



Relationships

Relationship	Product
Colorway Product	B252 Boys RL White/Dyed & Dunk Stripe Exp WB OE Brief (Colorways BW)
Pattern Product	T0409 Boys--Size:XS-2X Rib - Body 1x1 Brief (Innerwear Boys Patterns)
Label Product	LP 10056 Boys' Underwear Hanes Comfort Flex Tagless Btm (Mkt-Boys' UW Garment Labels)
Selling Product	SP- 21813 - B252P6 - P 6 - White Alpha Brief (BW Active Year)

Report

 Name



Construction

001 : KB001A-Exposed WB brief w/ front panel, bound fly/legs

Measurements

001 : T0409A FGM

Colorways

Colorways by Group

Colorway Group	Colorway Name
Basic Heathers	(LCU) CW 15042 B252 Grey Heather
Basic Heathers	(LFU) CW 15045 B252 Mid Blue Heather
Basic S14 Dunk Stripes	(11U) CW 15050 B252 B-DS-SP14-2
Basic S14 Dunk Stripes	(10U) CW 15051 B252 B-DS-SP14-1
Basic S14 Dunk Stripes	(13U) CW 15053 B252 B-DS-SP14-4
Basic S14 Dunk Stripes	(12U) CW 15052 B252 B-DS-SP14-3
Basic S14 Dunk Stripes	(WYU) CW 15054 B252 B-DS-SP14-10
Basic S15 Dunk Stripes	(3LU) CW 17072 E-DS-SP15-03 B252
Basic S15 Dunk Stripes	(3JU) CW 17074 E-DS-SP15-01 B252
Basic S15 Dunk Stripes	(3KU) CW 17075 E-DS-SP15-02 B252
Basic S15 Dunk Stripes	(3MU) CW 17073 E-DS-SP15-04 B252
Basic Solids	(EUU) CW 16181 Royalty Blue B252
Basic Solids	() CW 17076 Kiwi Ice B252
Basic Solids	() CW 17853 Best Red B252
Basic Solids	() CW 16191 White B252 w/Grey Elastic
Basic Solids	() CW 17793 Optical Blue B252
Basic Solids	(06U) CW 15044 B252 Black
Basic Solids	(WHU) CW 15015 B252 White

Measurements

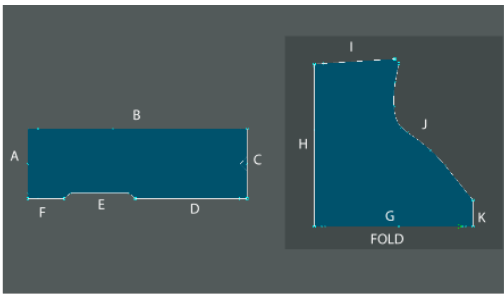
POM Number	Measurement Name	Placement Amount	Placement Reference	Plus Tolerance	Minus Tolerance	HTM Instructions	Comments	XS	S	M	L	XL	2X
200a	Waist - at top (half)			0.75	0.75		kids (c1) tolerance	9.25	10.25	11.0	12.0	13.0	13.5
200x	Min. Waist - Extended (half)			99.0	0.0			13.5	14.75	16.0	17.5	19.0	19.75
300	Waistband Width / Height			0.25	0.25		(c1) tolerance	1.25	1.25	1.25	1.25	1.25	1.25
210	Rise/Trunk Length - Flat			0.75	0.75		kids (c1) tolerance	9.0	9.5	10.5	11.375	12.125	12.75
210a	Front Rise - Top of Waistband			0.75	0.75		kids (c1) tolerance	10.625	11.125	12.125	13.0	13.75	14.375
211a	Back Rise - Top of Waistband			0.75	0.75		kids (c1) tolerance	7.375	7.875	8.875	9.75	10.5	11.125
215	Fly Length			0.25	0.25	.		2.75	3.0	3.25	4.0	4.75	5.25
215b	Fly Position			0.25	0.25			1.75	1.875	2.0	2.125	2.125	2.125
243	Panel Width - 4" Down (front or back)	4		0.5	0.5		(c1) tolerance	3.5	3.625	3.75	4.0	4.25	4.375
245b	Crotch Width - At Seam (front or back)			0.25	0.25			3.875	4.0	4.125	4.375	4.625	4.75
202e	Seat - At Top of Leg (half)			0.75	0.75		kids (c1) tolerance	8.625	9.625	10.625	11.75	12.875	13.375
206a	Leg Opening - At Edge (half)		Inseam 0-2	0.5	0.5		short-kids (c1) tolerance	6.125	6.75	7.375	8.375	9.25	9.875
206x	Min. Leg Opening - Extended (half)		Inseam 0-2	99.0	0.0			7.875	8.75	9.5	10.25	11.0	11.375
209a	Outseam - Top of Waistband		Inseam 0-2	0.5	0.5		short-kids (c1) tolerance	4.375	4.625	5.125	5.375	5.5	5.625
302	Leg Trim / Binding Width / Height			0.125	0.125			0.5625	0.5625	0.5625	0.5625	0.5625	0.5625
302	Fly Trim / Binding Width / Height			0.125	0.125			0.3125	0.3125	0.3125	0.3125	0.3125	0.3125

Constructions

Sewing Operation	Stitch Type / Description	Gauge Width	SPI	Seam/Trimoff Allowance	Garment Use	Needle Thread	Needle Visibility	Looper Thread	Looper Visibility	Comments
Seam waist elastic with latch-tack.	503 2 thread overedge	12gg / 4.8mm	25 min	1/8" trimoff	Waist	T18 Txt Poly	Side B	T18 Txt Poly	Side A/B	
Bind fly.	406 2N bottom coverstitch	8gg / 3.2mm	10	folder 1T-5/16" finish binding	Fly	T18 Txt Poly	Side A	T18 Txt Poly	Side B	
Seam panel with tape.	607 4N flatseam-no topcover	16gg / 6.4mm	10	1/4" trimoff	Tape	T18 Txt Poly	Side A	T18 Txt Poly	Side B	
Bind legs with elastic/rubber.	406 2N bottom coverstitch	8gg / 3.2mm	12	folder 1T-9/16" finish binding	Leg	T24 Txt Poly	Side A	T18 Txt Poly	Side B	
Attach exposed elastic to waist.	407 3N bottom coverstitch	16gg / 6.4mm	12	5/16" overlap; 1/4" trimoff	Waist	T24 Txt Poly	Side A	T18 Txt Poly	Side B	
Flatseam crotch.	607 4N flatseam	16gg / 6.4mm	14	1/4" overlap; 1/4" trimoff	Body	T18 Txt Poly	Side A	T18 Txt Poly	Side B	
Set garment label (heat transfer) centered over band seam.	N/A	N/A	N/A	N/A		N/A		N/A		
APPROVED ALTERNATES:										
Alternate seaming to be used only where 607 flatseam is not available due to capacity (Requires prior approval).										
Attach pieces.	504 3 thread overedge	8gg / 3.2mm	12	3/8"; 1/4" trimoff		T18 Txt Poly	Side B	T18 Txt Poly	Side B	
Topcover seams.	605 3N topcover	16gg / 6.4mm	12	no trimoff		T18 Txt Poly	Side A	T18 Txt Poly	Side B	

Documents

002 : Measurements - T0409A PMEAS



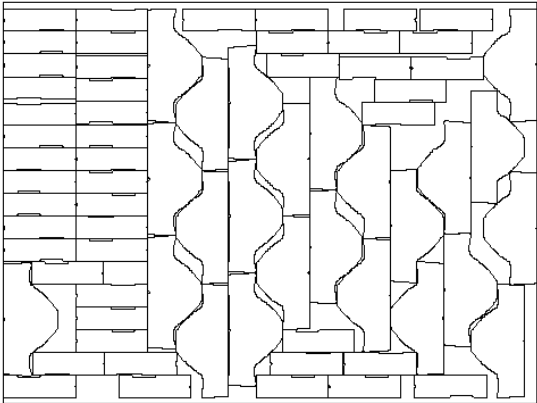
=Seasonal Sizes

Piece Name:	Pcs Per Gmt:	Name	XS	S	M	L	XL	2X
T0409AFT	2	A	3"16	3"20	3"24	4"	4" 8	4"12
		B	10"10	10"26	11"26	12"22	13"14	14" 3
		C	3"16	3"20	3"24	4"	4" 8	4"12
		D	5" 9	5"13	6" 1	6" 1	6" 1	6" 5
		E	3"18	3"27	4" 2	4"27	5"18	6" 2
		F	1"23	1"27	1"31	2" 3	2" 3	2" 3
T0409ABK	1	G	7" 1	7"17	8"17	9"13	10" 5	10"25
		H	6"31	7"29	8"23	9"23	10"21	11" 5
		I	3"19	3"27	4"11	4"19	4"23	4"27
		J	7" 2	8"	9" 2	10" 8	11"15	12" 6
		K	1" 9	1"10	1"13	1"18	1"22	1"24

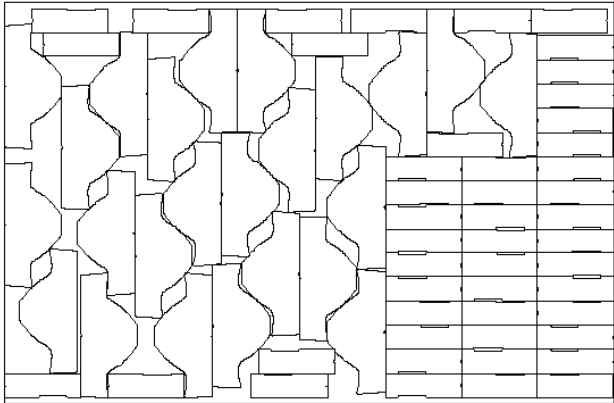
Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

004 : Marker Layout - T0409A-60 FT,BK-70.5

T0409A2L

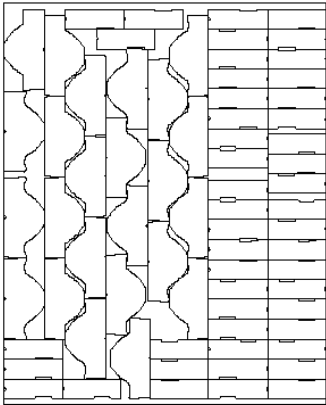


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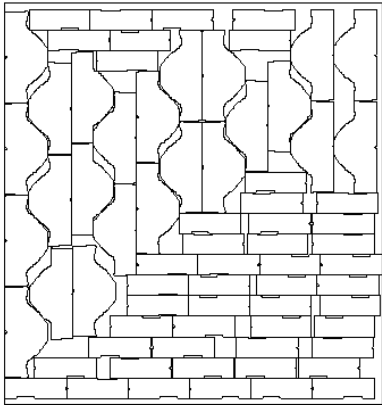


004 : Marker Layout - T0409A-60 FT,BK-70.5

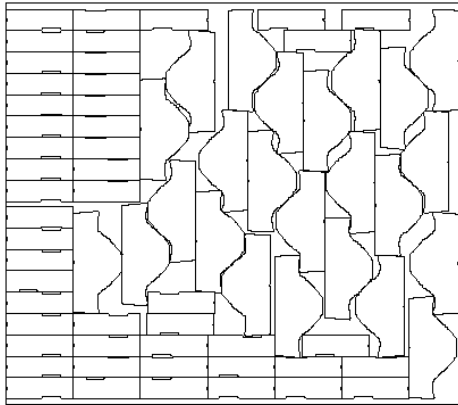
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T0409A2S

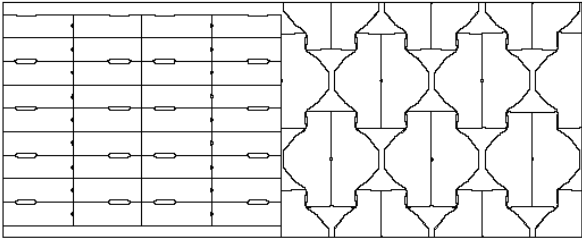


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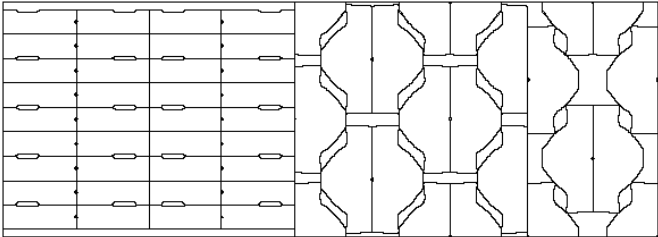


006 : Marker Layout - T0409A-60 FT,BK-35

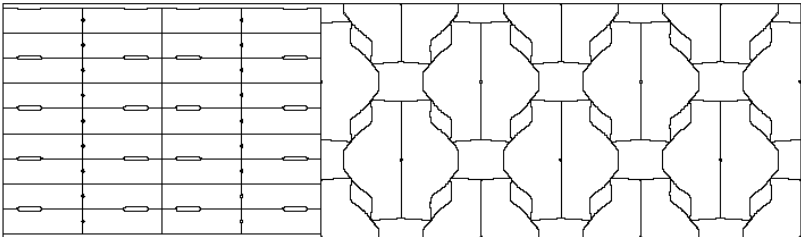
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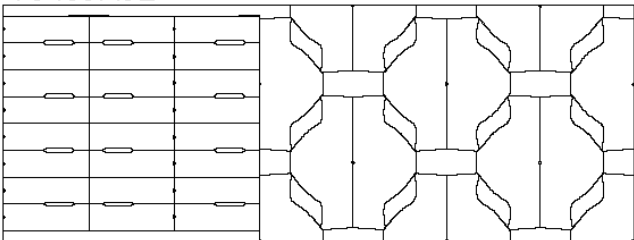
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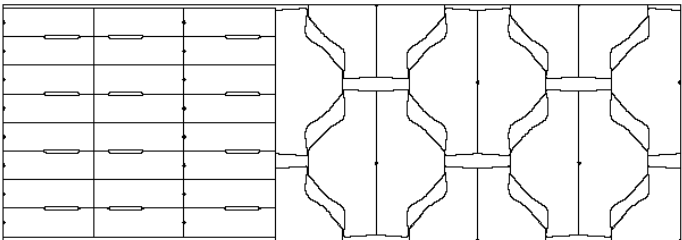
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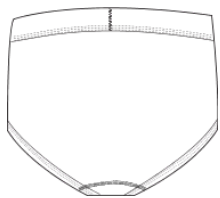
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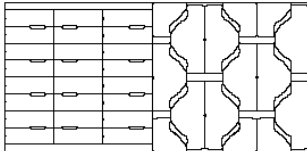


001 : Front/Back Image - Boys Ctn Knit Rib ExpWB

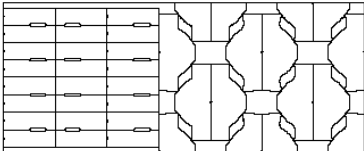


005 : Marker Layout - T0409A-60 FT,BK-31

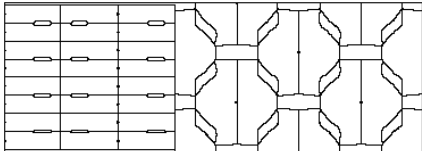
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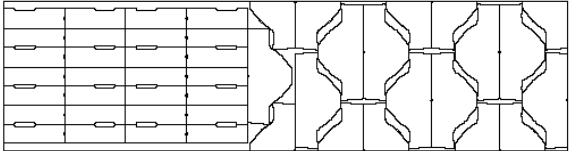


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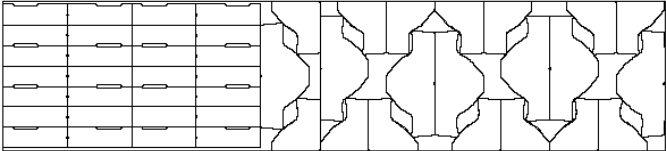


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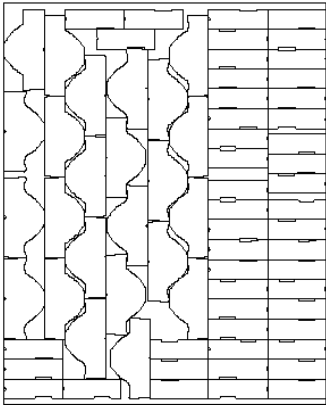


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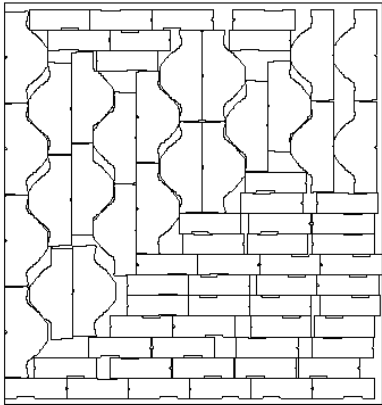


004 : Marker Layout - T0409A-60 FT,BK-70.5

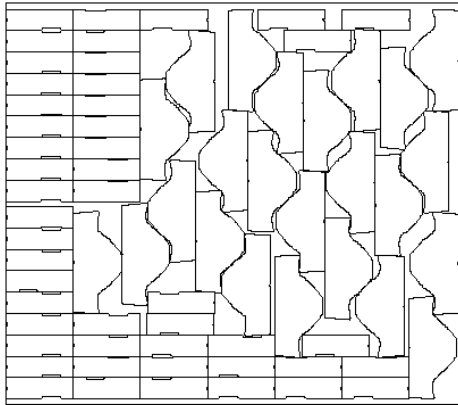
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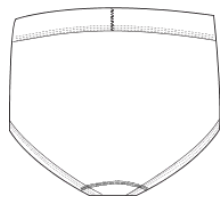
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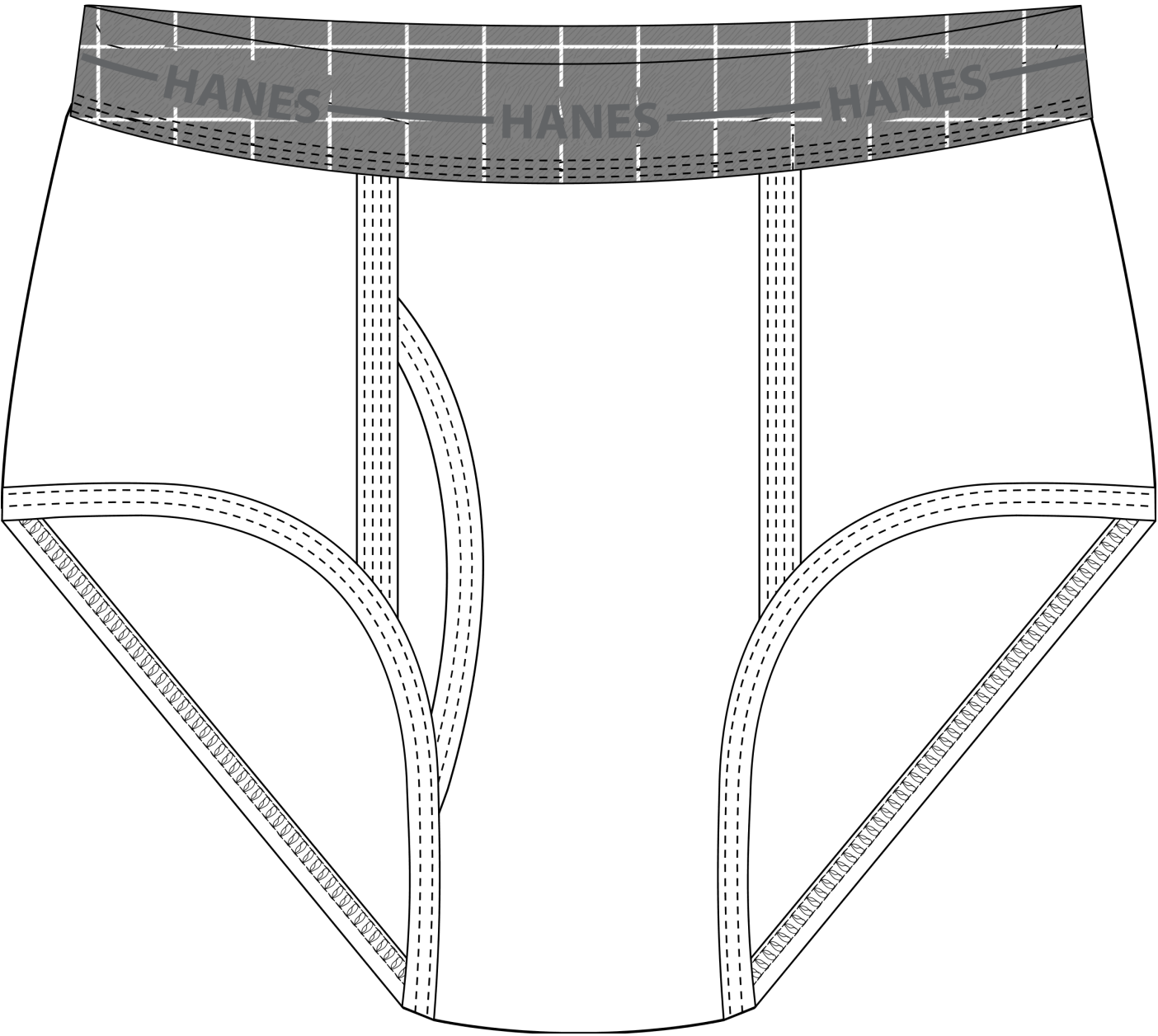


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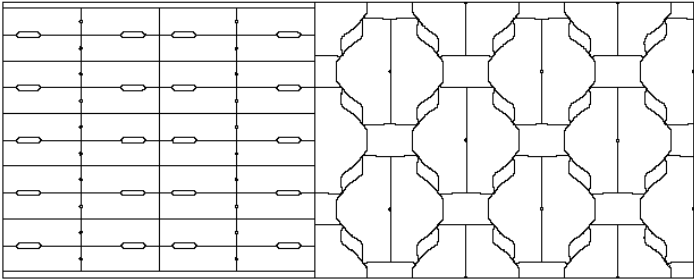
001 : Front/Back Image - Boys Ctn Knit Rib ExpWB



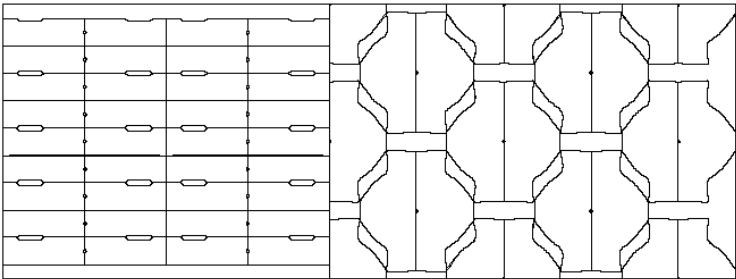


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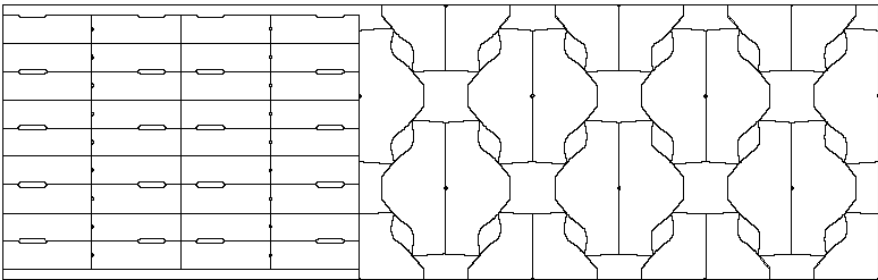
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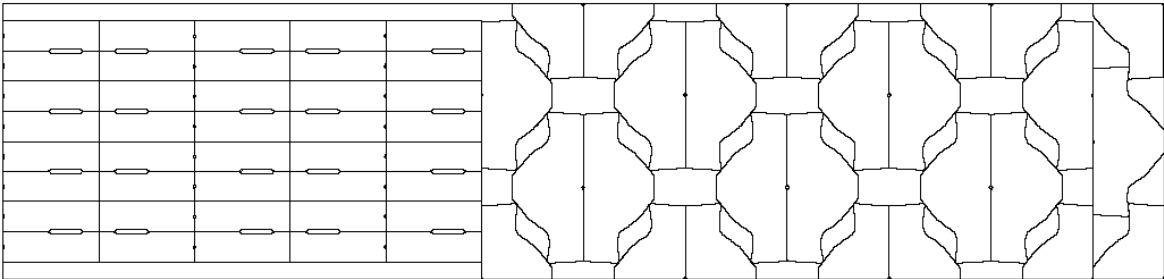
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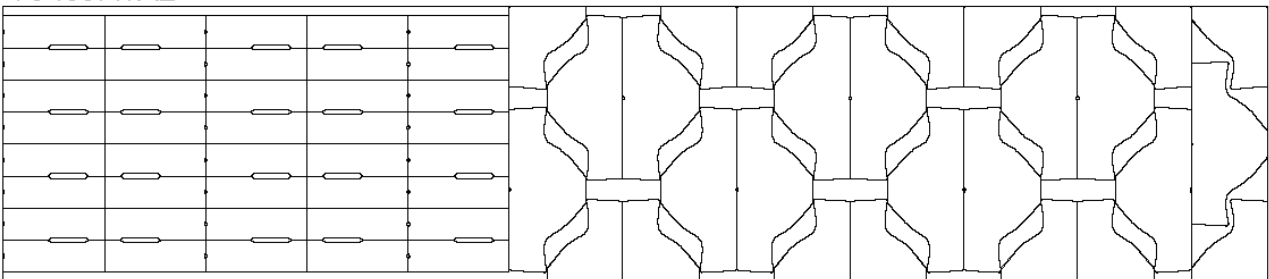
T0409A1M



T0409A1L

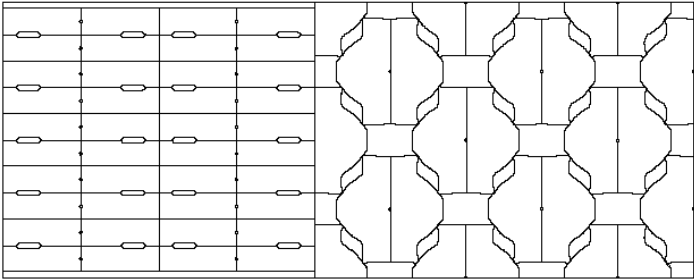


T0409A1XL

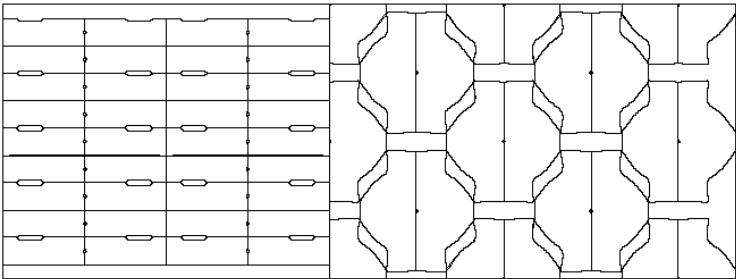


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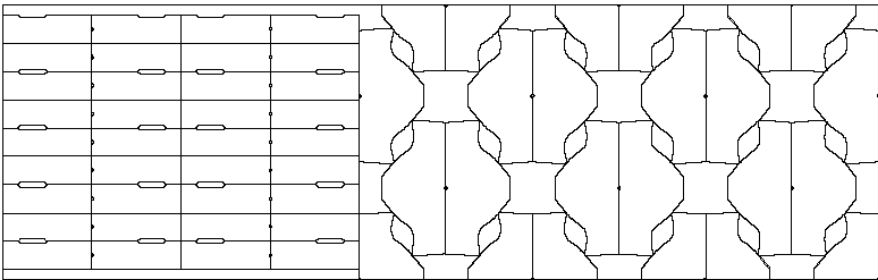
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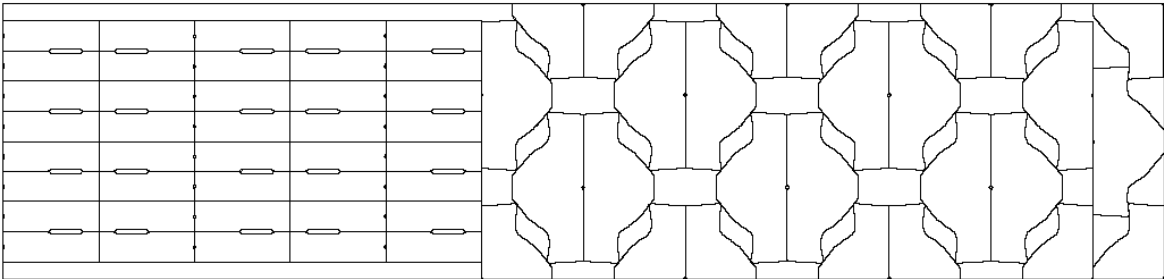
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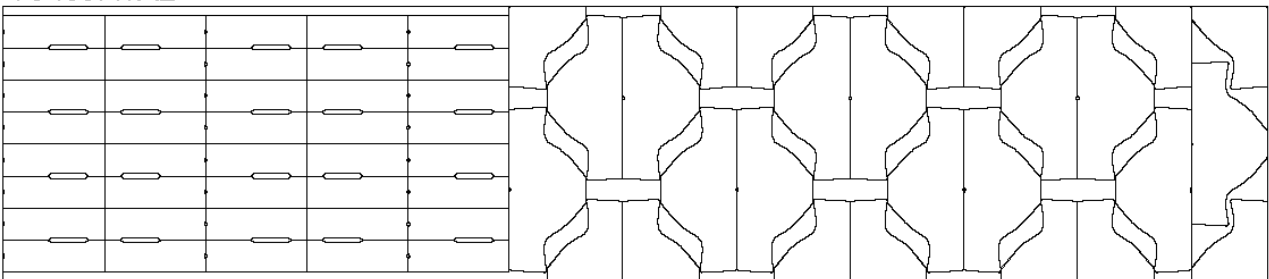
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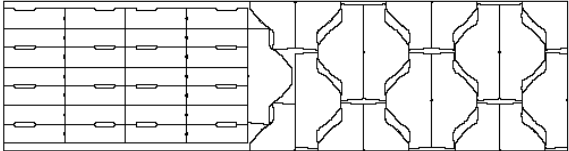


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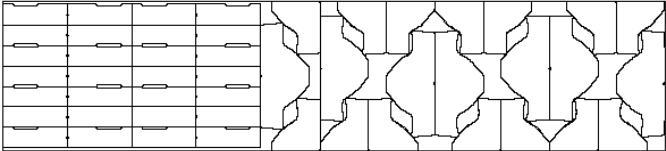


005 : Marker Layout - T0409A-60 FT,BK-31

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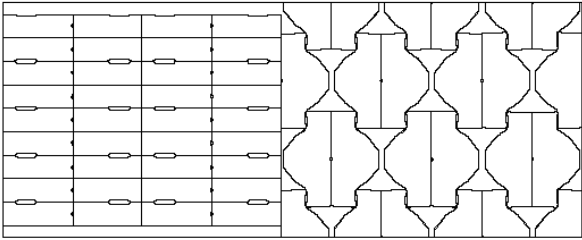


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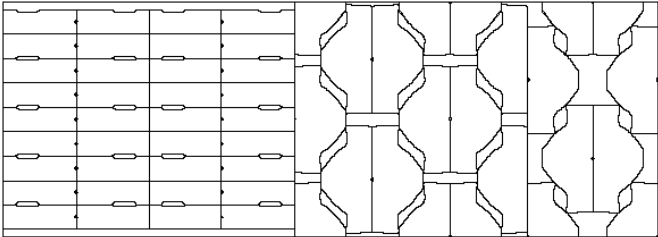


006 : Marker Layout - T0409A-60 FT,BK-35

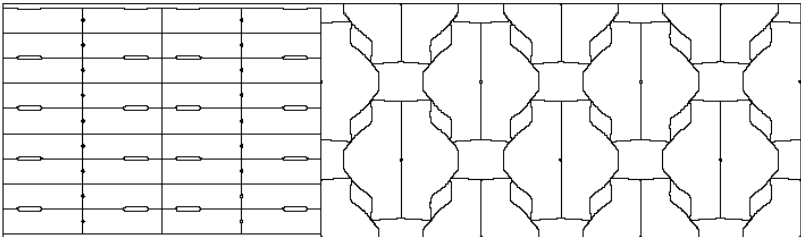
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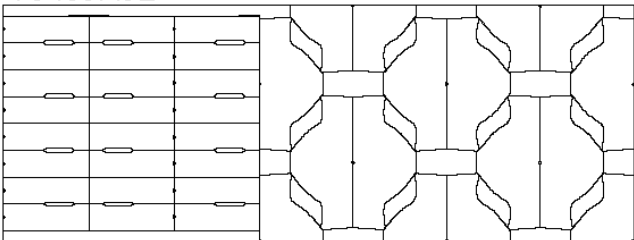
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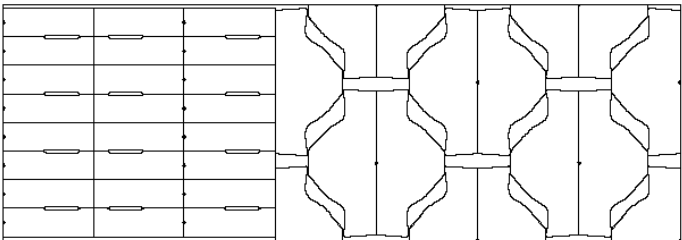
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T0409A5L



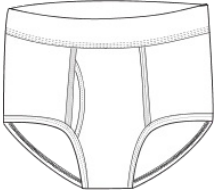
T0409A5XL



003 : Front/Back Image - Flow in Elastic GP10188 Exposed Elastic Brief



001 : Front/Back Image - Boys Ctn Knit Rib ExpWB

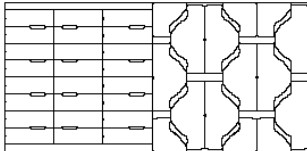


001 : Front/Back Image - Boys Ctn Knit Rib ExpWB

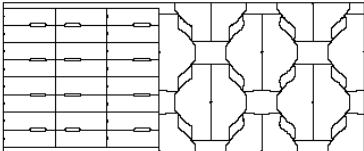


005 : Marker Layout - T0409A-60 FT,BK-31

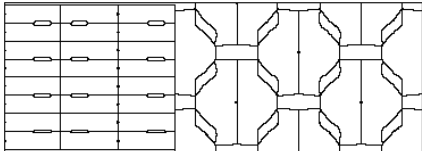
T0409A4XS



T0409A4S

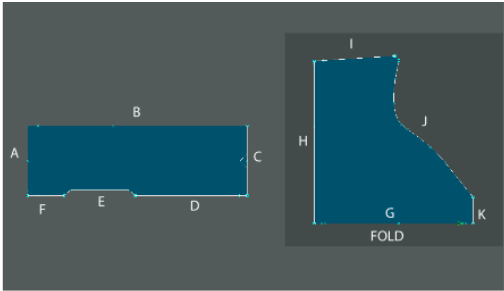


T0409A4M





002 : Measurements - T0409A PMEAS

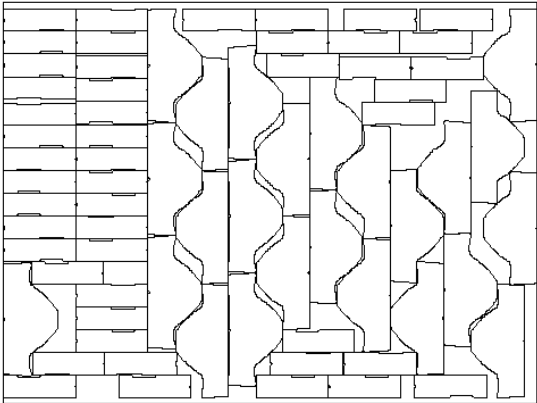


=Seasonal Sizes

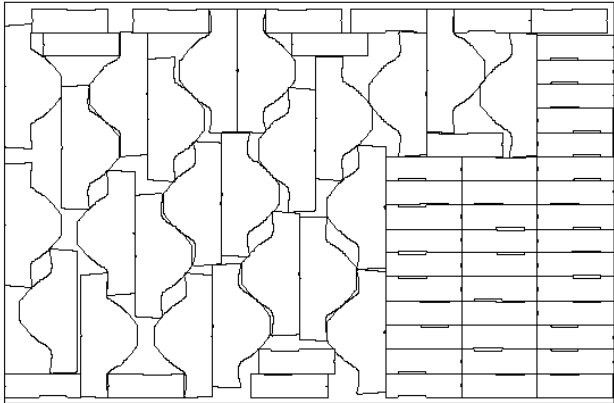
Piece Name:	Pcs Per Gmt:	Name	XS	S	M	L	XL	2X
T0409AFT	2	A	3"16	3"20	3"24	4"	4" 8	4"12
		B	10"10	10"26	11"26	12"22	13"14	14" 3
		C	3"16	3"20	3"24	4"	4" 8	4"12
		D	5" 9	5"13	6" 1	6" 1	6" 1	6" 5
		E	3"18	3"27	4" 2	4"27	5"18	6" 2
		F	1"23	1"27	1"31	2" 3	2" 3	2" 3
		G	7" 1	7"17	8"17	9"13	10" 5	10"25
T0409ABK	1	H	6"31	7"29	8"23	9"23	10"21	11" 5
		I	3"19	3"27	4"11	4"19	4"23	4"27
		J	7" 2	8"	9" 2	10" 8	11"15	12" 6
		K	1" 9	1"10	1"13	1"18	1"22	1"24

Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

T0409A2L



T0409A2XL



007 : Pattern Information - T0409A

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Sprd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	BK	EV	fabric	Fab. cat.	Message	acd	comment	sym.
1	T0409BFT	0	2	0	1	1	S13	FT	8% x 5% shrink allow	0
3	T0409BKK	0	1	0	1	1	S13	BK	Boys Brief Exp Elas. 04-30-12	0
2	T0409BKE	0	1	0	5	1	S13	EKF	sample use	0
4	T0409BFT	0	1	0	2	1	R0P	FT	8% x 5% shrink allow	0
5	T0409BKK	1	0	0	2	1	R0P	BK	Boys Brief Exp Elas. 04-30-12	0

Pattern Allowances:

- Fly Length -1/8
- Fly Position -1/4
- Trim- Straight Cut - Fly and Panel Tubing
- Leg Opening 98%
- Crotch Width -3/8
- Trim- Bias Cut - Leg Binding

003 : Front/Back Image - Flow in Elastic GP10188 Exposed Elastic Brief

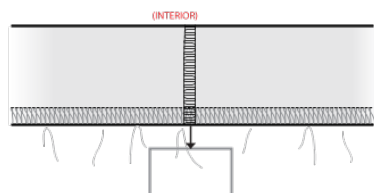
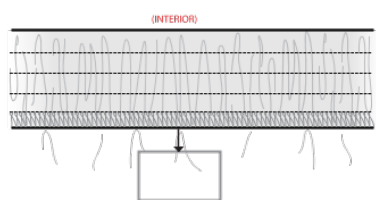


005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)

LP006: Inside Waist (no CB seam)

Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design

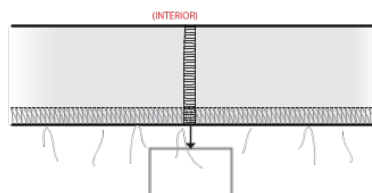
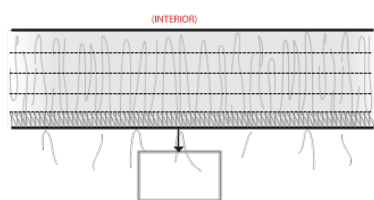


005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)

LP006: Inside Waist (no CB seam)

Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design



007 : Pattern Information - T0409A

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Sprd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	BK	EV	fabric	Fab. cat.	Message	acd	comment	sym.
1	T0409BFT	0	2	0	1	1	S13	FT	8% x 5% shrink allow	0
3	T0409BKK	0	1	0	1	1	S13	BK	Boys Brief Exp Elas. 04-30-12	0
2	T0409BKE	0	1	0	5	1	S13	EKF	sample use	0
4	T0409BFT	0	1	0	2	1	R0P	FT	8% x 5% shrink allow	0
5	T0409BKK	1	0	0	2	1	R0P	BK	Boys Brief Exp Elas. 04-30-12	0

Pattern Allowances:

- Fly Length -1/8
- Fly Position -1/4
- Trim- Straight Cut - Fly and Panel Tubing
- Leg Opening 98%
- Crotch Width -3/8
- Trim- Bias Cut - Leg Binding

