

URBAN OUTFITTERS MINIMUM QUALITY AND CONSTRUCTION STANDARDS: SWEATERS

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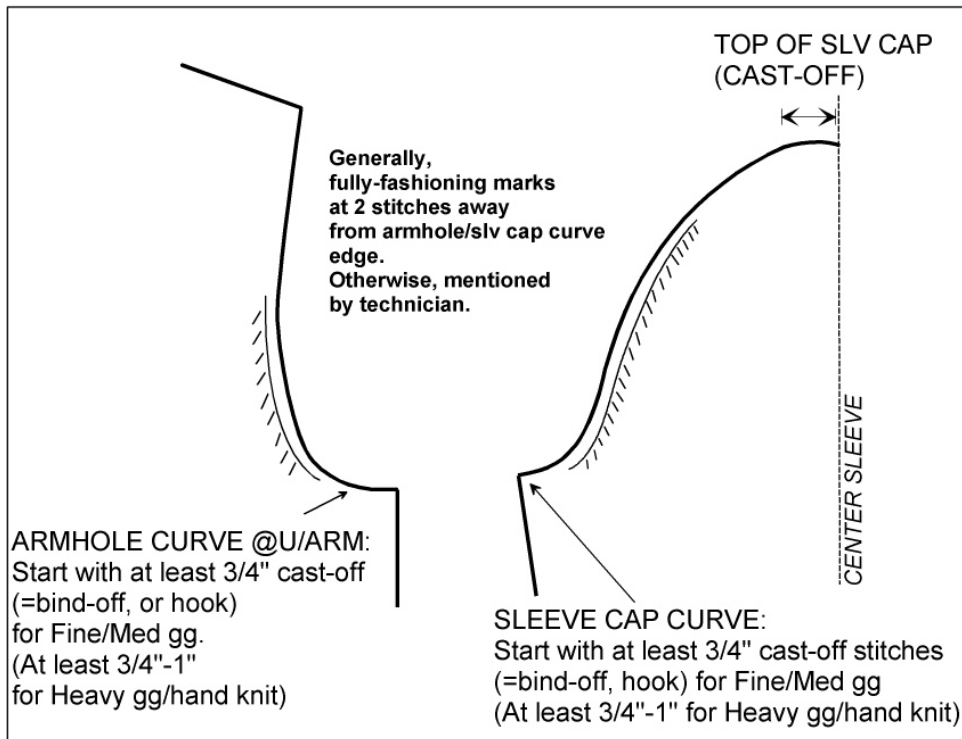
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The minimum quality and construction standards below are focused on sweater products only. Follow the general “Urban Outfitters Minimum Quality and Construction Standard” for other quality and construction standards which are not explained below.

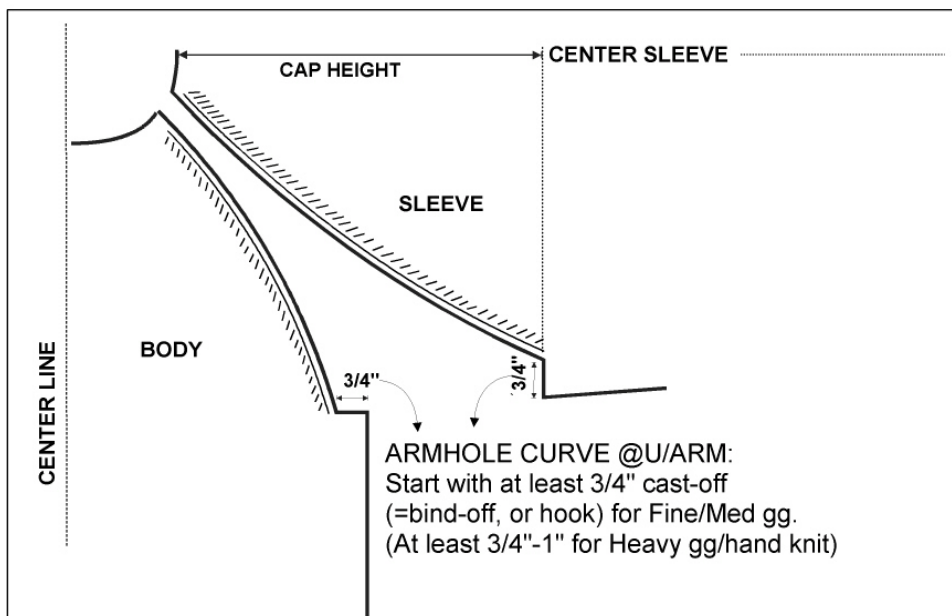
ARMHOLE CURVE & SLV CAP CURVE SHAPE

- Must have cast-off stitches at underarm on both body and sleeve panel. The only exception is the drop shoulder style.

SET-IN SLV ARMHOLE & SLV CAP CURVE SHAPE



RAGLAN SLV ARMHOLE & SLV CAP CURVE SHAPE



- To have bottom of armhole to reach underarm when garment is worn, add cast-off stitches (=bind-off stitch or hook) at underarm, before armhole curve/sleeve cap curve start.
- Visible/invisible ff marks and placement of marks to be determined by technician.

BEADS/SEQUINS

- Must be securely attached with a maximum float of 3/4". The floats must be double knotted every 1". At least 6 extra beads of every kind used on a garment must be placed in a poly bag which is attached with the price ticket.

BELT LOOP TYPE

- EYE LOOP/RABBIT EAR: Exits and enters at same point on side seam.
- 2 POINT LOOP: Exits and enters on two different points at side seam.



Chain stitched Eye (=Returned) Loop



Chain stitched – 2 PT Loop

Tech designer to advise belt loop quality

1. Use self-yarn, unless specified by technical designer.
2. Must be knitted to length.
3. Refer to the tech pack for specified placement.
4. Belt loop must be sewn or tacked securely to sustain normal use and washing.

BELT/TIE AND DRAWSTRING



ALL NEEDLE RIB



SPAGHETTI STRING

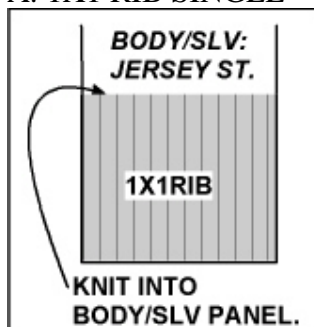
- Full needle Rib Strip/Spaghetti string :
 1. Most common construction for belt and tie; follow tech pack for correct quality
 2. Must be knitted to length with self-start and cast-off.
 3. If belt/tie is wider than 3/8" and supposed to be tacked at side seam, tie must be inserted during sewing of side seam.
 4. If belt/tie is narrower than 3/8" and supposed to be tacked at side seam, tie should be tacked securely to the side seam and finished from the inside of garment.
 5. End of yarn from cast-on and cast-off of the belt/tie must be tucked away properly.
 6. If tie is supposed to be tacked on garment, it must be tacked securely to sustain normal use and wearing.

BOTTOM/CUFF CONSTRUCTION

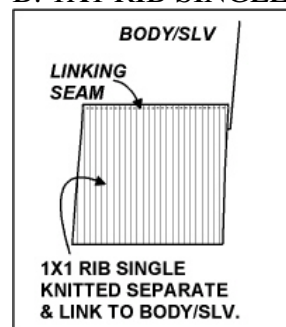
- Below construction sketches are most commonly used bottom/cuff trim.
- Most construction described below can be used for neck and placket trim as well.
- Bottom and cuff trim can be plaited with lycra on entire trim ht. Or lycra can be added on cast-on edge only for better recovery of the trim and stretch. Adding lycra on trim should be specified by technical designer.
- Hem edge must be smooth and flat with good recovery. No wavy edge. No pouch right above the bottom/cuff trim caused by improper knitting tension; unless otherwise requested
- For separately knitted bottom/cuff trim, the trim must be attached to body/sleeve panel with linking seam, unless specified by technical designer.

BC TRIM #1:

A: 1X1 RIB SINGLE

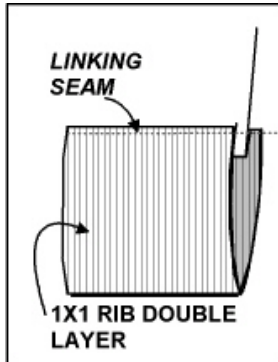


B: 1X1 RIB SINGLE



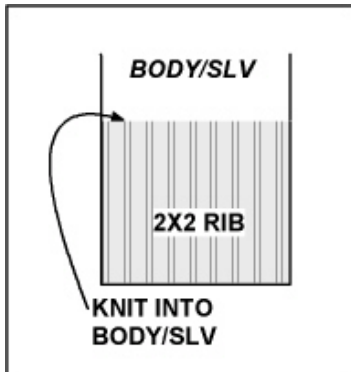
BC TRIM #2:

1X1 RIB DOUBLE/TUBULAR

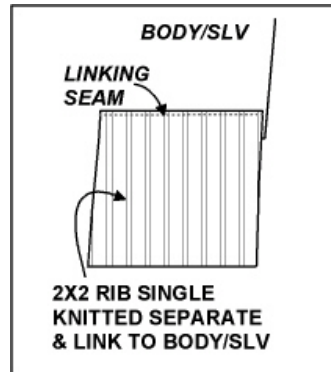


BC TRIM #3:

A: 2X2 RIB SINGLE

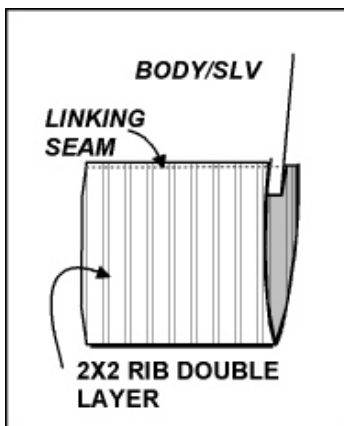


B: 2X2 RIB SINGLE

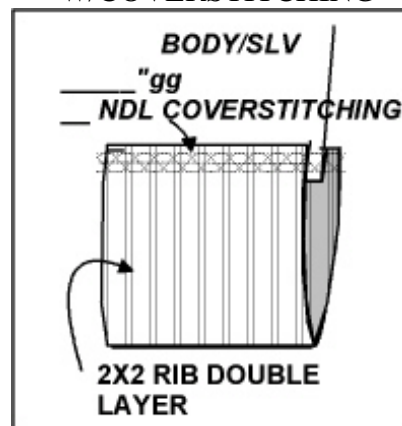


BC TRIM #4:

A: 2X2 RIB DOUBLE/TUBULAR



**B: 2X2 RIB DOUBLE/TUBULAR
W/COVERSTITCHING**



BC TRIM #5:
SELF-START



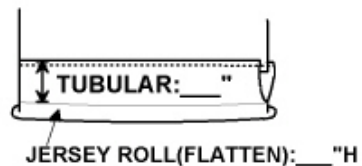
SELF-START ON 2 COLOR FLOAT JAC. FABRIC

BC TRIM #6:
A: JERSEY ROLL.

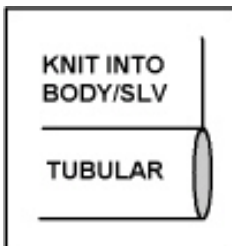


B: JERSEY ROLL WITH TUBULAR BASE
LINKED TO BODY/SLV PANEL

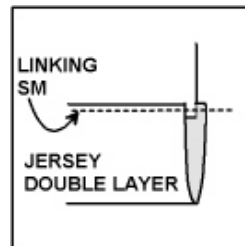
BOTTOM/CUFF TRIM:
JERSEY ROLL INTO TUBULAR.
EDGE OF BODY/SLV IS SANDWICHED
BETWEEN TUBULAR TRIM.
KNITTED SEPARATE & LINKED.



BC TRIM #7:
A: JERSEY TUBULAR



B: JERSEY TUBULAR. KNIT SEPARATE.



BC TRIM #8:

- CROCHET EDGE. CROCHET STITCH CAN BE APPLIED ON BOTTOM/CUFF EDGE.
- CROCHET STITCH LAYOUT TO BE SPECIFIED BY DESIGN.
- PICTURES BELOW ARE SEVERAL EXAMPLES OF HAND CROCHET STITCH LAYOUT.



Scallop edge crochet stitch



picot scallop crochet stitch



BC TRIM #9:

MODIFIED ALL NEEDLE RIB/FLAT BACK TO MIMIC RIB STITCH LOOK WITH STRAIGHT SIDE SEAM SHAPE. STITCH LAYOUT FOR MODIFIED ALL NEEDLE RIB IS SPECIFIED BY TECHNICAL DESIGNER.

Mock 1x1rib on modified all needle rib stitch/FLAT BACK



Face view



Bottom view

CLOSURE: BUTTON, HOOK & EYE, SNAP

- **BUTTON CLOSURE** – Buttons must be sewn securely and buttonholes must be the correct size for the button. The center of the button must align with the edge of the buttonhole.
 1. Hand Stitching- Needle is threaded with 2 plies, each hole gets 4 passes, wrap 2 times, double knot securely. Caution: DO NOT thread needle with more than 2 plies
 2. Machine Stitching- Use Lockstitch 304 Buttonsewer (this machine interlocks the needle thread with a bobbin thread so that it will not unravel) - Each hole gets at least 4 passes and must be knotted securely.
 3. All buttonholes must be densely stitched and the buttonholes cut with sharp knives so that there are no visible raw edges or threads in the buttonholes.
 4. Must be correctly aligned and spaced for their size and for the location of their use.
 5. An extra button must be placed in a poly bag which is attached with the price ticket or care label as specified by technical designer.
- **HOOK & EYE, SNAPS**–
 1. Must be securely attached to the garment.
 2. Thread needle with 2 plies, each hole gets 4 passes, wrap 2 times, double knot securely. Caution: DO NOT thread needle with more than 2 plies.

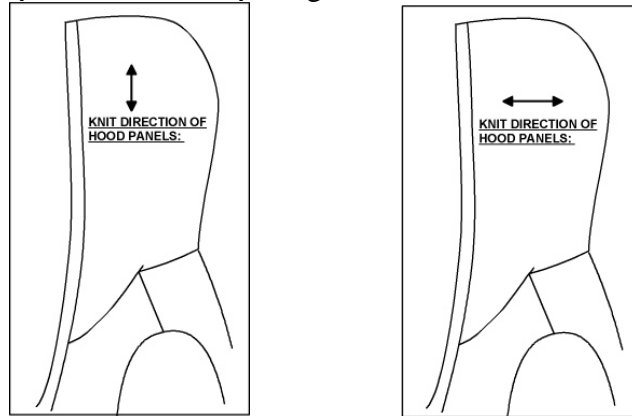
HANGER LOOP

- Garments with wide necklines over 10” must have hanger loops unless specified by technical designer.
- Deep double V-neck must have hanger loops.
- Edge of hanger loop must be clean finished or heat seal cut.
- Refer to Tech Pack for required length, quality and placement.
- Must be securely attached to sweater.

HOOD & HOOD OPENING TRIM

- See bottom/cuff, neck trim, and placket trim construction section for hood opening trim construction reference.
- Bottom of hood must have shape to fit neck contour.
- Hood shape at back of top should be smoothly curved. No bump at back corner.
- Hood consists of 2 pc or 3 pc panels, specified by designer/technical designer.
- For a style which has drawstring pulls through on hood opening trim, the opening for drawstring must be created by knitting unless specified by technical designer.

- Hood panel and hood opening trim can be vertical or horizontal knitting.



JACQUARD KNITTING TECHNIQUE TYPE

FLOAT JACQUARD:



Top View



Bottom View

INTARSIA:



Top View

Bottom View

LADDERBACKING JACQUARD:



Top View

Bottom View

INTARSIA + LADDERBACKING JACQUARD:



Top View

Bottom View

WELT BACKING JACQUARD:



Top View

Bottom View

BIRDSEYE BACKING JACQUARD:



Top View

Bottom View

TUBULAR JACQUARD:



Top View

Bottom View

KNITTING REQUIREMENT

- Knitting tension must be approved by designer/technical designer.
- No bare, broken, knotted yarn on garment.
- Stitch shape must be even throughout the garment. No zigzagged stitches or skipping stitches unless desired.
- No knotted end of yarn on face side of garment. The end of yarn must be tucked inside of garment.
- All yarn must be colorfast.
- Must not have more than 5% torque on sweater.
- For printed sweater, the print quality should be uniform throughout the garment, No poor registration or dye streak. No break in print pattern.
- For float Jacquard pattern, maximum float length 3/4".

- Jacquard and stripe pattern must match at side and armhole seam, unless specified by technical designer.

LINKING SEAM

- All sweater panels must be sewn using linker, unless specified by technical designer.
- All linking seams must have stretch and strength comparable to stretch and strength of the sweater fabric itself.
- Use best practice to decide appropriate linking machine gauge.
- Generally, self-yarn as linking thread quality.
- For textured or chunky yarn, use DTM straight yarn as linking seam yarn. The factory must inform technical designer in advance, if different type of yarn needs to be used on linking seam. Linking seam yarn must have comparable performances as sweater fabric itself.
- For cotton/cotton blends, wool/wool blends yarn on fine gauge sweater (12 gg and higher) with bodice seam or seam on bodice, add stretch nylon yarn on linking seam in addition to self-yarn.
- Linking seam must not shrink/stretch during and after washing more than sweater's shrinkage.

NECK & ARMHOLE TRIM

- Neck trim must have good recovery and stability.
- Must be knitted to height and length, unless specified by technical designer.
- Yarn from cast-on and cast-off(bind-off) edge must be cut short and tucked away properly.

NAT #1:

1X1 RIB SINGLE



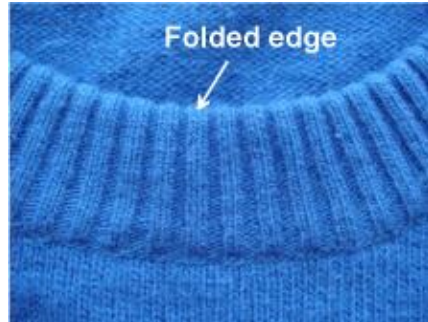
1X1 RIB DOUBLE/TUBULAR



NAT #2:
2X2 RIB SINGLE



2X2 RIB DOUBLE/TUBULAR



2X2 RIB WITH JERSEY TUBULAR BASE TRIM



NAT #3:
JERSEY TUBULAR



NAT #4:
JERSEY ROLL. JERSEY ROLL CAN BE ITSELF OR CAN BE COMBINED WITH RIB TRIM.



Jersey roll with rib

NAT #5:

SELF EDGE ON JERSEY STITCH FABRIC. THE EDGE TENDS TO ROLL.



NAT #6:

SELF CAST-OFF ON JERSEY STITCH FABRIC WITH HALF-MILANO STITCH ON BACK SIDE. SEE PT#8 PICTURE ON “PLACKET TRIM” SECTION.

NAT #7:

ALL NEEDLE RIB(= FULL NEEDLE RIB). CAN BE VERTICAL OR HORIZONTAL KNITTING DIRECTION. ALL NEEDLE RIB STITCH LAYOUT CAN BE MODIFIED.



All needle rib strip-Vertical direction



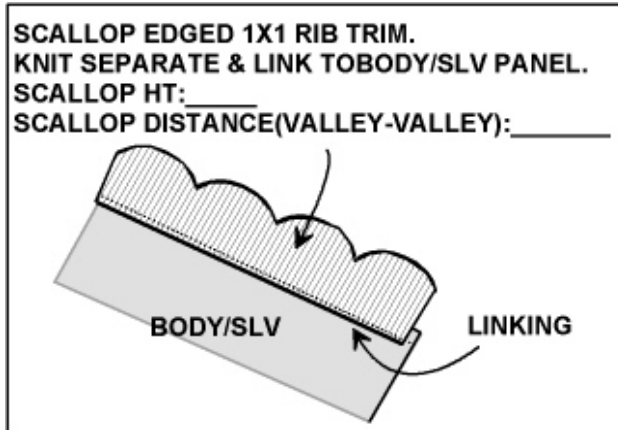
An example of modified all needle rib/flat back rib



Bottom view

NAT #8:

1X1 RIB WITH SCALLOP EDGE: SCALLOP DISTANCE AND HEIGHT TO BE SPECIFIED BY TECHNICAL DESIGNER.



NAT #9:

SCALLOP EDGE ON TUBULAR: SCALLOP DISTANCE & HEIGHT TO BE SPECIFIED BY TECHNICAL DESIGNER.



NAT #10:

LINKS & LINKS STITCH STRIP



VERTICAL KNITTING DIRECTION

NAT #11:

CROCHET EDGE: CROCHET STITCH REFERENCE DETERMINED BY TECHNICAL DESIGNER. THERE ARE MANY VARIATIONS ON CROCHET PATTERNS.

PLACKET

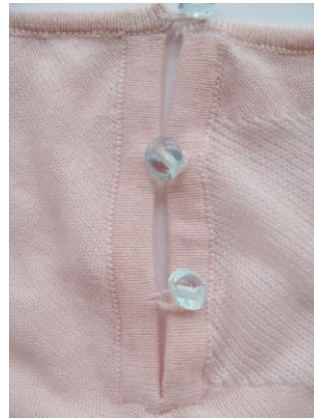
- Placket trim must be knitted with proper knitting tension, so there would not be any gapping on placket edge once garment is finished.
- No gapping on placket trim edge from loose knitting tension.
- Placket trim must be knitted to length and width unless specified by technical designer.
- Use proper placket trim length, so top of placket or bottom of placket at hem can be straight without being pulling fabric around or hiking up.
- Sweater fabric must stay flat around placket seams. No bulging of sweater due to inappropriate placket trim length.

PLACKET TRIM:

Placket application type:



Overlap Application



Kissing Application

PT #1:

JERSEY TUBULAR TRIM ON KISSING APPLICATION.



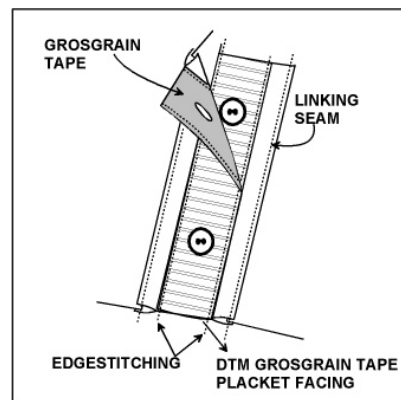
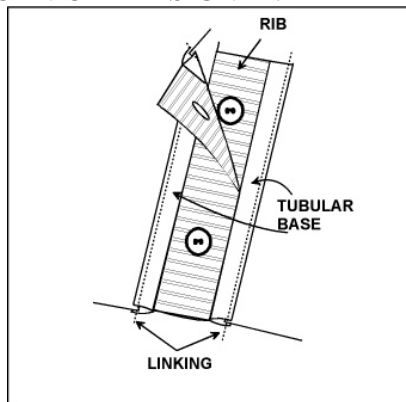
PT #2:

SELF-FABRIC FOLD-OVER WITH KISSING APPLICATION. NO SEPARATE TRIM.



PT #3:

RIB STITCH WITH TUBULAR BASE/JOIN. THE RIB STITCH LAYOUT SPECIFIED BY TECHNICAL DESIGNER.



TRIM FACED WITH GROSGRAIN TAPE

PT #4:

GROSGRAIN TAPE DOUBLE LAYER. NO KNITTED FABRIC. PLACKET EDGE OF BODY FABRIC IS SANDWICHED BETWEEN LAYERS OF GROSGRAIN TAPE.



PT #5:

SELF-FABRIC FOLD-OVER. GENERALLY, FACED WITH ALL NEEDLE RIB (=FULL NEEDLE RIB) STRIP.



BUTTON CLOSURE



SNAP CLOSURE

PT# 6:

ALL NEEDLE RIB TRIM. TRIM CAN BE VERTICAL OR HORIZONTAL KNITTING DIRECTION.



PT #7:

LINKS & LINKS STITCH TRIM. CAN BE VERTICAL OR HORIZONTAL KNITTING DIRECTION SPECIFIED BY TECHNICAL DESIGNER.



PT #8:

SELF EDGE WITH HALF-MILANO STITCH INSIDE AS FACING.



Face side: Jersey stitch



Bottom view: Half-milano stitch facing

POCKETS

- Fine gauge (12gg and higher) Jersey stitch as pocket bag fabric quality using self-yarn, unless specified by technical designer
- Pocket must be knitted to size, unless specified by technical designer.
- Pocket bag must not extend below hem, unless desired.
- Pockets must be balanced between Right and Left side unless otherwise advised
- Top corners of pocket opening edge must be securely attached to sweater to sustain normal use.
- Tack pocket bag to garment using crochet chain stitch string to stabilize pocket bag specified by technical designer.
- Ribbed pocket opening trim must be proper length, so sweater around the edge of pocket opening would not be pulled.

PATCH POCKET:

- Self finish edge all around, unless specified by technical designer.
- Pocket placement to be specified by technical designer.
- Pocket opening trim stitch to be specified by technical designer.



Pocket with Tubular opening trim



Pocket with Flap

WELT POCKET

- Fine gauge Jersey/Reverse Jersey stitch as pocket bag quality, otherwise specified by technical designer.



Top View



Bottom View with R. J. Pocket bag



Example of Slant welt pocket

INSEAM POCKET

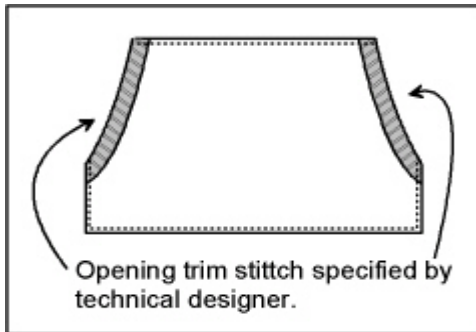


Top View



Bottom View with cut & sew pocket bag

KANGAROO POCKET



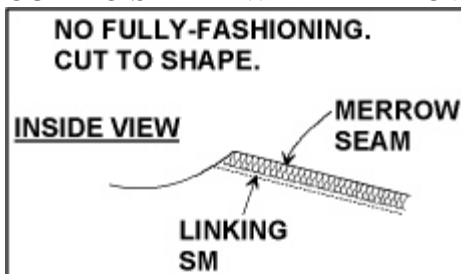
Example with 2x2 rib pocket opening trim

PRESSING

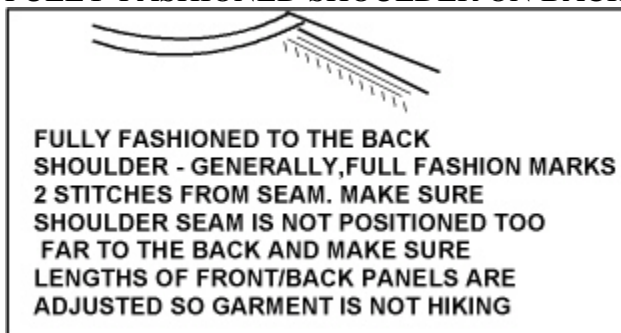
- All garments & garment seams must be fully pressed and wrinkle free unless specified by the Technical Designer. Lightly steamed/pressed. NO hard pressing or pressing to shape to meet spec
- Do not over-press the center of sleeves.
- No shiny pressing marks.

SHOULDER SEAM

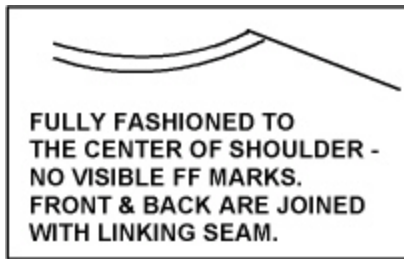
CUT-TO SHAPE WITH MERROW SEAM



FULLY-FASHIONED SHOULDER ON BACK PANEL/ CLASSIC BACK



FULLY-FASHIONED SHOULDER—SEAM ON NATURAL SHOULDER

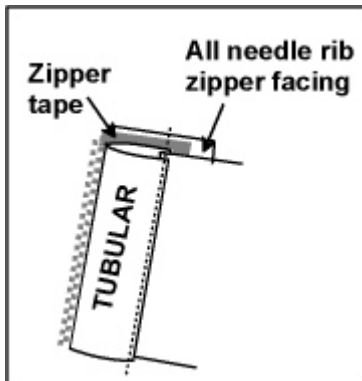


ZIPPERS

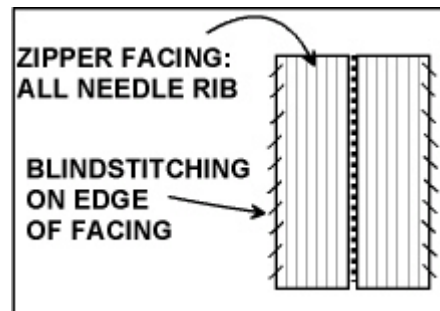
- Zippers must be fully operable.
- Use fine gauge (12 gg and higher) all needle rib (=full needle rib) strip as zipper facing trim to hide zipper tape. Unless otherwise advised by tech designer
- Use self-yarn as zipper facing quality unless specified by technical designer.
- Edge of zipper facing must not be caught during operation of zipper.
- Facing trim must be knitted to length.
- Blindstitch or handtack the edge of zipper facing to sweater.
- Use YKK zippers or equal quality must be approved by Urban Outfitters.
- Apply zipper with 301 single needle lockstitch.

ZA #1:

TUBULAR TRIM WITH HIDDEN ZIPPER TEETH



Face view



Bottom view

ZA #2:

TUBULAR TRIM WITH EXPOSED ZIPPER TEETH



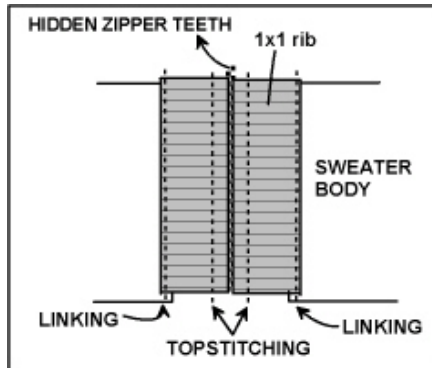
Face view



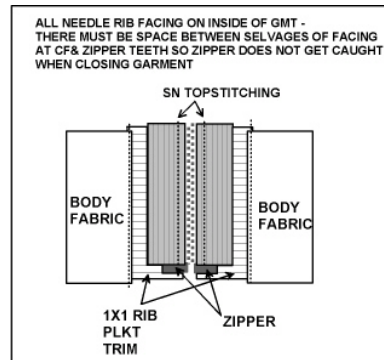
Bottom view

ZA #3:

1X1 RIB. THIS CAN BE SINGLE OR DOUBLE LAYER. ZIPPER TEETH CAN BE HIDDEN OR EXPOSED SPECIFIED BY TECHNICAL DESIGNER.



Face view



Bottom view

ZA # 4:

2X2 RIB. THIS CAN BE SINGLE OR DOUBLE LAYER. ZIPPER TEETH CAN BE HIDDEN OR EXPOSED SPECIFIED BY TECHNICAL DESIGNER.



Face view



Bottom view

ZA #5:

SELF-FABRIC FOLD-OVER. ZIPPER TEETH CAN BE EXPOSED OR HIDDEN. GENERALLY, FACED WITH ALL NEEDLE RIB(=FULL NEEDLE RIB).



Face view



Bottom view