

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-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

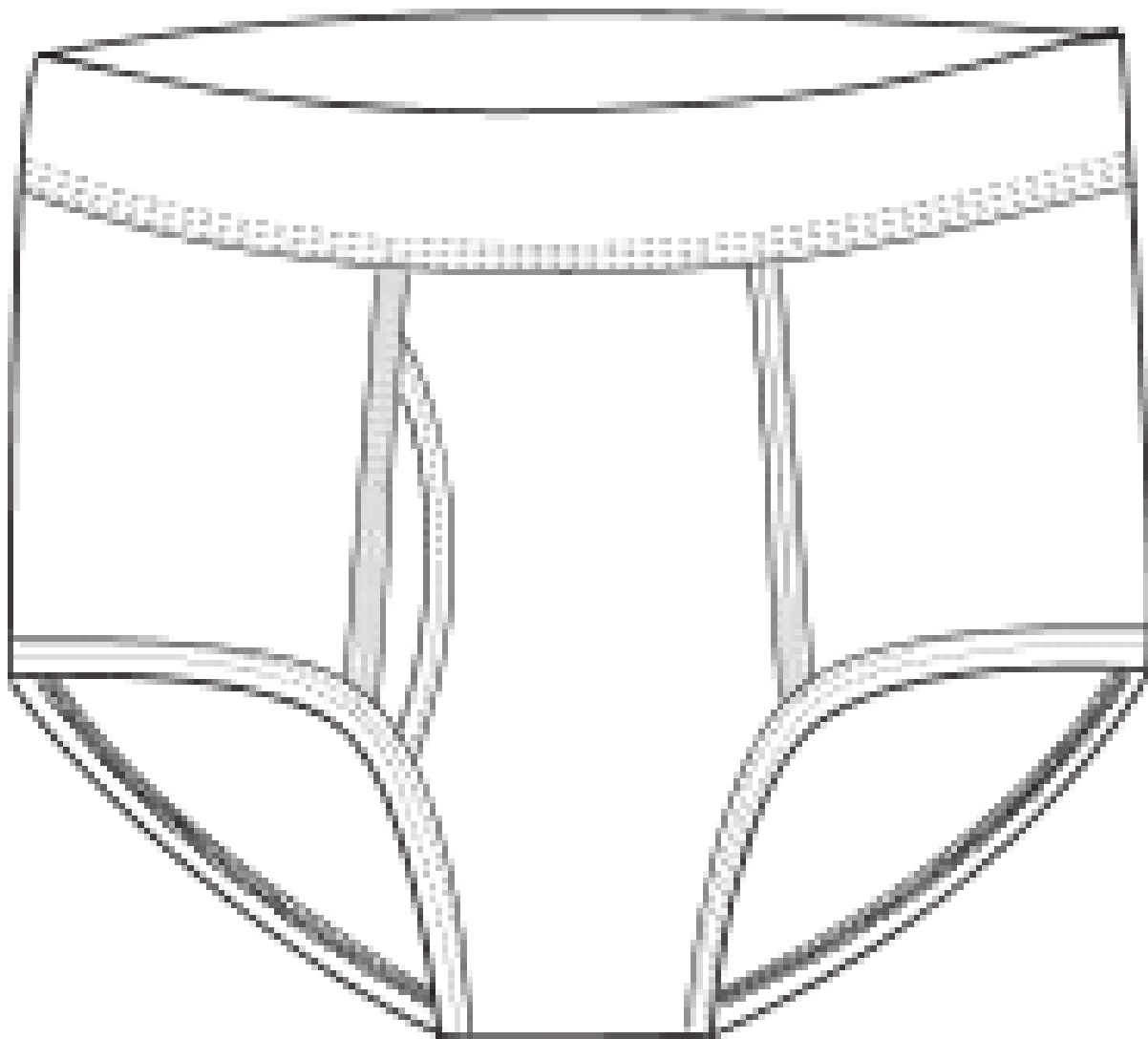
Colorways List

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)

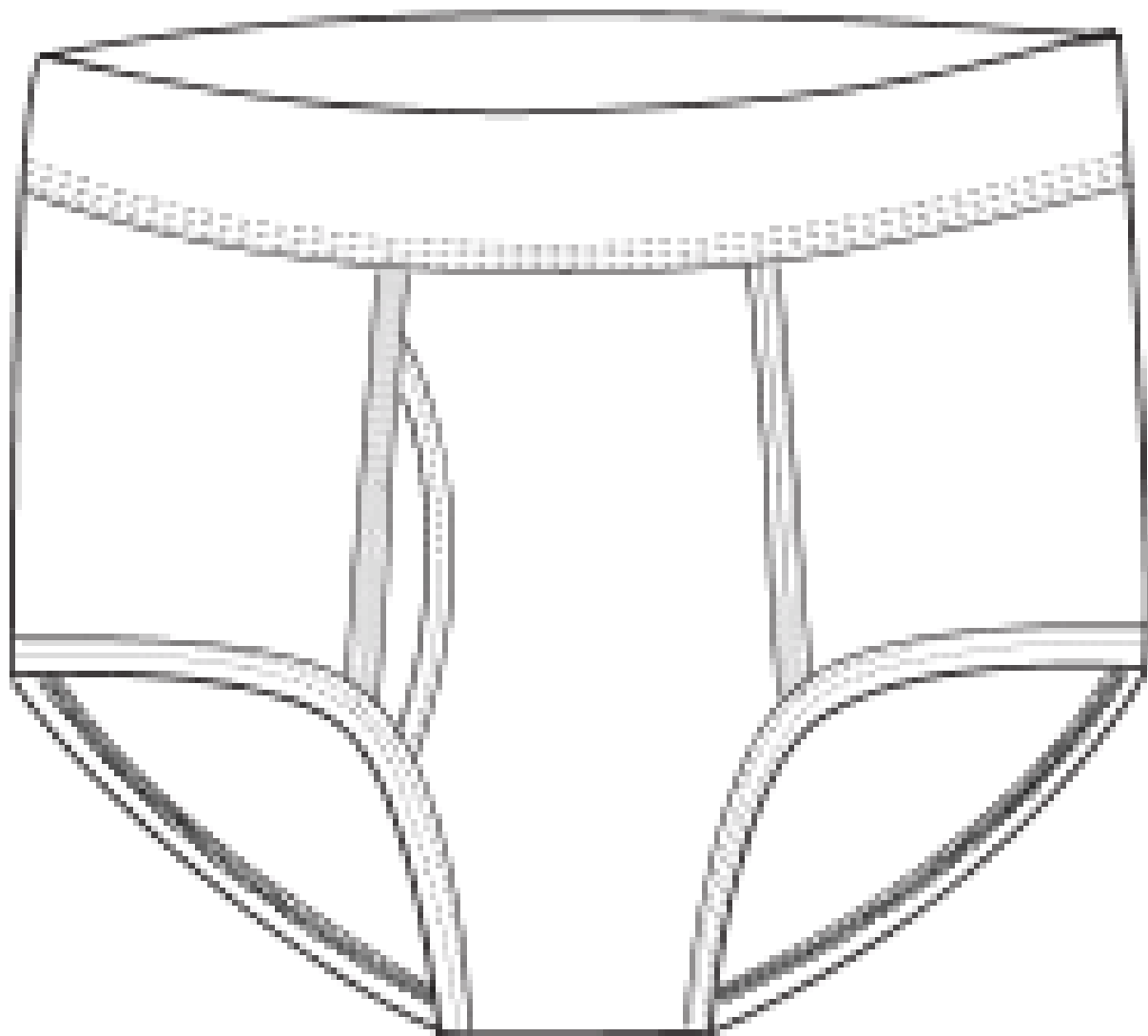
Sew Boms

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



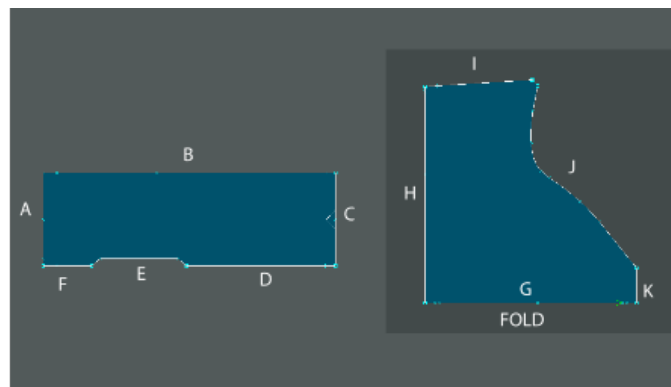
001 : Front/Back Image - Boys Ctn Knit Rib ExpWB_B252.2252.7764ft.bk-Cell1.png



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;"> 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;"> <thead> <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> </thead> <tbody> <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> </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										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: BBS07																																												

002 : Measurements - T0409A PMEAS_B252 PMEAS-Cell1.png



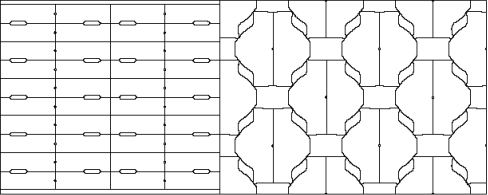
=Seasonal Sizes

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

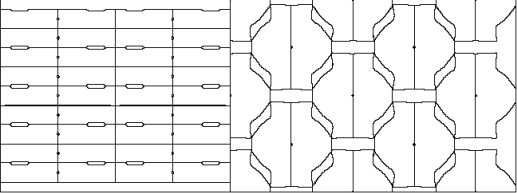
Note: All measurements are displayed in 32nds. Please refer to FlexPLM User Training Manual-PRODUCT SPECIFICATIONS for conversion chart.

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

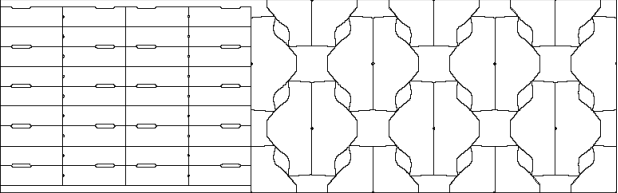
T0409A1XS



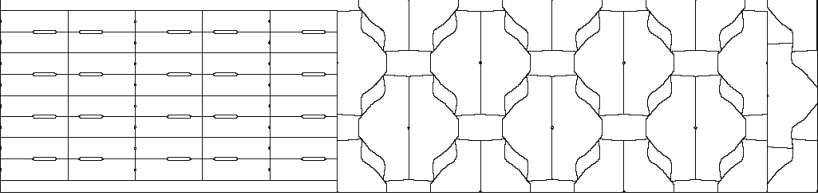
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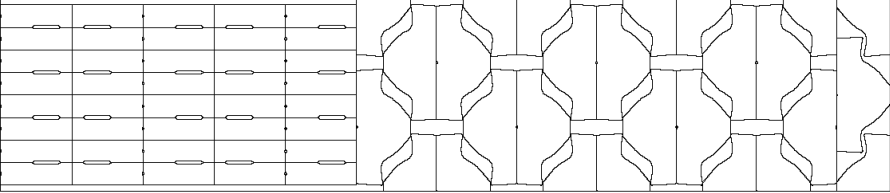
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T0409A1L

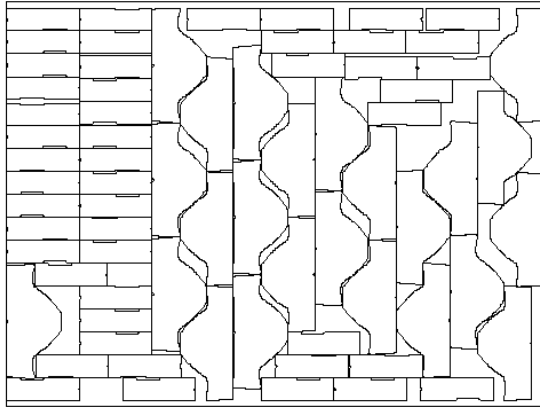


T0409A1XL

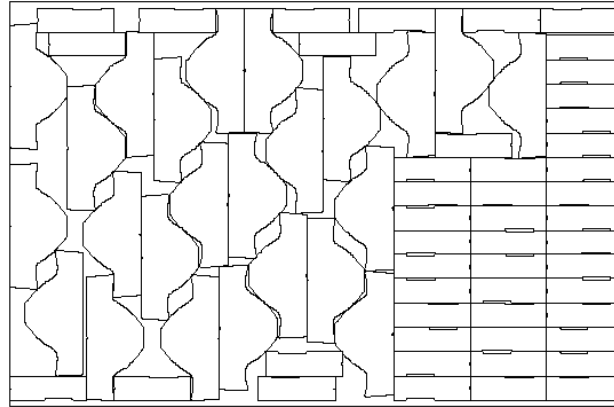


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T0409A2L

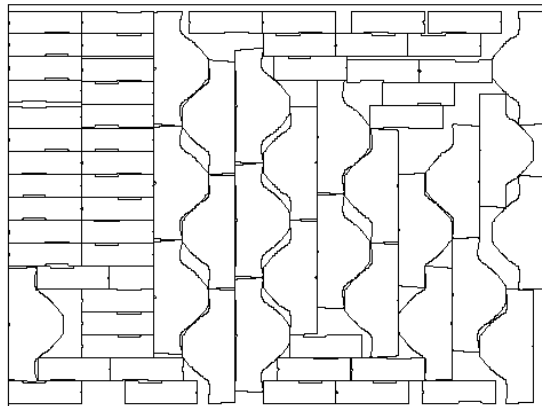


T0409A2XL

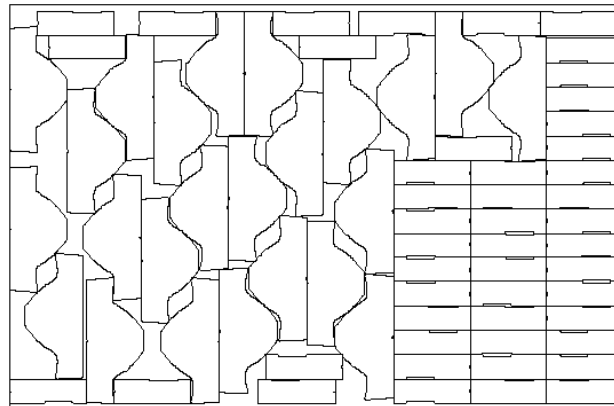


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T0409A2L

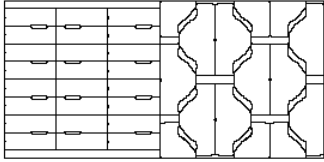


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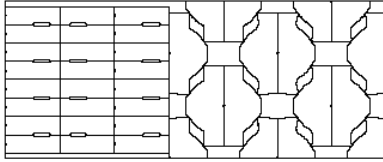


005 : Marker Layout - T0409A-60 FT,BK-31_T0409A4L-XL.png

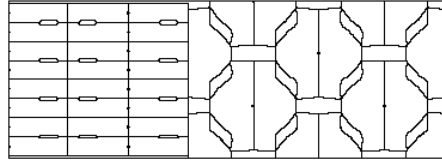
T0409A4XS



T0409A4S

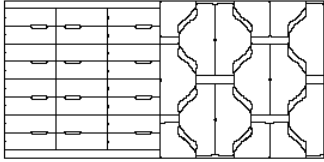


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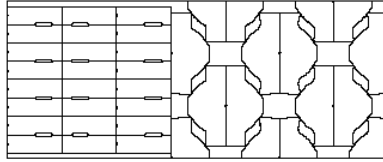


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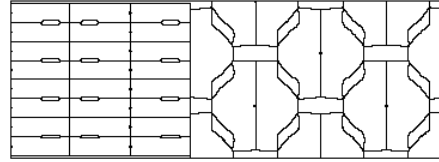
T0409A4XS



T0409A4S



T0409A4M

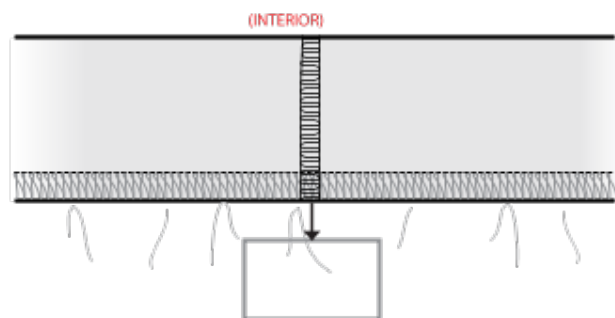
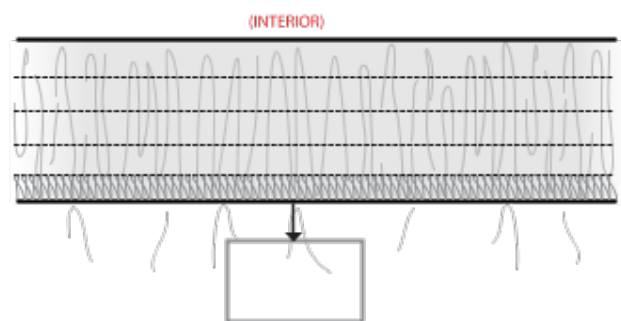


**005 : Placement Details - LP016: Fitted UW Inside Waist (no CB seam)_LP006 Fitted UW Inside Waist (no CB seam)-Cell1.
png**

LP006: Inside Waist (no CB seam)

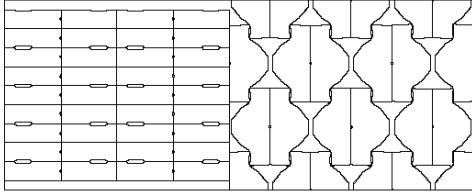
Placement Finished Garment: Centered on Back; 1/2" Down From Stitch/Seam

Placements are to the center/highest point of the design

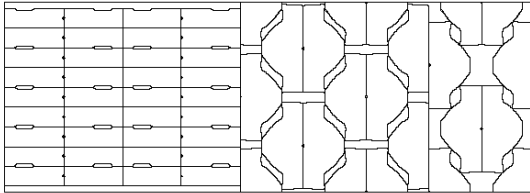


006 : Marker Layout - T0409A-60 FT,BK-35_T0409A35.png

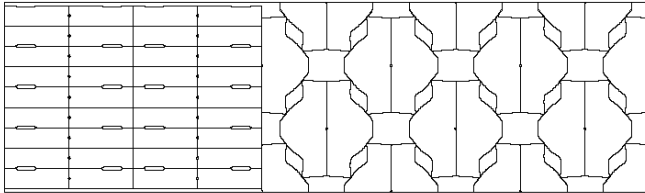
T0409A5XS



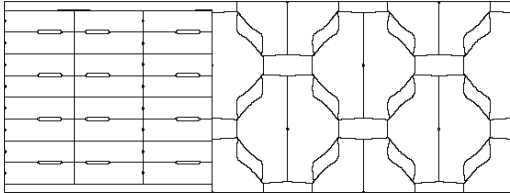
T0409A5S



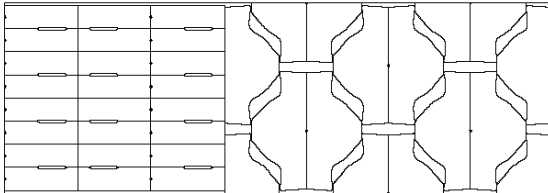
T0409A5M



T0409A5L



T0409A5XL



007 : Pattern Information - T0409A_T0409a-Cell1.png

CAD Storage:

Variant Screenshot: UW-Youth

T0409A - ModarisV6R1

T0409A 5/5 Articles


Sprd/Graphics

Variant

Piece Article

Export/Print

Links



	Piece name	S	DM	IV	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

