



\*Please note that this will apply to all Align styles with **straight panelled gusset**\*

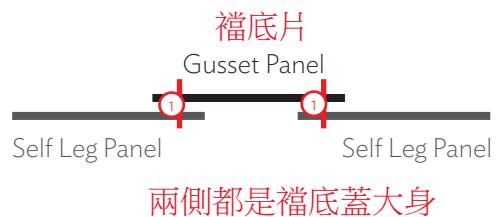
## 長褲 / 七分褲款式

## TAPERED PANELLED GUSSET:



## 裁片擺放順序

## SEQUENCE OF CONSTRUCTION:



\*Please note that this applies to all Align styles with **tapered panelled gusset**\*