
Processing guidelines for Workmanship, Production and Quality

Quality assurance for JAKO-O, FIT-Z and Qiéro!

Standards and regulations:

Baby and kids styles must be conform with:

- [DIN-Norm EN 14682:2014](#) „Safety of children's clothing - Cords and drawstrings on children's clothing - Specifications “
- [DIN EN 71-1:2014](#) „Safety of toys“ in terms of small parts

Workmanship:

- Fabrics have to be free from defects. Fold lines in front or back of the garment part are not accepted.
- Shoulder seams have to be advanced into front part about 1,0cm (for Babies 0,7cm).
- The stripe and check pattern must match at side seam, in the center front and center back. (Special regulations must be approved by the Quality assurance.)
- All fixed waistband variations have to be worked with interlining. The exception is for adjustable and/or elastic waistband versions.
- Always use proper material-specific needles. Holes and ladders must be avoided.
- Pay attention to a clean inside workmanship. Seam or thread ends have to be secured and trimmed clearly.
- Take care of a clean and symmetrical workmanship.
- All 2-needle-seams must be worked clear and secured with an additional sink-stitched bar tack. Ripped or broken seams are not accepted.
- Pay attention to a straight mesh line/thread line.
- Ironing marks, fold lines, stains and other impurities are not accepted.
- Seam allowances must always be placed into the same direction.

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- All seams shall be worked elastically according to the material elasticity.
 - Take care of a constant thread tension. Stitch length 4-5 stitches/1cm.
 - Distance between buttons and button holes must be equal.
 - Shoulder seams have to be worked with an elastic shoulder band.
 - Topstitchings must be worked parallel to the edges or seams.
 - Allover prints or placed prints must be accurate and free from defects.
 - Shell fabric and lining must be slip resistant.
 - Darts must be sewn flat. Bags at the dart ends are not accepted.
 - Closing seams must be sewn with a 4-thread-safety-stitch. (minimum 8mm)
 - Embroidery/Applications must be backed with a suitable interlining.
 - All tops with zipper must be worked with a facing or with a ribbon band at the inside of zipper.
 - All tops with zipper must be worked with a chin-protection.
 - Before cutting, all fabric rolls need to be checked on its colour fastness and shrinkage.
 - All ingredients must be tested for their wash durability. Metal accessories are not allowed to oxidize.

Trimmings:

- Generally spare buttons must be mounted with buttonable articles (from 2 buttons). Those have to be attached to carelabel so the material and care instruction is still readable. For press buttons or jeans buttons there is no need for a spare button.
- The Artwork of carton label for stockings will be sent from the buying department for the respective order.
- For all required hangtags, note detail placement. Own material or functional hangtags (eg Polartec® oder bluesign®) can be applied after consultation of Quality assurance.
- Buttons and rivets must be worked securely.
- All details and labels may only be purchased from the specified supplier.
- For detail and label position note our detail placement.
- Zippers must not have sharp edges.
- For the crotch button panel for Baby Bodies snap buttons in size 15“ LIN must be used.
- Baby bodies must be worked with a gusset extension at crotch, except this is not explicitly required.

Tops:

- The neck opening / arm holes should not be stretched out or gathered in while sewing.
- The neckline (rib / piping) must have an even shape and must lie flat.
- The neck should not be stretched out or gathered in while sewing in the collar. The collar seam must be even in width.
- The armhole must not be stretched out or gathered in when sewing the sleeves. The extra width on the sleeve must be evenly distributed over the sleeve head.
- The upper collar must cover the collar stand.
- The collar button must be placed correctly, the overlap must cover exactly the underlap in the center front.

Bottoms:

- The line of waistband in center front needs to be at 90° angle.
- The waist button must be placed correctly, the zipper seam must not be pulled apart. The zipper must be opened and closed easily over the waistband seam.
- Waistband facing must not be visible on the right side.
- Front and back rise seams must not be stretched out or gathered in while sewing or topstitching.
- The zipper overlap must not be weavy.
- The zipper bar tack needs to be at the same height as the end of zipper.
- The mesh line/thread line within the working piece and especially at hem must be straight.
- Side seams are not allowed to be stretched out or gathered in.

Knitwear:

Workmanship:

- All seams shall be worked elastically according to the material elasticity.
- All (rib) cuff-qualities must be with elastane, if this was not explicitly required otherwise.
- Neckbands at back neck opening must be elastic.
- The side seams in underwear articles must be worked with flatlock seams.

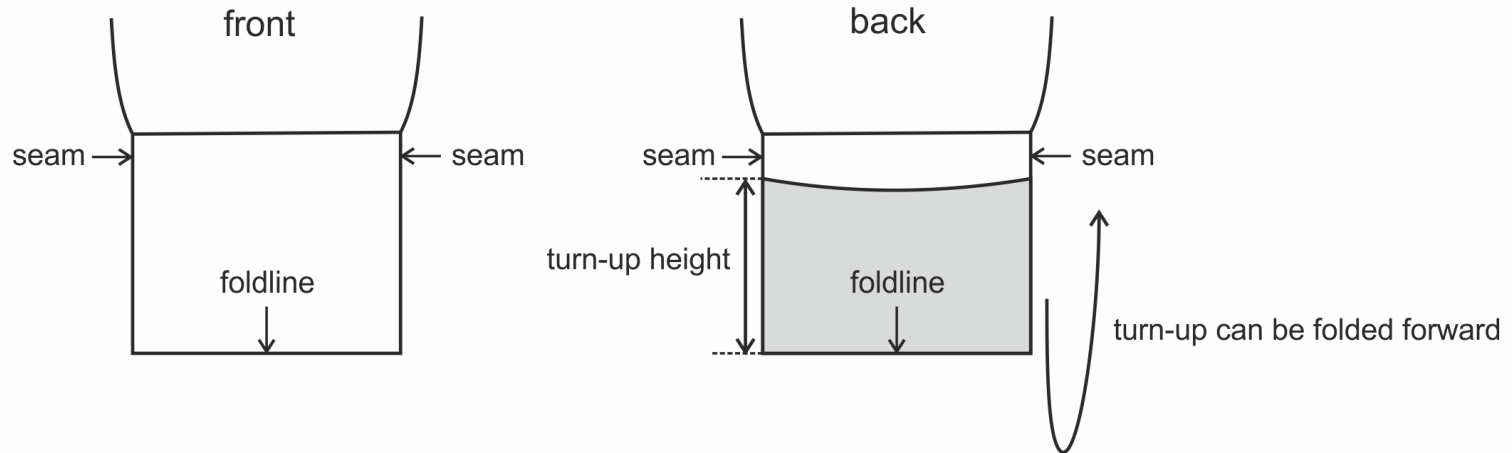
Buttons, embroideries, applications, zippers, other details:

- For button panels always use 2-hole-buttons.
- For all knitwear styles small buttonholes must be stitched safely; large buttonholes have to be knitted into the fabric.
- All jackets need to be with a hanger loop inside center back of neck. The hanger loop must correspond with DIN-Norm EN 14682:2014 .
- All buttonholes, snap buttons and eyelets must be with interlining and must be worked safely.

Product-specific workmanship for baby- and kids-styles (JAKO-O):

Baby:

- Neck openings worked with piping must be worked with 2 snap buttons. All styles with neck rib must be worked from size 80/86 with 3 buttons. Snap buttons (also at neck rib) must be worked with interlining. Size of interlining should be 1cm bigger than diameter of button. Snap buttons must be worked in safely, so holes will not appear.
- Button panels at crotch are only worked till size 80/86.
- For styles with folding cuffs: please note workmanship sketch!



Kids:

- All kids pants with fixed waistband must be with an adjustable buttonhole-elastic inside waistband.
- All pants with permanently inside elastic must have a buttonhole in center front.
- All rubber drawstrings and cord stoppers at hem must be secured with a ribbon band inside at side seam.

Woven fabrics:

Jackets and Blazer (only valid for FIT-Z and Qiéro!):

Workmanship:

- Armholes, neck holes, front part, collar and cuffs need to be fixed with a suitable interlining.
- All parts with lining must be worked with a movement pleat in center back from neck till hem edge.
- All blazer must be worked with eyelet buttonholes and bar tack. According to style also piped buttonholes can be worked.
- The inner lining of the right front part of outdoor-jackets should have a cell phone pocket. It should be placed at waist height. Upper edge should be worked with an elastic.

Buttons, zippers, other details:

- Generally buttons must be sewn with a stem.
- All jackets and blazer must be with a hanger loop in center back.

Transportation:

- Walking slits in center back must be secured for transport with a cross stitch.
- The pocket opening has to be closed for transport with large basting stitches.

Pants and Skirts:

Workmanship:

- For all pants and jeans the inside leg seams need to be closed first. Afterwards the front and seat seam must be sewn continuously.
- The lining of skirts must be worked with dart pleats.
- All kids pants with fixed waistband must be with an adjustable buttonhole-elastic inside waistband. For FIT-Z only till size 158.

Buttons, zippers, other details :

- All jeans pants are without hanger loops at waistband.
- Generally for skirts add 4 hangers at side seam, front part and back part.
- Metal buttons at waistband must be worked with plastic rings or a suitable interlining.

Blouses and Shirts:

Workmanship:

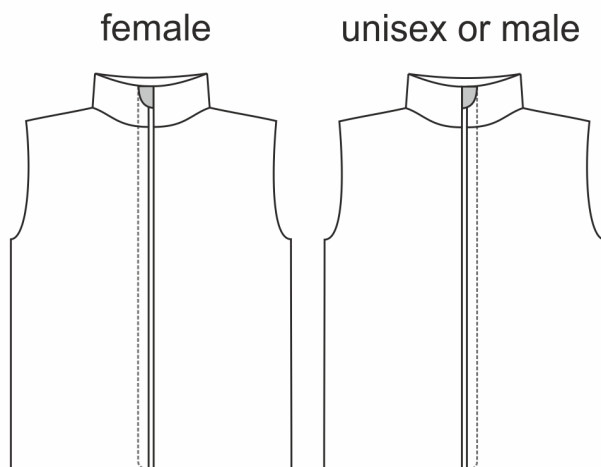
- Collar, cuffs and front edge must be worked with a suitable interlining.
- For buttonholes make absolutely sure that they are worked and cut clean.

Buttons, zippers, other details:

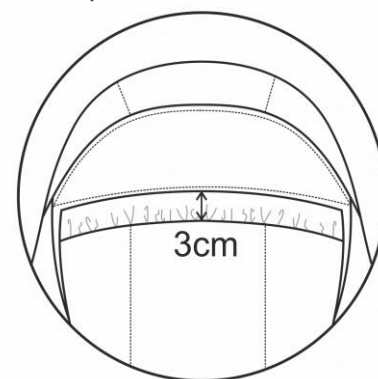
- For button panels always use 2-hole-buttons.

Functional articles

- The shoulder seams need to be advanced into front part 1,5cm (Babies 1,2cm).
- For the workmanship/placement of chin protection note sketch. This rule applies also for button panels and zipper facings.
- Zipper facings inside must be worked over the entire length of zipper.
- Sleeve cuffs with elastic must be worked with fleece on the inside.
- Hood/neck seam must be placed upwards.
- Wind protection hood: height in center front 3cm, elastic width inside max. 7mm. Also note sketch below.
- For pants with taped seams note, that inside leg seam must be advanced into the front ca. 3cm .
- Backside trimmings must be double stitched.
- Work overalls / pants with lining from the knees to hem with taffeta lining.



wind protection inside hood



elastic width max. 7mm