

Product Revision Attributes

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Mfg Style Addition	0	0	Robert Williamson	New MFG # A40N and Fabric for purchased fabric JE1220, Load MFG# for A40N garment colors Solids BKF, WHF,3AF; FASHION RKF, T1F, 27F, 28F, 1JF,53F, 57F,ODF, 2TF, and Add print (FO) for MFG# 400N	2016-02-21
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Fabric Addition	0	0	AnneMarie Pembaur	Cut Bom Change	2016-02-08
G0466 Women's Numeric--Size:4-13 Jersey Brief	001	Fabric Addition	Updated Marker Image Page	0	AnneMarie Pembaur	Updated Marker images	2016-02-08
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Sourced BOM Change	0	0	AnneMarie Pembaur	Added Sourced BOM	2016-02-02
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Label Change	0	0	Diana Rothwell	Updated MANUFACTURED LABELS page.	2016-01-31
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Addition	0	0	Diana Rothwell	@120664 / (20 colors) / Fall 2016 COLORS/ PRINTS	2015-12-22
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	0	0	0	Diana Rothwell	ADDED PLANT (95) to be LOADED with mfg# 40AB ALL COLORS	2015-10-20

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Change	0	0	Diana Rothwell	DYE CODES upgraded to WICKING	2015-09-23
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Addition	0	0	Diana Rothwell	@ 107491, 107760 (39 colors) - Spring '16 COLORS/PRINTS / Plant Addition (95)	2015-07-22
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Cut BOM Change	Fabric Addition	0	Cara Christiansen	Added 8813 fabric with 009 finish	2015-05-10
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Addition	0	0	Diana Rothwell	(1 color) - LOAD Solid (NU - Nude) w/MFG# 40AB	2015-03-24
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Addition	0	0	Diana Rothwell	@91943 & 93650 (40 colors) - Fall '15 COLORS/PRINTS. Load COLORS ONLY with MFG# 400N, 40AB, HN40 / Updated ELASTIC usage & BINDING block weight.	2015-02-19
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Colorway Change	0	0	Robert Williamson	Spring '15 COLORS/PRINTS Solid (0N, U6, XH) Print (DA, DB, D2, D3) with MFG# 40AB	2014-12-08
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Updated to PLM format	Cut BOM Change	Sew BOM Change	Robert Williamson	Upadetd spec into PDF format and update to revise Leg rubber and Elastic usage for all colors and updated leg binding calaculation to Standard	2014-08-27
G0466 Women's Numeric--Size:4-13 Jersey Brief		Updated to PLM format	Sew BOM Change	0	bishawky (deleted)	Updated Leg Rubber and Waist Elastic Calculation	2014-08-26

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
1400 Womens Knit Brief Low Rise, ExpWB, Crotch Panel	001	Updated to PLM format	0	0	Tony Truong		2013-06-30
G0466 Women's Numeric--Size:4-13 Jersey Brief	001	Updated to PLM format	Cut BOM Change	Sew BOM Change	Tony Truong	Corrected binding typos on cut method code and runoff allowances. Took binding, elastic, and rubber calaculations to standard format- elastic/ rubber usages slightly reduced and binding usage slightly increased.	2013-06-30

Sizing Table

Garment Size	Size Code
4/XS	30
5/S	31
6/M	32
7/L	33
8/XL	34
9	35
10	36
11	37
12	38
13	39

Approved Suppliers

Supplier	Mfg Flow	Green Seal	Red Seal	Comments
-- HBI Make	Internal	01-JUL-13	01-JUL-13	
R3 BEST IN	Source Cut Parts	01-JUL-13	01-JUL-13	

Construction

Sewing Operation	Stitch Type / Description	Gauge Width	SPI	Seam/Trimoff Allowance	Garment Use	Needle Thread	Needle Visibility	Looper Thread	Looper Visibility
Attach crotch panel and liner to front and back.	504 3 thread overedge	8gg / 3.2mm	12	3/8"; 1/4" trimoff	Body	T18 Txt Poly	Side B	T18 Txt Poly	Side B
Bind legs with elastic/rubber. Seams allowed.	406 2N bottom coverstitch	8gg / 3.2mm	12	folder 1T-3/8" finish binding	Leg	T24 Txt Poly	Side A	T18 Txt Poly	Side B
Seam wearer's left side with latch tack at leg.	504 3 thread overedge	8gg / 3.2mm	16	3/8"; 1/4" trimoff	Body	T18 Txt Poly	Side B	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
Seam wearer's right side with latch tack at leg and waist.	504 3 thread overedge	8gg / 3.2mm	16	3/8"; 1/4" trimoff	Body	T18 Txt Poly	Side B	T18 Txt Poly	Side B
Set garment label. See placement details for additional information.	N/A	N/A	N/A	N/A		N/A		N/A	

Measurements

POM#	Measurement Name	Tol (+)	Tol(-)	4	5	6	7	8	9	10	11	12	13
200a	Waist - at top (half)	1.0	1.0	10.375	11.125	12.0	12.875	13.625	14.5	15.25	16.125	17.0	17.75
200x	Min. Waist - Extended (half)	99.0	0.0	19.5	20.5	21.5	23.0	25.0	27.0	28.0	29.0	30.0	31.0
300	Waistband Width / Height	0.25	0.25	0.8125	0.8125	0.8125	0.8125	0.8125	0.8125	0.8125	0.8125	0.8125	0.8125
210e	Front Rise-Fold Contour	1.0	1.0	7.5	8.0	8.5	9.0	9.375	9.875	10.375	10.875	11.25	11.75
211e	Back Rise-Fold Contour	1.0	1.0	10.875	11.375	11.875	12.375	12.75	13.25	13.75	14.25	14.625	15.125
245a	Crotch Width - at Narrowest Point	0.25	0.25	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
245b	Crotch Width - At Seam (front)	0.25	0.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25
245b	Crotch Width - At Seam (back)	0.25	0.25	6.0	6.0	6.0	6.0	6.25	6.25	6.25	6.25	6.5	6.5
246	Crotch Length-Fold Contour	0.5	0.5	5.5	5.5	5.5	5.5	5.75	5.75	5.75	5.75	6.0	6.0
202g	Hip / Seat - Folded-Top of Leg (half)	1.0	1.0	14.0	15.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0
206a	Leg Opening - At Edge (half)	0.75	0.75	8.625	9.125	9.625	10.125	10.625	11.125	11.625	12.125	12.625	13.125
206x	Min. Leg Opening - Extended (half)	99.0	0.0	11.625	12.125	12.625	13.375	14.375	15.5	16.0	16.625	17.125	17.75
209a	Outseam - Top of Waistband	0.75	0.75	5.125	5.375	5.625	5.875	6.125	6.375	6.625	6.875	7.125	7.375
302	Leg Trim / Binding Width / Height	0.125	0.125	0.375	0.375	0.375	0.375	0.375	0.375	0.375	0.375	0.375	0.375

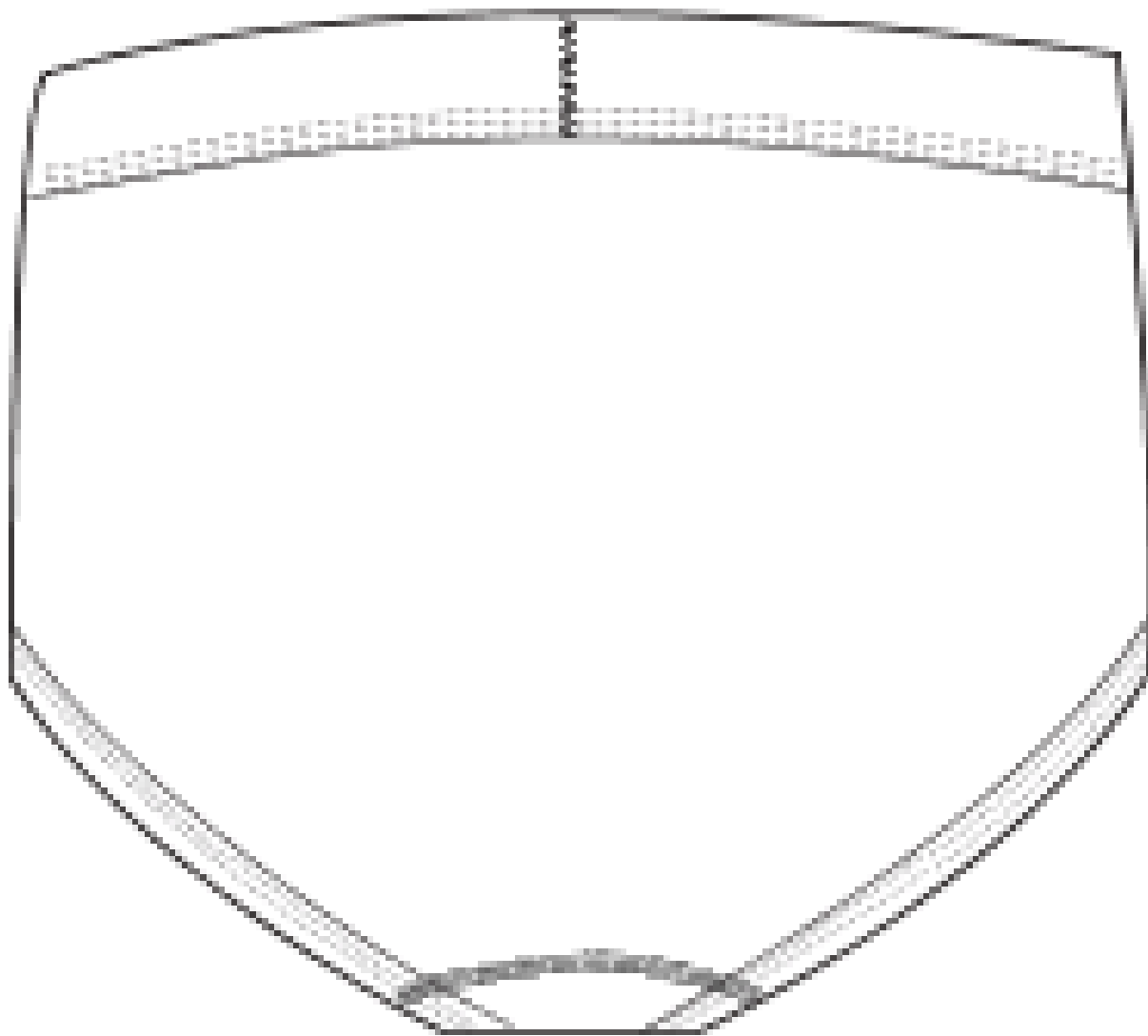
Sew Boms

Garment Use	Material	Minor Category	Description	12	13	4	5	6	7	8	9	10	11
Waist	AK0458	Narrow Elastic	13/16" Knit Waistband Plush Back Elastic - White	12.25	12.75	7.8333	8.3333	8.9167	9.5	10	10.5833	11.0833	11.6667
Leg	AK0638	Elastic	1/4" X 0.0115 Natural Rubber White	0.0807	0.0837	0.057	0.06	0.063	0.0659	0.0689	0.0719	0.0748	0.0778

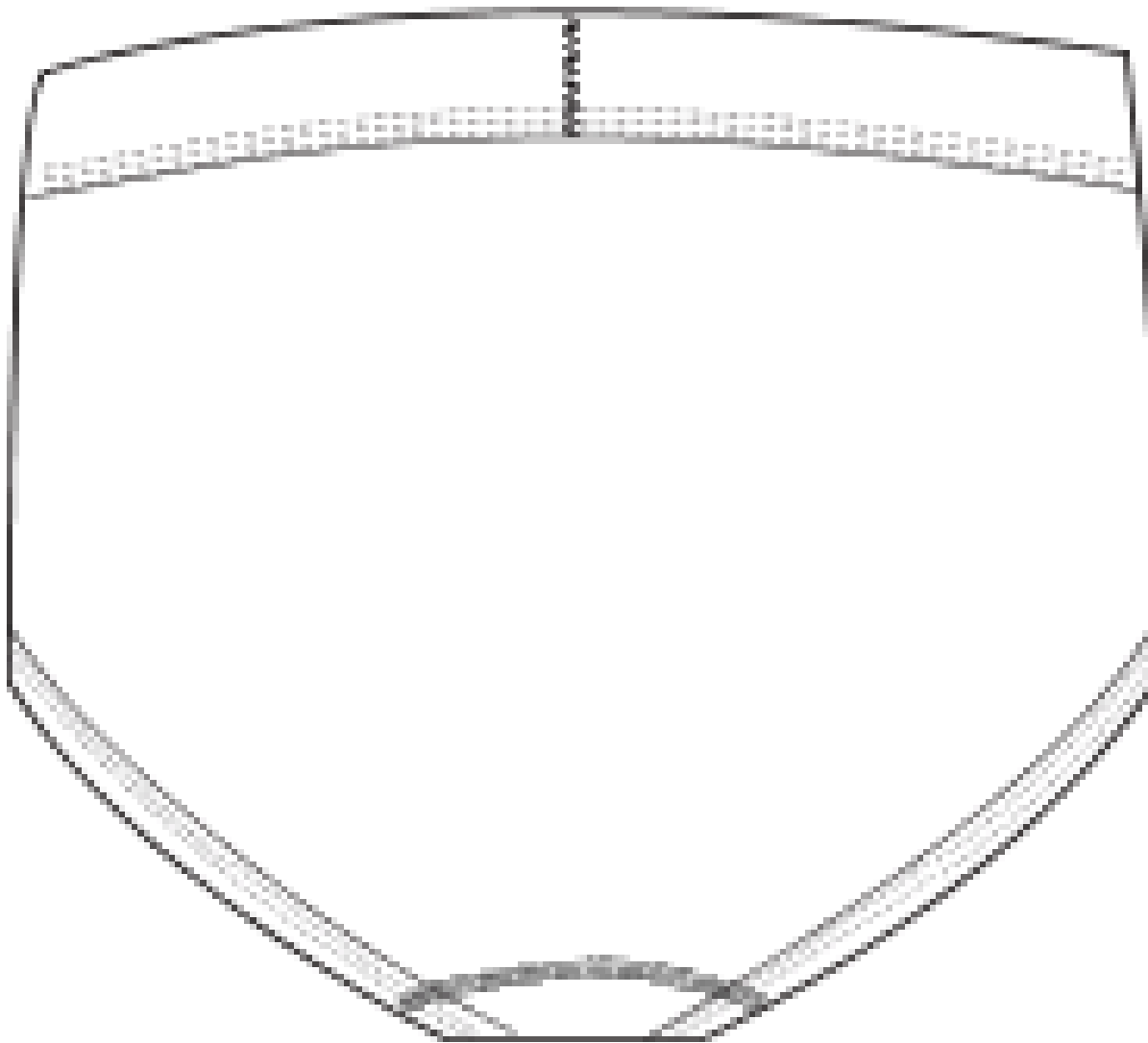
Source Boms

Garment Use	Material	Description	Minor Category
Leg	AK0638	1/4" X 0.0115 Natural Rubber White	Elastic
Waist	AK0458	13/16" Knit Waistband Plush Back Elastic - White	Narrow Elastic

001 : Front/Back Image - 1400 Core brief_front.back-Cell1.png



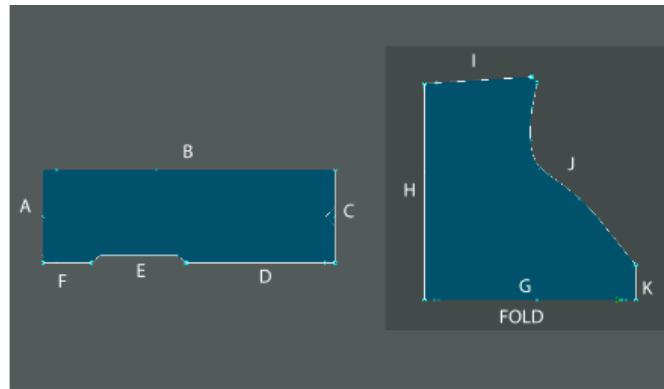
001 : Front/Back Image - 1400 Core brief_front.back-Cell1.png



002 : Development Details - 1400 core brief_1400 Development Details-Cell1.png

brand logo here		DEVELOPMENT DETAILS (PRODUCT)		NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL		DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal																																													
Boys																																																			
						FABRICS: 1.Use: Body/Leg Binding Fabric #: 1290 solids; 1361 heathers Content: 100C Finish: 001 2.Use: Panel tape/fly binding Fabric #: 4043 solids; 1361 heathers Content: 100C Finish: 001 3.Use: XX Fabric #: XX Content: XX Finish: XX 4.Use: XX Fabric #: XX Content: XX Finish: XX																																													
						TRIMS: 1.Use: Waist Elastic Item #: AK0552 2.Use: Leg Rubber Item #: AK0649 3.Use: Tagless Label Item #: XX 4.Use: XX Item #: XX 5.Use: XX Item #: XX																																													
COLOR KEY: <table border="1"> <thead> <tr> <th>Position</th> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>E</th> <th>F</th> <th>G</th> <th>H</th> <th>I</th> <th>J</th> </tr> </thead> <tbody> <tr> <td>Combo 1</td> <td>Grey heather</td> <td>Grey heather</td> <td>Grey heather</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Combo 2</td> <td>Camo Print</td> <td>Federal Blue</td> <td>Black</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Combo 3</td> <td>XX</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>						Position	A	B	C	D	E	F	G	H	I	J	Combo 1	Grey heather	Grey heather	Grey heather								Combo 2	Camo Print	Federal Blue	Black								Combo 3	XX										LOGO: 1.Use: NA Item #: XX 2.Use: XX Item #: XX 3.Use: XX Item #: XX	
Position	A	B	C	D	E	F	G	H	I	J																																									
Combo 1	Grey heather	Grey heather	Grey heather																																																
Combo 2	Camo Print	Federal Blue	Black																																																
Combo 3	XX																																																		
						FIT REFERENCE: BB507																																													

002 : Marker Layout - G0466A-ID FT,BK,CT,CL-36_G0466A1(4-8).png



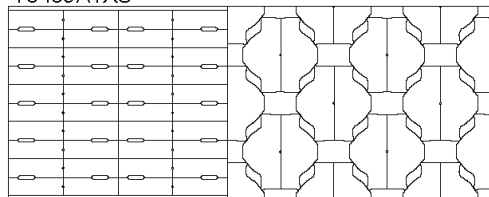
=Seasonal Sizes

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

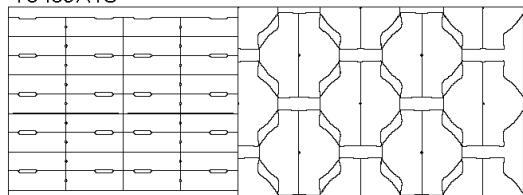
Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

004 : Marker Layout - G0466A-ID FT,BK,CT,CL-21.5_G0466A5(4-8).png

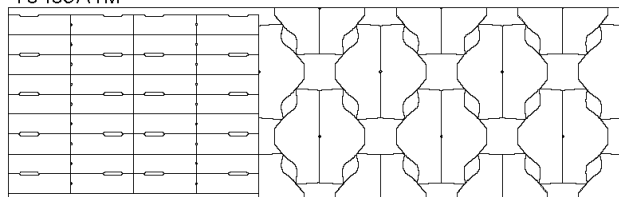
T0409A1XS



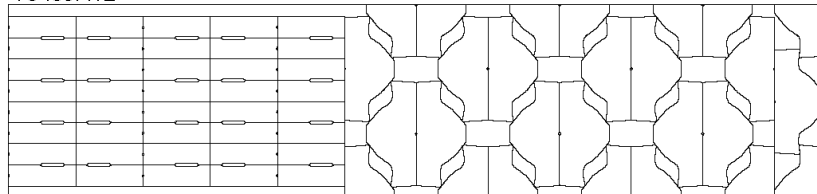
T0409A1S



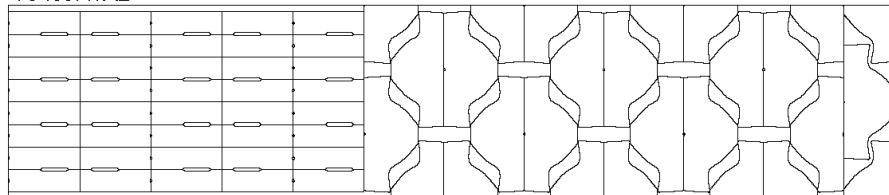
T0409A1M



T0409A1L

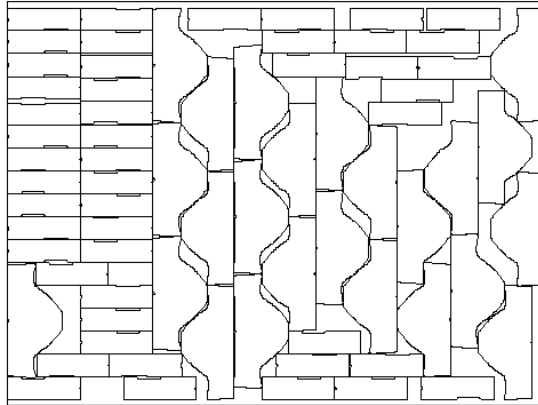


T0409A1XL

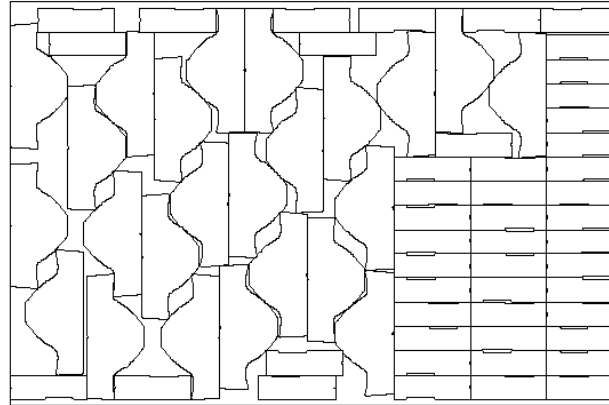


005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)_LP006 Fitted UW Inside Waist (no CB seam)-Cell1.
png

T0409A2L

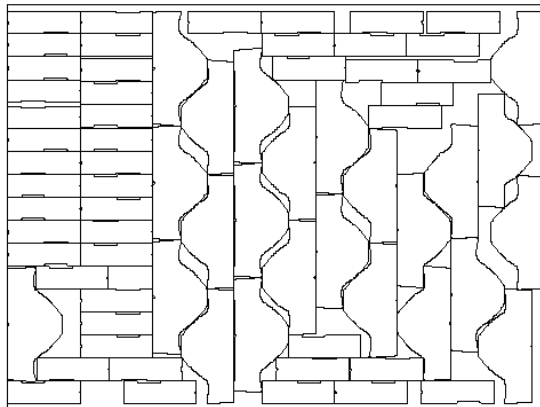


T0409A2XL

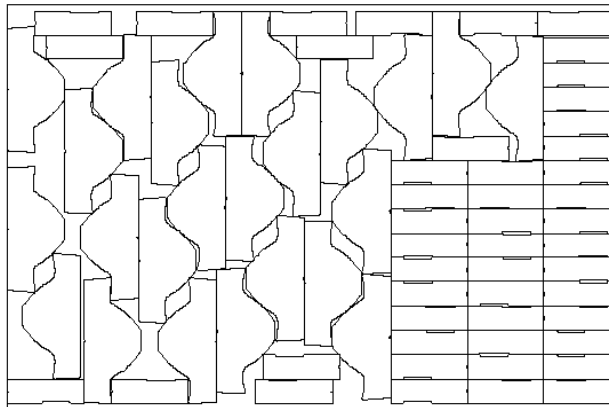


006 : Marker Layout - G0466A-70 FT,BK,OUT CRT-70.5_G0466A2(9-13).png

T0409A2L

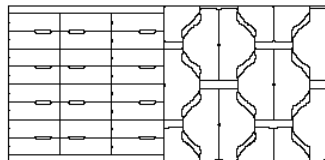


T0409A2XL

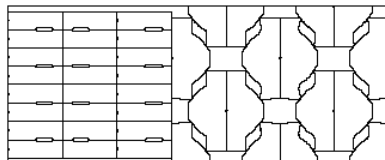


006 : Marker Layout - G0466A-70 FT,BK,OUT CRT-70.5_G0466A2(9-13).png

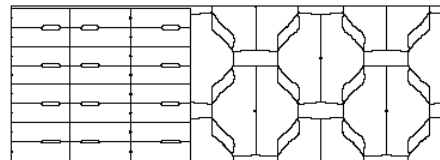
T0409A4XS



T0409A4S

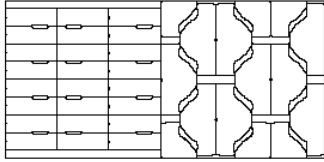


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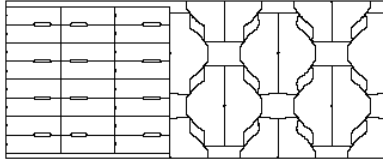


007 : Marker Layout - G0466A-10 CRT Liner-36_G0466A4(4-13).png

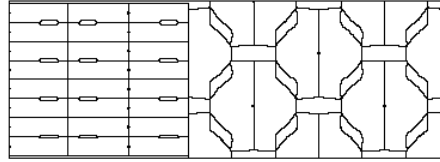
T0409A4XS



T0409A4S



T0409A4M

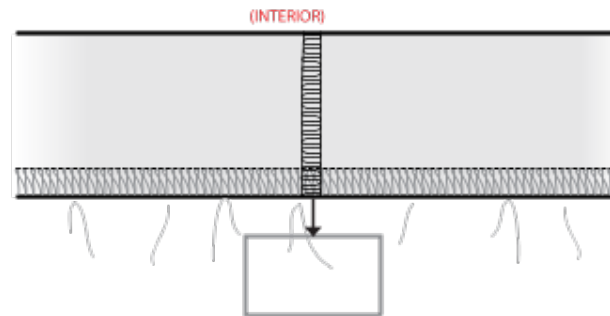
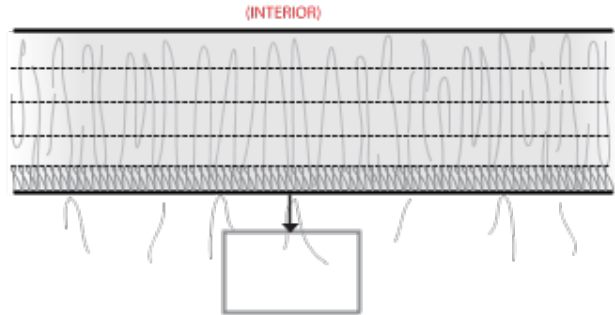


008 : Pattern Information - G0466A_Print_PI Page - G0466A _Print-Cell1.png

LP006: Inside Waist (no CB seam)

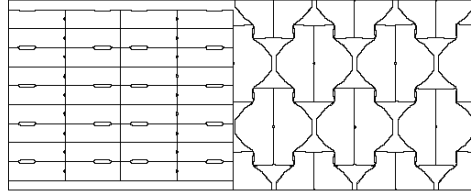
Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design

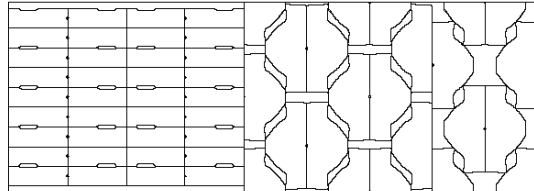


009 : Pattern Information - G0466A_Solid_PI Page - G0466A_Solid-Cell1.png

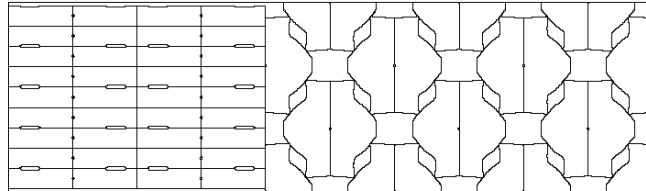
T0409A5XS



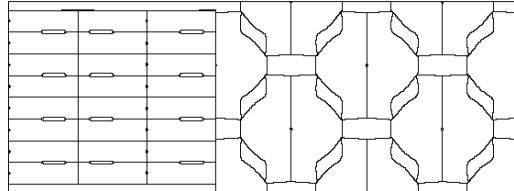
T0409A5S



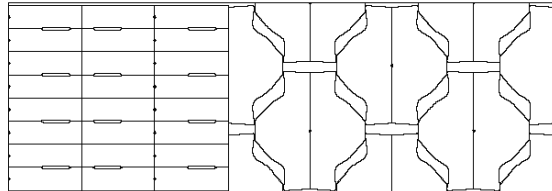
T0409A5M



T0409A5L



T0409A5XL



010 : Measurements - G0466A_PMEAS_PMEAS - G0466A-Cell1.png

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Sprd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	DM	DV	fabric	Fab. cat.	Message	acd	comment	sym.
1	T0409RFT	0	2	0	1	1	S13	FT	% x 5% shrink allow	0
3	T0409REK	0	1	0	1	1	S13	BK	Boys Brief Exp Elas. 04-30-12	0
2	T0409RBEF	0	1	0	5	1	S13	BKF	sample use	0
4	T0409RFT	0	1	0	2	1	ROP	FT	% x 5% shrink allow	0
5	T0409REK	1	0	0	2	1	ROP	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

Product Revision Attributes

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
B252 Boys Ctn Knit Rib ExpWB	001	0	0	0	Alexis DAnjou	Added colors 3LU,3MU,WDU,3JU and LYU	2016-04-06
B252 Boys Ctn Knit Rib ExpWB	003	Mfg Style Addition	0	0	Rose Joyce	Updated Waistband Closures. Update to wicking. Load new mfg. style UW52. Inactivate planning USB2. Add plant 91	2016-03-08
B252 Boys Ctn Knit Rib ExpWB	003	Updated Construction Method Code	0	0	Rose Joyce	Updated Waistband Closure.	2016-01-05
B252 Boys Ctn Knit Rib ExpWB	003	Mfg Style Deletion	0	0	Rose Joyce	Inactivate mfg. style UBM2	2015-11-16
B252 Boys Ctn Knit Rib ExpWB	003	Colorway Addition	0	0	Rose Joyce	S16 Color Update. Added new color 1CU	2015-08-16
B252 Boys Ctn Knit Rib ExpWB	003	Colorway Addition	0	0	Rose Joyce	S16 Color Update. Added new colors VHU and VTU	2015-08-02
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Construction Details Change	0	0	hoshephe	Updated to 504 WB closure	2015-07-27
B252 Boys Ctn Knit Rib ExpWB	003	0	0	0	jekeels (deleted)	Added 4556CY/AY fabrics (JK 12/03/14)	2014-12-02
B252 Boys Ctn Knit Rib ExpWB	003	0	0	0	Lori Chambers	changed elastic from AK0552 to AK2367 (LC 09/26/14)	2014-09-25
B252 Boys Ctn Knit Rib ExpWB	002	0	0	0	jekeels (deleted)	Updated fabrics for SOFTER (JK 06/13/14)	2014-06-12
B252 Boys Ctn Knit Rib ExpWB	002	0	0	0	jekeels (deleted)	Updated BOM fabrics per ALT table (JK 05/22/14)	2014-05-21
B252 Boys Ctn Knit Rib ExpWB	002	Fabric Addition	0	0	Susana Alas	Fabrics Addition according Alt Table 4557CD/CP	2014-05-21

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T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Fabric Deletion	Fabric Addition	0	Susana Alas	Removed fabric 4557 AD/AP replaced by 4557 CD/CP	2014-01-23
B252 Boys Ctn Knit Rib ExpWB	002	Fabric Addition	0	0	Treva Monday	New Alternate for Fabric for S14 Dunk Stripes	2013-08-13
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Sew BOM Change	0	0	Ernesto Molina	Updated Elastic Usage	2013-05-19
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Cut BOM Change	0	0	Ernesto Molina		2013-05-19
B252 Boys Ctn Knit Rib ExpWB	001	Updated to PLM format	0	0	Wendy Lee	trim usage change	2012-11-27
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Updated to PLM format	0	0	Wendy Lee	trim usage change	2012-11-27
B252 Boys Ctn Knit Rib ExpWB	003	See "Product Revision for Pattern"	0	0	hoshephe	HS 7-28-15	

Sizing Table

Garment Size	Size Code
XS	40
SM	41
MD	42
LG	43
XL	44

Approved Suppliers

Supplier	Mfg Flow	Green Seal	Red Seal	Comments
-- HBI Make	Internal			

Construction

Sewing Operation	Stitch Type / Description	Gauge Width	SPI	Seam/Trimoff Allowance	Garment Use	Needle Thread	Needle Visibility	Looper Thread	Looper Visibility
Seam waist elastic with latch-tack.	504 (break open) 3 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

Measurements

POM#	Measurement Name	Tol (+)	Tol(-)	XS	S	M	L	XL	2X
200a	Waist - at top (half)	0.75	0.75	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	1.25	1.25	1.25	1.25	1.25	1.25
210	Rise/Trunk Length - Flat	0.75	0.75	9.0	9.5	10.5	11.375	12.125	12.75
210a	Front Rise - Top of Waistband	0.75	0.75	10.625	11.125	12.125	13.0	13.75	14.375
211a	Back Rise - Top of Waistband	0.75	0.75	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)	0.5	0.5	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	8.625	9.625	10.625	11.75	12.875	13.375
206a	Leg Opening - At Edge (half)	0.5	0.5	6.125	6.75	7.375	8.375	9.25	9.875
206x	Min. Leg Opening - Extended (half)	99.0	0.0	7.875	8.75	9.5	10.25	11.0	11.375
209a	Outseam - Top of Waistband	0.5	0.5	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

Label Bom

Country	Garment Use	Material	Application	Label Size	Fiber Code-Content	Ink Colors	Usage Per Dozen	Usage UOM	Std Waste Factor	Usage Price
Made in Dominican Republic (DO)	Waist	LSU3596D	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in Dominican Republic (DO)	Waist	LSU3600D	Pad Print	2T-3T - XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU3440E	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2985E	Pad Print	2T-3T - XL/TG/ XG	LE - 63%COTTON/ 37%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2986E	Pad Print	2T-3T - XL/TG/ XG	SD - 67%COTTON/ 33%POLY	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2984E	Pad Print	2T-3T - XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU3441E	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	2	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3602V	Pad Print	2T-37- XL/TG/ XG	NJ - 58%COTTON/ 42%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3600V	Pad Print	2T-37- XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0

Country	Garment Use	Material	Application	Label Size	Fiber Code-Content	Ink Colors	Usage Per Dozen	Usage UOM	Std Waste Factor	Usage Price
Made in Vietnam (VN)	Waist	LSU3576V	Pad Print	2T-XL	CP - 62%COTTON/ 38%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3604V	Pad Print	2T-XL	CP - 62%COTTON/ 38%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3603V	Pad Print	2T-3T- XL/TG/ XG	SD - 67%COTTON/ 33%POLY	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3601V	Pad Print	2T-3T- XL/TG/ XG	LE - 63%COTTON/ 37%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3596V	Pad Print	2T-3T- XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3598V	Pad Print	2T-3T - XL/TG/ XG	09 - 95%COTTON/ 5%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3713V	Pad Print	2T-3T - XL/TG/ XG	56 - 60%COTTON/ 40%POLYESTER	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0

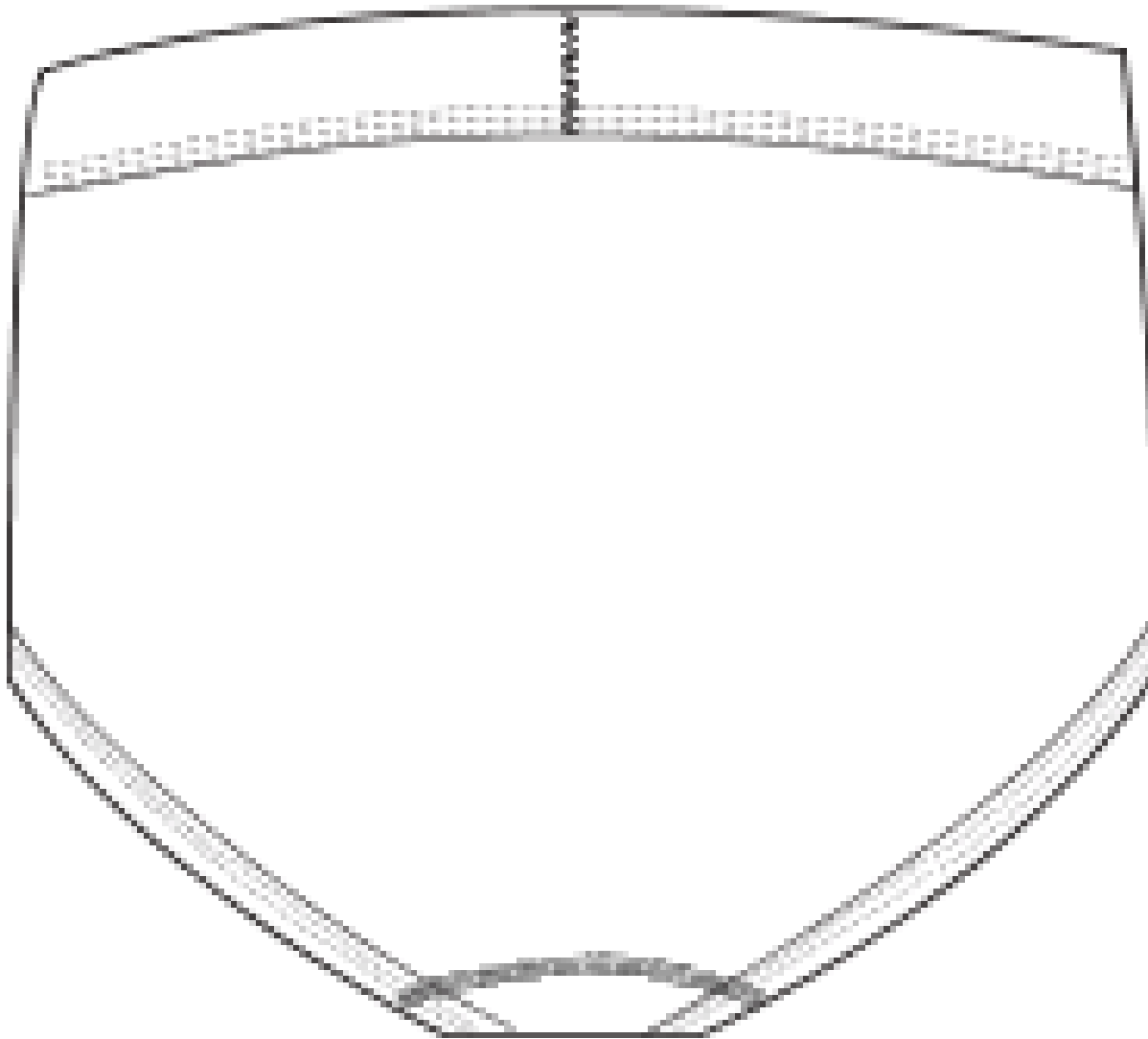
Colorways List

Colorway Group	Colorway Name
001 : Basic Solids	() Black (06U)
001 : Basic Solids	() White (WHU)
001 : Basic Solids	() Royalty Blue B252 (EUU)
001 : Basic Solids	() Kiwi Ice B252 (1CU)
001 : Basic Solids	() Best Red B252 (VTU)
001 : Basic Solids	() White/Grey B252 w/Grey Elastic (WEU)
001 : Basic Solids	() Optical Blue B252 (VHU)
002 : Basic Heathers	() Grey Heather (LCU)
002 : Basic Heathers	() Stonewash Blue Heather (LEU)
002 : Basic Heathers	() Mid Blue Heather (LFU)
002 : Basic Heathers	() Mid Charcoal Heather (LBU)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-2 (11U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-1 (10U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-3 (12U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-4 (13U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-10 (WYU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-03 B252 (3LU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-01 B252 (3JU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-02 B252 (3KU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-04 B252 (3MU)

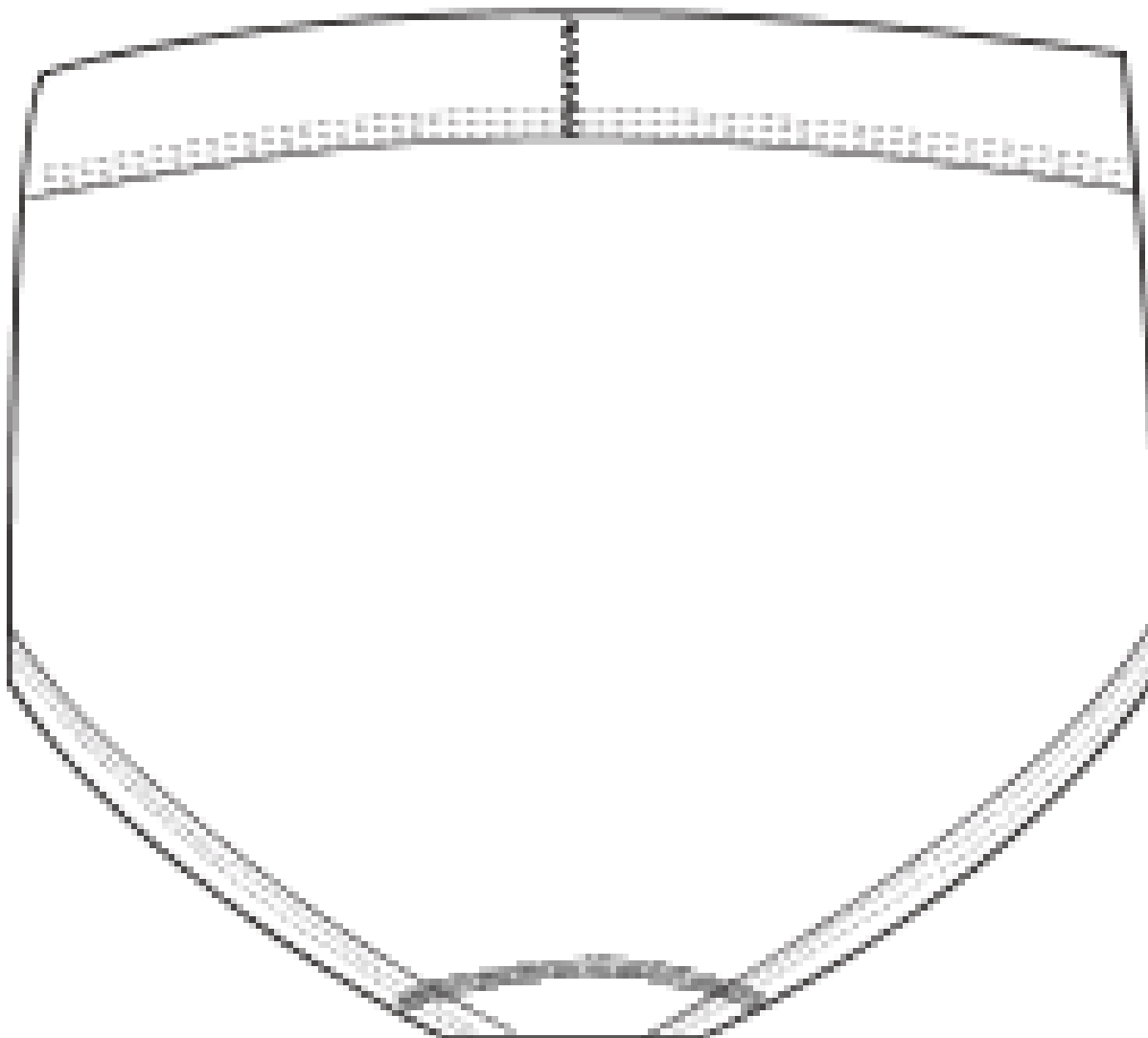
Sew Boms

Garment Use	Material	Minor Category	Description	XS	S	M	L	XL	2X
Leg	AK0649	Elastic	1/4" X .0075 Natural Rubber White	0.0284	0.0303	0.0338	0.0373	0.0408	0.0433
Waist	AK0552	Waistband	1-1/4" Woven Elastic Logo/Stripe - white	6.25	6.9167	7.4167	8.0833	8.75	9.0833

001 : Front/Back Image - Boys Ctn Knit Rib ExpWB_B252.2252.7764ft.bk-Cell1.png



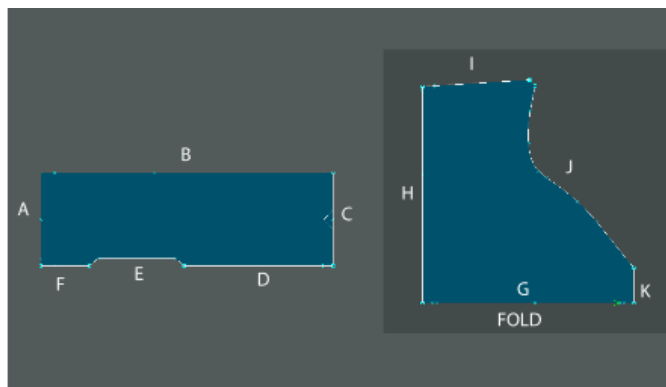
001 : Front/Back Image - Boys Ctn Knit Rib ExpWB_B252.2252.7764ft.bk-Cell1.png



002 : Development Details - Boys Core Brief_B252 Development Details-Cell1.png

brand logo here <div style="text-align: center; font-weight: bold; font-size: 1.2em;">Boys</div>	DEVELOPMENT DETAILS (PRODUCT)	<table style="width: 100%; border: none;"> <tr> <td style="border: none; vertical-align: top;"> NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL </td> <td style="border: none; vertical-align: top;"> DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal </td> </tr> </table>	NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL	DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal																																										
NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL	DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal																																													
		FABRICS: 1.Use: Body/leg Binding Fabric #: 1290 solids; 1361 heathers Content: 100C Finish: 001 2.Use: Panel tape/fly binding Fabric #: 4043 solids; 1361 heathers Content: 100C Finish: 001 3.Use: XX Fabric #: XX Content: XX Finish: XX 4.Use: XX Fabric #: XX Content: XX Finish: XX																																												
COLOR KEY: <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th style="font-size: 0.8em;">Position</th> <th style="font-size: 0.8em;">A</th> <th style="font-size: 0.8em;">B</th> <th style="font-size: 0.8em;">C</th> <th style="font-size: 0.8em;">D</th> <th style="font-size: 0.8em;">E</th> <th style="font-size: 0.8em;">F</th> <th style="font-size: 0.8em;">G</th> <th style="font-size: 0.8em;">H</th> <th style="font-size: 0.8em;">I</th> <th style="font-size: 0.8em;">J</th> </tr> <tr> <td style="font-size: 0.8em;">Combo 1</td> <td style="font-size: 0.8em;">Grey heather</td> <td style="font-size: 0.8em;">Grey heather</td> <td style="font-size: 0.8em;">Grey heather</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="font-size: 0.8em;">Combo 2</td> <td style="font-size: 0.8em;">Camo Print</td> <td style="font-size: 0.8em;">Federal Blue</td> <td style="font-size: 0.8em;">Black</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="font-size: 0.8em;">Combo 3</td> <td style="font-size: 0.8em;">XX</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		Position	A	B	C	D	E	F	G	H	I	J	Combo 1	Grey heather	Grey heather	Grey heather								Combo 2	Camo Print	Federal Blue	Black								Combo 3	XX										TRIMS: 1.Use: Waist Elastic Item #: AK0552 2.Use: Leg Rubber Item #: AK0649 3.Use: Tagless Label Item #: XX 4.Use: XX Item #: XX 5.Use: XX Item #: XX
Position	A	B	C	D	E	F	G	H	I	J																																				
Combo 1	Grey heather	Grey heather	Grey heather																																											
Combo 2	Camo Print	Federal Blue	Black																																											
Combo 3	XX																																													
LOGO: 1.Use: NA Item #: XX 2.Use: XX Item #: XX 3.Use: XX Item #: XX		FIT REFERENCE: BB507																																												

002 : Measurements - T0409A PMEAS_B252 PMEAS-Cell1.png



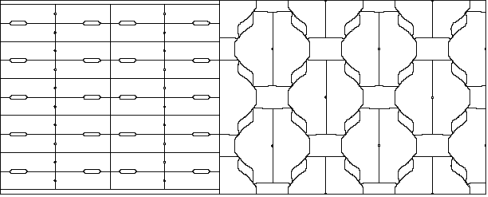
=Seasonal Sizes

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

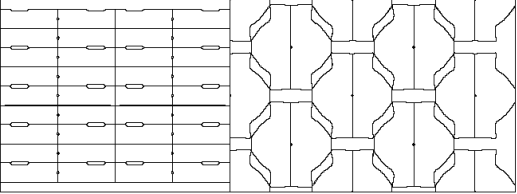
Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

003 : Marker Layout - T0409A-60 FT,BK-36.5_T0409A-36.5.png

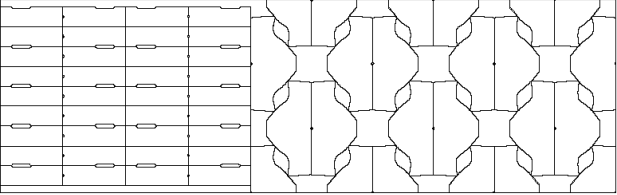
T0409A1XS



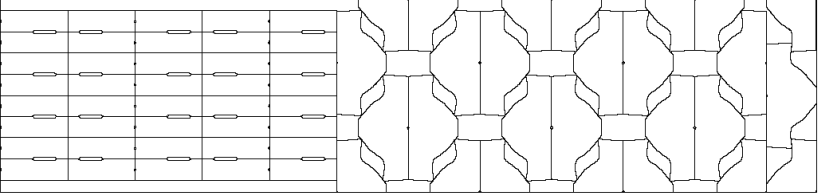
T0409A1S



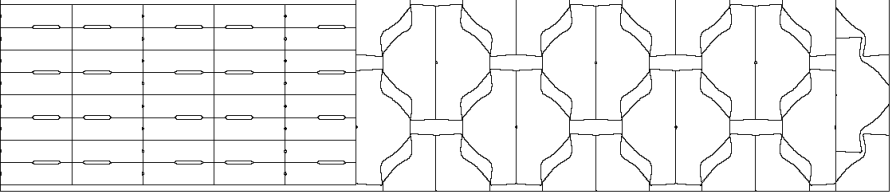
T0409A1M



T0409A1L

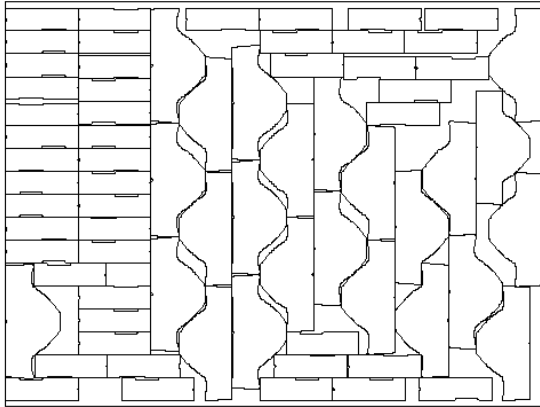


T0409A1XL

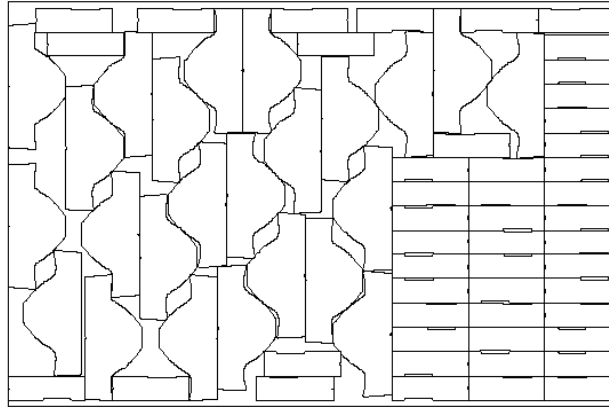


004 : Marker Layout - T0409A-60 FT,BK-70.5_T0409A2XS-S-M.png

T0409A2L

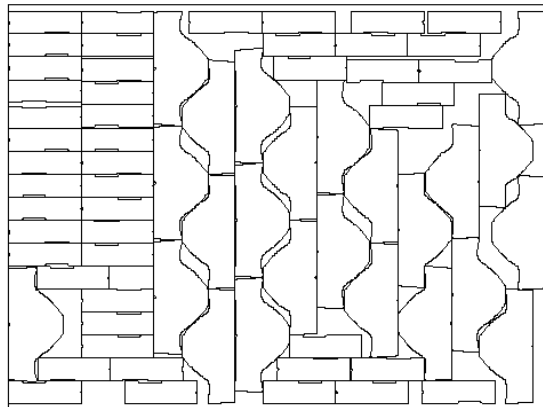


T0409A2XL

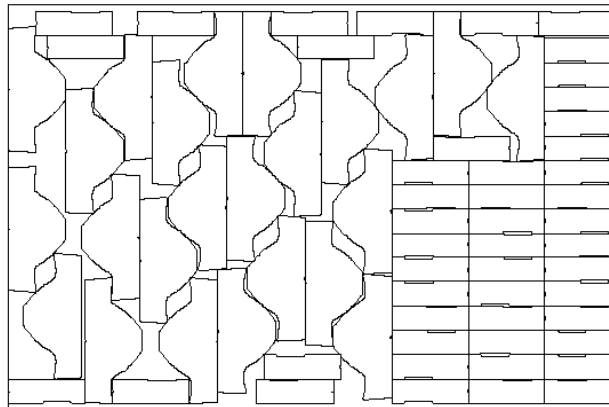


004 : Marker Layout - T0409A-60 FT,BK-70.5_T0409A2XS-S-M.png

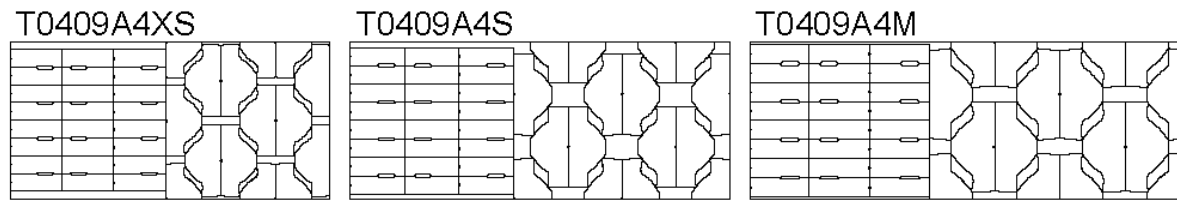
T0409A2L

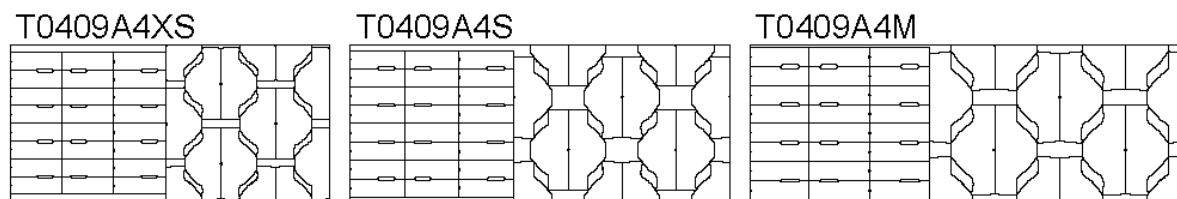


T0409A2XL



005 : Marker Layout - T0409A-60 FT,BK-31_T0409A4L-XL.png



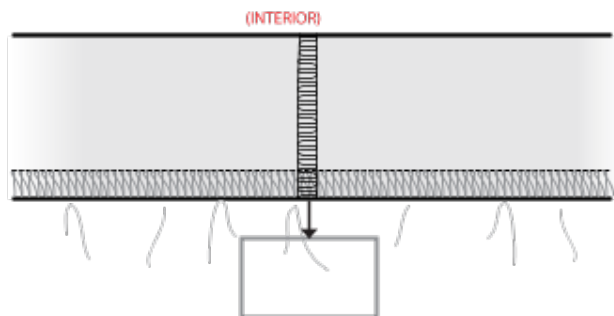
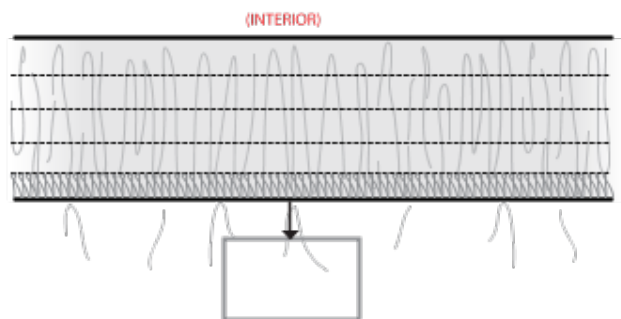
005 : Marker Layout - T0409A-60 FT,BK-31_T0409A4L-XL.png

005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)_LP006 Fitted UW Inside Waist (no CB seam)-Cell1.
png

LP006: Inside Waist (no CB seam)

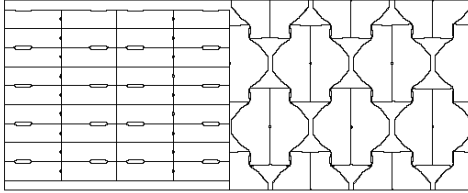
Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design

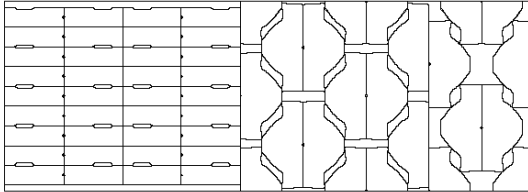


006 : Marker Layout - T0409A-60 FT,BK-35_T0409A35.png

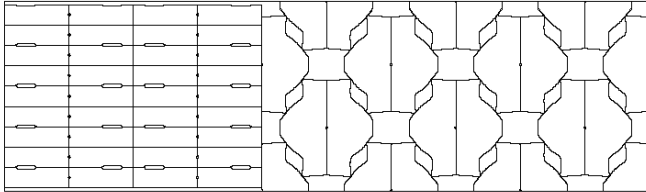
T0409A5XS



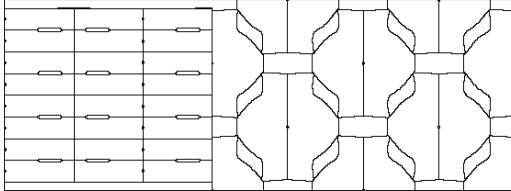
T0409A5S



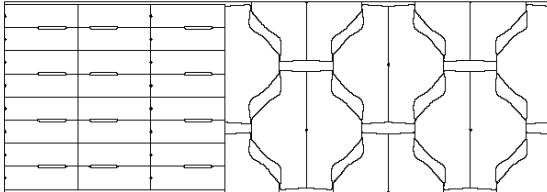
T0409A5M



T0409A5L



T0409A5XL



007 : Pattern Information - T0409A_T0409a-Cell1.png

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Sprd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	DM	DV	fabric	Fab. cat.	Message	acd	comment	sym
1	T0409RFT	0	2	0	1	1	S13	FT	% x 5% shrink allow	0
3	T0409REK	0	1	0	1	1	S13	BK	Boys Brief Exp Elas. 04-30-12	0
2	T0409RBKE	0	1	0	5	1	S13	BKE	sample use	0
4	T0409RFT	0	1	0	2	1	ROP	FT	% x 5% shrink allow	0
5	T0409REK	1	0	0	2	1	ROP	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

Product Revision Attributes

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
B252 Boys Ctn Knit Rib ExpWB	001	0	0	0	Alexis DAnjou	Added colors 3LU,3MU,WDU,3JU and LYU	2016-04-06
B252 Boys Ctn Knit Rib ExpWB	003	Mfg Style Addition	0	0	Rose Joyce	Updated Waistband Closures. Update to wicking. Load new mfg. style UW52. Inactivate planning USB2. Add plant 91	2016-03-08
B252 Boys Ctn Knit Rib ExpWB	003	Updated Construction Method Code	0	0	Rose Joyce	Updated Waistband Closure.	2016-01-05
B252 Boys Ctn Knit Rib ExpWB	003	Mfg Style Deletion	0	0	Rose Joyce	Inactivate mfg. style UBM2	2015-11-16
B252 Boys Ctn Knit Rib ExpWB	003	Colorway Addition	0	0	Rose Joyce	S16 Color Update. Added new color 1CU	2015-08-16
B252 Boys Ctn Knit Rib ExpWB	003	Colorway Addition	0	0	Rose Joyce	S16 Color Update. Added new colors VHU and VTU	2015-08-02
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Construction Details Change	0	0	hoshephe	Updated to 504 WB closure	2015-07-27
B252 Boys Ctn Knit Rib ExpWB	003	0	0	0	jekeels (deleted)	Added 4556CY/AY fabrics (JK 12/03/14)	2014-12-02
B252 Boys Ctn Knit Rib ExpWB	003	0	0	0	Lori Chambers	changed elastic from AK0552 to AK2367 (LC 09/26/14)	2014-09-25
B252 Boys Ctn Knit Rib ExpWB	002	0	0	0	jekeels (deleted)	Updated fabrics for SOFTER (JK 06/13/14)	2014-06-12
B252 Boys Ctn Knit Rib ExpWB	002	0	0	0	jekeels (deleted)	Updated BOM fabrics per ALT table (JK 05/22/14)	2014-05-21
B252 Boys Ctn Knit Rib ExpWB	002	Fabric Addition	0	0	Susana Alas	Fabrics Addition according Alt Table 4557CD/CP	2014-05-21

Product Name	Spec	Rev one	Rev two	Rev three	Last Edited By	Comments	Last Modified
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Fabric Deletion	Fabric Addition	0	Susana Alas	Removed fabric 4557 AD/AP replaced by 4557 CD/CP	2014-01-23
B252 Boys Ctn Knit Rib ExpWB	002	Fabric Addition	0	0	Treva Monday	New Alternate for Fabric for S14 Dunk Stripes	2013-08-13
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Sew BOM Change	0	0	Ernesto Molina	Updated Elastic Usage	2013-05-19
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Cut BOM Change	0	0	Ernesto Molina		2013-05-19
B252 Boys Ctn Knit Rib ExpWB	001	Updated to PLM format	0	0	Wendy Lee	trim usage change	2012-11-27
T0409 Boys--Size: XS-2X Rib - Body 1x1 Brief	001	Updated to PLM format	0	0	Wendy Lee	trim usage change	2012-11-27
B252 Boys Ctn Knit Rib ExpWB	003	See "Product Revision for Pattern"	0	0	hoshephe	HS 7-28-15	

Sizing Table

Garment Size	Size Code
XS	40
SM	41
MD	42
LG	43
XL	44

Approved Suppliers

Supplier	Mfg Flow	Green Seal	Red Seal	Comments
-- HBI Make	Internal			

Construction

Sewing Operation	Stitch Type / Description	Gauge Width	SPI	Seam/Trimoff Allowance	Garment Use	Needle Thread	Needle Visibility	Looper Thread	Looper Visibility
Seam waist elastic with latch-tack.	504 (break open) 3 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

Measurements

POM#	Measurement Name	Tol (+)	Tol(-)	XS	S	M	L	XL	2X
200a	Waist - at top (half)	0.75	0.75	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	1.25	1.25	1.25	1.25	1.25	1.25
210	Rise/Trunk Length - Flat	0.75	0.75	9.0	9.5	10.5	11.375	12.125	12.75
210a	Front Rise - Top of Waistband	0.75	0.75	10.625	11.125	12.125	13.0	13.75	14.375
211a	Back Rise - Top of Waistband	0.75	0.75	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)	0.5	0.5	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	8.625	9.625	10.625	11.75	12.875	13.375
206a	Leg Opening - At Edge (half)	0.5	0.5	6.125	6.75	7.375	8.375	9.25	9.875
206x	Min. Leg Opening - Extended (half)	99.0	0.0	7.875	8.75	9.5	10.25	11.0	11.375
209a	Outseam - Top of Waistband	0.5	0.5	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

Label Bom

Country	Garment Use	Material	Application	Label Size	Fiber Code-Content	Ink Colors	Usage Per Dozen	Usage UOM	Std Waste Factor	Usage Price
Made in Dominican Republic (DO)	Waist	LSU3596D	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in Dominican Republic (DO)	Waist	LSU3600D	Pad Print	2T-3T - XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU3440E	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2985E	Pad Print	2T-3T - XL/TG/ XG	LE - 63%COTTON/ 37%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2986E	Pad Print	2T-3T - XL/TG/ XG	SD - 67%COTTON/ 33%POLY	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU2984E	Pad Print	2T-3T - XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0
Made in El Salvador (SV)	Waist	LSU3441E	Pad Print	2T-3T - XL/TG/ XG	05 - 100%COTTON	2	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3602V	Pad Print	2T-3T - XL/TG/ XG	NJ - 58%COTTON/ 42%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3600V	Pad Print	2T-3T - XL/TG/ XG	18 - 75%COTTON/ 25%POLYESTER	1	12	EA	0	0

Country	Garment Use	Material	Application	Label Size	Fiber Code-Content	Ink Colors	Usage Per Dozen	Usage UOM	Std Waste Factor	Usage Price
Made in Vietnam (VN)	Waist	LSU3576V	Pad Print	2T-XL	CP - 62%COTTON/ 38%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3604V	Pad Print	2T-XL	CP - 62%COTTON/ 38%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3603V	Pad Print	2T-3T- XL/TG/ XG	SD - 67%COTTON/ 33%POLY	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3601V	Pad Print	2T-3T- XL/TG/ XG	LE - 63%COTTON/ 37%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3596V	Pad Print	2T-3T- XL/TG/ XG	05 - 100%COTTON	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3598V	Pad Print	2T-3T - XL/TG/ XG	09 - 95%COTTON/ 5%POLYESTER	1	12	EA	0	0
Made in Vietnam (VN)	Waist	LSU3713V	Pad Print	2T-3T - XL/TG/ XG	56 - 60%COTTON/ 40%POLYESTER	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0
Printed in Plant	Waist	LSU3607	Pad Print	ALL SIZES	Printed in Plant	1	12	EA	0	0

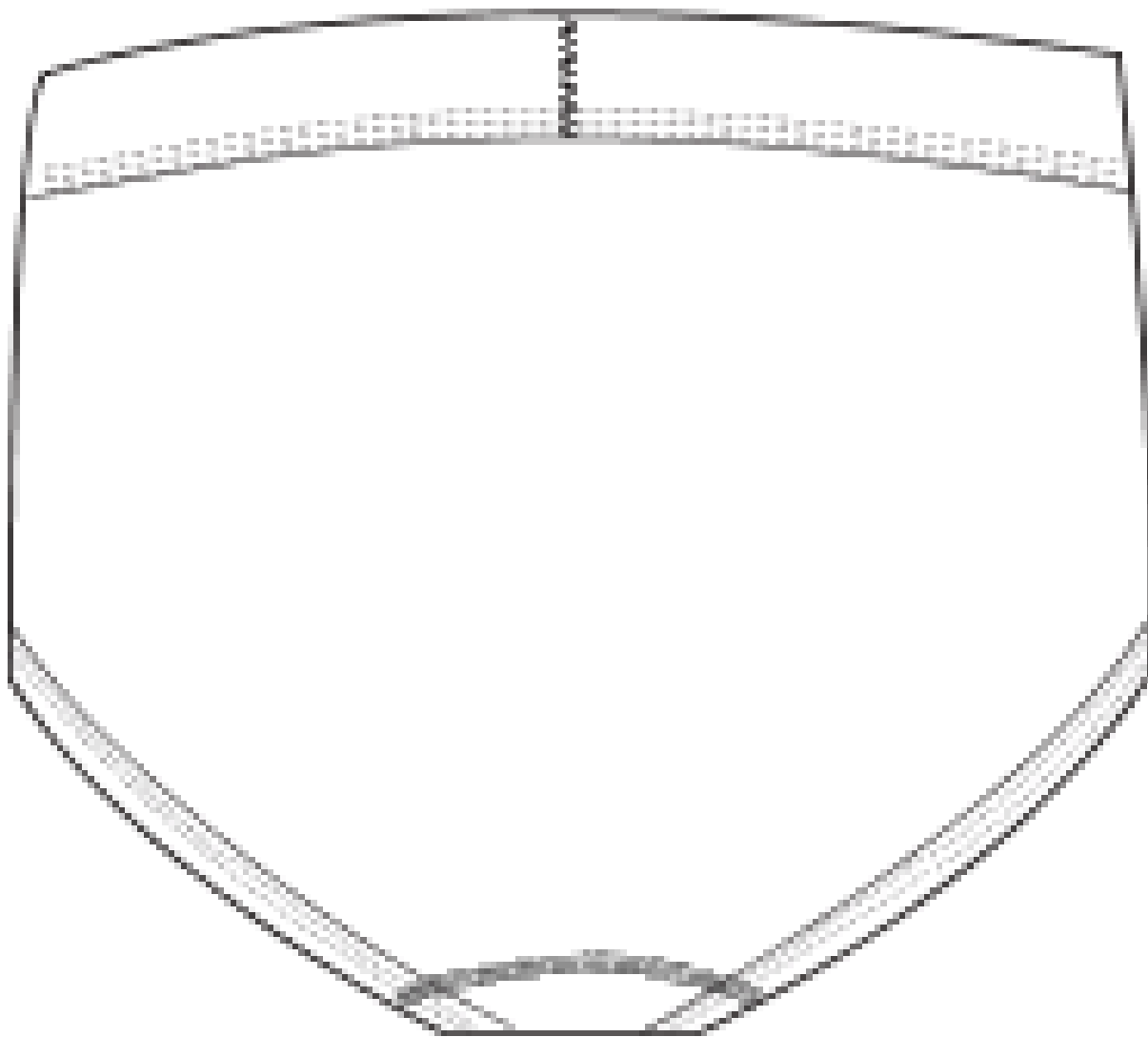
Colorways List

Colorway Group	Colorway Name
001 : Basic Solids	() Black (06U)
001 : Basic Solids	() White (WHU)
001 : Basic Solids	() Royalty Blue B252 (EUU)
001 : Basic Solids	() Kiwi Ice B252 (1CU)
001 : Basic Solids	() Best Red B252 (VTU)
001 : Basic Solids	() White/Grey B252 w/Grey Elastic (WEU)
001 : Basic Solids	() Optical Blue B252 (VHU)
002 : Basic Heathers	() Grey Heather (LCU)
002 : Basic Heathers	() Stonewash Blue Heather (LEU)
002 : Basic Heathers	() Mid Blue Heather (LFU)
002 : Basic Heathers	() Mid Charcoal Heather (LBU)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-2 (11U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-1 (10U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-3 (12U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-4 (13U)
004 : Basic S14 Dunk Stripes	() B-DS-SP14-10 (WYU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-03 B252 (3LU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-01 B252 (3JU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-02 B252 (3KU)
005 : Basic S15 Dunk Stripes	() E-DS-SP15-04 B252 (3MU)

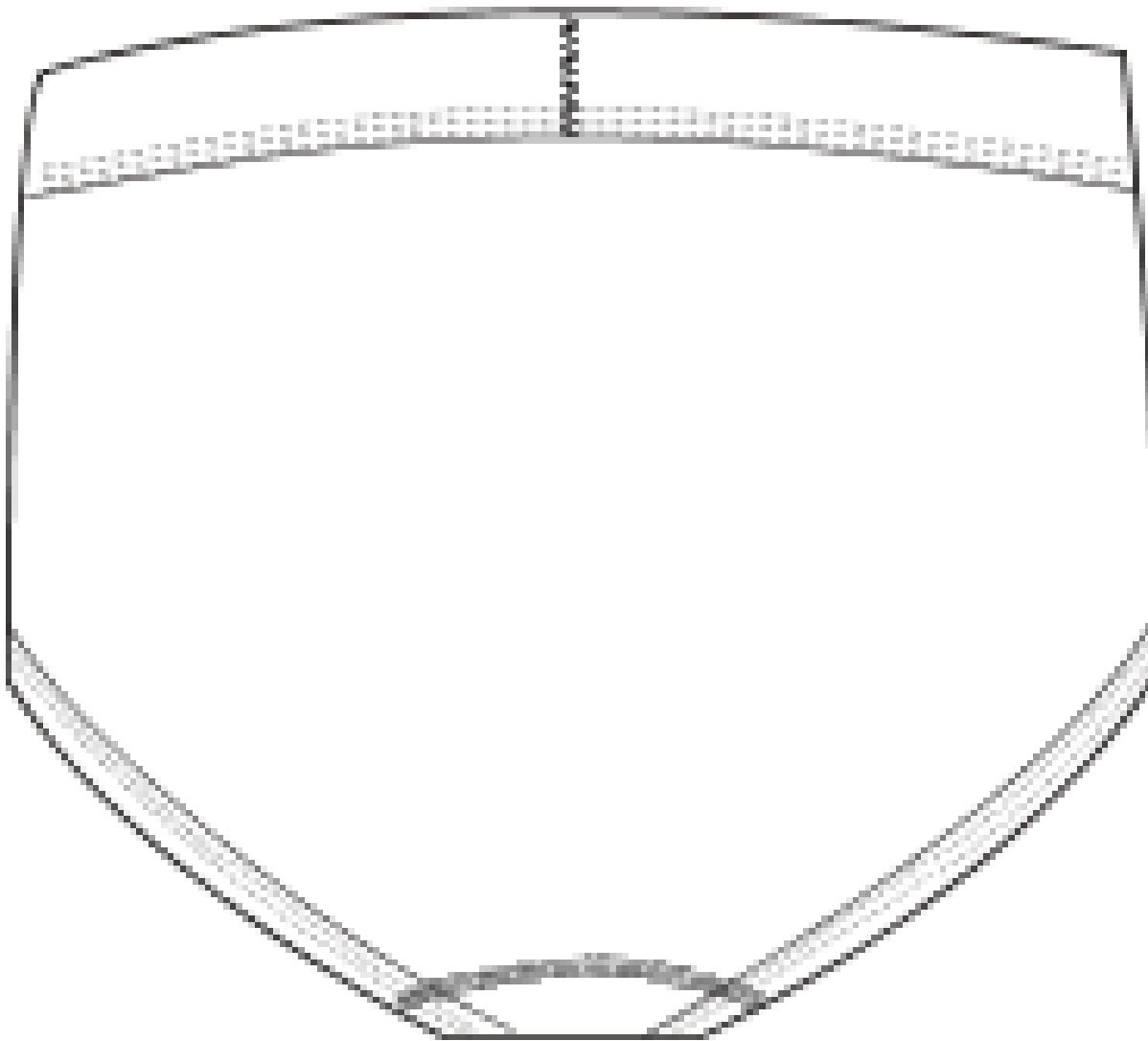
Sew Boms

Garment Use	Material	Minor Category	Description	XS	S	M	L	XL	2X
Leg	AK0649	Elastic	1/4" X .0075 Natural Rubber White	0.0284	0.0303	0.0338	0.0373	0.0408	0.0433
Waist	AK0552	Waistband	1-1/4" Woven Elastic Logo/Stripe - white	6.25	6.9167	7.4167	8.0833	8.75	9.0833

001 : Front/Back Image - Boys Ctn Knit Rib ExpWB_B252.2252.7764ft.bk-Cell1.png



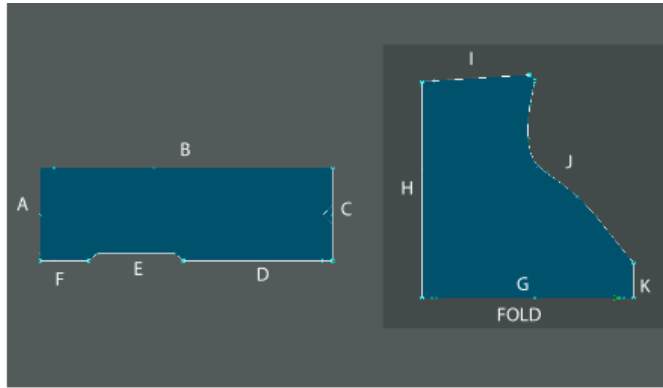
001 : Front/Back Image - Boys Ctn Knit Rib ExpWB_B252.2252.7764ft.bk-Cell1.png



002 : Development Details - Boys Core Brief_B252 Development Details-Cell1.png

brand logo here <div style="text-align: center; font-weight: bold; font-size: 1.2em;">Boys</div>	DEVELOPMENT DETAILS (PRODUCT)	<table style="width: 100%; border: none;"> <tr> <td style="border: none;"> NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL </td> <td style="border: none; text-align: right;"> DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal </td> </tr> </table>	NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL	DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal																																										
NAME: Sherry Kimel SEASON: F12 PLM #/@Task #: 12345 DESCRIPTION: Brief COLLECTION: Core SEASONAL SIZE OFFERING: S,M,L,XL	DATE: 5.23.12 PACK SIZE: P3 WHERE MAKE: Internal																																													
		FABRICS: 1.Use: Body/leg Binding Fabric #: 1290 solids; 1361 heathers Content: 100C Finish: 001 2.Use: Panel tape/fly binding Fabric #: 4043 solids; 1361 heathers Content: 100C Finish: 001 3.Use: XX Fabric #: XX Content: XX Finish: XX 4.Use: XX Fabric #: XX Content: XX Finish: XX																																												
COLOR KEY: <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th style="font-size: 0.8em;">Position</th> <th style="font-size: 0.8em;">A</th> <th style="font-size: 0.8em;">B</th> <th style="font-size: 0.8em;">C</th> <th style="font-size: 0.8em;">D</th> <th style="font-size: 0.8em;">E</th> <th style="font-size: 0.8em;">F</th> <th style="font-size: 0.8em;">G</th> <th style="font-size: 0.8em;">H</th> <th style="font-size: 0.8em;">I</th> <th style="font-size: 0.8em;">J</th> </tr> <tr> <td style="font-size: 0.8em;">Combo 1</td> <td style="font-size: 0.8em;">Grey heather</td> <td style="font-size: 0.8em;">Grey heather</td> <td style="font-size: 0.8em;">Grey heather</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="font-size: 0.8em;">Combo 2</td> <td style="font-size: 0.8em;">Camo Print</td> <td style="font-size: 0.8em;">Federal Blue</td> <td style="font-size: 0.8em;">Black</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="font-size: 0.8em;">Combo 3</td> <td style="font-size: 0.8em;">XX</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		Position	A	B	C	D	E	F	G	H	I	J	Combo 1	Grey heather	Grey heather	Grey heather								Combo 2	Camo Print	Federal Blue	Black								Combo 3	XX										TRIMS: 1.Use: Waist Elastic Item #: AK0552 2.Use: Leg Rubber Item #: AK0649 3.Use: Tagless Label Item #: XX 4.Use: XX Item #: XX 5.Use: XX Item #: XX
Position	A	B	C	D	E	F	G	H	I	J																																				
Combo 1	Grey heather	Grey heather	Grey heather																																											
Combo 2	Camo Print	Federal Blue	Black																																											
Combo 3	XX																																													
LOGO: 1.Use: NA Item #: XX 2.Use: XX Item #: XX 3.Use: XX Item #: XX		FIT REFERENCE: BB507																																												

002 : Measurements - T0409A PMEAS_B252 PMEAS-Cell1.png



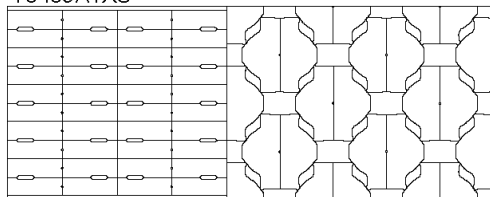
=Seasonal Sizes

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

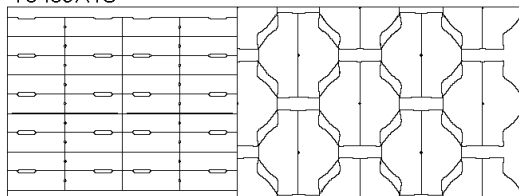
Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

003 : Marker Layout - T0409A-60 FT,BK-36.5_T0409A-36.5.png

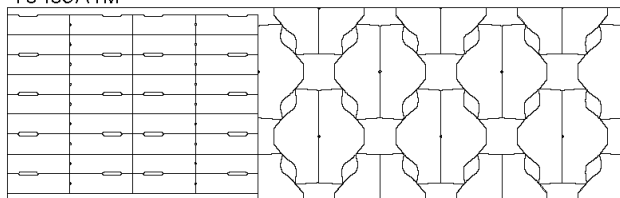
T0409A1XS



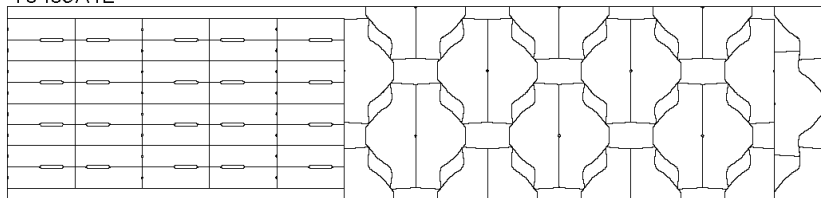
T0409A1S



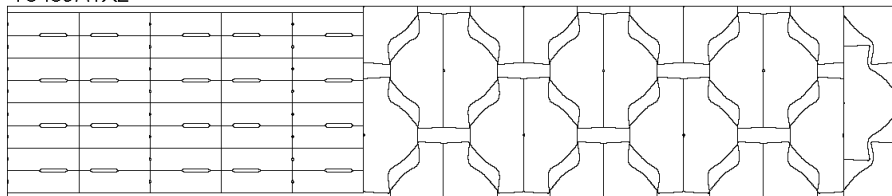
T0409A1M



T0409A1L

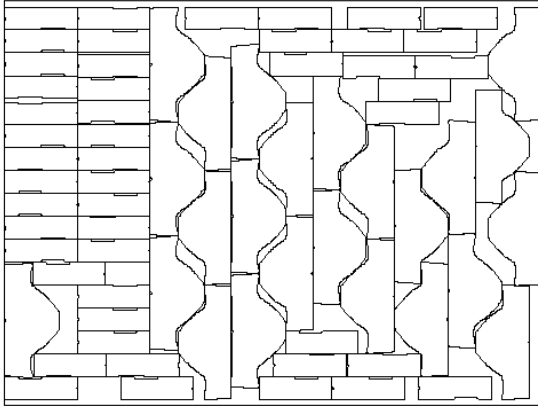


T0409A1XL

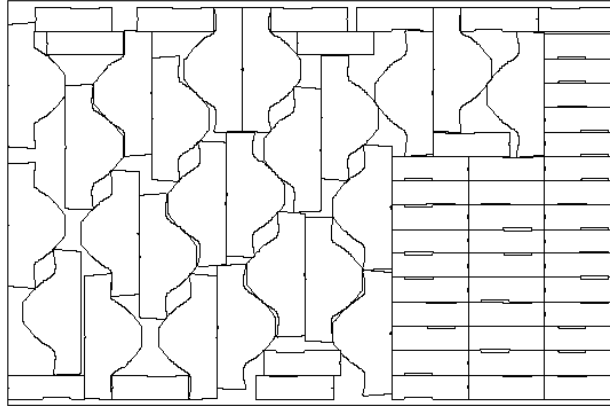


004 : Marker Layout - T0409A-60 FT,BK-70.5_T0409A2XS-S-M.png

T0409A2L

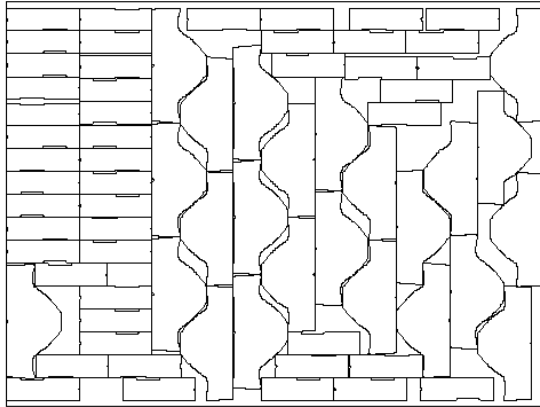


T0409A2XL

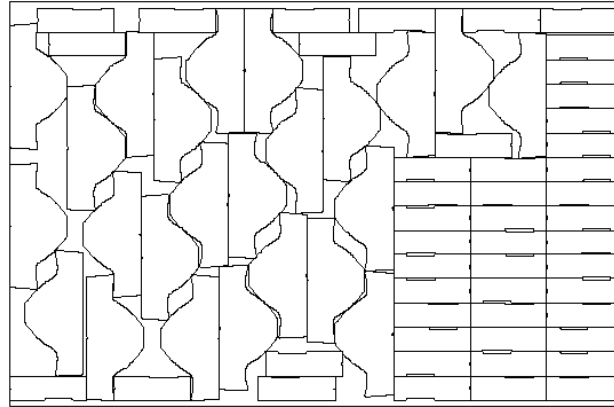


004 : Marker Layout - T0409A-60 FT,BK-70.5_T0409A2XS-S-M.png

T0409A2L

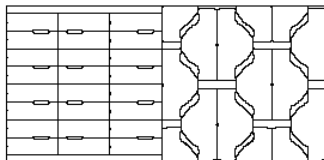


T0409A2XL

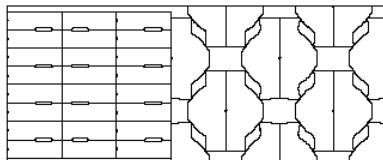


005 : Marker Layout - T0409A-60 FT,BK-31_T0409A4L-XL.png

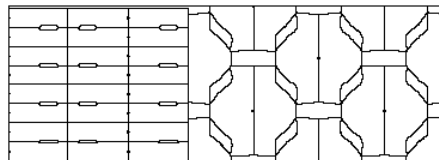
T0409A4XS



T0409A4S

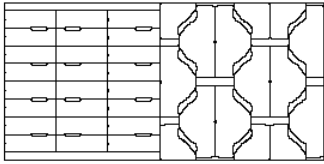


T0409A4M

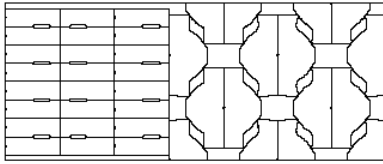


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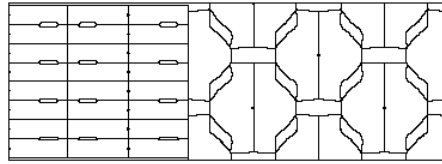
T0409A4XS



T0409A4S



T0409A4M

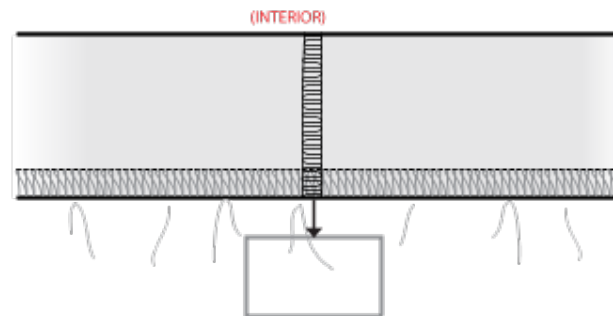
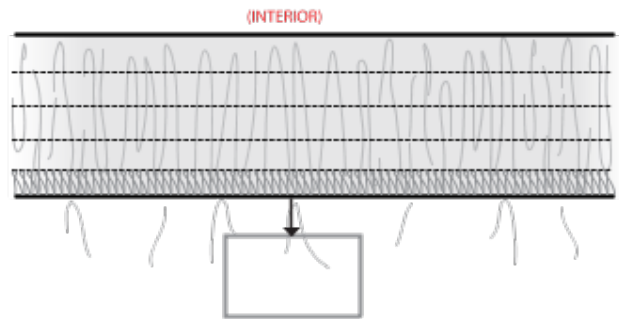


005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)_LP006 Fitted UW Inside Waist (no CB seam)-Cell1.
png

LP006: Inside Waist (no CB seam)

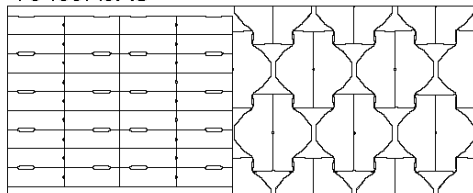
Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design

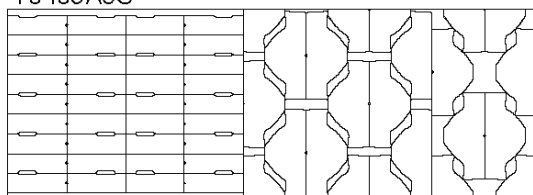


006 : Marker Layout - T0409A-60 FT,BK-35_T0409A35.png

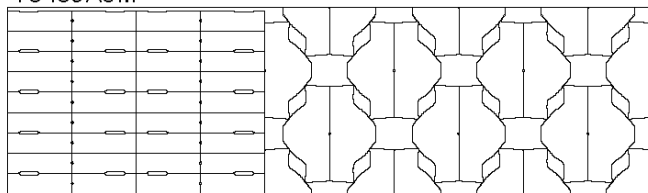
T0409A5XS



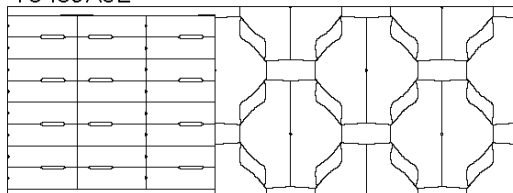
T0409A5S



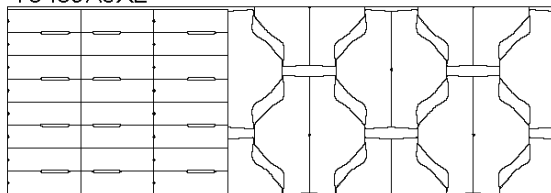
T0409A5M



T0409A5L



T0409A5XL



007 : Pattern Information - T0409A_T0409a-Cell1.png

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Spnd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	DM	DV	fabric	Fab. cat.	Message	acd	comment	sym.
1	T0409RFT	0	2	0	1	1	S13	FT	% x 5% shrink allow	0
3	T0409BEK	0	1	0	1	1	S13	BK	Boys Brief Exp Elas. 04-30-12	0
2	T0409BKE	0	1	0	5	1	S13	BKE	sample use	0
4	T0409RFT	0	1	0	2	1	ROP	FT	% x 5% shrink allow	0
5	T0409BEK	1	0	0	2	1	ROP	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

