



Faculty of Engineering

Department of Textile Engineering

Topic/Title: Study on Buyers Comparison

Course code: TH-519. Course title: Project

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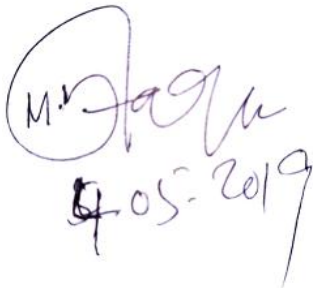
Designation: Professor and Head of Textile Dept.

A thesis submitted in partial fulfillment of the requirements for the degree of
Master of Science in Textile Engineering

May 4, 2019

Declaration

I hereby declare that this master thesis is my own work. I have acknowledged information & gather materials from different source. I have clearly marked and given references to all quotations & information that identifies this work is mine and there isn't any part of this paper which is directly copied or followed to acquire the educational certificate.



Mr. Jagu
4.05.2019

Supervisor's name: Prof. Dr. Md. Mahbul Haque

Designation: Professor and Head of Textile Department

Acknowledgement

This thesis has been oriented with the scope of Department of Textile Engineering at the Daffodil International University within the period of July 2018 to April 2019.

Due to personal preference and my educational background in Textile Engineering, I was interested in gathering information about the buyers in textile industry. Thus every manufacturing or innovation comes with the hand of the buyer's different requirements in textile industry, buyer's preferences and characteristics provide an extensive overview on trends for researchers to develop strategies and facilities that helps an organization to fulfill the buyer's requirements and quality.

Even though I am working to find out the buyers differences, this finding should also be open for further researches to update the information for time to time.

This research gave me a challenge to develop my information finding capabilities with classified data of different buyers in their purchase order. During the time of my research, I received enormous support from Prof. Dr. Md. Mahbubul Haque who supervised me during the stages of my research. I would also like to thanks all of those professionals working in textile industry/buying-house who provided me different information & materials of different buyers.

1. Md. Nazmul Islam, Elite Group.
2. Md. Faysal Nasir, Renascence Group.
3. Md. Mizanur Rahman, Adams Apparel.
4. Md. Kawsar Akon, Newage Group.
5. Md. Sajal Hossen, Denimach Ltd.
6. Md. Shobuz, Micro Fibre Group.
7. Md. Rafiqul Islam, Amantex Ltd.
8. Md. Firoz Al Mamun, Shonest Group.
9. Md. Shadeed Mostofa, Hamim Group.

Abstract

This research pointed out the buyer's characteristics, difference in behavior & instruction's while placing orders of knit-t-shirt, woven shirts & woven pants. To find out these criteria's, technical data sheets & order sheets were collected from various factories and buying houses. Differences were found out by separating individual components and factors that mostly differentiate them from each other. Different aspects were investigated like; fabric construction, design, sewing threads count, SPI, Button, GSM of fabric, Dyeing, washing, finishing, measurements, shipment, costing, payment & order. Major differences were found in fabric, design & making, measurements and costing. The investigation finds that, fabric differences were found in GSM range and in color shades. Design & making differences were found in design of individual parts & SPI. Measurements differences were found in size differences & same size products differences. Costing differences were found in unit pricing, price effecting factors, payment method, order quantity & delivery method. This research compared different buyers with its elements which provides consequential information's about those buyers.

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1 Introduction

Bangladesh is declared as a digital country among the globe which is geographically in Asian region. It is a developing country in enrichment status. Bangladesh is not a fully developed country, though textile sector is developing vastly. In the past few years the sector is developing as it is the major earning sector of foreign export. In the industry sector textile sector offering the major job offering for millions. Textile industry maximize the job potential for women's and unemployed literates, which enrich Bangladesh economical condition and significant contribution from the export income. Textile sector in Bangladesh have a very good reputation in different foreign buyers. The sector offers higher quality product in a convenient price than other country or region. That's why higher ranked buyers from different part of the world is very much interested to place order throughout the year.

2 Literature Review

Bangladesh has a reputation from the time when muslin and jamdani was the luxury of clothing. They have been the royal figure in the world for so many decades. Foreigners (British) found out the potential of the products thus they destroyed the sector from our country. They want the establishment of importing luxury products from their country. But the scenario changed when individual person want to make a product for himself. Individual tailor ship established. But there was lack of fabric supply for which the individual's supply their own fabric. Knit fabric was very rare to find, only woven fabric was available at that time.¹

In Bangladesh, after 1970 the sector started to spread. Within a short time it started to become a profitable export oriented industry. For the incensement of disposal income and the attraction to the luxury made the sector more demanding & the sector attained very much potentiality. With such demand, potentiality the sector stated to earn foreign exchange that increased the GDP. The growing sector also made opportunity for employment for male and female.²

Reaz Garments Ltd, Desh Garments Ltd, Trexim Ltd was the major starter for the business. Within a decade the number of garments manufacturing unit become 47 at the year 1982. Breakthrough occurred in 1984-1985. The number reached at 587.³

Phenomenal growth in exporting RMG products happens in recent years. Numbers of total RMG factories become 2900 in 1999. Bangladesh is now 12 largest supplier among the world. 6th in the US market & 5th in the EU market for T-shirt. The industry has a roughly growth rate of 22% during the 1990s. Incensement of denim pants and jackets are very potential as the global demands are increasing.⁴

Globally textile products consumption is increasing day by day due to developing economical condition and less costly garments products with latest fashion. Average consumption of textile is

up to 5kg with a growth rate of 5.5%. Within 2020 the textile mill market value will be 842.6 billion usd & the growth rate will be 4%. Average growth rate of textile mill market from 2015-2020 would be around 4.8%. As to the apparel market the market value will be 1004.6 billion usd in 2021 and the growth rate would be 3.5%. Average growth rate of apparel market of apparel market from 2016-2021 would be around 3.6%. The apparel retail market is the vast market for textile product. In the 2020 the market will reach a value of 1652.7 billion usd & the average growth rate of apparel retail market from 2015-2020 would be 5.7%.⁵

Bangladesh is now a leading name in exporting textile garments and gained the title of Asian tiger with a growth rate over 6%. Bangladesh had a GDP of 6.29 billion usd in 1972, but with the incensement of the textile industry Asian tiger managed to make 173.82 billion usd in 2014. The export quantity was about 31.2 billion, on which 82% was with RMG products. The new Asian tiger holds the 2nd position in exporting RMG products and RMG exporting managed to export 28.14 billion usd on the year 2016-2017. 80.7% was earnings exports. It contribution was around 12.36% of the GDP.⁶

Garments are being made to do business in the textile market. Buyers come from different area or country to gain low buying prices that helps them to gain more profit. Garments do usually made as they instructs to do. In the processing of buying a garment item the item should match their quality level and their capabilities as a buyer wants.

Different buyer behaves in different ways & they poses their own system of different process. Bangladeshi Textile industries are now currently working with over 100 of buyers in different section of garments and textile products. Europe, USA, Canada, japan, Australia are the main source of buyers. Some are very important because of their continuous process of buying order.

Some important buyers that are very important for the textile industry are given below:

H&M, Target, GAP, JCPenny, Levi's, Li & Fung, C&A, Adidas, Zara, Nike, Old Navy, Next, KiK, NAFTA, NEWWORKER, Mina, Wik, LiDL, Zola times, American Eagle, endo, US polo, PEPCO, Play today, zLabels etc.

H&M

H&M is now one of the leading buyer of garments and operating its business through 4600 stores in different area of the world. The company is now operating its business in sub branches which are independent. The independent brands are named as COS, ARKET, MONKI, CHEAP MONDAY, WEEKDAY, Other Stories, H&M Home & H&M. For these brands the company recruits around 161000 employees around the world. The sales of 2016-2017 season were near about 223 billion including tax and made around 18.6 billion Swedish Krona. The company holds its stores in around 68% of clothing market and covers up the online market of clothing around 41%.

H&M is not operating sourcing operation in Bangladesh. The company not only imports RMG product from Bangladesh but also contributes in development of quality and improvement of RMG products. The company helps domestic companies on becoming more sustainable and efficient in choosing resource. These domestic organizations also learning business concepts and business culture with wiser vision. H&M comes out with a better supply chain and digitalization which makes the company doing business use of digital sales & advance e commerce. Digital system with online simulator and with the help of big data concept helps to modify the business as per different time and situation. With the fashion trend, lead time, customization and speed of changing fashions the organization catch up with its production and value chain. H&M manages to import less and try to make the product in-house which enables to reduce the lead time of any production by which products can be in the market with in a very short time. The organization also gaining the advantages of collaboration and joint venture. The organization plans to get the fabric, fiber, and yarn from the manufacturer in a short time by collaboration and joint venture. This enables the future security of facing challenges from getting the required products from the supplier. The organization also plans to develop the traditional technology and system in Bangladesh, in a result they are taking advantages of automation of system and different process. H&M also planning to gain enormous business opportunities by implementing circular fashion strategy. This can enables to recycle the used product and turn them into textile material and other fashion product.⁷

LiDL

LiDL which is origins from Germany and very much famous for importing shirt from Bangladesh. The company plans to increase its purchasing quantity day by day. In 2015 the company imports near about 2510 millions of apparel goods. After that they increased the quantity at average 20%

and now the company purchase apparel goods worth 700-800 million usd in a year. The company also imports non apparel goods but apparel goods are the main import business of LiDL. LIDL have greater interest in doing business those who implement green technologies and water saving technology (WST). Right now more than 30 factories are using WTS. This technology enables the whole garments making process more efficient on using water. The technology reduces the water consumption to 7 liters from 15 liters, which is more than 50%. The company also encourage different factories to receive leadership in energy and environment design certification which is named as LEED certification. This makes a good handful agreement on doing business with environmental friendly component.⁸

C&A

This is a Dutch company and generally operated in Europe and Asia. The biggest market place is Asia for the organization. This company tries to import budget friendly products for the overall. This company was nearly formed over 170 years ago and the main vision was to help people to choose and buy their own preferable clothes. C&A always up to on adaptive design, technology and system and helps to innovate new system. The company plans to sustain mutual benefits and sustainability of progress by researching and planning for future generation. The company collects design from domestic region and develop as to the real life using with modern style. The company now focus to accelerate high growth in marketing in Asian market with emerging market and digital market with e-commerce. Passion for customer, responsibility with trust, delivering together, integrity, continuous commitment is the fact that makes the company growing with more value. The company is planning to establish 1575 general store throughout the Europe. The company also research to develop fashion industry in Bangladesh. Rahinga issue makes them to contribute on NGOs and they are planning to work with governments, the company is encouraging in using organic better cotton and to have cradle to cradle certification. The company buys around 1.3 million pieces from different RMG products with this certified factories. Reducing of water wastage in cotton production is also a vision of this company. They also works on organic better cotton which reduced water consuming near to 43%.⁹

zLabels

zLabels is a European company which was found in Berlin. The company is well known for creating very successful and contemporary fashion products. The company view is to find out the shoppers demand, wants and affordability. The mother company Zalando operates the company

from Europe and its main focus is to starting the fashion from Europe. The company have near about 2000 brands with 300000 products related to fashion and life style. The company is not only importing textile goods from Bangladesh the company but also establishing human rights, health, safety for the employees for different factories. The company also working for green economy for that they include environmental protection and products safety issues while order placing. Ethical value with supply chain meets with a highest value for the supply chain which confirms the responsibility to improve lives and working environment. The company also works for the betterment of the environment and for the reduction of waste. The company build a policy to work in safe and sound system where the workers safety and facilities are well mannered. The company helps to develop materials and products with the use of organic cotton, the company also encourage the factories of Bangladesh to gain Global Organic Textile Standard (GOTS). The company aims to source 30% better cotton in total cotton based products. zLabels is also participation in ECAP which is known as European clothing action plan to reduce water and environmental hazard carbon. This will reduce the waste of carbon and water to 10%. Working with more environmental friendly elements and recycled polyester helps them to become a committed to protecting the forests. This also helps on using man made elements and cellulosic fabric on RMG production. The company is now implementing new technologies to the Bangladeshi factories to reduce the use of water in wet processing and washing. This helps to the environment of Bangladesh because of using organic substance dye which is bio degradable also ensuring works and employee's health and safety issues.¹⁰

KiK

It is a German company which operates its business around nine countries. KiK is a very successful textile retailer and supplier and been an example for its textile trade for years. The company operates its business with 3564 stores and online store. The company build up a concept and a greater value chain to have discount that can work in online realm. With this discount concept the company managed to sales 2 billion euros in a year. The strategy also enables them to increase their turnover by 2.4%. To operate the company the company recruits near about 26852 personals in different section of the business organization. The online shop kik.de is operated with good logistics, supply chain & immersive administration. The business policy also includes environmental friendly measures. The organization uses less non bio degradable material like plastic and other chemicals. The company have a bad reputation of giving low wages and very bad practices in Bangladesh. The company also have a bad reputation of secret credit rating of different functional staff. They also have bad reputation on not paying overtime payments.¹¹

JCPenny

This company is based on American market and was founded in United States. The company started its journey in 1972 and now operating its business in many countries but their most focus is the American market. The company manages to gain market revenue of 12.547 billion usd. The organization have near about 875 departmental stores and online shop for the business purpose. To run the business, the company recruit 106000 personal for supply chain, administration, marketing and other functions related to the business. This company imports a vast amount of apparel goods. The organization buys apparel good worth of 160-180 million usd per year. Sourcing strategies like direct and indirect strategies makes to possible buying this much apparel goods. The company also export near around 50 million usd products from Bangladesh to Hong Kong and India. There had been no bad controversies heard about the company in Bangladesh.¹²

GAP

It is one of the biggest buyer which is known for ordering denim products in Bangladeshi textile industry. The company operates near about 3727 general stores and online market. To run the business, the company recruits near about 135,000 personals. The company build a unique supply chain and marketing team which focused to the young generation. Unique & develop multiple formation of design and culture the company manages to get around revenue of 15.855 billion usd. In Bangladesh GAP had come controversies on workers safety and health issue. The company was ranked at worst company for the Rana Plaza incident. Though the company have a very bad reputation of different issues relates to the business, the company imports huge amount of apparel goods from near to 45 factories from Bangladesh which is significant contribution to the textile industry of Bangladesh. Recently the organization is trying to improve their business policy in Bangladesh by implementing four part fire & building safety action plan they joined with alliance for Bangladesh workers safety. The company also inspects the facilities, practices and they are giving training to 1.3 million workers per year related to fire & safety.¹³

PEPCO, Play today, Mina, endo, Wik are also major imports apparel goods from Bangladeshi textile sector, they have a huge market of t-shirts, shirts and pants. For that they imports a huge quantity of products as to fulfill the demands. These companies also contributes to the development

of the textile goods. It is very much beneficial for the Bangladeshi workforce and system that updated with the development of technique and system. These companies also develop their supply chain system and other administration that enables them to outsource the textile goods which plays a major role in the economy of Bangladesh. Textile industry of Bangladesh is the major income source of exporting goods. More than 80% of the total earning is provided by the sector. This sector also provides a huge amount of job. The number is near to 5 million people with a greater number of women. In a research of International Finance corporation Bangladesh will export around 50 billion RMG products by 2021. This sector is providing the main stream of income source for decades for Bangladesh. Now Bangladesh have near about 5000 factories. These factories are capable of producing very high quality woven, knit and sweater products. In the recent year of 2013-2014 Bangladesh earned about 24 billion usd from this sector. With the help of advance experience of producing huge quantity and a very good quality product, the target is not very high ambitious. Expert technicians, a very long tenure of goodwill and maintaining on time shipment, product quality, compliance & safety will make a strong bonding with buyer those usually purchase apparel goods from Bangladesh.¹⁴

The main purpose of doing business is to make profit, thus Bangladeshi textile industry runs the business for making profit from the business. To cut a good amount of profit garment costing calculation is the main fact that runs the whole manufacturing business. It is the cost of a total purchase good and other elements that runs the process. Different buyer prefer different type of garments and they make them brand by introducing new fashion to the retail market. Major considering point like Quantity, fabrication, fabric color, test requirements, shipment, size specification, payment method, GSP, yarn costing, overhead cost, process cost, quality, CTM, commission rate of dealer, shortage in process, CIF, quota for specific product, packaging, price etc. should be in the calculation before confirmation of any order confirmation. But to get order manufacturing plan should meet some requirements that makes buyers interest to place an order. Higher quality product, short lead time in manufacturing apparel goods, competitive price of the product, on time delivery, small order & variety of product style, safety of the product, labeling, using green environment on the factories, using hazard free chemicals or dyes in the product, social compliance & quick response time of communication.¹⁵

Buyers which are active in Bangladeshi textile industry differs from one from another. This differences are mainly because of their business method, culture of business, target of customers and level of business. Some are focused to make quality and fashionable product and some buyer is focused to do business with affordable apparel goods. This also makes famous in three economical sector i.e. high, medium & low class. These buyers also can be differentiate with their targeted apparel category. Some are into men's product and some are in women's product only. There is also a targeted market of kid's products in the segment of market. Home textile, lingerie

products have a very narrow market in Bangladesh right now, but the market is now developing day by day as to the increase rate of consuming these products. Buyers can be differentiated with many points with their behavior and the style of the business. Quality, short quantities, costing, shipment method, order quantity, size of the product, unit price, packaging, shipment time, code of conduct, approvals, International commercial and shipping terms of the goods, order cancellation policy etc. ¹⁶

This study is all about the information of the garments buyers from different regions for the garments industry by which working with different buyers will be much easier. Differences between the buyers and their working culture can be recognized with the help of technical and business differences. With the help of the differentiation garments manufacturers will have pre-setup strategies to deal with the problems; like preferable fabrics, accessories, order quantity, SPI, packaging, finishing, testing procedure, sewing threads, buttons, shipment, payment, rules & regulations, communication and the culture of doing business with the buyers. Thus the process can be done with a very short lead time.

3 Experimental Details

The survey consists of different products of different buyers on basis of the product's class and type.

Generally, four to five types of products are most popular in Garments industry in Bangladesh. Knit t-shirts, Woven shirts, Pants and home textile.

Products are differentiate into below criteria.



1. Knit T-Shirts.
2. Woven Shirts.
3. Woven Pants.
4. Home-textiles.
5. Lingerie.

Within these knit t-shirt, woven shirts & woven pants have major workload in Bangladesh.

3.1 Differences of 5 Knit T-Shirt buyers

3.1.1 Details of the buyers order & business elements

C&A

	Registered Brand: Angelo Litrico	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12	Age Group: Adult
	Season: 2019 Q2 Apparel Men	Gender: Male	
Product Division: Apparel	Product Category: Tops	Fit Reference Block #:	
Product Group: T-Shirts	Class: 617	Sizing:	
Technologist: Philomene SADI MATETA NSUADI	Merchant: Nathalie VAN PRAET	Date: 10/11/2018	
Designer: Camille VITS	Number: 001	Spec Status: 1st Proto	






Figure 1: Artwork of C&A buyer.

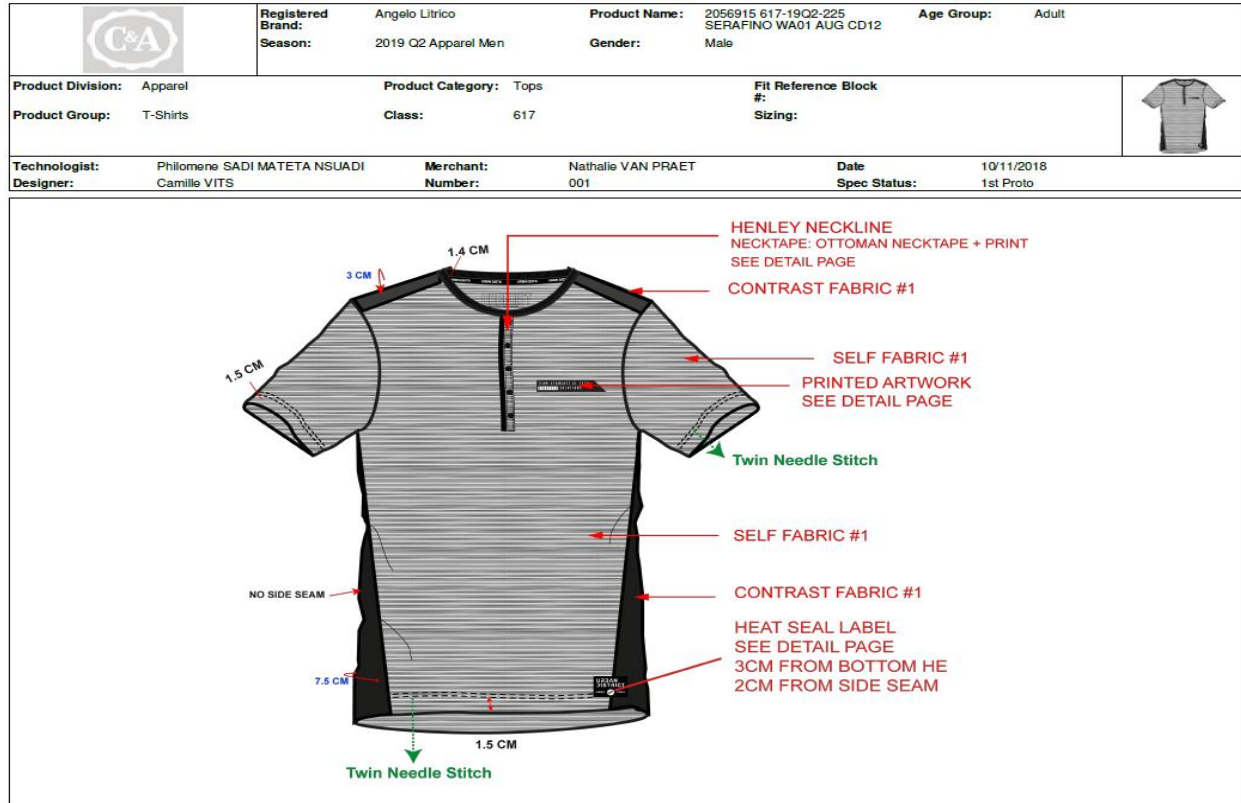


Figure 2: Artwork of front details of C&A buyer.

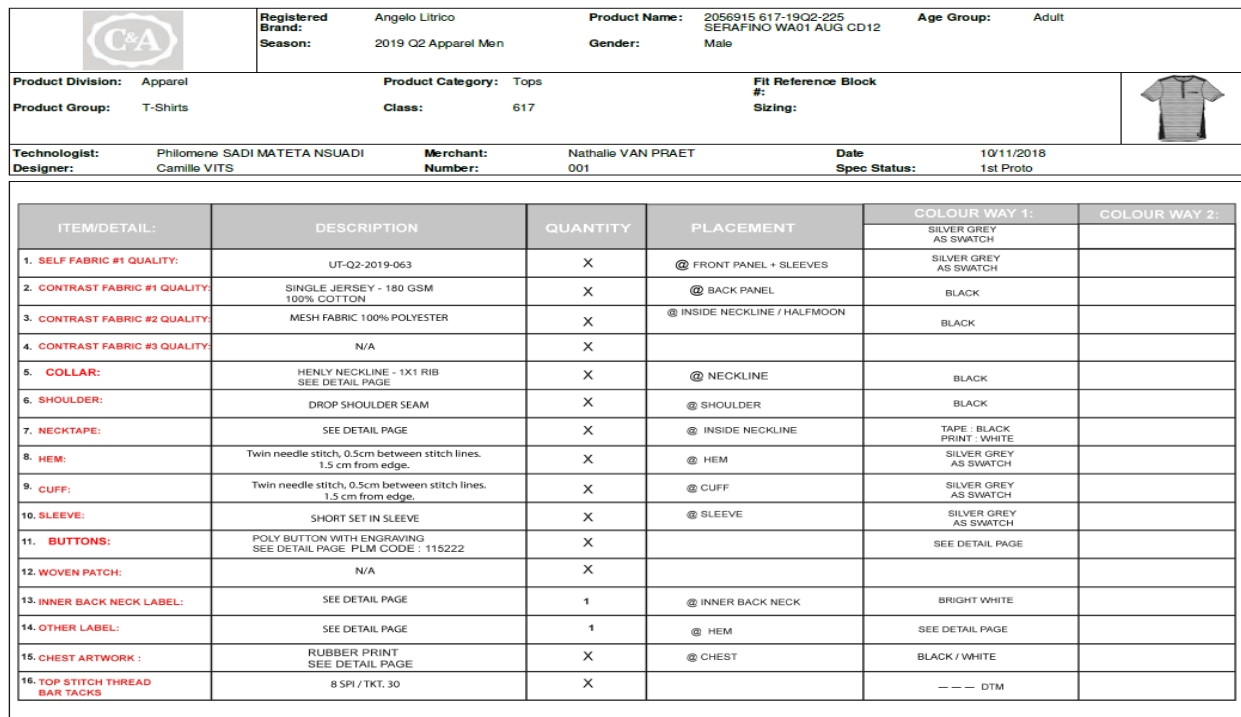


Figure 3: Item details of C&A buyer.

	Registered Brand: Angelo Litrico Season: 2019 Q2 Apparel Men	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12 Gender: Male	Age Group: Adult
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 617	Fit Reference Block #: Sizing:	
Technologist: Philomene SADI MATETA NSUADI Designer: Camille VITS	Merchant: Nathalie VAN PRAET Number: 001	Date: 10/11/2018 Spec Status: 1st Proto	

TRIMS / ACCESSOIRES :

REFERENCE FOR OTTOMAN TAPE
QUALITY: 100% POLYESTER
COLOUR: BLACK

PRINT TECHNIQUE: RUBBER PRINT
PRINT COLOUR: WHITE

HEATSEAL PRINT
size: 42 mm x 31 mm

Figure 4: Trims/Accessories of C&A buyer.

	Registered Brand: Angelo Litrico Season: 2019 Q2 Apparel Men	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12 Gender: Male	Age Group: Adult
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 617	Fit Reference Block #: Sizing:	
Technologist: Philomene SADI MATETA NSUADI Designer: Camille VITS	Merchant: Nathalie VAN PRAET Number: 001	Date: 10/11/2018 Spec Status: 1st Proto	

crew-neck serafino collar
WIDTH 1,4 cm - BINDING COLLAR
twin needle topstitch (2 mm in between)
collar 2x2 rib

placket 1,5 cm x 18 cm in selffabric
PIPING AT EDGE OF UNDERPLACKET - WIDTH 3MM



BRANDED BUTTONS
SEE DETAIL PAGE

polybutton UD16-B02
size: 18L for collar + pocket
- engraved + filled with white

FRONT SIDE

engraving

Figure 5: Artwork (chest) of C&A buyer.

	Registered Brand: Angelo Litrico Season: 2019 Q2 Apparel Men	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12 Gender: Male	Age Group: Adult
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 617	Fit Reference Block #: Sizing:	
Technologist: Philomene SADI MATETA NSUADI Designer: Camille VITS	Merchant: Nathalie VAN PRAET Number: 001	Date: 10/11/2018 Spec Status: 1st Proto	

TRIMS / ACCESSOIRES :

REFERENCE FOR CHEST PRINT
PRINT TECHNIQUE: HIGH RAISED RUBBER PRINT
PRINT COLOURS: BLACK + WHITE






Figure 6: Trims/Accessories details of C&A buyer.

	Registered Brand: Angelo Litrico Season: 2019 Q2 Apparel Men	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12 Gender: Male	Age Group: Adult
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 617	Fit Reference Block #: Sizing:	
Technologist: Philomene SADI MATETA NSUADI Designer: Camille VITS	Merchant: Nathalie VAN PRAET Number: 001	Date: 10/11/2018 Spec Status: 1st Proto	



Figure 7: Artwork (front) of C&A buyer.

		Registered Brand: Angelo Litrico Season: 2019 Q2 Apparel Men	Product Name: 2056915 617-19Q2-225 SERAFINO WA01 AUG CD12 Gender: Male	Age Group: Adult
Product Division: Apparel Product Group: T-Shirts	Product Category: Tops Class: 617	Fit Reference Block #: Sizing:		
Technologist: Philomene SADI MATETA NSUADI Designer: Camille VITS	Merchant: Nathalie VAN PRAET Number: 001	Date: 10/11/2018 Spec Status: 1st Proto		

Measurement Set: 001 : Varsity/Utility T-SHIRT , Sample Size: M , UOM: cm

POM #	Name	Tol (+)	Tol (-)	XS	S	M	L	XL	2XL	3XL
A16	Front Length from HPS-Garment (flat front)	1.00	1.00	70.00	71.00	72.00	73.00	74.00	75.00	76.00
B1	Across Shoulder	1.00	1.00	41.00	43.00	45.00	47.40	49.80	52.80	55.80
A1	Across Front	1.00	1.00	36.00	38.00	40.00	42.40	44.80	47.80	50.80
A4	1/2 Chest	1.00	1.00	45.00	49.00	53.00	57.00	61.00	66.00	71.00
A8	1/2 Waist	1.00	1.00	43.00	47.00	51.00	55.00	59.00	64.00	69.00
A10	1/2 Hem	1.00	1.00	43.00	47.00	51.00	55.00	59.00	64.00	69.00
B2	Across Back	1.00	1.00	37.50	39.50	41.50	43.90	46.30	49.30	52.30
C12b	Sleeve Length from Shoulder 1/2 Slv	0.00	0.00	21.00	21.50	22.00	22.50	23.00	23.50	24.00
C16b	Sleeve Length from Lowest Point of Armhole 1/2 Slv	0.00	0.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00
C20	1/2 Bicep	1.00	1.00	18.00	19.00	20.00	21.00	22.00	23.60	25.20
C09b	1/2 Sleeve Opening 1/2 Slv	1.00	1.00	16.00	17.00	18.00	19.00	20.00	21.50	23.00
C4	Armhole Straight	1.00	1.00	20.60	21.80	23.00	24.20	25.40	26.80	28.20
D1	Neck Width Seam to Seam	1.00	1.00	18.40	19.20	20.00	21.00	22.00	23.20	24.40
D10	Front Neck Drop Seam to Seam (crew)	0.50	0.50	8.30	8.90	9.50	10.10	10.70	11.30	11.90
D11	Back Neck Drop Seam to Seam	0.50	0.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50
D8	Neck Rib Depth	0.00	0.00	1.50	1.50	1.50	1.50	1.50	1.50	1.50

Figure 8: Measurements sheet of C&A buyer.

zLabels

JOB NUMBER : ATL-19-1006		Amantex Limited		FABRIC BOOKING DATE : 23.03.2019											
BUYER : zLabels		Boisgirards, Sripier, Gaspier, Baeglsdek.		SHIP DATE : 08.05.2019											
STYLE / REF / ART : TT-0719-01021		Finished Fabric Booking													
ORDER NUMBER : ZLP029530															
ORDER QUANTITY : 2000 Pcs															
ITEM : T-shirt															
FABRICS : 100% BCI COTTON SLUD, S/J 160 GSM															
YARN COUNT : T-shirt															
SPECIAL INSTRUCTION : FABRIC SHOULD BE ENZYME WASH, SOFT HAND FEEL & MUST HAVE TO ENSURE ALL TESTING REQ. AS PER ZLABELS MAP															
A. Color & Size Wise Order Quantity						APPROVED LD NO									
BODY COLOR	Size	2XS	XS	S	M	L	XL	2XL	Total	Remark	COLOR NAME	PARTNER NO	LD NO	OPTION	
001 - white		60	150	330	270	130	60		1,000		001 - white		192667 OPT C		
802 - black			60	150	330	270	130	60	1,000		802 - black		191116 OPT A		
Total			120	300	660	540	260	120	2,000						
B. Color, Yarn, Fabric & Tape Requirements:										NOTE: BEFORE DYEING, PLS CHECK WITH APPROVED LD NO OR PROVIDED SWATCH & LET US KNOW IF U FIND ANY DISCREPANCY HERE.					
BODY-BACK TAPE FABRIC DIA- TO - OPEN		NECK BINDING DIA-ANY													
100% BCI COTTON SLUD, S/J 160 GSM		ELASTEN RIB IX1 260 GSM													
BODY COLOR	YARN COMPOSITION	2.75	Color	Spacings	9.18	Color	Spacings	Requirement	Process	Requirement	In Kg	Loss	IN KG		
001 - white	100% Cotton	225	White	15				240	17%	201					
802 - black		225	Black	15				240	17%	201					
Total		450		30				480		562					
Note : Please Follow The Approved Lab For Fabric Color.		2.50 2.75													
Manufacturer (HSFO)	App. Manager (HSFO)	AGHM (HSFO)	DGH (D-zLabels)	MANAGER (SAMPLE & CAD)	GH (Marketing & Merchandising)									Received By	

Figure 9: Fabric booking sheet of zLabels buyer.

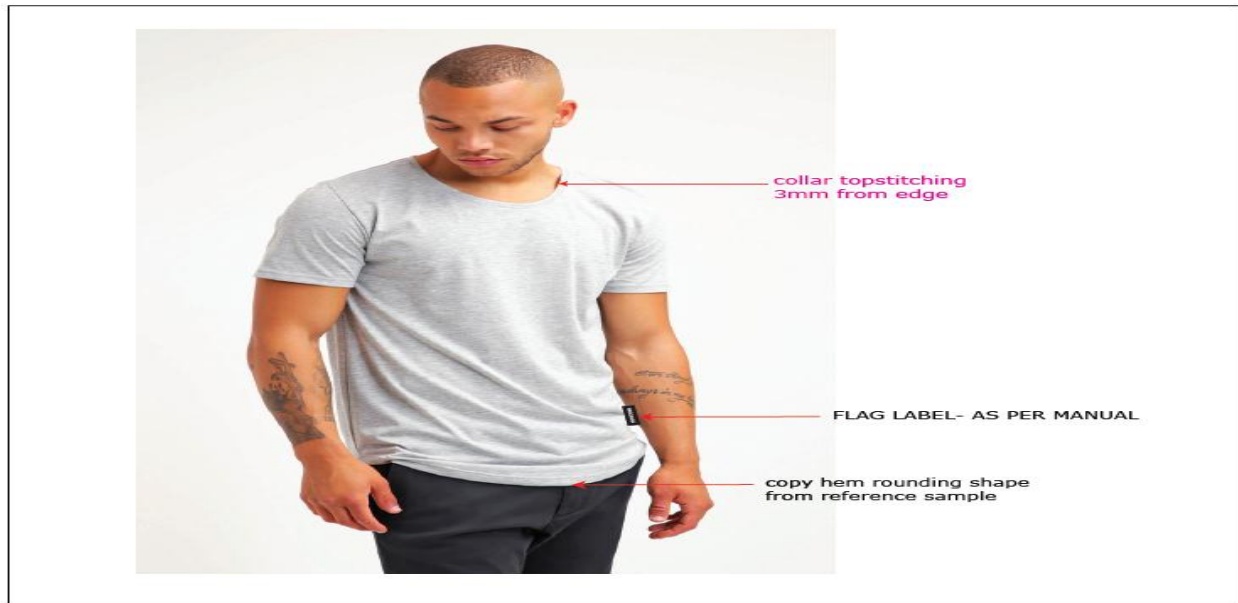
DEPARTMENTS	PO	STYLE	PACKING TYPE	COLOR	2XS	XS	S	M	L	XL	2XL	TOTAL QTY	SHIP DATE	Remarks	
YOUR TURN	ZLPO10821	YT-BAS0-0120		503 - dark blue_001 - white	51	19	188	436	296	129	8	1,127	16/4		
												-			
												-			
												-			
												-			
G.TOTAL (SIZEWISE SUMMARY)					51	19	188	436	296	129	8	1,127			
			Colorwise Break down	503 - dark blue_001 - white #REF!	51	19	188	436	296	129	8	1,127			
												-			

Figure 10: Fabric breakdown sheet of zLabels buyer.

Updated On: 3/21/2019		Order Execution Status (OES)															E									
																	FR									
Buyer: ZLabels																	TNA									
																	Special Operations' Status (Yes/No)									
PO Receive Date	Style/Item No.	Style/Item / ATL No. (REPEAT)	Garments Description/ Product Type	ATL No/ AO#	P. O Number	Fab Construction	Count	GSM	Weight/ Piece	CM/ Piece	FOB/ Piece	SMV/ Piece	Colour	Order Qty	Original Ship Date	Ex-Factory	Mode	Order LT	Brush/ Suede	Emb	Print	AOP	YD	Wash		
3/21/2019	YT-0719-01021		Mens T- shirt	19-1006	ZLPO29530	100% BCI Cotton Single Jersey 160 Gsm	26's	160	0.22	0.38	2.39	6.99	001 - white	1000	8-May	6-May	Sea	46	No	No	Yes	No	No	No		
3/21/2019	YT-0719-01021		Mens T- shirt	19-1006	ZLPO29530	100% BCI Cotton Single Jersey 160 Gsm	26's	160	0.22	0.38	2.39	6.99	802 - black	1000	8-May	6-May	Sea	46	No	No	Yes	No	No	No		
														Total	2000											

Figure 11: Order Execution Status (OES) sheet of zLabels buyer.

STYLE NUMBER: YT-0719-01021		YOURTURN		SUPPLIER:	
DATE: 2019-02-12 //		CRD: 2019-xx-xx //		PROTO ETA: 2019-02-27	
BLOCK PATTERN	m-tee-regular-1118 (big hem drop)	pls see provided spec for pattern amendments to be made based on ref. sample		ARTWORK	
SHELL FABRIC 1	100% CO single Jersey CAVIAR 19-4006 TCX	181116 OPT A			
RIB 1x1	95%CO- 5%EA DTM SHELL FABRIC 1	collar rib		WASH	



AS PER CK MANUAL							
MAIN LABEL		HANG TAG	YT-HT-01-WH	SIZE LABEL		BACK NECKTAPE	0,8CM WIDTH DTM BODY
CARE LABEL	CL-3012TAF	CAUTION HANGTAG	Z-CAHT	SATIN LOOP	0,4CM WIDTH DTM BODY	BACK NECK PRINT	REGULAR FIT XXS TO XXL GLACIER GEY 14-4102 TCX

Figure 12: Artwork of zLabels buyer.

Style: YT-0719-01021		Requested Measurements	Sample Measurements			
POM	Description	M	PROTO	DIFFERENCE	REVISED	Tol +/-
C	1/2 chest width	53		-53	53	1.5
WPF	waist position front from HSP	46		-46	46	0.7
W	1/2 waist width	52.6		-52.6	51	1.5
BW	1/2 bottom width	52		-52	52	1.5
FL	front length from HSP	79		-79	79	1
BL	back length from HSP	79		-79	79	1
CFWP	cross front width position from HSP	20.4		-20.4	20.4	0.5
CFW	cross front width	40.3		-40.3	42.5	1
CBWP	cross back width position from HSP	20		-20	20	0.3
CBW	cross back width	42.3		-42.3	44	1
SHW	shoulder width	46.9		-46.9	46.9	1
AH	armhole height	22.1		-22.1	23	0.4
HRF	hem rounding front	9		-9	9	0.3
HRB	hem rounding back	9		-9	9	0.3
NO2	neck opening	19		-19	19	0.3
NDF	neck drop front	11		-11	12	0.3
NDB	neck drop back	1.5		-1.5	1.5	0.3
CH	collar height	1.3		-1.3	1.3	0.3
SL short	sleeve length - short	22.5		-22.5	22.5	0.5
UAW	1/2 upper arm width	19		-19	20.5	0.4
HWS short	1/2 sleeve hem width - short	17		-17	18	0.4

Figure 13: Measurements sheet sheet of zLabels buyer.

zLabels GmbH, D-11501 Berlin
Bestseller United China Ltd.
Unit 2509 - 2511 Miramar Tower, 132
Kowloon 999999
Hong Kong

Berlin 19/3/2019
Enis Sezer

enis.sezer@zlabels.de

CC: Amantex LTD.
Boiragirchala, Sreepur,
Gazipur 1740
Bangladesh

1/2

PURCHASE ORDER # ZLPO29530

Pos.	Image	Size Assortment ID Supplier Article ID Development Code	Description	Cargo ready date Mode of transport Incoterms Port of loading Packing type Factory name	Quantity	Total price (US Dollar)
1		37pby-ty YT-0719-01021 YOL_FW19_2-2-O_048	YOURTURN 37pby-ty YT-0719-01021 Ses-In Curved Hem SS / 001 - white	8/3/2019 Sea transport FCA BDCGP Chittagong - Sea transport Lying Amantex (F) [K86847]	1000	2,450.00
2		37pby-qy YT-0719-01021 YOL_FW19_2-2-O_048	YOURTURN 37pby-qy YT-0719-01021 Ses-In Curved Hem SS / 802 - black	8/3/2019 Sea transport FCA BDCGP Chittagong - Sea transport Lying Amantex (F) [K86847]	1000	2,450.00
Net total before discount						4,900.00
Discount						0.00
Line discounts:						-122.50
Net total after discount						4,777.52

Payment terms: Open Invoice 60 days

Season: Autumn Winter 2019

Delivery	Pos.	Identifiers	HTS Code Customs description	Size (All)	Quantity	Unit price (US Dollar)
8/3/2019 Sea transport FCA BDCGP Chittagong - Sea transport Lying Amantex (F) [K86847]	1	37pby-ty YOL_FW19_2-2-O_048	-		1000	-
	1.1	37pby-ty-pd YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	XS	60	2.39
	1.2	37pby-ty-qd YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	S	150	2.39
	1.3	37pby-ty-xd YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	M	330	2.39
	1.4	37pby-ty-od YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	L	270	2.39
	1.5	37pby-ty-ld YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	XL	150	2.39
	1.6	37pby-ty-1d YT-0719-01021	61091000100 T-Shirt, knit, 100% Cotton	2XL	60	2.39

Registered with the commercial register of the local court
Berlin Charlottenburg HRB 123673 B
Tax Number: 27/125/21776
Value Added Tax ID: DE270699778

Figure 14: Purchase Order sheet of zLabels buyer.

KiK



Figure 15: Artwork of KiK buyer.

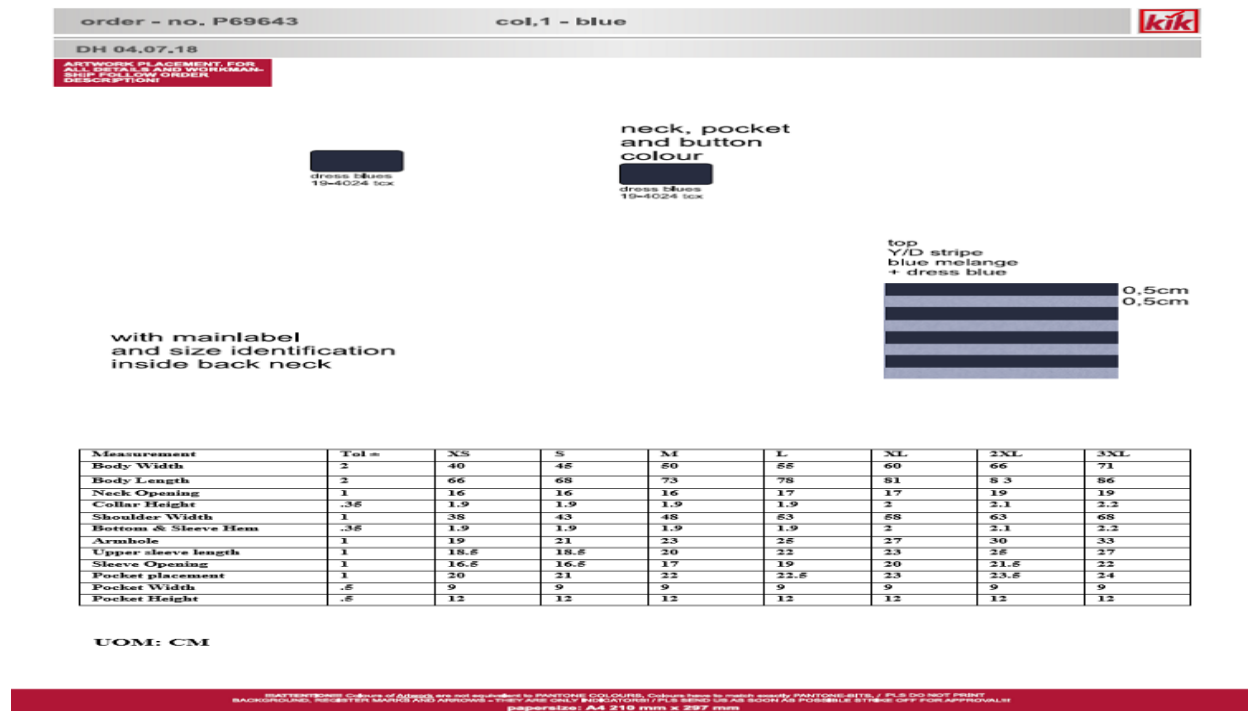


Figure 16: Trims/Accessories details & Measurements sheet of KiK buyer.

NAFTA



Premium
Style 1701

Adult Tee

Weight 5.5 oz/yd² (9.1 oz/ly, 186 g)
Fabric 100% soft spun cotton
Yarn Size 20/1
Colors 28
Sizes XS - 3XL

Features

- Soft spun fabric provides a great hand and nice drape
- Double-needle bottom and sleeve hems
- Shoulder-to-shoulder taping
- Rib collar

NAFTA

SPECS

	XS	S	M	L	XL	2XL	3XL	Tol +/-
Body Width (1" Below Armhole)	16"	18"	20"	22"	24"	26"	28"	1"
Body Length (HPS to Edge)	26"	27"	29"	31"	32"	33"	34"	1"
Neck Opening (Seam to Seam)	6½"	6½"	6½"	7"	7"	7½"	7½"	½"
Collar Height (Seam to Edge)	¾"	¾"	¾"	¾"	¾"	¾"	¾"	⅛"
Shoulder Width (Seam to Seam)	15"	17"	19"	21"	23"	25"	27"	½"
Bottom & Sleeve Hem (Edge to Top Stitch)	¾"	¾"	¾"	¾"	¾"	¾"	¾"	⅛"
Armhole (Straight)	7¾"	8¾"	9¾"	10¾"	11½"	12½"	13½"	½"
Upper Sleeve Length (Armhole to Edge)	7¾"	7¾"	8¾"	9"	9½"	9½"	10"	½"
Sleeve Opening (Relaxed)	6½"	6½"	7"	7½"	8"	8½"	9"	½"

Figure 17: Artwork & Measurements sheet of NAFTA buyer.

COLORS & SIZES

Color Name	Color #	Sizes	Color Name	Color #	Sizes	Color Name	Color #	Sizes
Athletic Heather ^o	005	XS - 3XL	Forest Green	1160	XS - 3XL	Red	2015	XS - 3XL
Banana	1088	XS - 3XL	Harbor Blue	2289	XS - 3XL	Royal	1397	XS - 3XL
Black	695	XS - 3XL	Kelly	1086	XS - 3XL	Sand	094	XS - 3XL
Burgundy	2023	XS - 3XL	Lime	1290	XS - 3XL	Silver	2293	XS - 3XL
Cardinal	2290	XS - 3XL	Military Green	1133	XS - 3XL	Slate	1076	XS - 3XL
Celadon	1332	XS - 3XL	Navy	026	XS - 3XL	Tar	165	XS - 3XL
Charcoal	013	XS - 3XL	Orange	1395	XS - 3XL	Turquoise	051	XS - 3XL
Charcoal Heather [^]	177	XS - 3XL	Powder Blue	2350	XS - 3XL	White	000	XS - 3XL
Cream	1084	XS - 3XL	Purple	1287	XS - 3XL	Yellow	494	XS - 3XL
Dark Chocolate	017	XS - 3XL						

*Athletic Heather 90/10 cotton/polyester ^Charcoal Heather 50/50 cotton/polyester

800.225.1364 west coast | 800.621.6578 east coast | 866.275.7860 canada | alstyle.com

Figure 18: Breakdown sheet of NAFTA buyer.

NEWWORKER

PRE-ORDER Version of supplier **NEWYORKER** Date: 03.01.2019
VO-825148

The NY Pre-Order is not a binding order! It is for the purpose of information request/invitations to tender only. These kind of requests/invitations to tender on our part do not constitute a legally binding offer within the meaning of § 145 of the German Civil Code (BGB), but rather only constitute a request to submit offers ("invitation ad offerendum").

General information

Pre-Order-ID VO-825148
 Prov. item number 02.02.200.0984
 Style-ID supplier FBS-AW19-11
 Order type Standard
 Set-ID
 Set - Description

Sales unit 1-Pack
 Supplier Team Sourcing Co., Ltd.
 Companies headquarter: Dhaka Bangladesh
 Agent

Terms of Payment L/C
 L/C opening date

Date of Pre-Order 27.12.2018

Delivery

Delivery condition FOB
 Place of destination Bangladesh-Chittagong
 Way of transport Sea
 ETD 26.05.2019

Labels

Label FB Sister
 Label-Type Label-ID
 Combi CFS01A

Assortment / Price

Assortment-ID SO-0252154
 Assortments in total 1600

Color	Partcode	Price	Disc.	Size	XXS	XS	S	M	L	XL	XXL	Total
Ginger Bread	18-1244TCX	USD5,26			0	3	4	4	2	2	0	16

Quantity / Package

Total pieces 24.000

Our General Conditions of Purchase are valid in the currently applicable version. These conditions are acknowledged by the supplier when he fulfills an order. General Conditions of Purchase, shipping instructions and annexes can be found under www.newworker.biz.

Figure 19: Artwork & Order sheet of NEWWORKER buyer.

PRE-ORDER Version of supplier

NEWYORKER

Date: 03.01.2019
VO-825148

The NY Pre-Order is not a binding order! It is for the purpose of information request/invitations to tender only. These kind of requests/invitations to tender on our part do not constitute a legally binding offer within the meaning of § 145 of the German Civil Code (BGB), but rather only constitute a request to submit offers ("invitation ad offerendum").

Color	Size	XXS	XS	S	M	L	XL	XXL	Total
Ginger Bread		0	4.500	6.400	6.400	3.200	3.200	0	24.000
Tr.-Cart.-ID	Description	Quantity	Piece/Carton	Colors	Assortment-ID				
400047048		1.600	15	Ginger Bread	SO-0252154				

Material Information / Style Attributes

Country of origin: BD

Fibre content

Pos: 10 Outer Shell
60 % Cotton
40 % Polyester

Description of style

040_200_Fabric_w: -
040-043_200-203_Bottom_w: -
040-043_200-203_Length_w: mini
040-041_043_200-201_203_Print_w...: solid
200-203_Style_w: loose fit
Acc_w: zipper
Neckline_w: collar
Sleeve_w: dropped shoulder
Sleeve-Length_w: 1/1 length
colour_article description: brown

Supplementary description

Style: Same as counter sample dated 16.11.2018

Quality: Same as art. 02 02 200 2066

Please add pockets at side seams

Color: Ginger Bread 15-1244 txx

Please send a full size set before production.
Please also send photo sample in size S after production approval (at least 2 weeks before ETD).

Our General Conditions of Purchase are valid in the currently applicable version. These conditions are acknowledged by the supplier when he fulfills an order. General Conditions of Purchase, shipping instructions and annexes can be found under www.newyorker.biz.

Figure 20: Item details of NEWWORKER buyer.

The NY Pre-Order is not a binding order! It is for the purpose of information request/invitations to tender only. These kind of requests/ invitations to tender on our part do not constitute a legally binding offer within the meaning of § 145 of the German Civil Code [BGB], but rather only constitute a request to submit offers ("invitation ad offerendum")."

Color _____ Size XXS XS S M L XL XXL Total
Ginger Bread 0 4.800 6.400 6.400 3.200 3.200 0 24.000

Tr.-Cart.-ID	Description	Quantity	Piece/Carton	Colors	Assortment-ID
400047046		1.600	15	Ginger Bread	SO-0252154

Measurement unit: cm





Measurement	Tol ±	XXS	XS	S	M	L	XL	XXL
Body Width	2	40	45	50	55	60	66	71
Body Length	2	66	68	73	78	81	83	86
Neck Opening	1	16	16	16	17	17	19	19
Sleeve Opening	1	18	19	20	21	22	23	24
Shoulder Width	1	38	43	48	53	58	63	68
Bottom & Sleeve Hem	.35	1.9	1.9	1.9	1.9	2	2.1	2.2
Sleeve openinh	.5	7	8	8	9	9	9	10
Sleeve length	1	62	64	65	66.5	67.5	69	71
Collar height	.35	4.5	4.5	4.5	4.5	4.5	4.5	4.5
Collar point	.35	5.5	5.5	5.5	5.5	5.5	5.5	5.5

Please send a full size set before production.
Please also send photo sample in size S after production approval (at least 2 weeks before ETD).




Our General Conditions of Purchase are valid in the currently applicable version. These conditions are acknowledged by the supplier when he fulfils an order. General Conditions of Purchase, shipping instructions and annexes can be found under www.newyorker.biz.

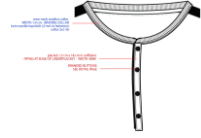







Figure 21: Measurements sheet of NEWWORKER buyer.

3.1.2 Table-1 Comparison among 5 Knit T-Shirt buyers

Buyer →	C&A	zLabels	KiK	NAFTA	NEWWORKER
Logo		zLabels			
Origin of the Buyer	Germany	Berlin, Germany	Bönen, Germany	Europe	Europe
Biggest Market	America	Europe	Germany	Europe	Europe
Product division	Apparel	Apparel	Apparel	Apparel	Apparel
Registered brand	Angelo Litrico	YOURTURN	KiK	NAFTA	NEWWORKER
Photo sample					
Product user division	Male	Male	Male	Male	Male/ female
Product Category	Tops	Tops	Tops	Tops	Tops
Product Group	T-Shirts	T-Shirts	T-Shirts	T-Shirts	Full sleeve T-Shirts

Fabric placement	Front panel, sleeves, back panel, inside neckline / halfmoon	Front panel, sleeves, back panel, neckline	Front panel, sleeves, back panel, inside neckline / halfmoon	Front panel, sleeves, back panel, inside neckline / halfmoon	Front panel, sleeves, back panel, inside neckline / halfmoon
Fabric Color	Silver gray, black	White, black	Blue mélange, Dress blue	28 various color	Gingerbread
Collar	Henly neckline – 1*1 rib	neckline – 1*1 rib	neckline – 1*1 rib	neckline – 1*1 rib	neckline – 1*1 rib
Collar color	Black	Same as body fabric color	Dress blue	Same as body fabric color	Gingerbread
Shoulder	Drop shoulder seam	Drop shoulder seam	Drop shoulder seam	Drop shoulder seam	Drop shoulder seam
Shoulder color	Black	Same as body fabric color	Dress blue	Same as body fabric color	Gingerbread
Neck tape	Flat seam	Flat seam	Flat seam	Flat seam	Flat seam
Neck tape color	Tape black, print white	Same as body fabric color	Dress blue	Same as body fabric color	Gingerbread
Hem	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines,
Hem color	Silver gray	Same as body fabric color	Blue mélange, Dress blue	Same as body fabric color	Gingerbread
Cuff	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines, 1.5 cm from edge	Twin needle stitch, 0.5 cm between stitch lines,	Twin needle stitch, 0.5 cm between stitch lines

				1.5 cm from edge	
Cuff color	Silver gray	Same as body fabric color	Blue mélange, Dress blue	Same as body fabric color	Gingerbread
Sleeve	Short set in sleeve	Short set in sleeve	Short set in sleeve	Short set in sleeve	Long set in sleeve
Sleeve color	Silver gray	Same as body fabric color	Blue mélange, Dress blue	Same as body fabric color	Gingerbread
Buttons	Poly button with engraving	N/A	Poly button	N/A	N/A
Buttons color	Black	N/A	Dress blue	N/A	N/A
Buttons size	18L	N/A	18L	N/A	N/A
Photo sample of button		N/A		N/A	N/A
Pocket	N/A	N/A		N/A	N/A
Fake pockets	N/A	N/A	N/A	N/A	N/A
Woven Patch	N/A	N/A	N/A	N/A	N/A
Zipper	N/A	N/A	N/A	N/A	Metal zipper

					
Inner back neck label	100% polyester	100% polyester	100% polyester	100% polyester	100% polyester
Inner back neck label color	Bright white	Black	Dress blue	Same as body fabric color	Gingerbread
Chest artwork					
Top stitch thread bar tacks	8 SPI / TKT.30	8 SPI	8 SPI	8 SPI	9 SPI
Trims/Accessories fabric	100% Polyester	100% Polyester	100% Polyester	100% Polyester	100% Polyester
Trims/Accessories fabric color	Black/ White	Black, white	Red, silver	White	White, Red
Print color	White	N/A	N/A	N/A	N/A
Photo sample of trims					

	M: 53.00 L: 57.00 XL: 61.00 2XL: 66.00 3XL: 71.00	M: 52.00 L: 58.50 XL: 63.00 2XL: 68.00	M: 50.00 L: 55.00 XL: 60.00 2XL: 66.00 3XL: 71.00	M: 50.80 L: 55.88 XL: 60.96 2XL: 66.04 3XL: 71.12	S: 50.00 M: 55.00 L: 60.00 XL: 66.00 2XL: 71.00
Body Width Allowance	± 1.00	± 1.50	± 2.00	± 2.54	± 2.00
Body Length	XS: 70.00 S: 71.00 M: 72.00 L: 73.00 XL: 74.00 2XL: 75.00 3XL: 76.00	XS: 73.00 S: 75.00 M: 79.00 L: 83.00 XL: 86.00 2XL: 89.00	XS: 66.00 S: 68.00 M: 73.00 L: 78.00 XL: 81.00 2XL: 83.00 3XL: 86.00	XS: 66.04 S: 68.58 M: 73.66 L: 78.74 XL: 81.28 2XL: 83.82 3XL: 86.36	XXS: 66.00 XS: 68.00 S: 73.00 M: 78.00 L: 81.00 XL: 83.00 2XL: 86.00
Body Length Allowance	± 1.00	± 1.00	± 2.00	± 2.54	± 2.00
Neck Opening	XS: 18.40 S: 19.20 M: 20.00 L: 21.00 XL: 22.00 2XL: 23.20 3XL: 24.40	XS: 18.00 S: 18.50 M: 19.00 L: 19.50 XL: 20.00 2XL: 20.50	XS: 16.00 S: 16.00 M: 16.00 L: 17.00 XL: 17.00 2XL: 19.00 3XL: 19.00	XS: 16.51 S: 16.51 M: 16.51 L: 17.78 XL: 17.78 2XL: 19.05 3XL: 19.05	XXS: 16.00 XS: 16.00 S: 16.00 M: 17.00 L: 17.00 XL: 19.00 2XL: 19.00

Neck Opening Allowance	± 1.00	± 0.40	± 1.00	± 1.27	± 1.00
Collar Height	XS: 1.50 S: 1.50 M: 1.50 L: 1.50 XL: 1.50 2XL: 1.50 3XL: 1.50	XS: 1.90 S: 1.90 M: 1.90 L: 1.90 XL: 1.90 2XL: 1.90 3XL: 1.90	XS: 1.90 S: 1.90 M: 1.90 L: 1.90 XL: 2.00 2XL: 2.10 3XL: 2.20	XS: 1.905 S: 1.905 M: 1.905 L: 1.905 XL: 1.905 2XL: 1.905 3XL: 1.905	XXS: 4.50 XS: 4.50 S: 4.50 M: 4.50 L: 4.50 XL: 4.50 2XL: 4.50
Collar Height Allowance	± 0.00	± 0.30	± 0.35	± 0.3175	± 0.35
Shoulder Width	XS: 41.00 S: 43.00 M: 45.00 L: 47.40 XL: 49.80 2XL: 52.80 3XL: 55.80	XS: 43.00 S: 45.00 M: 46.9 L: 48.00 XL: 51.00 2XL: 54.00	XS: 38.00 S: 43.00 M: 48.00 L: 53.00 XL: 58.00 2XL: 63.00 3XL: 68.00	XS: 38.10 S: 43.18 M: 48.26 L: 53.34 XL: 58.42 2XL: 63.50 3XL: 68.58	XXS: 38.00 XS: 43.00 S: 48.00 M: 53.00 L: 58.00 XL: 63.00 2XL: 68.00
Shoulder Width Allowance	± 1.00	± 1.00	± 1.00	± 1.27	± 1.00
Bottom & Sleeve Hem (Edge to top stitch)	XS: 1.50 S: 1.50 M: 1.50 L: 1.50	XS: 1.90 S: 1.90 M: 1.90 L: 1.90	XS: 1.90 S: 1.90 M: 1.90 L: 1.90	XS: 1.905 S: 1.905 M: 1.905 L: 1.905	XXS: 1.90 XS: 1.90 S: 1.90 M: 1.90

	XL: 1.50 2XL: 1.50 3XL: 1.50	XL: 1.90 2XL: 1.90	XL: 2.00 2XL: 2.10 3XL: 2.20	XL: 1.905 2XL: 1.905 3XL: 1.905	L: 1.90 XL: 1.90 2XL: 1.90
Bottom & Sleeve Hem Allowance (Edge to top stitch)	± 0.50	± 0.30	± 0.35	± 0.3175	± 0.35
Armhole	XS: 20.60 S: 21.80 M: 23 L: 24.20 XL: 25.40 2XL: 26.80 3XL: 28.20	XS: 20.30 S: 21.30 M: 22.10 L: 23.80 XL: 24.90 2XL: 25.50	XS: 19.00 S: 21.00 M: 23.00 L: 25.00 XL: 27.00 2XL: 30.00 3XL: 33.00	XS: 19.685 S: 22.225 M: 24.765 L: 27.305 XL: 29.21 2XL: 31.75 3XL: 34.29	XXS: N/A XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A
Armhole Allowance	± 1.00	± 0.40	± 1.00	± 1.27	N/A
Upper sleeve length	XS: 21.00 S: 21.50 M: 22.00 L: 22.50 XL: 23.00 2XL: 23.50 3XL: 24.00	XS: 21.50 S: 22.00 M: 22.50 L: 23.00 XL: 23.50 2XL: 24.00	XS: 18.50 S: 18.50 M: 20.00 L: 22.00 XL: 23.00 2XL: 25.00 3XL: 27.00	XS: 18.415 S: 19.685 M: 20.955 L: 22.86 XL: 24.13 2XL: 24.13 3XL: 25.40	XXS: 62.00 XS: 64.00 S: 65.00 M: 66.50 L: 67.50 XL: 69.00 2XL: 71.00
Upper Sleeve	± 0.00	± 0.50	± 1.00	± 1.27	± 1.00

length Allowance					
Sleeve Opening	XS: 16.00 S: 17.00 M: 18.00 L: 19.00 XL: 20.00 2XL: 21.50 3XL: 23.00	XS: 17.00 S: 19.00 M: 21.00 L: 22.50 XL: 24.00 2XL: 25.00	XS: 16.50 S: 16.50 M: 17.00 L: 19.00 XL: 20.00 2XL: 21.50 3XL: 22.00	XS: 16.51 S: 16.51 M: 17.78 L: 19.05 XL: 20.32 2XL: 21.59 3XL: 22.86	XXS: 18.00 XS: 19.00 S: 20.00 M: 21.00 L: 22.00 XL: 23.00 2XL: 24.00
Sleeve Opening Allowance	± 1.00	± 0.50	± 1.00	± 1.27	± 1.00
Pocket Placement	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A 3XL: N/A	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A	XS: 20.00 S: 21.00 M: 22.00 L: 22.50 XL: 23.00 2XL: 23.50 3XL: 24.00	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A 3XL: N/A	XXS: N/A XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A
Pocket Placement Allowance	N/A	N/A	± 1.00	N/A	N/A
Pocket Width	XS: N/A S: N/A M: N/A L: N/A	XS: N/A S: N/A M: N/A L: N/A	XS: 9.00 S: 9.00 M: 9.00 L: 9.00	XS: N/A S: N/A M: N/A L: N/A	XXS: N/A XS: N/A S: N/A M: N/A

	XL: N/A 2XL: N/A 3XL: N/A	XL: N/A 2XL: N/A	XL: 9.00 2XL: 9.00 3XL: 9.00	XL: N/A 2XL: N/A 3XL: N/A	L: N/A XL: N/A 2XL: N/A
Pocket Width Allowance	N/A	N/A	± 0.50	N/A	N/A
Pocket Height	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A 3XL: N/A	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A	XS: 12.00 S: 12.00 M: 12.00 L: 12.00 XL: 12.00 2XL: 12.00 3XL: 12.00	XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A 3XL: N/A	XXS: N/A XS: N/A S: N/A M: N/A L: N/A XL: N/A 2XL: N/A
Pocket Height Allowance	N/A	N/A	± 0.50	N/A	N/A
Fabric & GSM	Single jersey - 180 GSM 100% cotton, mash fabric 100% polyester	Single jersey - 160 GSM 100% BCI cotton	Single jersey - 180 GSM 100% cotton, (stripe-5/5cm)	100% soft spun cotton, GSM 160	Single jersey - 200 GSM 60-40 cotton, polyester blend. mash fabric 100% polyester
Print Technique	Rubber print (heat-sealed)	N/A	N/A	N/A	N/A
Packaging	Poly bag	Poly bag	Poly bag	Poly bag	Poly bag
Unit Price	\$2.30	\$2.39	\$1.80	\$2.10	\$2.70
Delivery method	FOB (Sea/Air)	FOB (by Sea)	FOB (Sea/Air)	FOB (Sea/Air)	FOB (by Sea)

Order Quantity	650000 pieces per 3 month	1000 pieces per 2 or 3 months	650000 pieces per 3 month	700000 pieces per 3 month	300000 pieces per 6 month
Payment Method	LC (90 Days)	LC (60 Days)	LC (90 Days)	LC (90 Days)	LC (Not Specified)

3.2 Differences of 5 Woven Shirt buyers

3.2.1 Details of the buyers order & business elements

H&M

H&M Fabric Technical Details (FTD)

1 (3)

A – Woven Fabric Information

To be filled in by fabric suppliers

Garment/product supplier or other buyer of the fabric should fill in the head (for reference) and send to fabric supplier to fill in the results before garment wash/treatment. The fabric should be evaluated if suitable for requested print/wash/other treatments. All results should include eventual garment treatment. To be filled in by product supplier before order placement.

Style/Order NO.: Jayden LS Plaid Western Shirt S.O- Akij	Product Type: Yarn Dyed	Department:	Date: 10.12.18
Garment Supplier:			
Fabric Supplier: AKIJ TEXTILE MILS LTD. a.shohel@akij.net; arif.atml@akij.net; pronab.atml@akij.net mehedi.atml@akij.net			
Fabric Article Number: 3189-18	Country Of Origin: Bangladesh		
Sustainable Material:	Organic <input type="checkbox"/> Post-consumer <input type="checkbox"/>	Tencel <input type="checkbox"/> Pre-consumer <input type="checkbox"/>	Better Cotton <input checked="" type="checkbox"/> Recycle <input type="checkbox"/>
Compositions: (Sustainable fibre should be indicated clearly)	100% Cotton		
Yarn count: (indicate unit of measure i.e. Ne, denier, tex etc. and no of filament if applicable also yarn type like combed, card, OE, vortex etc.)	Density: 40/2x40/2/64x56	Weave: 2/2 Z twill	
Dyeing/Printing Mill: (Mention PU name)	Akij Textile Mills Ltd	Print Unit: (product)	N/A
Dyes/Print type: (Mention dyestuff type like Reactive, Pigment etc.)	Reactive	Print Method: (product)	N/A
		Wash Unit: (product)	N/A
Fabric Finishing:	Brush	Wash Method: (product)	
Fabric Weight (g/m²):	140 ±5%	Cutable Width:	56"
Price	USD 2.05/Yard	Lead-time:	3-5 weeks
Care Instructions:			

FTD is a documentation of physical parameters of the material/product. For colour fastness tests, please specify for which colour way the result is referring to. Always refer to the darkest colorway if possible. The material/product must also to fulfill H&M Chemical restrictions. Fiber analyses should be applied (when requested).

Figure 22: Fabric Technical details of H&M buyer.

H&M Fabric Technical Details (FTD)

2 (3)

B - H&M Fabric technical data (FTD) (tested by knitted fabric) To be completed by Fabric suppliers & Garment suppliers

Items		Test Results (By fabric supplier)	Test results (By garment supplier after the garment treatment process)	Comments
2	Dimensional stability to household laundering/dry clean (if applicable. See H&M Lab Manual)	Length: ±4.0 %	%	
		Width: ±4.0 %	%	
		Twisting: 4 %	%	
3	Colour fastness to household washing/dry clean (if applicable) (See HM Lab manual)	Colour staining: 3/4		
		Change in colour: 4		
		Cross staining: 4/5		
4	Colour fastness to rubbing (ISO 105-X12)	Dry rubbing before wash: 4		
		After wash: 4		
		Wet rubbing before wash: 2/3		
		After wash: 2/3		
5	Colour fastness to perspiration (ISO 105-E04 or GB/T 3922)	Colour staining: 4		
		Change in colour: 4		
		Cross staining: 4/5		
6	Colour fastness to saliva (for baby's wear size 44-98cl) (GB/T 18886)	Colour staining: 4		
		Change in colour: 4		
		Cross staining: 4/5		
7	Colour fastness to water (ISO 105 - E01)	Color staining: 4		
		Change in colour: 4		
		Cross staining: 4/5		
8	Flammability General: 16 CFR 1610 Children's nightwear: EN 14878	Time in seconds: 7 sec (Class 1)		
9	Stretch and recovery ASTM D3107, 4lbs loading after 3household washes, for stretch fabric and direction	Stretch under loading after 30min	N/A %	%
		Growth after static extension & 30min recovery	N/A	
		Recovery after static extension & 30 min recovery	N/A	
10	Pile Loss(Corduroy & Pile fabric) ISO 12947-2 Annex:2	In revolution: N/A		
11	Seam Slippage (ISO 13936-2)	In mm: <6 mm		
		Warp (in N): 10 N		
12	Tear Strength			

Figure 23: Fabric Technical details of H&M buyer.

H&M Fabric Technical Details (FTD)

3 (3)

	(EN ISO 13937-2)	Weft (in N): 10 N		
13	Color fastness to Ozone (AATCC 109 , 2 cycles)	Change in colour: N/A		
		Change in colour: 3		
14	Colour fastness to artificial light (ISO 105-B02)	2000 revolution: N/A		
15	Pilling resistance woven (martindale) (ISO 12945-2)	After 5 washing & drying cycles: No Major Change		
16	Appearance after wash			
17	Additional (please mention any other risky parameter here)			

Figure 24: Fabric Technical details of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT	DEPT: L.O.G.G 5767	S: 0	H&M
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Info

FABRIC DIRECTION

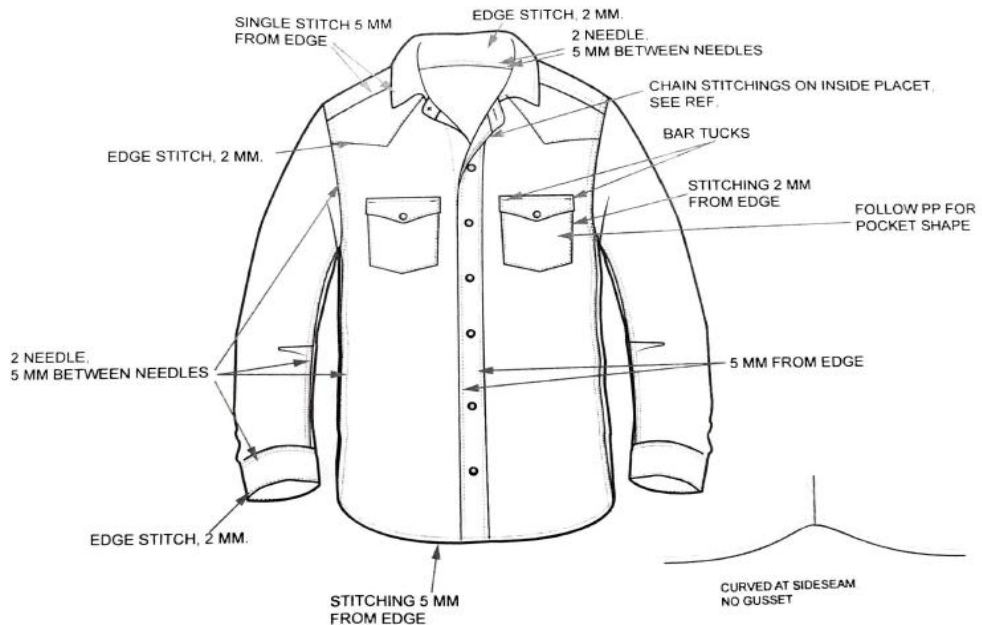


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Figure 25: Artwork of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT	DEPT: L.O.G.G 5767	S: 0	H&M
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Thread Layout



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Figure 26: Artwork (front) details of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT

DEPT: L.O.G.G 5767

S: 0

H&M

Info

FABRIC DIRECTION



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REVISION: X XXXXXX

DATE OF CREATION: 181128

Figure 27: Fabric direction of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT

DEPT: L.O.G.G 5767

S: 0

H&M

Details

BUTTONS

SNAP BUTTON - ALL BUTTONS EXCEPT
COLLAR STAND BUTTON



18L

REF. DESIGN AND COLOUR FOR
COLLAR STAND AND SLEEVE PLACKET BUTTON

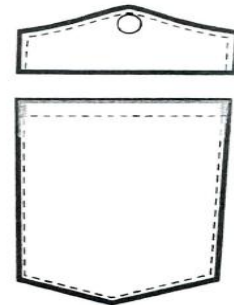
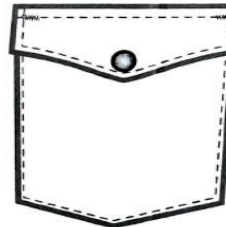


FINISH: IMITATION COROZO (M)
COLOUR: VANILLA



18L COLLAR

POCKETS



THR, ALL CWYS:

THREAD COUNT: 20/2
SPI: 11
STITCH: PLAIN

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REVISION: X XXXXXX

DATE OF CREATION: 181128

Figure 28: Pocket details of H&M buyer.

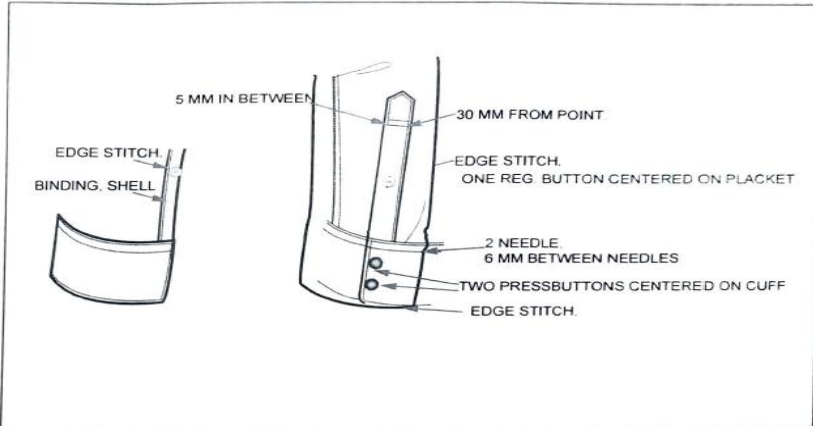
STYLE: JAYDEN LS PLAID WESTERN SHIRT	DEPT: L O G G 5767	S: 0	H&M
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Details

REF. FRONT PLACKET MAKING



SLEEVEPLACKET INFO



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Figure 29: Sleeve placket info of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT	DEPT: L O G G 5767	S: 0	H&M
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REF FOR STYLE

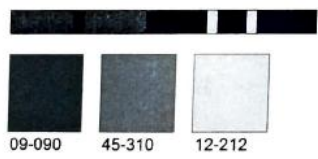
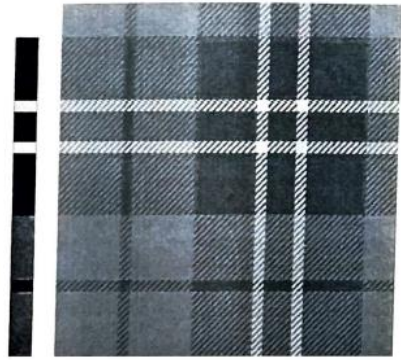


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Figure 30: Artwork of H&M buyer.

STYLE: JAYDEN LS PLAID WESTERN SHIRT	DEPT: L.O.G.G 5767	S: 0	H&M
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COLOURS
COL.1 - BASE FABRIC
COL.2 - THREAD COLOUR



Warp Repeat: 2.79 Inches
Weft Repeat: 2.79 Inches
Panel Name: S.0-2018-11-30-01-M



CWY A

COL. 1 COL. 2

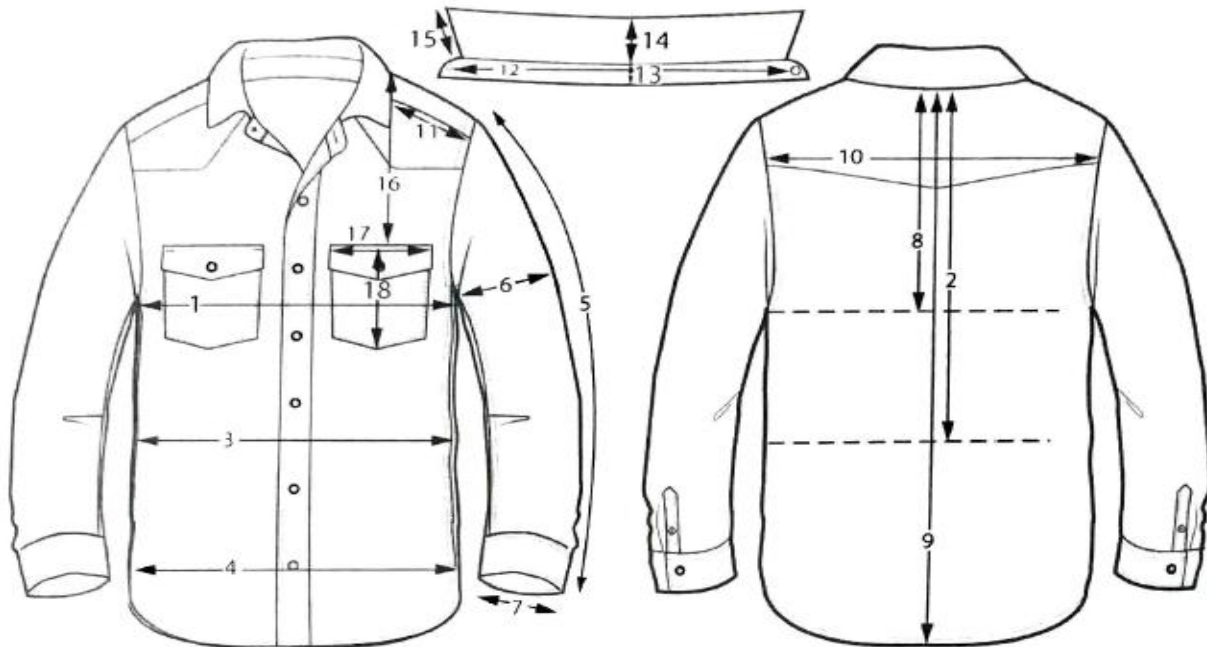
45-310 09-090

SEE CHECK

MARBLE VANILLA,
WORN SILVER RING

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Figure 31: Color assessment details of H&M buyer.



*=rev. m-ment	XS	S	M	L	XL	XXL
QC 1 CHEST	97	105	113	121	129	137
2 LENGHT TO WAIST	47.25	48.25	49.25	50.25	51.25	52.25
QC 3 WAIST	91	99	107	115	123	131
QC 4 BOTIOM	92	100	108	116	124	132
QC 5 SLEEVE LENGHT *	64	65.25	66.5	67.75	69	70.25
6 BICEPS *	38	40.5	43	45.5	48	50.5
7 BOTTOM SLEEVE when buttoned	21	22	23	24	25	26
QC 8 SCYE DEPTH	25	26	27	28	29	30
QC 9 BACK LENGHT	73	74.5	76	77.5	79	80.5
10 BACK WIDTH AT YOKE SEAM	41.25	43.25	45.25	47.25	49.25	51.25
11 SHOULDER SEAM	15.15	15.7	16.25	16.8	17.35	17.9
QC 12 COLLAR LENGHT when buttoned	38.5	40.5	42.5	44.5	46.5	48.5
13 COLLAR STAND HEIGHT at cb	3	3	3	3	3	3
14 COLLAR HEIGHT at cb	4.5	4.5	4.5	4.5	4.5	4.5
15 COLLAR POINT	5.5	5.5	5.5	5.5	5.5	5.5
16 POCKET PLACEMENT	21.5	22	22.5	23	23.5	24
17 POCKET FLAP WIDTH	11.5	12	12.5	13	13.5	14
18 POCKET HEIGHT	13	13.5	14	14.5	15	15.5

Figure 32: Pattern details & Measurements sheet of H&M buyer.

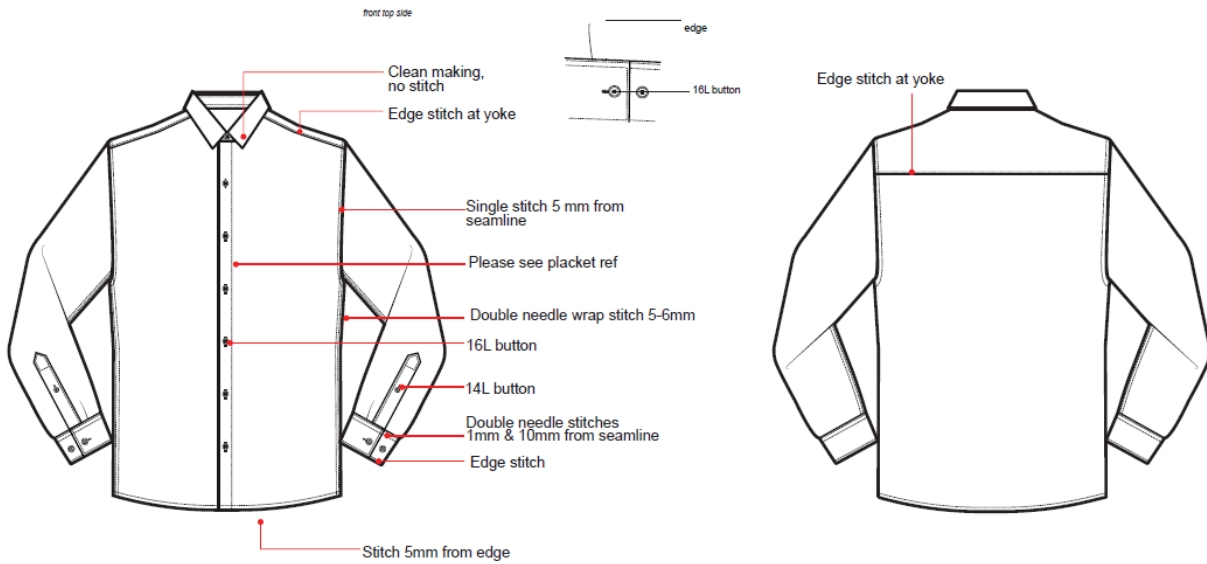


Figure 33: Artwork (front) of MINA buyer.



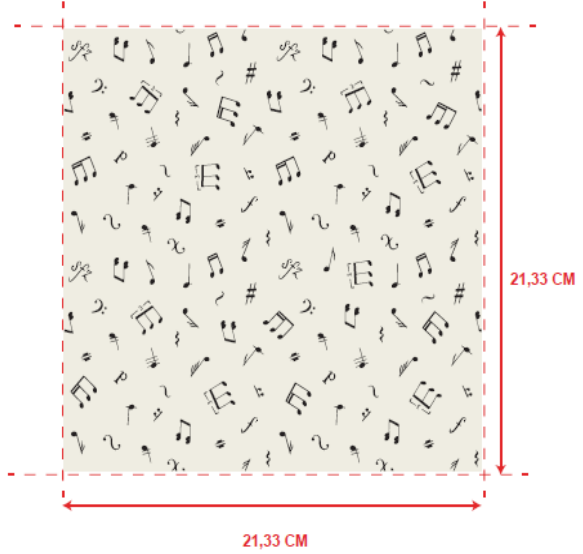
Figure 34: Button details of MINA buyer.

L

ARTWORK INFO



REPEAT SIZE



ARTWORK INFO



PIGMENT
PRINT

Figure 35: Artwork of MINA buyer.



ARTWORK INFO



Figure 36: Artwork of MINA buyer.



SIZE (Measurement unit: cm)	XS	S	M	L	XL	XXL
CHEST	95	100	107	112	120	135
LENGTH TO WAIST	47.25	48.15	49.50	50.25	51.15	52.50
WAIST	90	99	106	122	123	130
BOTTOM	90	98	106	115	122	131
SLEEVE LENGTH	62.15	64.30	66.15	68.50	69.25	70.75
BICEPS	37	39	42	44	47	50
BOTTOM SLEEVE	20	21	23	24	25	26
SCYE DEPTH	24	25	25	26	28	29
BACK LENGTH	72	72	75	76	78	80
BACK WIDTH AT YOKE SEAM	41.25	42.50	44.25	45.50	47.15	50.15
SHOULDER SEAM	15.15	15.75	16.15	16.50	16.75	17.15
COLLAR LENGTH	37	38	40.50	43.50	45.50	47.50
COLLARSTAND HEIGHT at cb	2.50	2.50	2.50	2.50	2.50	2.50
COLLAR HEIGHT at cb	4.25	4.25	4.25	4.25	4.25	4.25
COLLARPOINT	5.25	5.25	5.25	5.25	5.25	5.25

Figure 37: Measurements sheet of MINA buyer.

WiK

Product Pass	
IAN:	296532
Article Description:	Men Shirt Leisure Long Sleeves Linen/Cotton, 4
1. Article Main Data	
Selection (YYMM)	1707
Pre-Selection No. (YYMM_XXXX)	1707_1391
Old IAN	284265
Old Article Description	Men Shirt Leisure Long Sleeves Linen/Cotton
Product Group	100.270 Men's Shirts
New Product Group	100.270 Men's Shirts
Units per carton	16
Theme	20.1 - Ladies Men Textile (Linen)
Vendor FOB Week (YYWW) : See	Quantity Breakdown
Buyer	WiK
2. Labelling	
Brand	Livergy
Logo (-printing) process	Woven label
Position	Inside
3. Quantity	
Total Quantity	286336
Calculated Total Quantity	286336
4. Testing Criteria	
Testing institute	Hohenstein
Fitting Label	3 Ticks Label
Other Testing Criteria	
5. Certifications/ Features	
Hohenstein	
Okotex	
6. Logos on Packaging	
Hohenstein	
With linen	
Okotex	
7. Packaging	
Retail packaging	Special Packaging
Material Thickness of Retail Packaging	Packaging Briefing will be sent
Agency	
NonFood Werbeagentur GmbH	
10. Version No.	
6	



Page 1

Figure 38: Order sheet of WiK buyer.

Article Description	Product Description	Style & Photo		
		Photo 1	Photo 2	Photo 3
296532				
296532				
296532				
296532				



Figure 39: Artwork of WiK buyer.

2.3 Only leather goods				
3. Finishing				
Finishing	Garment Washed	Garment Washed	Garment Washed	Garment Washed
4. Components				
4.1 Zipper				
4.2 Buttons	4-hole	4-hole	4-hole	4-hole
Material	Plastic	Plastic	Plastic	Plastic
Plain / Embossed / Others	Plain	Plain	Plain	Plain
Colour	as original	as original	as original	as original
Quantity	must be calculated -> see Tech Pack	must be calculated -> see Tech Pack	must be calculated -> see Tech Pack	must be calculated -> see Tech Pack
Number of spare buttons	1	1	1	1
4.3 Other				
5. Care Instruction				
Care Instructions				
Additional Text of Care Instruction	Wash with similar colors! We recommend to use color detergent/ Iron whilst damp	Wash with similar colors! We recommend to use color detergent/ Iron whilst damp	Wash with similar colors / Iron whilst damp	Wash with similar colors! We recommend to use color detergent/ Iron whilst damp
6. Colour (Shell fabric)				

Page 2

Figure 40: Item details of WiK buyer

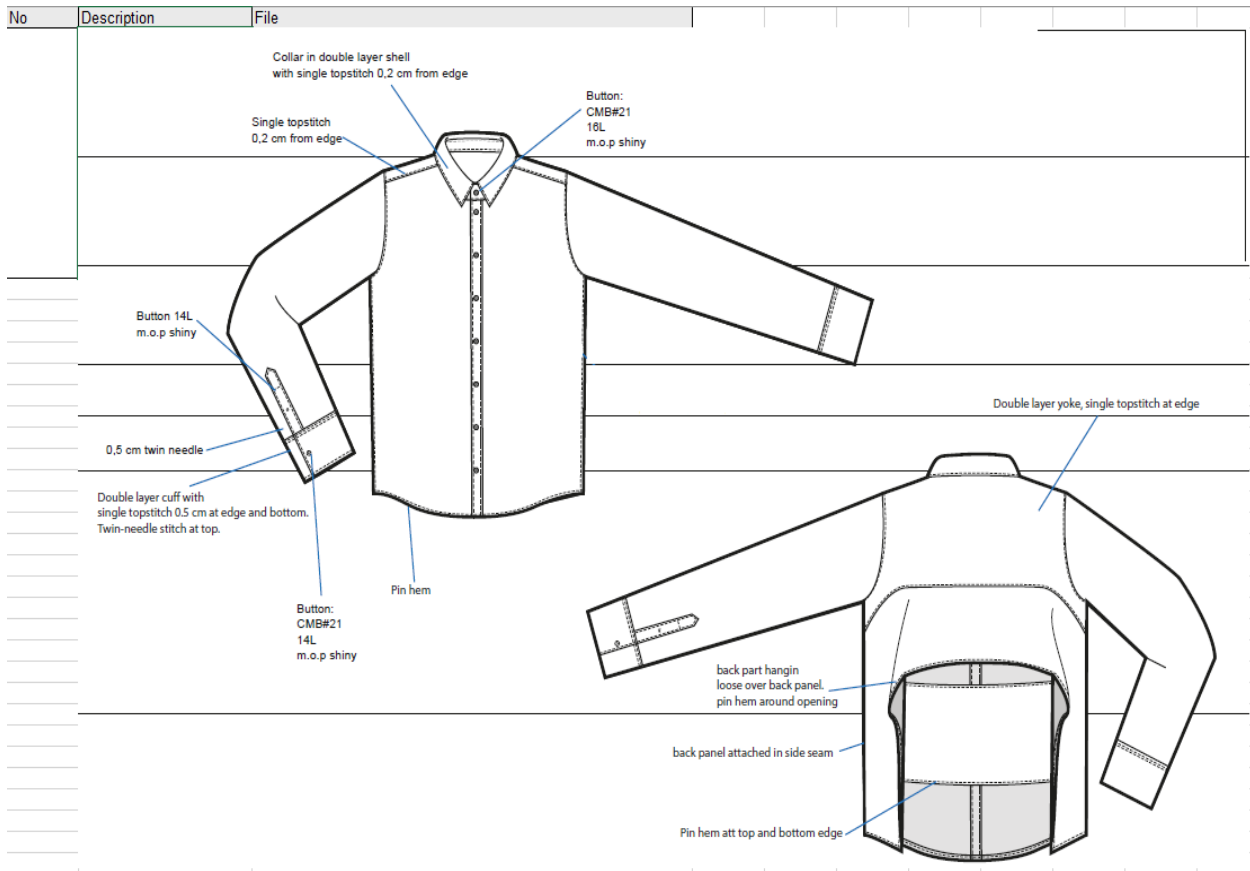


Figure 41: Artwork of WiK buyer.


	Style A	Style B	Style C	Style D
	White	Green	Beige	Navy
1. Material				
1.1 Shell/Outer Fabric	55% Linen 45% Cotton	55% Linen 45% Cotton	55% Linen 45% Cotton	55% Linen 45% Cotton
Fabric weight in g/m²	150	125	125	125
Unit Weight	M39/40), 320g	M39/40), 320g	M39/40), 320g	M39/40), 320g
1.2 Lining				
Sleeve Lining	Page 1	Page 12	Page 23	Page 34
Body Lining				
Fabric weight in g/m²				
1.3 Filling				
Padding				
Fabric weight in g/m²				
1.4 Other	Interlining for button facing, collar, cuff. Please pay attention, that white is not too transparent.	Interlining for button facing, collar, cuff.	Interlining for button facing, collar, cuff.	Interlining for button facing, collar, cuff.
Fabric weight in g/m²				
2. Quality/technical Data				
2.1 Woven Fabric				
Material Construction	Plain weave	Plain weave	Plain weave	Plain weave

Figure 42: Assortment & Fabric details of WiK buyer.






Messpunkte / measurement points	Maschen- / Webware / knitted / woven fabrics	Toleranz in cm	Größe / size								
			M 39/40		L 41/42		XL 43/44		XXL 45/46		
			Soll		Soll		Soll		Soll		
1	1/2 Brustweite 1/2 chest width	+/- 1,0	58,0		62,0		66,0		69,0		
2	Messpunkt für Taille von HSP measurement point for waist from HPS										
3	1/2 Taillenweite 1/2 waist width	+/- 1,0									
4	1/2 Saumweite 1/2 hem width	+/- 1,0	56,0		60,0		64,0		69,0		
4a	Differenz VM zu HM difference between CF to CB	+/- 0,5									
4b	Differenz Seitennaht zu HM difference between side seam to CB	+/- 0,5	4,0		4,0		4,0		4,0		
5	Schulterbreite shoulder width	+/- 0,5	16,5		17,2		17,9		18,6		
6	Armellänge von Schulterpunkt sleeve length from shoulder point	+/- 1,0	67,5		68,5		69,5		70,5		
7	1/2 Armsaumweite 1/2 sleeve hem width	+/- 0,5									
8	Armlochhöhe armhole height	+/- 1,0	24,0		25,0		26,0		27,0		
9	1/2 Oberarmweite 1/2 upper arm width	+/- 1,0	23,0		23,5		24,0		24,5		
10	Halslochweite neck width	+/- 1,0									
11	Ausschnitttiefe vorne neck drop front	+/- 0,5	9,5		10,0		10,5		11,0		
12	Ausschnitttiefe hinten neck drop back	+/- 0,5									
13	Länge hintere Mitte length CB	+/- 1,0	80,0		81,0		82,0		83,0		
14	Rückenlänge von HSP back length from HPS	+/- 1,0									
15	Kragenweite collar width	+/- 0,5	40,5		42,5		44,5		46,5		
16	Kragenhöhe in HM collar height at CB	+/- 0,3	4,6		4,6		4,6		4,6		
17	Steghöhe in HM collar stand height at CB	+/- 0,3	3,1		3,1		3,1		3,1		
18	Kragenhöhe in VM collar height at CF	+/- 0,3	6,0		6,0		6,0		6,0		
19	Kragenlänge außen collar length upper edge	+/- 0,5	41,0		43,0		45,0		47,0		
20	Kragenlänge innen collar length at neckline	+/- 0,5	39,8		41,8		43,8		45,8		
21	Manschettenweite cuff width	+/- 0,5	24,0		24,0		25,0		26,0		
22	Manschettenhöhe cuff height	+/- 0,5	6,5		6,5		6,5		6,5		
23a	Messpunkt für VT Breite von HSP measurement point for front width from HPS		17,0		17,0		17,0		17,0		
23b	Vorderteilbreite front width	+/- 1,0	42,0		44,0		46,0		48,0		
24a	Messpunkt für RT Breite von HSP measurement point for back width from HPS		17,0		17,0		17,0		17,0		
24b	Rückenteilbreite back width	+/- 1,0	45,0		47,0		49,0		51,0		
a.	yoke height	+/- 1,0	19,0		19,0		19,5		19,5		see photo

Figure 43: Measurements sheet of WiK buyer.


LiDL

Techpacks by  **20.1 WLS Lady Men Textile (Linen)**
IAN No: 296532 (A - D)
Men Leisure Shirt, Longsleeve

Colours:

 Navy Blazer 19-3923 TCX	 Plaza Taupe 16-1105 TCX weft: Bright White 11-0601 TCX yarn dyed	 Bright White 11-0601 TCX	 Warp: Dark Slate 19-4220 TCX weft: Bright White 11-0601 TCX yarn dyed	 xx-xxxx TCX Pantone
---	---	--	---	---

Date: 19.09.17 page 1/5



A navy
B beige
C white
D chambray

All seams, stitchings and trimmings only for styling reference, however they must comply with the LiDL standard! *The disclosure of this Tech Pack to a third party is only permitted as far as it is necessary within the context of the cooperation with the LiDL Group. Unauthorized disclosure to third parties or use outside the context of cooperation with the LiDL Group constitutes, among others, a copyright infringement and can be punishable. The goods are intended for distribution to the end customer in the US. The following requirements for the goods are based on regulations applicable in the European Union. Requirements agreed upon under the framework agreement or purchase agreement shall remain unaffected thereof and shall prevail. This shall apply in particular with regard to the seller's obligation to ensure compliance of the goods and the packaging with all legal regulations applicable in the US, if and insofar as the seller, while observing the following requirements, cannot guarantee compliance of the goods with the legal regulations applicable in the US, the seller shall make adjustments. Furthermore it is expressly clarified, that any goods produced based on this Tech Pack need to be free from any third party rights.*

Figure 44: Artwork of LiDL buyer.



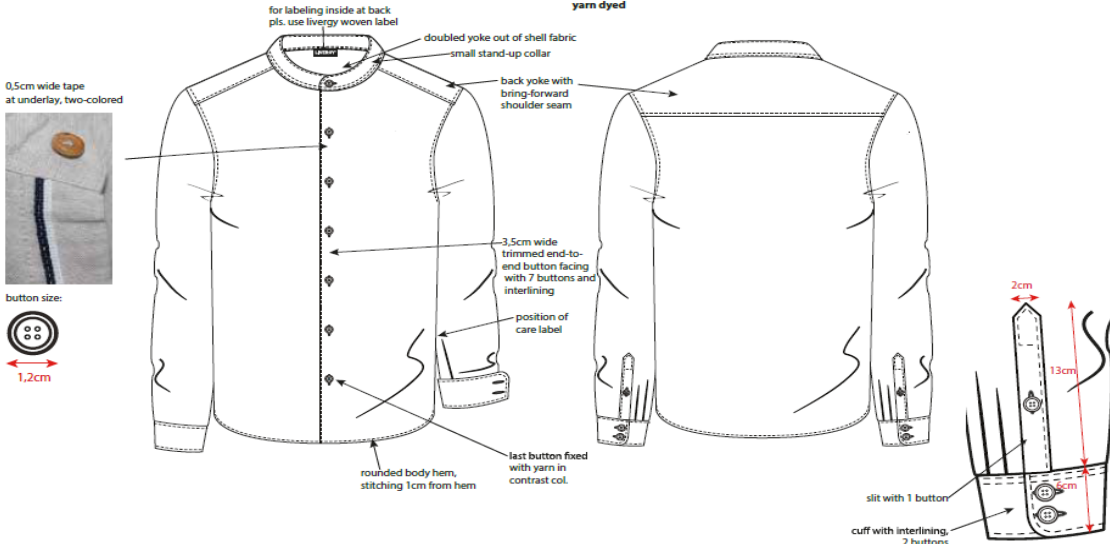
20.1 WLS Lady Men Textile (Linen)
IAN No: 296532 (A,B)
Men Leisure Shirt, Longsleeve

Colours:

F1	F2	F3	F4	F5
Navy Blazer 19-3923 TCX	Plaza Taupe 16-1105 TCX wef: Bright White 11-0601 TCX yarn dyed	XX-XXXX TCX Pantone	XX-XXXX TCX Pantone	XX-XXXX TCX Pantone

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Date: 19.09.17



All seams, stitchings and trimmings only for styling reference, however they must comply with the Lidl standard! *The disclosure of this Tech Pack to a third party is only permitted as far as it is necessary within the context of the cooperation with the Lidl Group. Unauthorized disclosure to third parties or use outside the context of cooperation with the Lidl Group constitutes, among others, a copyright infringement and can be punishable. The goods are intended for distribution to the end customer in the US. The following requirements for the goods are based on regulations applicable in the European Union. Requirements agreed upon under the framework agreement or purchase agreement shall remain unaffected thereof and shall prevail. This shall apply in particular with regard to the seller's obligation to ensure compliance of the goods and the packaging with all legal regulations applicable in the US. If and insofar as the seller, while observing the following requirements, cannot guarantee compliance of the goods with the legal regulations applicable in the US, the seller shall make adjustments. Furthermore it is expressly clarified, that any goods produced based on this Tech Pack need to be free from any third party rights.*

Figure 45: Artwork (front, back & sleeve) of LiDL buyer.



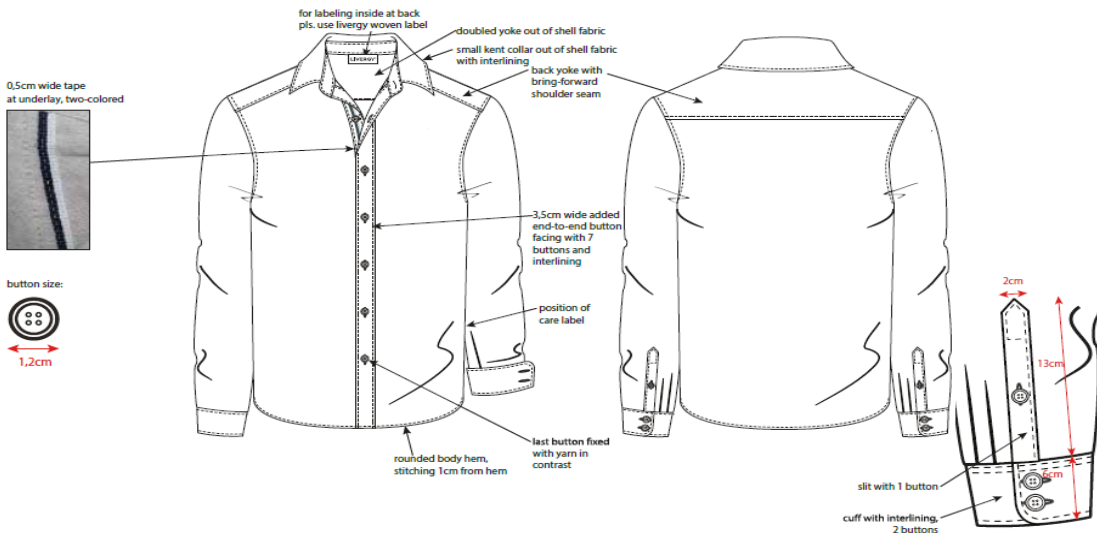
20.1 WLS Lady Men Textile (Linen)
IAN No: 296532 (C)
Men Leisure Shirt, Longsleeve

Colours:

F1	F2	F3	F4	F5
Bright White 11-0601 TCX	XX-XXXX TCX Pantone	XX-XXXX TCX Pantone	XX-XXXX TCX Pantone	XX-XXXX TCX Pantone

page 3/5

Date: 19.09.17



All seams, stitchings and trimmings only for styling reference, however they must comply with the Lidl standard! *The disclosure of this Tech Pack to a third party is only permitted as far as it is necessary within the context of the cooperation with the Lidl Group. Unauthorized disclosure to third parties or use outside the context of cooperation with the Lidl Group constitutes, among others, a copyright infringement and can be punishable. The goods are intended for distribution to the end customer in the US. The following requirements for the goods are based on regulations applicable in the European Union. Requirements agreed upon under the framework agreement or purchase agreement shall remain unaffected thereof and shall prevail. This shall apply in particular with regard to the seller's obligation to ensure compliance of the goods and the packaging with all legal regulations applicable in the US. If and insofar as the seller, while observing the following requirements, cannot guarantee compliance of the goods with the legal regulations applicable in the US, the seller shall make adjustments. Furthermore it is expressly clarified, that any goods produced based on this Tech Pack need to be free from any third party rights.*

Figure 46: Artwork (front, back & sleeve) of LiDL buyer.



20.1 WLS Lady Men Textile (Linen)
IAN No: 296532 (D)
Men Leisure Shirt, Longsleeve

Colours:

F1
warp: Dark Slate
19-4220 TCX
weft: Bright White
11-9601 TCX
yarn dyed

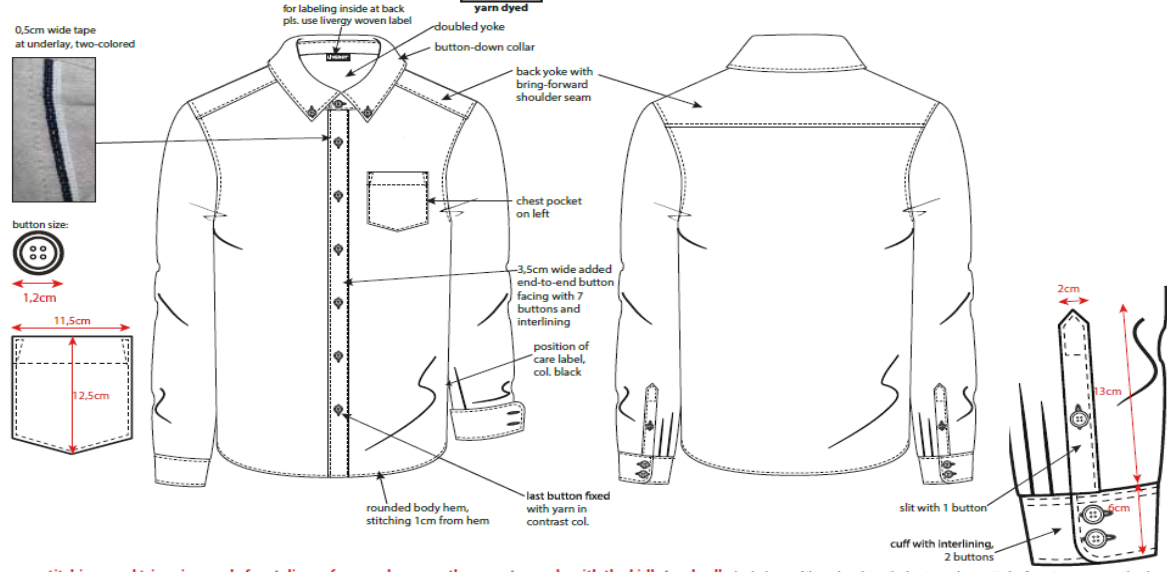
F2
xx-xxxx TCX
Pantone

F3
xx-xxxx TCX
Pantone

F4
xx-xxxx TCX
Pantone

F5
xx-xxxx TCX
Pantone

Date: 19.09.17



All seams, stitchings and trimmings only for styling reference, however they must comply with the Lidl standard! "The disclosure of this Tech Pack to a third party is only permitted as far as it is necessary within the context of the cooperation with the Lidl Group. Unauthorized disclosure to third parties or use outside the context of cooperation with the Lidl Group constitutes, among others, a copyright infringement and can be punishable. The goods are intended for distribution to the end customer in the US. The following requirements for the goods are based on regulations applicable in the European Union. Requirements agreed upon under the framework agreement or purchase agreement shall remain unaffected thereof and shall prevail. This shall apply in particular with regard to the seller's obligation to ensure compliance of the goods and the packaging with all legal regulations applicable in the US, if and insofar as the seller, while observing the following requirements, cannot guarantee compliance of the goods with the legal regulations applicable in the US, the seller shall make adjustments. Furthermore it is expressly clarified, that any goods produced based on this Tech Pack need to be free from any third party rights."

Figure 47: Artwork (front, back & sleeve) of LiDL buyer.



Date: 15.11.17

STYLE:	LABEL COL.:	
A	black (pls. follow colour standard)	<p>LIVERY WOVEN LABEL:</p> <p>SIZE LABEL:</p>
B	white (pls. follow colour standard)	
C	white (pls. follow colour standard)	
D	black (pls. follow colour standard)	

All seams, stitchings and trimmings only for styling reference, however they must comply with the Lidl standard! "The disclosure of this Tech Pack to a third party is only permitted as far as it is necessary within the context of the cooperation with the Lidl Group. Unauthorized disclosure to third parties or use outside the context of cooperation with the Lidl Group constitutes, among others, a copyright infringement and can be punishable. The goods are intended for distribution to the end customer in the US. The following requirements for the goods are based on regulations applicable in the European Union. Requirements agreed upon under the framework agreement or purchase agreement shall remain unaffected thereof and shall prevail. This shall apply in particular with regard to the seller's obligation to ensure compliance of the goods and the packaging with all legal regulations applicable in the US, if and insofar as the seller, while observing the following requirements, cannot guarantee compliance of the goods with the legal regulations applicable in the US, the seller shall make adjustments. Furthermore it is expressly clarified, that any goods produced based on this Tech Pack need to be free from any third party rights."

Figure 48: Trims/Accessories of LiDL buyer.

Hemd mit einges. Ärmel / shirt with insert sleeve		17.7.21577/4, sp. 09+10					
		OK		08.11.2017			
125 g/m ² , 55% Leinen/leinen, 45% Baumwolle/cotton, plain-weave							
Lidl description: Men Shirt Leisure Long Sleeves, Linen/cotton, 4 assorted		alm / age group: Casual/basic 25+, 35+	version D7_17	A014300			
IAN / article no.: 296532		product description: Casual, straight, 1/2 sleeve length, 1/2 backside covered+ (2.0 cm) small stand up collar					
style no.: A/ Navy, B/ Beige		date: 08.11.2017					
Messpunkte / measurement points	Maschen- / Webware / knitted / woven fabrics	Größe / size					
		M 39/40	L 41/42	XL 43/44	XXL 45/46		
		Toleranz in cm					
		Soll	Soll	Soll	Soll		
1	1/2 Brustweite 1/2 chest width	±1,0	58,0	62,0	66,0	69,0	
2	Messpunkt für Taille von HSP measurement point for waist from HPS						
3	1/2 Taillenweite 1/2 waist width	±1,0					
4	1/2 Saumweite 1/2 hem width	±1,0	56,0	60,0	64,0	69,0	
4a	Differenz VM zu HM difference between CF to CB	±0,5					
4b	Differenz Seitennaht zu HM difference between side seam to CB	±0,5	4,0	4,0	4,0	4,0	
5	Schulterbreite shoulder width	±0,5	16,5	17,2	17,9	18,6	
6	Ärmellänge von Schulterpunkt sleeve length from shoulder point	±1,0	67,5	68,5	69,5	70,5	
7	1/2 Ärmelsaumweite 1/2 sleeve hem width	±0,5					
8	Ärmlochhöhe armhole height	±1,0	24,0	25,0	26,0	27,0	
9	1/2 Oberarmweite 1/2 upper arm width	±1,0	23,0	23,5	24,0	24,5	
10	Halschwelle neck width	±1,0	17,0	17,5	18,0	18,5	
11	Ausschnitttiefe vorne neck drop front	±0,5	9,5	10,0	10,5	11,0	
12	Ausschnitttiefe hinten neck drop back	±0,5					
13	Länge hintere Mitte length CB	±1,0	80,0	81,0	82,0	83,0	
14	Rücklänge von HSP back length from HPS	±1,0					
15	Kragenweite collar width	±0,5	42,0	44,0	46,0	48,0	
16	Kragenhöhe in HM collar height at CB	±0,3					
17	Steghöhe in HM collar stand height at CB	±0,3	3,0	3,0	3,0	3,0	
18	Kragenhöhe in VM collar height at CF	±0,3					
19	Kragenlänge außen collar length upper edge	±0,5					
20	Kragenlänge innen collar length at neckline	±0,5					
21	Manschettenweite cuff width	±0,5	24,0	24,0	25,0	26,0	
22	Manschettenhöhe cuff height	±0,5	6,5	6,5	6,5	6,5	
23a	Messpunkt für VT Breite von HSP measurement point for front width from HPS		17,0	17,0	17,0	17,0	
23b	Vorderteilbreite front width	±1,0	42,0	44,0	46,0	48,0	
24a	Messpunkt für RT Breite von HSP measurement point for back width from HPS		17,0	17,0	17,0	17,0	
24b	Rückenteilbreite back width	±1,0	45,0	47,0	49,0	51,0	
a	yoke height	±1,0	19,0	19,0	19,5	19,5	see photo



Kommentar zur Fertigmaßtafel / comment to ready measurement chart:
 - The expectable shrinkage during production and cut is to be considered in the measurement chart.
 - size L 41/42 and XXL 45/46 were not available for fitting test

*Beschaffungsgarantie / Performance Guarantee:
 Die in dieser Maßtafel festgelegten Maße werden vom Verkäufer als verbindlich garantiert.
 The measurements of this measurement chart are binding.*

Figure 49: Measurements sheet of LiDL buyer.

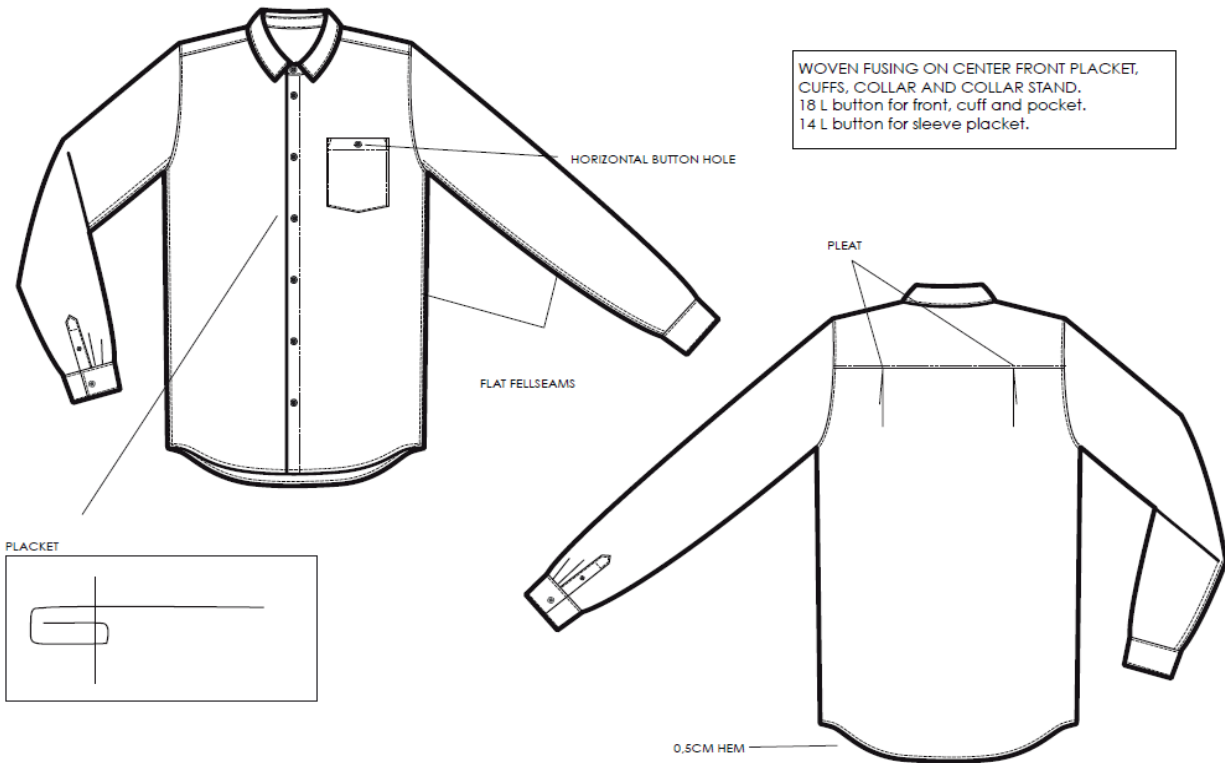


Figure 50: Artwork (front, back) of Zola Times buyer.

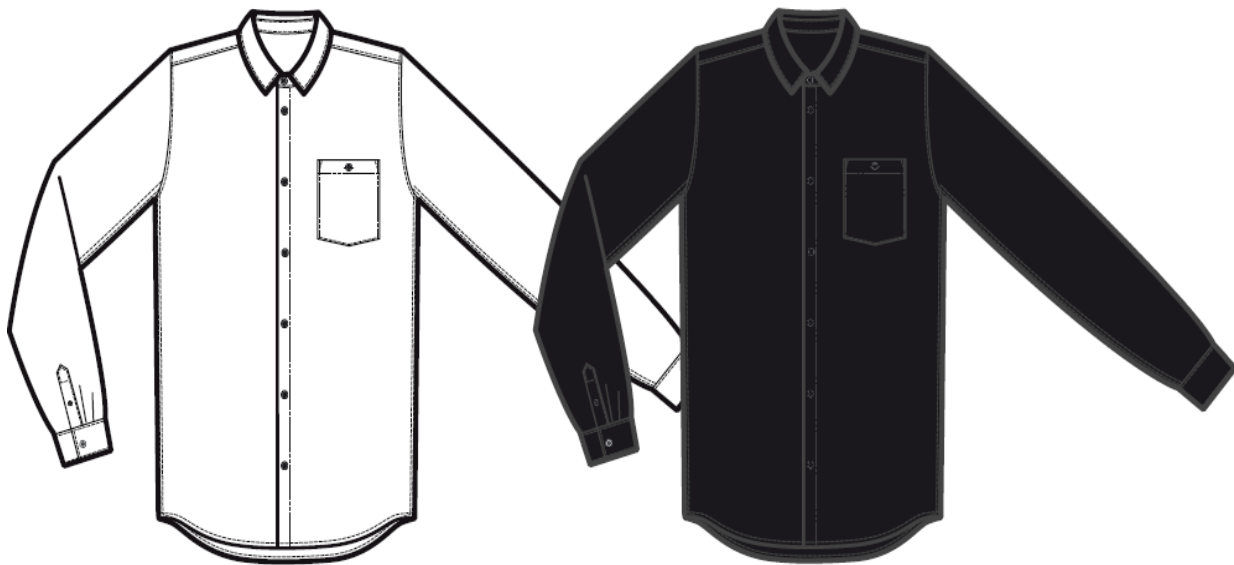


Figure 51: Artwork (front) of Zola Times buyer.

BUTTON STYLE :
OUR WEEKDAY BRANDED BUTTON
18 L button for front, cuff and pocket.
14 L button for sleeve placket

BUTTON COLOUR:
FOR 10-100

BUTTON COLOUR FOR 09-090:
DTM SEMI MATTE

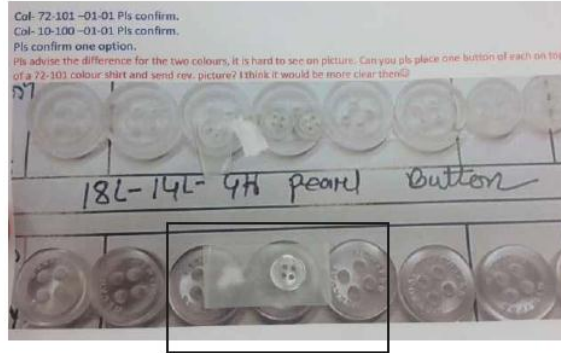


Figure 52: Button details of Zola Times buyer.

Messpunkte / measurement points	Maschen- / Webware / knitted / woven fabrics	Größe / size									
		S 37/38		M 39/40		L 41/42		XL 43/44		XXL 45/46	
		Toleranz in cm	Soll	Soll	Soll	Soll	Soll	Soll	Soll	Soll	Soll
1	1/2 Brustweite 1/2 chest width	+/- 1,0	54,0	58,0	62,0	66,0	69,0				
2	Messpunkt für Taille von HSP measurement point for waist from HPS										
3	1/2 Taillenweite 1/2 waist width	+/- 1,0									
4	1/2 Saumweite 1/2 hem width	+/- 1,0	52,0	56,0	60,0	64,0	69,0				
4a	Differenz VM zu HM difference between CF to CB	+/- 0,5									
4b	Differenz Seitennaht zu HM difference between side seam to CB	+/- 0,5	4,0	4,0	4,0	4,0	4,0				
5	Schulterbreite shoulder width	+/- 0,5	15,8	16,5	17,2	17,9	18,6				
6	Ärmellänge von Schulterpunkt sleeve length from shoulder point	+/- 1,0	24,0	25,0	25,0	26,0	26,0				
7	1/2 Ärmelsaumweite 1/2 sleeve hem width	+/- 0,5	18,5	19,0	19,5	20,0	20,5				
8	Armlochhöhe armhole height	+/- 1,0	23,0	24,0	25,0	26,0	27,0				
9	1/2 Oberarmweite 1/2 upper arm width	+/- 1,0	22,5	23,0	23,5	24,0	24,5				
10	Halslochweite neck width	+/- 1,0									
11	Ausschnitttiefe vorne neck drop front	+/- 0,5	9,0	9,5	10,0	10,5	11,0				
12	Ausschnitttiefe hinten neck drop back	+/- 0,5									
13	Länge hintere Mitte length CB	+/- 1,0	79,0	80,0	81,0	82,0	83,0				
14	Rücklänge von HSP back length from HPS	+/- 1,0									
15	Kragenweite collar width	+/- 0,5	38,5	40,5	42,5	44,5	46,5				
16	Kragenhöhe in HM collar height at CB	+/- 0,3	4,6	4,6	4,6	4,6	4,6				
17	Steghöhe in HM collar stand height at CB	+/- 0,3	3,1	3,1	3,1	3,1	3,1				
18	Kragenhöhe in VM collar height at CF	+/- 0,3	6,0	6,0	6,0	6,0	6,0				
19	Kragenlänge außen collar length upper edge	+/- 0,5	39,0	41,0	43,0	45,0	47,0				
20	Kragenlänge innen collar length at neckline	+/- 0,5	37,8	39,8	41,8	43,8	45,8				
21	Manschettenweite cuff width	+/- 0,5									
22	Manschettenhöhe cuff height	+/- 0,5									
23a	Messpunkt für VT Breite von HSP measurement point for front width from HPS		17,0	17,0	17,0	17,0	17,0				
23b	Vorderteilbreite front width	+/- 1,0	40,0	42,0	44,0	46,0	48,0				
24a	Messpunkt für RT Breite von HSP measurement point for back width from HPS		17,0	17,0	17,0	17,0	17,0				
24b	Rückenteilbreite back width	+/- 1,0	43,0	45,0	47,0	49,0	51,0				
a	yoke height	+/- 0,0	18,5	19,0	19,0	19,5	19,5				

Figure 53: Measurements sheet of Zola Times buyer.

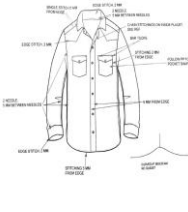
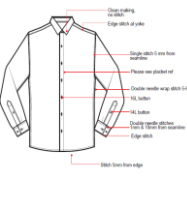
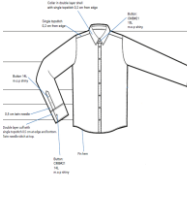
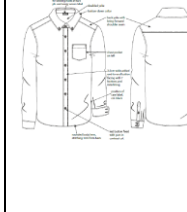
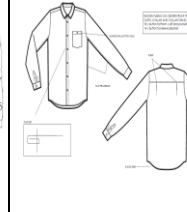

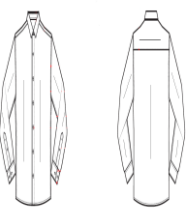

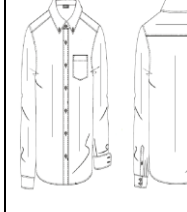







3.2.2 Table-2 Comparison among 5 Woven Shirt buyers

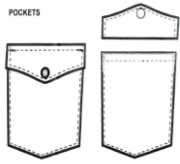
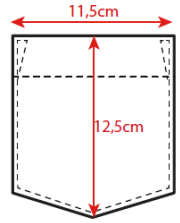
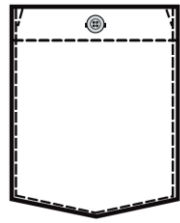





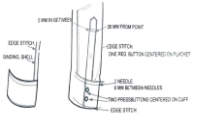
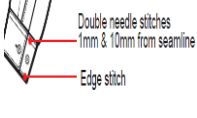
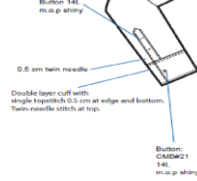
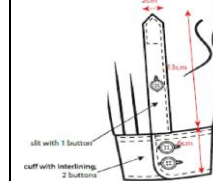
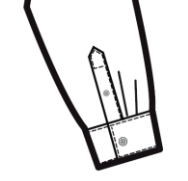

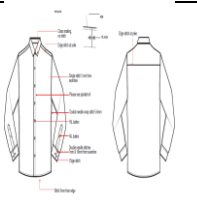
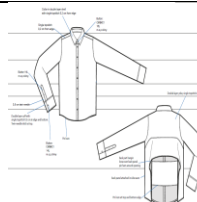
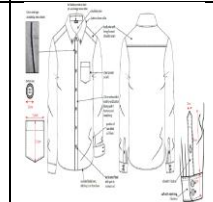

Buyer →	H&M	MINA	Wik	LiDL	ZOLA Times
Logo					
Origin of the Buyer	Stockholm, Sweden	Europe	Europe	Neckarsulm, Germany	USA
Biggest Market	Europe	Europe	Europe	Europe, United States	USA
Product division	Apparel	Apparel	Apparel	Apparel	Apparel
Registered brand	JAYDEN	MINA	Liveryg	Liveryg	ZOLA
Photo sample					
Product user division	Male	Male	Male	Male	Male
Product category	Tops	Tops	Tops	Tops	Tops
Style	Western	Basic	Basic	Western	Basic
Product Group	Plain Shirt	Plain Shirt	Plain Shirt	Plain Shirt	Plain Shirt
Yarn density	40/2×40/2/64×56	N/A	N/A	N/A	N/A






Fabric width	56"	45"	55"	55"	55"
Fabric color	Brown Light, Green, black & white (check fabric)	Print (multi-color)	Navy, Beige, White, Chambray	Navy Blazer, Plaza Taupe, Bright White, Dark Slate, Pantone	White, Black
Dimensional stability to household laundering/ dry clean	Length: $\pm 4\%$, Width: $\pm 4\%$, Twisting: 4% (H&M lab standard)	N/A	N/A	N/A	N/A
Color fastness to household washing / dry clean	Color staining: 3/4, Change in color: 4, Cross staining: 4/5 (H&M lab standard)	N/A	N/A	N/A	N/A
Color fastness to rubbing (ISO105-x12)	Dry rubbing before wash: 4, After wash: 4	N/A	N/A	N/A	N/A
Color fastness to perspiration (ISO)	Color staining: 4, Change in color: 4,	N/A	N/A	N/A	N/A

105-E04)	Cross staining: 4/5				
Color fastness to saliva (GB/T 18886)	Color staining: 4, Change in color: 4, Cross staining: (no result)	N/A	N/A	N/A	N/A
Color fastness to water (ISO 105-E01)	Color staining: 4, Change in color: 4, Cross staining: 4/5	N/A	N/A	N/A	N/A
Flammability (16 CFR 1610)	7 Sec (Class1)	7 Sec (Class1)	8 Sec (Class1)	7 Sec (Class1)	7 Sec (Class1)
Stretch and Recovery (ASTM D3107)	Stretch under loading after 30 min: N/A%, Growth after static extension & 30 min recovery: N/A%, Recovery after static extension & 30 min recovery: N/A%	N/A	N/A	N/A	N/A
Pile loss (ISO	N/A	N/A	N/A	N/A	N/A

12947-2)					
Seam slippage (ISO 13936-2)	<6 mm	<5mm	<5mm	<7mm	<6mm
Tear Strength (EN ISO 13937-2)	10 N	9 N	12 N	9.5 N	11 N
Color fastness to Ozone (AATC C 109, 2 cycle)	Change in color: N/A	Change in color: 1	Change in color: 1	Change in color: N/A	Change in color: N/A
Color fastness to artificial light (ISO 105-B02)	Change in color: 3	Change in color: 4	Change in color: 3	Change in color: 3	Change in color: 3
Pilling resistance woven (ISO 12945-2)	2000 revolution: N/A	2000 revolution: N/A	2000 revolution: N/A	2000 revolution: N/A	2000 revolution: N/A

Appearance after wash	No major change after 5 washing & drying cycles	No major change after 5 washing & drying cycles	No major change after 5 washing & drying cycles	No major change after 5 washing & drying cycles	No major change after 5 washing & drying cycles
Thread layout					
Fabric direction					
Buttons	Snap Button, poly button	poly button	poly button	poly button	poly button
Button color	White , White (transparent)	White (transparent)	White (transparent)	Brown (transparent)	White (transparent)
Button size	18L	14L, 16L	14L, 16L	1.2cm/ 20L	14L, 18L
Button photo sample	 18L  18L COLLAR				
Spere buttons	1	1	1	1	1

Pocket		N/A	N/A		
Fake pockets	N/A	N/A	N/A	N/A	N/A
Chest Artwork					
Sewing thread	100% polyester	100% polyester	100% polyester	100% polyester	100% polyester
Sewing thread count	20/2	20/2	20/2	20/2	20/2
SPI	11	11	11	10	11
Stitch	Plain	Plain	Plain	Plain	Plain
Sleeve placket					
Artwork					
Care instructions	Wet wash, dry wash, ironing	Wet wash, dry wash, ironing	Wet wash, ironing	Wet wash, dry wash, ironing	Wet wash, dry wash, ironing

Trims / Accessories fabric	100% polyester	100% polyester	100% polyester	100% polyester	100% polyester
Trims / Accessories color	White	White	White	White, black	White
Final product					
Measurements/ sizes	XS, S, M, L, XL, XXL	XS, S, M, L, XL, XXL	M, L, XL, XXL	M, L, XL, XXL	S, M, L, XL, XXL
UOM	cm	cm	cm	cm	cm
Full Chest	XS: 97.00 S: 105.00 M: 113.00 L: 121.00 XL: 129.00 XXL: 137.00	XS: 95.00 S: 100.00 M: 107.00 L: 112.00 XL: 120.00 XXL: 135.00	M: 116.00 L: 124.00 XL: 132.00 XXL: 138.00	M: 116.00 L: 124.00 XL: 132.00 XXL: 138.00	S: 108.00 M: 116.00 L: 124.00 XL: 132.00 XXL: 138.00
Chest Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Length to Waist	XS: 47.25 S: 48.25 M: 49.25	XS: 47.25 S: 48.15 M: 49.50	M: 56.00 L: 60.00 XL: 62.00	M: 57.00 L: 61.00 XL: 63.00	S: 53.50 M: 56.50 L: 60.50

	L: 50.25 XL: 51.25 XXL: 52.25	L: 50.25 XL: 51.15 XXL: 52.50	XXL: 65.00	XXL: 66.00	XL: 62.50 XXL: 65.50
Length to Waist Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Waist	XS: 91.00 S: 99.00 M: 107.00 L: 115.00 XL: 123.00 XXL: 131.00	XS: 90.00 S: 99.00 M: 106.00 L: 122.00 XL: 123.00 XXL: 130.00	M: 112.00 L: 120.00 XL: 128.00 XXL: 138.00	M: 114.00 L: 124.00 XL: 129.00 XXL: 139.00	S: 104.00 M: 114.00 L: 124.00 XL: 129.00 XXL: 139.00
Waist Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Bottom	XS: 92.00 S: 100.00 M: 108.00 L: 116.00 XL: 124.00 XXL: 132.00	XS: 90.00 S: 98.00 M: 106.00 L: 115.00 XL: 122.00 XXL: 131.00	M: 89.50 L: 91.00 XL: 92.50 XXL: 94.00	M: 89.50 L: 91.00 XL: 92.50 XXL: 94.00	S: 78.00 M: 89.50 L: 91.00 XL: 92.50 XXL: 94.00
Bottom Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Sleeve length	XS: 64.00 S: 65.25	XS: 62.15 S: 64.30	M: 67.50 L: 68.50	M: 67.50 L: 68.50	S: 66.50 M: 67.50

	M: 66.50 L: 67.75 XL: 69.00 XXL: 70.25	M: 66.15 L: 68.50 XL: 69.25 XXL: 70.75	XL: 69.50 XXL: 70.50	XL: 69.50 XXL: 70.50	L: 68.50 XL: 69.50 XXL: 70.50
Sleeve length Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Biceps	XS: 38.00 S: 40.50 M: 43.00 L: 45.50 XL: 48.00 XXL: 50.50	XS: 37.00 S: 39.00 M: 42.00 L: 44.00 XL: 47.00 XXL: 50.00	M: 46.00 L: 47.00 XL: 48.00 XXL: 49.00	M: 46.00 L: 47.00 XL: 48.00 XXL: 49.00	S: 45.00 M: 46.00 L: 47.00 XL: 48.00 XXL: 49.00
Biceps Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Bottom Sleeve when buttoned	XS: 21.00 S: 22.00 M: 23.00 L: 24.00 XL: 25.00 XXL: 26.00	XS: 20.00 S: 21.00 M: 23.00 L: 24.00 XL: 25.00 XXL: 26.00	M: 24.00 L: 24.00 XL: 25.00 XXL: 26.00	M: 24.00 L: 24.00 XL: 25.00 XXL: 26.00	S: 22.00 M: 24.00 L: 24.00 XL: 25.00 XXL: 26.00
Bottom Sleeve when buttoned	± 0.00	± 0.00	± 0.50	± 0.50	± 0.50

Allowance					
Scye depth	XS: 25.00 S: 26.00 M: 27.00 L: 28.00 XL: 29.00 XXL: 30.00	XS: 24.00 S: 25.00 M: 25.00 L: 26.00 XL: 28.00 XXL: 29.00	M: N/A L: N/A XL: N/A XXL: N/A	M: N/A L: N/A XL: N/A XXL: N/A	S: N/A M: N/A L: N/A XL: N/A XXL: N/A
Scye depth Allowance	± 0.00	± 0.00	N/A	N/A	N/A
Back length	XS: 73.00 S: 74.50 M: 76.00 L: 77.50 XL: 79.00 XXL: 80.50	XS: 72.00 S: 72.00 M: 75.00 L: 76.00 XL: 78.00 XXL: 80.00	M: 80.00 L: 81.00 XL: 82.00 XXL: 83.00	M: 80.00 L: 81.00 XL: 82.00 XXL: 83.00	S: 79.00 M: 80.00 L: 81.00 XL: 82.00 XXL: 83.00
Back length Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Back width at Yoke Seam	XS: 41.25 S: 43.25 M: 45.25 L: 47.25 XL: 49.25	XS: 41.25 S: 42.50 M: 44.25 L: 45.50 XL: 47.15	M: 45.00 L: 47.00 XL: 49.00 XXL: 51.00	M: 45.00 L: 47.00 XL: 49.00 XXL: 51.00	S: 40.00 M: 42.00 L: 44.00 XL: 46.00 XXL: 48.00

	XXL: 51.25	XXL: 50.15			
Back width at Yoke Seam Allowance	± 0.00	± 0.00	± 1.00	± 1.00	± 1.00
Shoulder Seam	XS: 15.15 S: 15.70 M: 16.25 L: 16.80 XL: 17.35 XXL: 19.90	XS: 15.15 S: 15.75 M: 16.15 L: 16.50 XL: 16.75 XXL: 17.15	M: 15.25 L: 16.00 XL: 16.25 XXL: 16.75	M: 16.50 L: 17.20 XL: 17.90 XXL: 18.60	S: 45.80 M: 16.50 L: 17.20 XL: 17.90 XXL: 18.60
Shoulder Seam Allowance	± 0.00	± 0.00	± 0.50	± 0.50	± 0.50
Collar length when buttoned	XS: 38.50 S: 40.50 M: 42.50 L: 44.50 XL: 46.50 XXL: 48.50	XS: 37.00 S: 38.00 M: 40.50 L: 43.50 XL: 45.50 XXL: 47.50	M: 40.50 L: 42.50 XL: 44.50 XXL: 46.50	M: 42.00 L: 44.00 XL: 46.00 XXL: 48.00	S: 35.50 M: 40.50 L: 42.50 XL: 44.50 XXL: 46.50
Collar length when buttoned Allowance	± 0.00	± 0.00	± 0.50	± 0.50	± 0.50

Collar stand height at cb	XS: 3.00 S: 3.00 M: 3.00 L: 3.00 XL: 3.00 XXL: 3.00	XS: 2.50 S: 2.50 M: 2.50 L: 2.50 XL: 2.50 XXL: 2.50	M: 3.10 L: 3.10 XL: 3.10 XXL: 3.10	M: 3.00 L: 3.00 XL: 3.00 XXL: 3.00	S: 3.10 M: 3.10 L: 3.10 XL: 3.10 XXL: 3.10
Collar stand height at cb Allowance	± 0.00	± 0.00	± 0.30	± 0.30	± 0.30
Collar height at cb	XS: 4.50 S: 4.50 M: 4.50 L: 4.50 XL: 4.50 XXL: 4.50	XS: 4.25 S: 4.25 M: 4.25 L: 4.25 XL: 4.25 XXL: 4.25	M: 4.60 L: 4.60 XL: 4.60 XXL: 4.60	M: 4.50 L: 4.50 XL: 4.50 XXL: 4.50	S: 4.60 M: 4.60 L: 4.60 XL: 4.60 XXL: 4.60
Collar height at cb Allowance	± 0.00	± 0.00	± 0.30	± 0.30	± 0.30
Collar point	XS: 5.50 S: 5.50 M: 5.50 L: 5.50 XL: 5.50	XS: 5.25 S: 5.25 M: 5.25 L: 5.25 XL: 5.25	M: 6.00 L: 6.00 XL: 6.00 XXL: 6.00	M: 5.50 L: 5.50 XL: 5.50 XXL: 5.50	S: 6.00 M: 6.00 L: 6.00 XL: 6.00 XXL: 6.00

	XXL: 5.50	XXL: 5.25			
Collar point Allowance	± 0.00	± 0.00	± 0.30	± 0.30	± 0.30
Pocket Placement	XS: 21.50 S: 22.00 M: 22.50 L: 23.00 XL: 23.50 XXL: 24.00	XS: N/A S: N/A M: N/A L: N/A XL: N/A XXL: N/A	M: N/A L: N/A XL: N/A XXL: N/A	M: 22.00 L: 22.50 XL: 23.00 XXL: 23.50	S: 21.50 M: 22.00 L: 23.00 XL: 23.50 XXL: 24.00
Pocket Placement Allowance	± 0.00	N/A	N/A	± 0.30	± 0.30
Pocket Flap width	XS: 11.50 S: 12.00 M: 12.50 L: 13.00 XL: 13.50 XXL: 14.00	XS: N/A S: N/A M: N/A L: N/A XL: N/A XXL: N/A	M: N/A L: N/A XL: N/A XXL: N/A	M: 11.50 L: 11.50 XL: 11.50 XXL: 11.50	S: 10.00 M: 10.00 L: 10.00 XL: 10.00 XXL: 10.00
Pocket Flap width Allowance	± 0.00	N/A	N/A	± 0.00	± 0.00
Pocket height	XS: 13.00	XS: N/A	M: N/A	M: 12.50	S: 11.00


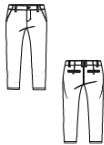
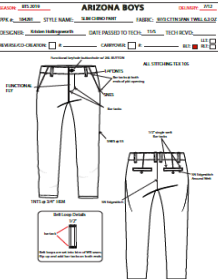
	S: 13.50 M: 14.00 L: 14.50 XL: 15.00 XXL: 15.50	S: N/A M: N/A L: N/A XL: N/A XXL: N/A	L: N/A XL: N/A XXL: N/A	L: 12.50 XL: 12.50 XXL: 12.50	M: 11.00 L: 11.00 XL: 11.00 XXL: 11.00
Pocket height Allowance	± 0.00	N/A	N/A	± 0.00	± 0.00
Fabric	100% Cotton	100% Cotton	55% Linen, 45% Cotton	100% Cotton	100% Cotton
Fabric sustainable material	Better cotton	Cotton	Linen, Better cotton	Cotton	Cotton
Weave	2/2 Z twill	Plain weave	Plain weave	Plain weave	Plain weave
Fabric price	USD 2.05/yard	USD 2.50/yard	N/A	USD 2.85/yard	N/A
Packaging	Poly bag	Poly bag	Poly bag	Poly bag	Poly bag
Fabric weight (g/m ²)	140±5%	150±5%	150	150±5%	150
Dyes / Print type	Reactive	Pigment	Reactive	Reactive	Reactive
Fabric finishing	Brush	Soft	Garment Washed	Brush	Garment Washed
Unit Price	\$5.80	\$4.90	\$5.90	\$6.00	\$6.00

Delivery Method	FOB (by sea)	FOB (by sea)	FOB (by sea)	FOB (by sea)	FOB (by sea)
Payment Method	L/C	L/C	L/C	L/C	L/C
Order Quantity	120000 pieces	100000 pieces	150000 pieces	200000 pieces	200000 pieces

3.3 Differences of 5 Woven Pant buyers

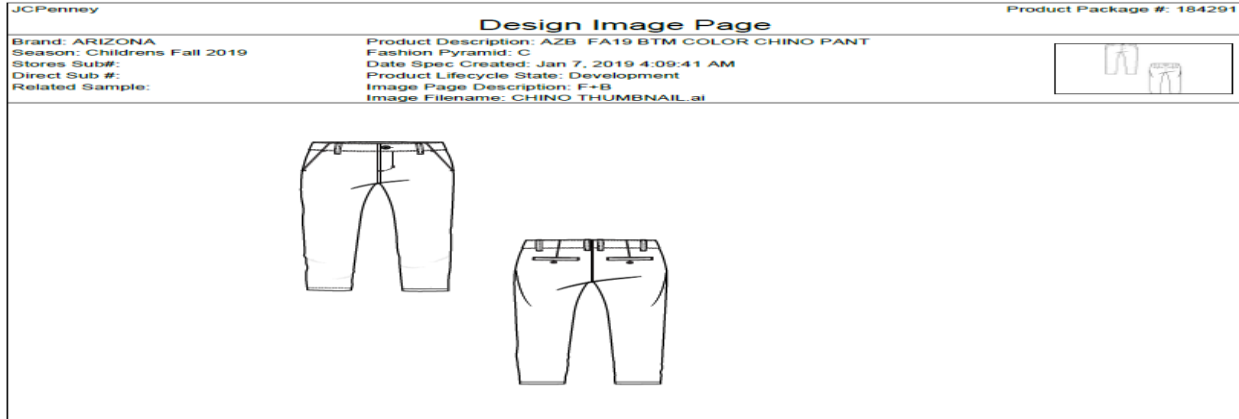
3.3.1 Details of the buyers order & business elements

JCPenney

JCPenney		Product Package #: 184291	
Design (Full) Summary			
Brand: ARIZONA	Product Description: AZB FA19 BTM COLOR CHINO PANT	Product Manager: Jennifer L Riggs	
Season: Childrens Fall 2019	Fashion Pyramid: C	Designer: Kristen L Hollingsworth	
Stores Sub#:	Date Spec Created: Jan 7, 2019 4:09:41 AM	Technical Designer: Mary Gurley	
Direct Sub #:	Product Lifecycle State: Development	Sourcing Manager: Sharyn E Lindblad	
Item #:	Specification: 003 : Primary Spec	Buyer: Aaron Worley	
Estimated Size Range :	Target Stores Units :0	Product Performance Spec # :	
Floor Set Date :	Target Direct Units :0	Block Pattern # :	
Reverse Product Package :No	Final Fit Due :	Test Program :	
			Comments:

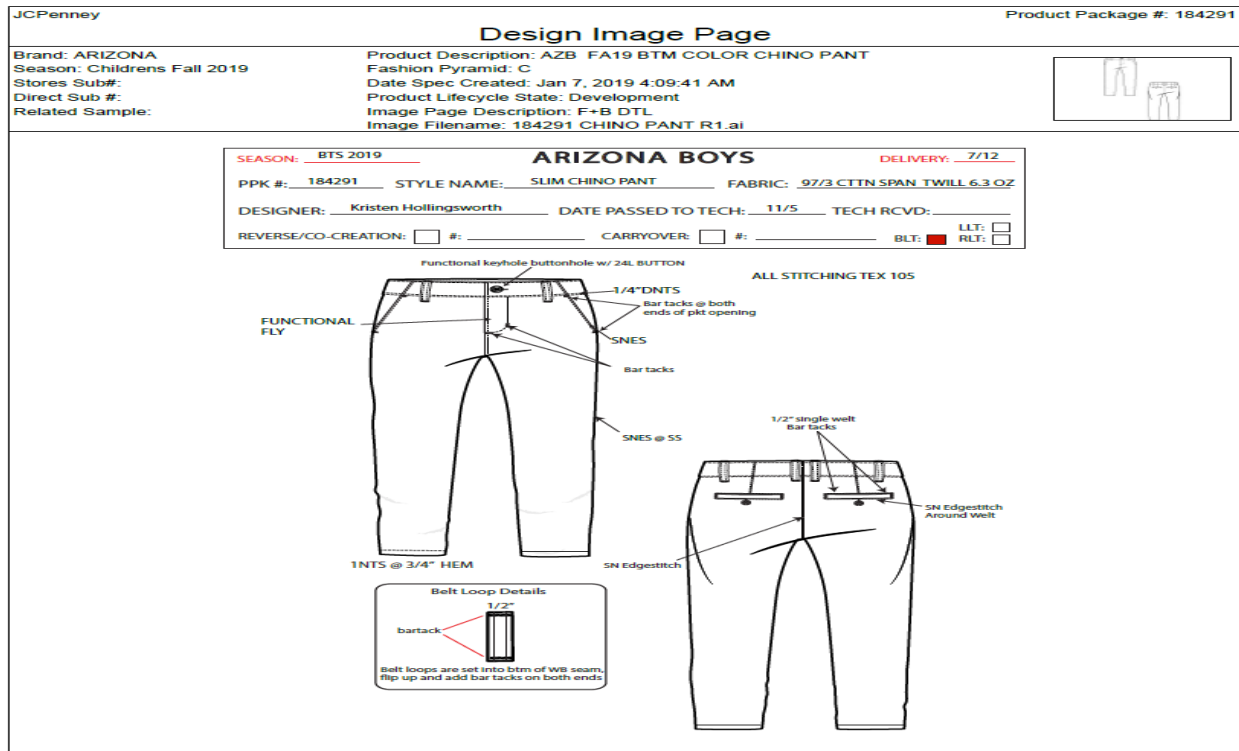
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Date Created: Jan 7, 2019 4:09:41 AM Page 2 of 20

Figure 54: Artwork of JCPenny buyer.



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Figure 55: Artwork of JCPenny buyer.



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Figure 56: Artwork (design) of JCPenny buyer.


JCPenney		Bill of Materials						Product Package #: 184291	
Brand: ARIZONA		Product Description: AZB FA19 BTM COLOR CHINO PANT			Product Manager: Jennifer L Riggs				
Season: Childrens Fall 2019		Fashion Pyramid: C			Designer: Kristen L Hollingsworth				
Stores Sub:		Date Spec Created: Jan 7, 2019 4:09:41 AM			Technical Designer: Mary Gurley				
Direct Sub #:		Product Lifecycle State: Development			Sourcing Manager: Sharyn E Lindblad				
Item #:									
Fabrication									
Primary	Part Name	Material	Description	Supplier	Mill Reference ID	BLACK	SAFARI KHAKI	Placement/Comments	Quantity
	MAIN BODY OPTION- 2	98/2 CTTN SPAN TWILL 7.4 @ 2		NISHAT	NDF-03147/N	BLACK	SAFARI KHAKI	ENZYME GARMENT WASH	
	POCKETIN G	TC POCKETING 80% POLY 20% COTTON		HEBEI TIANMA	TM9672 PLAIN VERSION	natural	natural	POCKETING	
Trim									
Primary	Part Name	Material	Description	Supplier	Mill Reference ID	BLACK	SAFARI KHAKI	Placement/Comments	Quantity
	HOOK AND BAR	(FOR PRESCHOOL 4-7)				ANTI BRASS	ANTI BRASS		
	24L NON LOGO BUTTON	FAUX HORN		OCEANRICH	FHNL1924	MD BROWN	MD BROWN	@ BACK POCKETS	2
	ADJUSTABLE ELASTIC 3/4"			FACTORY SOURCED		DTM MAIN BODY	DTM MAIN BODY	INSIDE WAISTBAND	
	24L CLEAR BUTTONS	CLEAR PLASTIC BUTTON		OCEANRICH	CP4H1924	CLEAR	CLEAR	INSIDE WAISTBAND	2
	THREAD-BUTTON HOLE @ ADJ.WAIST			COATS		DTM BODY	DTM BODY		
	POLY ZIPPER TAPE	100% POLYESTER		EURO-A-ZIPPERS		DTM	DTM	FLY	
	ZIPPER	4.5 SEMI AUTO LOCK ANTIQUE BRASS		EURO-A-ZIPPERS		DTM BODY	DTM BODY	FLY	1
	INTERLINING	NON WOVEN FUSIBLE		CHARGEURS/HEBEI TIANMA	7725/7746	CHARCOAL	WHITE		
	THREAD-MAIN BODY	TEX 105		COATS		DTM	DTM	8 SPI	
	28L NON LOGO BUTTON	FAUX HORN		OCEANRICH	FHNL1928	MD BROWN	MD BROWN	CF CLOSURE	1
	THREAD-BUTTON SEW			COATS		C8979	C8979		
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Figure 57: Item details of JCPenny buyer.


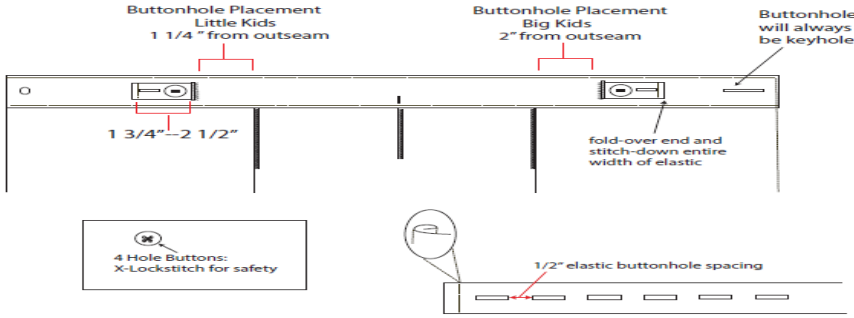
JCPenney		Construction Image Page				Product Package #: 184291	
Brand: ARIZONA		Product Description: AZB FA19 BTM COLOR CHINO PANT					
Season: Childrens Fall 2019		Fashion Pyramid: C					
Stores Sub#:		Date Spec Created: Jan 7, 2019 4:09:42 AM					
Direct Sub #:		Product Lifecycle State: Development					
Related Sample:		Image Page Description: Inside Adjustable Waistband Elastic Image Filename: Inside waist elastic.ai					
<h3>Big and Little Boys Inside Waistband Elastic</h3> <p>(Revised 7-29-13)</p> <p>Use 3/4" buttonhole elastic - insert into waistband thru buttonhole for all waist sizes. Waistband should have a smooth flat appearance from face side of garment.</p> <p>Inside Waistband buttonhole placement: 2" from outseam for School age 1 1/4" from outseam for Preschool</p> <p>24L 4-hole Buttons; set 1/2" over from button-hole (must be set with "X" lockstitch for safety)</p> <p>Elastic is stitched down to waistband thru both layers 1 3/4" to 2 1/2" over from button hole; must be stitched entire width of elastic; Should not show on outside of garment.</p>							
 <p>Buttonhole Placement Little Kids: 1 1/4" from outseam</p> <p>Buttonhole Placement Big Kids: 2" from outseam</p> <p>Buttonhole will always be keyhole</p> <p>1 3/4" - 2 1/2"</p> <p>fold-over end and stitch-down entire width of elastic</p> <p>4 Hole Buttons: X-Lockstitch for safety</p> <p>1/2" elastic buttonhole spacing</p>							
<p>Comments :</p> <p>Contents within this document are CONFIDENTIAL AND PROPRIETARY TO JCPENNEY CORPORATION, JCPENNEY PURCHASING CORPORATION AND ANY AFFILIATES (TOGETHER "JCPENNEY")</p> <p>Date Created: Jan 7, 2019 4:09:43 AM Page 10 of 20</p>							

Figure 58: Waistband details of JCPenny buyer.


JCPenney	Measurement WorkSheet - Incremental											Product Package #: 184291	
Brand: ARIZONA Season: Childrens Fall 2019 Stores Sub#: Direct Sub #: Specification: 003 - Primary Spec			Product Description: AZB FA19 BTM COLOR CHINO PANT Fashion Pyramid: C Date Spec Created: Jan 7, 2019 4:09:43 AM Product Lifecycle State: Development Item #:										
Sample Size: 12H Measurement Set Name: 004 : 184291 - HUSKY - FA19 - Chino Pant Hollywood Waist Grading Template Name: 3303 Husky Big Boys 6H-20H Grading Method: Incremental UOM: Fractional Inch			Block Pattern#: Minimum Construction Standard: Children's Minimum Construction Specification How To Measure Manual: http://webnet.jcpenny.com/SUPPLIER/Prod_Dev_Mdse_Test/default.asp?appID=SPN_PRODQA Status:										
POM#	POM Description	HTM Comments	Tol(+)	Tol(-)	6H	7H	8H	10H	12H	14H	16H	18H	20H
356	Waistband Width Built Up (Btm) (Opt Grade)		1/8	1/8	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2
210.7	Waist @ Top Edge (Bottom)		1/2	1/2	24 1/2	25 1/2	26 1/2	27 1/2	29	30	31	32 1/2	34
212.1	Hip/Seat frm Crotch Seam	3" up from crotch seam	1/2	1/2	30 1/2	31 1/2	32 1/2	34	35 1/2	36 1/2	38	39 1/2	41
223.2	Thigh 1" Below Crotch		3/8	3/8	19 1/4	19 3/4	20 1/4	21 1/8	22	22 5/8	23 1/2	24 3/8	25 1/4
540	Knee Position frm Crotch		1/8	1/8	11	11	11	11	11	11	11	11	11
224	Knee		3/8	3/8	12	12 1/2	13	13 3/4	14 1/2	15	15 5/8	16 1/4	16 7/8
225.6	Leg Opening (Long) Rel		3/8	3/8	10 1/2	11	11 1/2	12 1/4	13	13 1/2	14 1/8	14 3/4	15 3/8
127.8	Inseam (Long)		1/2	1/2	20	22	23 1/2	25	26 1/2	28	29 1/4	29 3/4	30 1/4
128	Front Rise frm Top Edge		1/4	1/4	7 7/8	8 1/4	8 5/8	9 1/8	9 5/8	10	10 3/8	10 3/4	11
129	Back Rise frm Top Edge		1/4	1/4	11 5/8	12	12 3/8	12 7/8	13 3/8	13 3/4	14 1/8	14 1/2	14 3/4
197.3	Fly Stitch Lgth frm Top Edge		1/4	1/4	5 1/4	5 3/4	5 3/4	6 1/4	6 1/4	6 3/4	6 3/4	7 1/4	7 3/4
324	Fly Stitch Width to Outer Stitch		1/8	1/8	1 3/8	1 3/8	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2
POCKETS:													
335	Pocket-FRONT Opening-Top Edge to Outseam	at waistband seam	1/4	1/4	2	2	2	2 1/4	2 1/4	2 1/2	2 1/2	2 1/2	2 3/4
334	Pocket-FRONT Opening-Btm Edge of WB	from bottom of band	1/4	1/4	5 1/2	5 1/2	5 1/2	5 3/4	5 3/4	6	6	6	6 1/4
578	Back Pocket Position frm Top of Waist		1/8	1/8	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2
583.9	Pocket Pos frm CB Seam	centered on back leg panel	1/8	1/8	4 5/8	4 5/8	4 5/8	4 5/8	4 5/8	4 5/8	4 5/8	4 5/8	4 5/8
336	Pocket-BACK-Single Welt Length		1/4	1/4	- 1/2	- 1/4	- 1/4	0		1/4	1/4	1/4	1/2
Contents within this document are CONFIDENTIAL AND PROPRIETARY TO JCPENNEY CORPORATION, JCPENNEY PURCHASING CORPORATION AND ANY AFFILIATES (TOGETHER "JCPENNEY")													
Date Created: Jan 7, 2019 4:09:44 AM											Page 19 of 20		

Figure 59: Measurements sheet of JCPenny buyer.

GAP


Old Navy		Cover Page		
	Master Style: 439068: RELAXED SLIM FIT FASHION Product Description: RELAXED SLIM ETHAN BROWN CAST Product Status: Adopted BOM #: 000370634 Sourcing Office: India Vendor: ARMANA APPARELS LTD (1037305) Factory:	Line Plan: ON Mens Denim SU19 Product Team: ON Mens Denim Product Type: Pant Tech Designer: Beas, Flavio Merch Number(s): 205729 (Global, Regular);	Flow: C/O Area: FASHION Theme: Designer: Chu, Iris Vendor Collaboration:	
Tech Pack Summary				
Tech Pack Comment				
Sections Included				
Section Name	Section Description	Status	Modified Date	
BOM		Adopted	Oct 22, 2018 2:27 PM PDT	
Measurement Chart	Regular;	Final	Nov 20, 2018 5:35 PM PST	
Sample Measurements Full	Regular;	Final	Nov 20, 2018 5:35 PM PST	
Sample Measurements Summary	Regular;	Final	Nov 20, 2018 5:35 PM PST	
Sketches			Feb 13, 2018 2:47 PM PST	
Native Files Included				
Type	Description	File Name	File Size	Modified Date
Patterns	FA18 RELAXED SLIM FASHION DENIM ARMANA BLOCK	FA18 RELAXED SLIM FASHION DENIM ARMANA BLOCK.zip	14.98 kB	Nov 20, 2018 6:33 PM PST

Figure 60: Pattern info of GAP buyer.


Old Navy										Bill of Materials	
		Master Style: 439068; RELAXED SLIM FIT FASHION Product Description: RELAXED SLIM ETHAN BROWN CAST		Line Plan: ON Mens Denim SU19 Product Team: ON Mens Denim		Flow: C/O Area: FASHION					
Product Status: Adopted Category: DENIM & BOTTOMS BOM # 000370634		Sourcing Office: India Vendor: ARMANA APPARELS LTD (1037305)		Product Type: Pant Sub-Category: DENIM BOTTOM Tech Designer: Beas, Flavio		Theme: Item Type: LONG BOTTOMS Designer: Chu, Iffs					
Sourcing Office: India Vendor: ARMANA APPARELS LTD (1037305)		Merch Number(s): 205729 (Global, Regular);		Vendor Collaboration:							
Factory:		Packaging Instr: DENIM-HALF FOLD		BOM Last Mod: Oct 22, 2018 2:27 PM PDT							
Comments:											
										(SET A: CC1.1 of 1)	
Image	Type/Desc/RD#	Quality Details	Supplier / Supplier Article	Gauge/Tension/ Stitch/Ends	Size	UOM	Qty	Usage		CC1 TINTED MEDIUM	
Fabric											
	Denim 210918 Stretch Denim: Ethan Brown-Cast Indigo	89% Cotton, 1% Elastane / 57.0 in / 12.25 oz/sq yd / 69x50 / 7.2x7 NE x 10x70D NE / TBD	54419 ARVIND DENIM			yd	0.0	MAIN BODY		TINTED MEDIUM	
Trim											
	Thread Trim 37371 Spun Polyester Thread: Vendor Sourced	Spun Polyester / tex / Matte	Vendor Sourced TBD		105 tex	TBD	0.0	THREAD A: SEE THREAD GUIDE		C8600	
	Thread Trim 37371 Spun Polyester Thread: Vendor Sourced	Spun Polyester / tex / Matte	Vendor Sourced TBD		105 tex	TBD	0.0	THREAD B: SEE THREAD GUIDE		C8628	
	Thread Trim 37371 Spun Polyester Thread: Vendor Sourced	Spun Polyester / tex / Matte	Vendor Sourced TBD		105 tex	TBD	0.0	THREAD C: SEE THREAD GUIDE		C9199	
	Metal Shank 236772 OLD NAVY LOGO METAL_SHANK (GG893BT) SAME ARTWORK AS RD 236772	/	GLORY METAL, YKK		27 lgne	TBD	1.0	CF WAIST		ECO ANTI COPPER GY2013C	
	Burr Rivet 236770 UNDER PART FOR SHANK (RVT-108BT)	///	Glory Metal Products Mfg Ltd RVT-108BT		9.5mm	TBD	1.0			ECO ANTI COPPER GY2025C	
	Burr Rivet 236773 ON WASHER RIVET (GG893AR)	///	Glory Metal Products Mfg Ltd GG893AR		9.5mm	TBD	6.0	AT FRONT POCKET OPENINGS		ECO ANTI COPPER GY2013C	
Generated Date/Time: Nov 20, 2018 5:35:37 PM PST										Company Confidential, Gap Inc. Page 2 of 21	

Figure 61: Trim/Accessories details of GAP buyer.

Old Navy										Bill of Materials	
Master Style: 439068; RELAXED SLIM FIT FASHION Product Description: RELAXED SLIM ETHAN BROWN CAST		Sourcing Office: India Vendor: ARMANA APPARELS LTD (1037305)									
										(SET A: CC1.1 of 1)	
Image	Type/Desc/RD#	Quality Details	Supplier / Supplier Article	Gauge/Tension/ Stitch/Ends	Size	UOM	Qty	Usage		CC1 TINTED MEDIUM	
Trim											
	Burr Rivet 236771 UNDER PART FOR WASHER (RLB-150)	///	Glory Metal Products Mfg Ltd RLB-150		9.5mm	TBD	6.0			ECO ANTI COPPER GY2025C	
	Zipper 177731 SIZE 6_Metal Zipper Teeth_Semi-Auto Lock_Angular Puller with ON Logo	Metal / Metal / Semi-Lock / Closed End /	Euro A Zipper Co. Ltd. GSN6 ON18			TBD	1.0	FLY		ANT BRASS	
	Zipper 178384 SGG ZIPPER TEETH METAL	////	Euro A Zipper Co. Ltd. GSN6ON18			TBD	1.0	FLY		ANT BRASS	
	Tape 36583 Zipper Tape	//	YKK Snap Fasteners TBD			TBD	1.0	FLY		560 NAVY	
	Pocketing 192720 ON_Pocketing_BETTER_TWILL_6SP_35C	85% Polyester, 35% Cotton / 58.0 in / 4.0 oz/sq yd / 72x56 / 23 x 23 / TBD				yd	0.0	POCKET BAGS		NATURAL	
Finish / Wash											
	Finishing 02218495						0.0				
Packaging / Labels											
	Main Label 234696 Adult_Bottoms_RELAXED_SLIM_Built in Flex_Heat Transfer (Global/ Canada)	///	SHELL RD 234644			TBD	0.0			COOL GRAY 1C OR SC - DEPEND ING ON WASH	
	Sensor Tag 43841 OLD NAVY CHECK POINT HARD TAG - US/CA/CHINA STORES ONLY	/	7311288			TBD	0.0				
	Traceability Label/Joker Tag 149232 Core_Traceability Label_Coated Tape (Global)	///	Shell RD 153222			TBD	0.0				
	Price Ticket 117647 ONPT_HRD1_Universal_Alpha/Dual Alpha/Immer/Dual Numeric_Generic_Price Ticket (US/ USOL/CA/CAOL/HK/CIT/DF)	/	Shell RD 154621			TBD	0.0				
Generated Date/Time: Nov 20, 2018 5:35:37 PM PST										Company Confidential, Gap Inc. Page 3 of 21	

Figure 62: Trim/Accessories & Packaging details of GAP buyer.

Old Navy		Bill of Materials	
Master Style:	439068; RELAXED SLIM FIT FASHION	Sourcing Office:	India
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Vendor:	ARMANA APPARELS LTD (1037305)

Image	Type/Desc/RD#	Quality Details	Supplier / Supplier Article	Gauge/Tension/ Stitch/Ends	Size	UOM	Qty	Usage	(SET A: CC1-1 of 1)
Packaging / Labels									
	Hang Tag 233145	/	SHELL RD 233009			TBD	0.0		CC1 PRINTED MEDIUM
	Men_Built-In-Flex_Technology Hangtag (Global/Canada/China)	///	Shell RD# 191461			TBD	0.0		
	Case/Content Label 191462								
	ON_Universal_Hard Wash_C&C Label (for garments that get heavy washes) (Global)								
	Matchbook 232513	/	SHELL RD 232434			TBD	0.0		
	Men/ Women_Bottoms_RELAXEDSLIM_BUILT- IN FLEX_Matchbook (Global/Canada)								
	Size Sticker 242994	/	SHELL RD 222445			TBD	0.0		
	Men_Brand_Bottoms_Relaxed Slim_BUILT-IN FLEX_Size Strip (Canada)								
	Size Sticker 242990	/	SHELL RD 222273			TBD	0.0		
	Men_Brand_Bottoms_Relaxed Slim_BUILT-IN FLEX_Size Strip (Global Except Canada)								



Figure 63: Packaging & Labels details of GAP buyer.

	Old Navy					Measurement Chart - Regular;				
	Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O				
	Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION				
	BOM #:	000370634	Product Type:	Pant	Theme:	Designer: Chu, Iris				
	Sourcing Office:	India	Tech Designer:	Beas, Flavio	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:			
	Vendor:	ARMANA APPARELS LTD (1037305)	Grade Rule:	Old Navy Mens Woven Bottoms Numeric (Half) Woven; 26 - 50; Base (32)	Block:		MC Last Mod:	Nov 20, 2018 5:35 PM PST		
Factory:		Comments:	* New Half Spec/Grade Su18 Forward - added 28 and 38 Inseam - Updated Low Hip Placement Su19 Forward	MC Status:	Final	UOM:	Inches			

POM	Description	Add'l Comments	Variation	QC	Tol(-)	Tol(+)	Set B									
							36	38	40	42	44	46	48	50		
1186	Straight Waistband			Y	1/4	1/4	19 1/4	20 1/4	21 1/4	22 1/4	23 1/4	24 1/4	25 1/4	26 1/4		
1185	Waistband Height				0	0	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8		
1358	Front Rise to Waist Seam	Front Rise to Waist Seam; Front Rise to Waist Seam/stitch		Y	1/4	1/4	10 1/2	11 1/4	12	12 3/4	13 1/2	14 1/4	15	15 3/4		
1359	Back Rise to Waist Seam	Back Rise to Waist Seam; Back Rise to Waist Seam/stitch		Y	1/4	1/4	15 1/4	16	16 3/4	17 1/2	18 1/4	19	19 3/4	20 1/2		
1367	J-Stitch Length to Bottom of Waistband				1/8	1/8	6 1/2	6 1/2	6 1/2	7	7	7	7 1/2	7 1/2		
1369	J-Stitch Width				999	999	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4		
1206	Low Hip Position from_	Updated Low Hip Placement Su19 Forward	Waist Seam		999	999	5 1/2	6	6 1/2	7	7 1/2	8	8 1/2	9		
1215	Low Hip 3-Point Measurement	Updated Low Hip Spec Su19 Forward		Y	1/4	1/4	22 1/2	23 1/2	24 1/2	25 1/2	26 1/2	27 1/2	28 1/2	29 1/2		
1378	Thigh		2" from Rise Seam	Y	1/4	1/4	12 3/4	13 1/4	13 3/4	14 1/4	14 3/4	15 1/4	15 3/4	16 1/4		
1380	Knee	2" Above Half Inseam			1/8	1/8	8 3/4	9 1/8	9 1/2	9 7/8	10 1/4	10 5/8	11	11 3/8		
1258	Bottom Opening Straight		Pant	Y	1/8	1/8	7	7 3/8	7 3/4	8 1/8	8 1/2	8 7/8	9 1/4	9 5/8		
1516	Hem Height				999	999	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8		
1384	Inseam	Inseam 28	Pant	Y	1/2	1/2	27 1/2	27 1/2	27 1/2	27 1/2	27 1/2	27 1/2	27 1/2	27 1/2		
1384	Inseam	Inseam 30	Pant	Y	1/2	1/2	29 1/2	29 1/2	29 1/2	29 1/2	29 1/2	29 1/2	29 1/2	29 1/2		
1384	Inseam	Inseam 32	Pant	Y	1/2	1/2	31 1/2	31 1/2	31 1/2	31 1/2	31 1/2	31 1/2	31 1/2	31 1/2		
1384	Inseam	Inseam 34	Pant	Y	1/2	1/2	33 1/2	33 1/2	33 1/2	33 1/2	33 1/2	33 1/2	33 1/2	33 1/2		
1384	Inseam	Inseam 36	Pant	Y	1/2	1/2	35 1/2	35 1/2	35 1/2	35 1/2	35 1/2	35 1/2	35 1/2	35 1/2		
1384	Inseam	Inseam 38	Pant	Y	1/2	1/2	37 1/2	37 1/2	37 1/2	37 1/2	37 1/2	37 1/2	37 1/2	37 1/2		
1553	Yoke Height at Center		Back from Waist Seam		999	999	2 1/4	2 1/4	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2		
1554	Yoke Height at Side		Back from Waist Seam		999	999	3/4	3/4	1	1	1	1	1	1		

Figure 64: Measurements sheet of GAP buyer.

	Old Navy			Measurement Chart - Regular;			
	Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O	
	Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION	
	Product Status:	Adopted	Product Type:	Pant	Theme:		
	BOM #:	000370634	Tech Designer:	Beas, Flavio	Designer:	Chu, Iris	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:			
Vendor:	ARMANA APPARELS LTD (1037305)						
Factory:							
Grade Rule:	Old Navy Mens Woven Bottoms Numeric (Half) Woven; 26 - 50; Base (32)	Block:		MC Last Mod:	Nov 20, 2018 5:35 PM PST		
Comments:	* New Half Spec/Grade Su18 Forward - added 28 and 38 Inseam - Updated Low Hip Placement Su19 Forward			MC Status:	Final		
				UOM:	Inches		

POM	Description	Add'l Comments	Variation	QC	Tol(-)	Tol(+)	Set B									
							36	38	40	42	44	46	48	50		
1590	Pocket Opening Horizontal Along Waist		Front - Scoop		999	999	5	5	5	5 1/4	5 1/4	5 1/4	5 1/2	5 1/2		
1591	Pocket Opening Vertical Along Sideseam		Front - Scoop		999	999	2 5/8	2 5/8	2 5/8	2 3/4	2 3/4	2 3/4	2 7/8	2 7/8		
1617	Pocket Bag Height				999	999	10 3/4	10 3/4	10 3/4	10 3/4	11	11	11	11		
1618	Pocket Bag Width				999	999	7 1/4	7 1/4	7 1/4	7 1/4	7 1/2	7 1/2	7 1/2	7 1/2		
1592	Coin Pocket Width at Top				999	999	3 3/4	3 3/4	3 7/8	3 7/8	3 7/8	4	4	4		
1593	Coin Pocket Width at Bottom				999	999	3 1/8	3 1/8	3 1/4	3 1/4	3 1/4	3 3/8	3 3/8	3 3/8		
1594	Coin Pocket Height at Center				999	999	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2		
1595	Coin Pocket Height at Side				999	999	3	3	3	3	3	3	3	3		
1597	Coin Pocket Placement Horizontal from Sideseam		Pocket Scoop Edge to Coin Pocket Edge		999	999	5/8	5/8	5/8	5/8	5/8	5/8	5/8	5/8		
1598	Coin Pocket Placement Vertical from Waist Seam				999	999	3/4	3/4	7/8	7/8	7/8	7/8	7/8	7/8		
1565	Pocket Height at Center		Back Pocket - Jean		1/8	1/8	6 3/4	6 3/4	6 3/4	6 3/4	7	7	7	7		
1566	Pocket Height at Side		Back Pocket - Jean		1/8	1/8	5 7/8	5 7/8	5 7/8	5 7/8	6 1/8	6 1/8	6 1/8	6 1/8		
1567	Pocket Width at Top		Back Pocket - Jean		1/8	1/8	6 3/4	6 3/4	6 3/4	6 3/4	7	7	7	7		
1568	Pocket Width at Bottom		Back Pocket - Jean		1/8	1/8	5 1/4	5 1/4	5 1/4	5 1/4	5 1/2	5 1/2	5 1/2	5 1/2		
1670	Back Pocket Placement Horizontal from Center Back		Pant		1/8	1/8	2 1/4	2 1/2	2 3/4	3	3 1/4	3 1/2	3 3/4	4		
1659	Pocket Placement Vertical from Yoke Seam at Center Corner				0	0	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2		
1661	Pocket Placement Vertical from Yoke Seam at Side				0	0	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4	1 3/4		
1521	Cord Stitch Length				999	999	8	8	8	8	8	8	8	8		
1408	Beltloop Length				999	999	2 7/8	2 7/8	2 7/8	2 7/8	2 7/8	2 7/8	2 7/8	2 7/8		
1409	Belt Loop Width				999	999	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2		
1410	Beltloop Placement Horizontal from_		Front Pocket Edge to Beltloop Edge		1/8	1/8	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2		

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Figure 65: Measurements sheet of GAP buyer.

	Old Navy			Measurement Chart - Regular;			
	Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O	
	Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION	
	Product Status:	Adopted	Product Type:	Pant	Theme:		
	BOM #:	000370634	Tech Designer:	Beas, Flavio	Designer:	Chu, Iris	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:			
Vendor:	ARMANA APPARELS LTD (1037305)						
Factory:							
Grade Rule:	Old Navy Mens Woven Bottoms Numeric (Half) Woven; 26 - 50; Base (32)	Block:		MC Last Mod:	Nov 20, 2018 5:35 PM PST		
Comments:	* New Half Spec/Grade Su18 Forward - added 28 and 38 Inseam - Updated Low Hip Placement Su19 Forward			MC Status:	Final		
				UOM:	Inches		

POM	Description	Add'l Comments	Variation	QC	Tol(-)	Tol(+)	Set B										
							36	38	40	42	44	46	48	50			
1410	Beltloop Placement Horizontal from_		Back Side Seam to Beltloop Edge	Sideseam	1/8	1/8	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4		

Figure 66: Measurements sheet of GAP buyer.

Old Navy				Sketches - Front	
Master Style:	439068: RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:	Sketch View Last Mod: Feb 13, 2016 2:47 PM PST				

Use Gap Inc. Construction Standards for Denim bottoms. Details noted below are variations from the standards for this style only.
Follow BOM for all thread colors

2/N folder set WB with chainstitch inside 1/8" margin top and bottom.

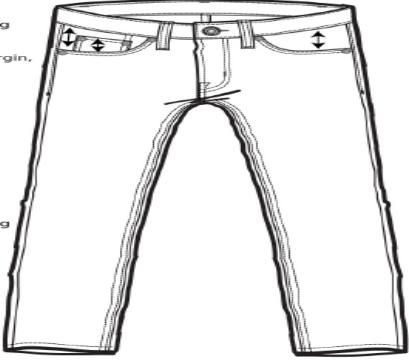
2/N set coin pkt 1/8" margin, 1/4" gg
Dog House Coin Pkt
Front side 2/N extends to WB
S/chainstitch coin pkt hem 3/8" margin, roll hem twice.
Rivet & Burr at each corner

2/N pkt scoop opening 1/8" margin 1/4" gg.
set rivet/burr at ends of pkts
Self roll pocket opening 1/8" to avoid pocketing from being exposed

2/N J stitch 1/4" gg
S/N topstitch CF fly edge 1/4" margin
Zip Fly

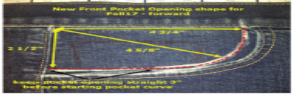
2/N lower rise 1/8" margin, 1/4" gg
Widening to 1/2" at bartack extending 3/4" above end of J Stitch

2nd bartack placed at 1/2" above the first bartack at inside row of J Stitch



Hem - turn and turn
S/N topstitch with chainstitch inside

* Cut Waistband Cross Grain
Add Interlining to waistband with Fabrications in Flex Max and Bi-Stretch (only).
+ Cut Waistband Straight Grain
No Interlining to waistband with fabrication in Ethan/Stretch Fabrications (only).



Fill at deepest part of curve point
this indicates grainline direction

S/N cordstitch back over front. 1/8" margin
1/2" vertical bartack at end

2/N fell inseam front over back, 1/8" margin, 1/4" gg
BUSTED open sideseam

Figure 67: Artwork (front) of GAP buyer.

Old Navy				Sketches - Back	
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:	Sketch View Last Mod: Feb 13, 2016 2:47 PM PST				

Premium Loop Construction - see detail page
 Bartack attach top and bottom of loop
 Side back loop is tacked onto the yoke seam
 See detail page for loop placement
 Size 26 - 36 total 5 loops
 Size 38 - 48 total 7 loops



indicates grainline direction

2/N fell yoke seam 1/8" margin 1/4" gg
 2/N fell back rise 1/8" margin, 1/4" gg
 Bk Pkt construction - see detail sketch

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Figure 68: Artwork (back) of GAP buyer.

Old Navy				Sketches - Product Detail	
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:	Sketch View Last Mod: Feb 13, 2016 2:47 PM PST				



J-STITCH DETAILS



updated 06/06/2017

Generated Date/Time: Nov 20, 2016 5:35:37 PM PST

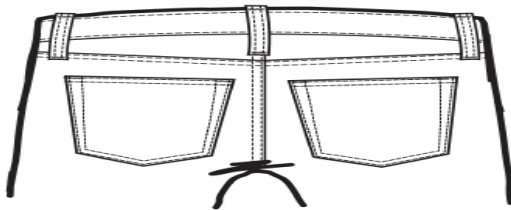
Company Confidential, Gap Inc.

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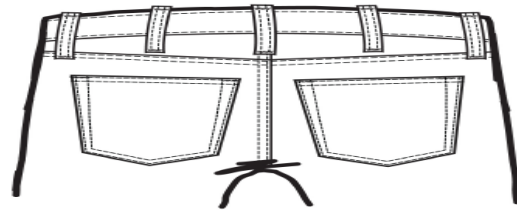
Figure 69: Artwork (j-stitch) of GAP buyer.

Old Navy		Sketches - generic			
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:					Sketch View Last Mod: Feb 13, 2016 2:47 PM PST

Back Loop Placement Sizes 26 - 36



Back Loop Placement Sizes 38 - 48
Add 2 Extra Loops Centered Between CB and Side Loops



Sketch is for Loop Placement ONLY - Not for Styling Details

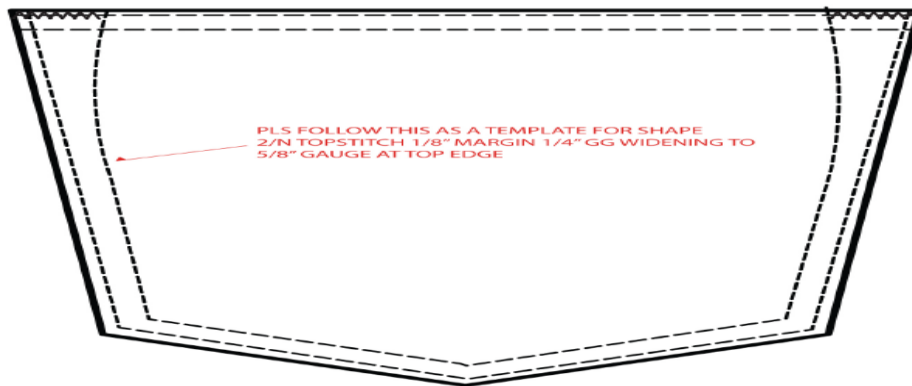
Figure 70: Artwork (back) of GAP buyer.

Old Navy		Sketches - generic			
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:					Sketch View Last Mod: Feb 13, 2016 2:47 PM PST

BACK POCKET CONSTRUCTION DETAILS

BARTACKS ARE SEWN AT TOP CORNERS OF THE POCKET.

2/CHAINSTITCH BACK PKT HEM
1/8" MARGIN 1/4" GG



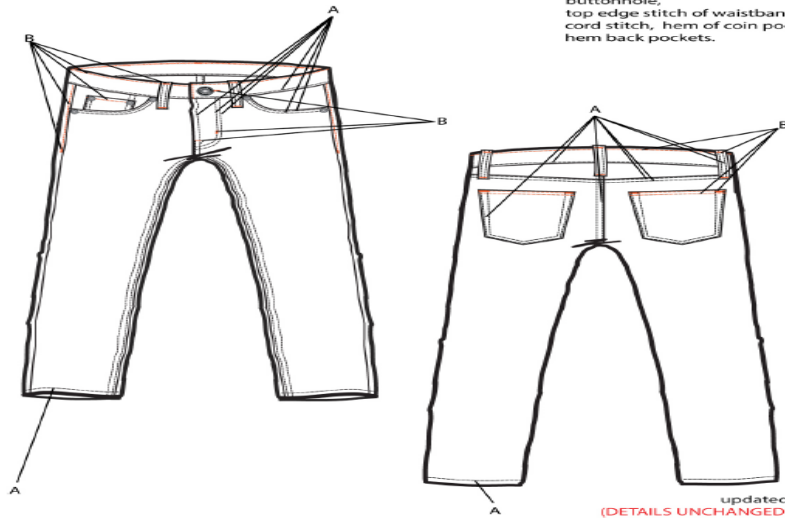
PLS FOLLOW THIS AS A TEMPLATE FOR SHAPE
2/N TOPSTITCH 1/8" MARGIN 1/4" GG WIDENING TO
5/8" GAUGE AT TOP EDGE

Figure 71: Artwork (back pocket) of GAP buyer.

Old Navy		Sketches - generic	
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim
Product Status:	Adopted	Product Type:	Pant
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);
Vendor:	ARMANA APPARELS LTD (1037305)	Vendor Collaboration:	
Factory:			
Comments:			Sketch View Last Mod: Feb 13, 2018 2:47 PM PST

FALL '16 FASHION DENIM-EXTERIOR THREAD COLOR KEY

- THREAD A. - 105tex 9/10 spi. Main top stitch, lower stitch of waistband, J-stitch, back yoke, back rise, hem, 2N stitch inseam.
- THREAD B. - 105 tex 9/10 spi. Bartacks, buttonhole, top edge stitch of waistband, cord stitch, hem of coin pocket, hem back pockets.



updated 3/31/2016
(DETAILS UNCHANGED FOR SP'18)

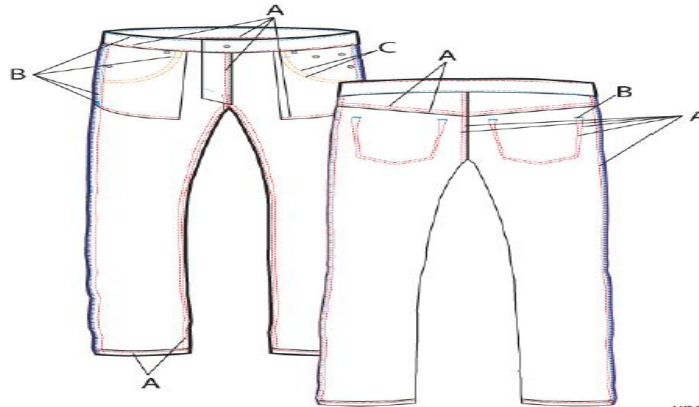
Figure 72: Artwork (back) of GAP buyer.

Old Navy				Sketches - generic	
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:	Sketch View Last Mod: Feb 13, 2018 2:47 PM PST				

SPRING 18 FASHION DENIM - INTERIOR THREAD COLOR KEY

SEE SEPARATE PAGE FOR OVERLOCK COLOR KEY

- THREAD A - 105 tex 9/10 spi main top stitch, bobbin for hem.
- 60 tex outseam single needle of 3thread overlock pls see diagram (outseam detail), join sideseam
- THREAD B - 60 tex - all loopers, zipper facing all bartacks.
- THREAD C - 60 tex Bobbin, attach pocket facings.



updated 06/06/2017

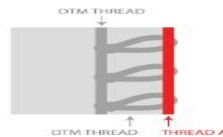
Figure 73: Interior thread lay details of GAP buyer.

Old Navy				Sketches - generic	
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION
Product Status:	Adopted	Product Type:	Pant	Theme:	
Sourcing Office:	India	Merch Number(s):	205729 (Global, Regular);	Vendor Collaboration:	
Vendor:	ARMANA APPARELS LTD (1037305)				
Factory:					
Comments:	Sketch View Last Mod: Feb 13, 2018 2:47 PM PST				

OVERLOCK STITCH DETAILS & COLOR KEY

3 THREAD OVERLOCK STITCH

1/8" WIDTH
T-60
14 SPI



updated 06/06/2017

Figure 74: Stitch details of GAP buyer.

Old Navy				Sketches - generic			
Master Style:	439068; RELAXED SLIM FIT FASHION	Line Plan:	ON Mens Denim SU19	Flow:	C/O		
Product Description:	RELAXED SLIM ETHAN BROWN CAST	Product Team:	ON Mens Denim	Area:	FASHION		
Product Status:	Adopted	Product Type:	Pant	Theme:			
Sourcing Office:	India	March Number(s):	205729 (Global, Regular);	Vendor Collaboration:			
Vendor:	ARMANA APPARELS LTD (1037305)						
Factory:							
Comments:				Sketch View Last Mod: Feb 13, 2016 2:47 PM PST			

CROSS SECTION OF QUAD-FOLD BELT LOOP CONSTRUCTION

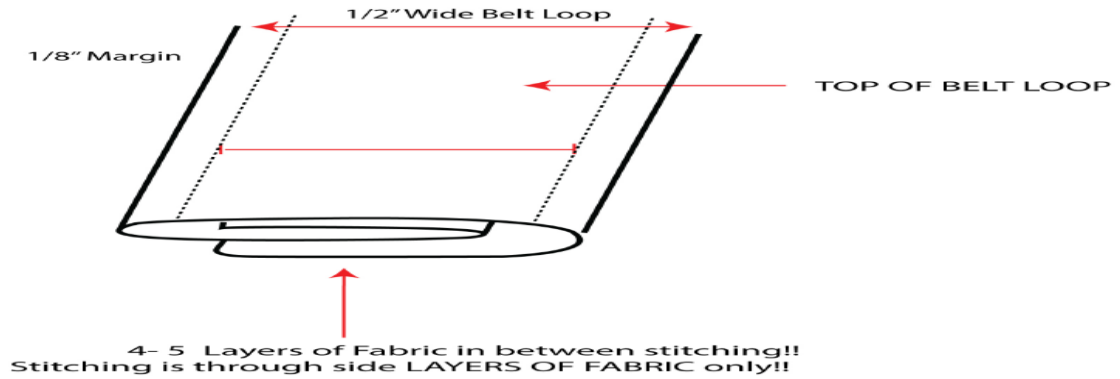


Figure 75: Belt loop details of GAP buyer.

Endo

endo	Designer:	PAULINA	Category:	CHLOPIEC	W	Size: 110-152	Base: K51003C
	Junior designer:		Subgroup:	SPODNIE JEANS DLUGIE			

1.OP. JEANS					UNIVERSAL			DEL. 1	2.OP. JEANS					DEL.		
A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	
DNAV	719	G777	232					LNAV	Z099	G777	226					
Y	19-4024		18-1160					Y			16-1133					

FABRIC		COLORS	
F1	JENS 18_305	A	
F2	RIB 6_445	B	
F3	SHIR 25_110	C	

ACCESSORIES	
AC1	BL1 BRAND
AC2	WT302a 100% COTTON 12 mm
AC3	S311 SINGLE CHAIN
AC4	S312 DOUBLE CHAIN
AC5	S307 BARTACK
AC6	BL8 B BRAND
AC7	ET317 polyester/elastan 35 mm

ARTWORK	
1.OP.	
2.OP.	

TREAT	
ENZYME STONE WASH	

Figure 76: Threat & Accessories details of Endo buyer.

1 OP.

2 OP.



Figure 77: Artwork of Endo buyer.

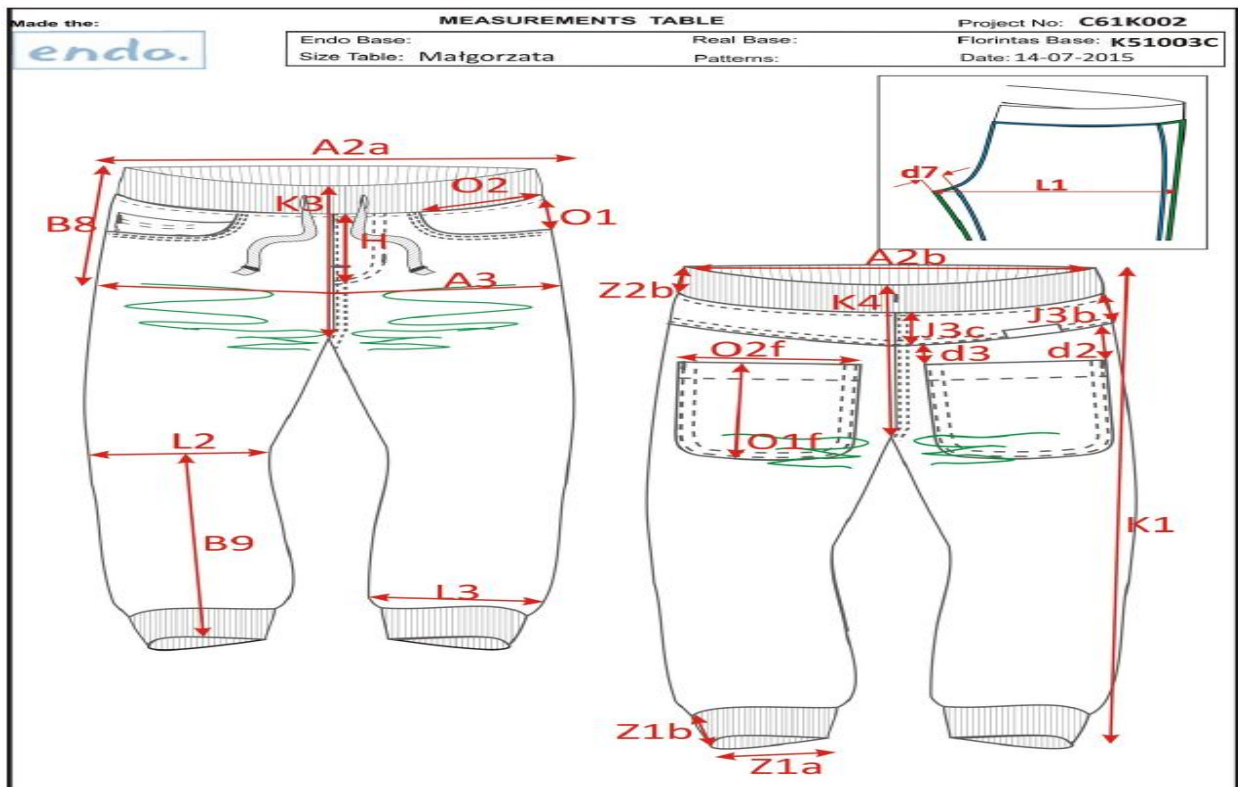


Figure 78: Artwork (front, back) of Endo buyer.

opis / rozm.	110	116	122	128	134	140	146	152
A2a - 1/2 waist width	30,60	31,40	32,20	33,00	33,80	34,80	35,80	36,80
A2b - 1/2 waist width	25,00	26,00	27,00	28,00	29,50	31,00	32,50	34,00
A3 - 1/2 hip width	32,80	33,70	34,60	36,10	37,60	39,10	40,60	42,10
B8 - hip height	13,00	13,50	14,00	14,50	15,00	15,50	16,00	16,50
B9 - knee height	29,00	31,00	33,00	35,00	37,00	39,00	41,00	43,00
d2	2,00	2,50	2,50	2,50	3,00	3,00	3,00	3,00
d3	2,00	2,50	2,50	2,50	3,00	3,00	3,00	3,00
d7	1,70	1,80	1,90	2,00	2,10	2,20	2,30	2,40
H - zipper length	10,50	10,50	11,00	11,00	11,50	11,50	11,50	12,50
J3a - back central yoke	5,00	5,50	5,50	5,50	6,00	6,00	6,00	6,00
J3b - back side yoke	3,00	3,50	3,50	3,50	4,00	4,00	4,00	4,00
K1 - total side leg length	65,40	69,10	72,80	76,50	80,20	83,90	87,60	91,30
K3 - front rise	19,60	19,90	20,20	20,50	21,10	21,70	22,30	22,90
K4 - back rise	27,20	27,80	28,40	29,00	29,90	30,80	31,70	32,60
L1 - thigh leg width	19,70	20,20	21,10	22,00	22,90	23,90	24,90	25,90
L2 - knee leg width	13,60	14,00	14,50	15,00	15,50	16,00	16,50	17,00
L3 - bottom leg width	12,80	13,20	13,60	14,00	14,40	14,80	15,20	15,60
O1 - pocket length	5,40	5,60	5,80	6,00	6,20	6,40	6,60	6,80
O1f - height back pocket	11,00	11,50	12,00	12,50	13,00	13,50	14,00	14,50
O2 - pocket width	7,60	7,90	8,20	8,50	8,80	9,10	9,40	9,70
O2f - back pocket width	10,30	10,70	11,10	11,50	11,90	12,30	12,70	13,10
Z1a - bottom welt width	10,10	10,40	10,70	11,00	11,30	11,60	11,90	12,20
Z1b - bottom welt height	4,00	4,00	4,00	4,00	4,00	4,00	4,00	4,00
Z2b - neck welt height	3,50	3,50	3,50	3,50	3,50	3,50	3,50	3,50

Figure 79: Measurements sheet of Endo buyer.

PEPCO

SS16OG13 - TECH PACK				PEPCO	
SEASON	SS 2016	BUYER	Aleksandra Komaszewska	THEME	
DATE	26-Mar-15	ASSISTANT	Hanna Wozniak	STYLE	SS16OG13
DEPARTMENT	Older	TECHNOLOGIST	Anna Michalak	DESCRIPTION	weekend trousers
GROUP	Outwear	CLASS	Trousers	SUB CLASS	Trousers casual
ORIGINAL GARMENT (PHOTO)			FABRICATION & TRIMS		
			FABRICATION		
			MAIN SHELL FABRIC	Woven	
			Fabric	Twill, 98% Cotton, 2% Elasthane, 285 gsm	
			Dye	Fabric Dye	
			Finishing		
			2nd SHELL FABRIC		
			Fabric		
			Dye		
			Finishing		
			OTHER FABRICS	<input type="checkbox"/> lining <input type="checkbox"/> edging	
			TRIMS		
			BUTTONS	Select Material	Select Type
			ZIP		
			Select		
			<input type="checkbox"/> Applique	<input type="checkbox"/> Embroidery	<input type="checkbox"/> Sequins
			<input type="checkbox"/> Badge	<input type="checkbox"/> Lace	<input type="checkbox"/> Tape
			<input type="checkbox"/> Braid	<input type="checkbox"/> Embroidered	<input type="checkbox"/> ID
			<input type="checkbox"/> Belt	<input checked="" type="checkbox"/> Zippers	
			OTHER		
			PRINT		
			TECHNIQUE	<input type="checkbox"/> Discharge <input type="checkbox"/> Dye <input type="checkbox"/> Full <input type="checkbox"/> Ink <input type="checkbox"/> Photo Print <input type="checkbox"/> Resective <input type="checkbox"/> Lick <input type="checkbox"/> Screen <input type="checkbox"/> Water <input type="checkbox"/> Letter <input type="checkbox"/> Laser	
			NUMBER OF COLORS	<input type="checkbox"/> <input checked="" type="checkbox"/> 10-5 <input type="checkbox"/> More than 5	
			COMMENTS		
Comments: shipment as per original sample					
COLORS:					
SOURCING AREA:		Bangladesh	China	HTD DATE:	
TARGET PRICE:		2,50 USD		UNITS: 20000	
SIZE RANGE:		7,8,9,10,11,12,13,14 (Year)		SIZE RATIO:	

Figure 80: Tech pack of PEPCO buyer.

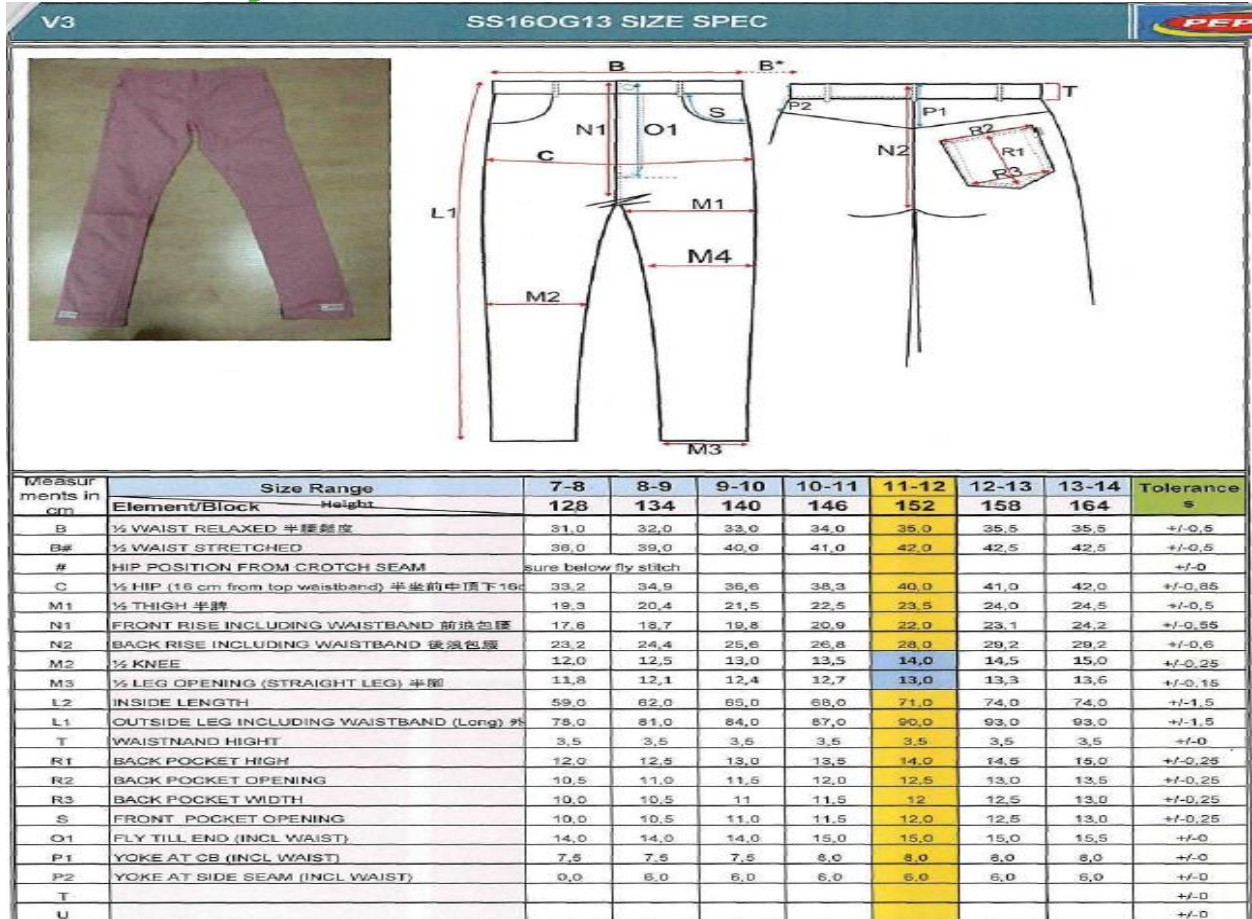


Figure 81: Artwork & Measurements sheet of PEPCO buyer.



Figure 82: Artwork of PEPCO buyer.



Figure 83: Artwork of PEPCO buyer.

Play today


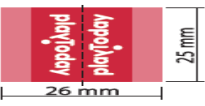
playToday FW 2015-16	351007	Size's range 98, 104, 110, 116, 122, 128
Pants (брюки текстильные для мальчика)		
Shell fabric	Herring bone tape	Inside waistband-Elastic tape
Metal Rivet	Metal Press Button	
Lining, Fleece	Decor stitches color: P 18-4005 TPX P 19-1664 TPX	
Jacquard chevron color: P 19-1664 TPX P 19-4006 TPX optic white 		Picture #1 Label flay Size 1:1  P 19-1664 TPX optic white

Figure 84: Artwork of Play today buyer.








playToday FW 2015-16		351007		Size's range 98, 104, 110, 116, 122, 128		
Materials	Color	Composition	Quality/construction	Finishing	Sample	
Shell fabric	P 19-3908 TPX Water print P 19-4006 TPX	100% cotton	Printed Carvas 96x48/16x16 Style Ref# 131102	Enzyme +Silicon wash	35 AL PDF files - 351007 fabric	
Accessories	Color	Quality	Size	Quantity	Photo sample	Care Label
Press Button	Gun Metal	Metal	D = 14 mm	4 pieces		
Metal Rivet	Gun Metal	Metal	D = 9 mm	4 pieces		
Harring bone Tape	P 19-4006 TPX P 19-1664 TPX	100% polyester	W=16 mm			
Elastic tape	Optic (pure) White	100% polyester	For size 98-104, W=35 mm for size 110-116, W=40 mm for size 122-128, W=45 mm			
Woven jacquard chevron	P 19-1664 TPX P 19-4006 TPX optic white	100% polyester	25 x 22 mm,	1 piece	Picture #2	
Name	Colors of Threads	Quality	Photo sample			
Stitches	Matching shell fabric					
Bar tack	Matching shell fabric					
Decor stitches	P 18-4005 TPX P 19-1664 TPX	Thick threads				
Name	Packing					
Main label	PT-ML-001					
Size label	PT-SL-001					
Care Label						
Hang tag	PT-HT-001 PT-HT-002					
Polybag	Individual Polybag					







Figure 85: Item details of Play today buyer.


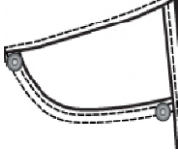

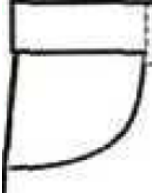

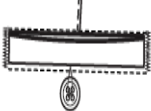
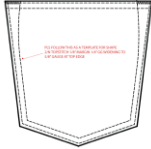
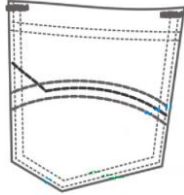


Measurements in cm	Size Range		2/3y	3/4y	4/5y	5/6y	6/7y	Tolerances
	Element/Block	Height	98	104	110	116	122	
B	½ WAIST RELAXED		26,8	27,8	28,0	28,5	29,0	+/-0,13
C	½ HIP		27,0	29,0	30,0	31,0	32,0	+/-0,5
M1	½ THIGH		16,5	17,0	17,5	18,5	19,5	+/-0,25
M2	½ KNEE		11,9	12,2	12,5	13,0	13,5	+/-0,15
M3	½ LEG OPENING- LONG		10,9	11,2	11,5	12,0	12,5	+/-0,15
N1	FRONT RISE WITH BAND		15,6	16,3	17,0	17,9	17,9	+/-0,35
N2	BACK RISE WITH BAND		23,2	24,1	25,0	26,1	27,2	+/-0,45
L2	INSIDE SEAM LENGTH		38,8	43,3	47,0	49,8	53,8	+/-1,88
R1	POCKET HIGHT AT FRONT- with band		7,5	8,0	8,5	9,0	9,5	+/-0,25
R2	POCKET WIDTH AT FRONT - stretched position		6,0	6,5	7,0	7,5	8,0	+/-0,25
R3	POCKET BAG WIDTH		9,0	9,5	10,0	10,5	11,0	+/-0,25
O2	FLY STITCHING LENGTH (WITH BAND)		10,5	11,0	11,5	12,0	12,5	+/-0,25
T	WAISTBAND HEIGHT		3,5	3,5	3,5	3,5	3,5	+/-0
X1	YOKE AT BACK HEIGHT		7,4	7,7	8	8,5	9,0	+/-0,15
X2	YOKE AT SIDE HEIGHT		5,6	5,9	6,2	6,7	7,2	+/-0,15
X5	POCKET AT BACK HEIGHT		8,9	9,2	9,5	10,0	10,5	+/-0,15
X3	POCKET AT BACK WIDTH- TOP		8,6	8,9	9,2	9,7	10,2	+/-0,15
X4	POCKET AT BACK WIDTH- BOTTOM		6,4	6,7	7,0	7,5	8,0	+/-0,15

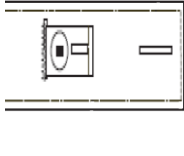


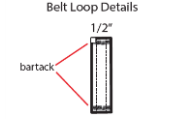



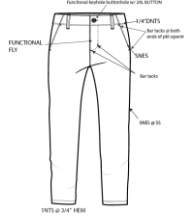
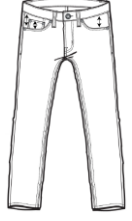
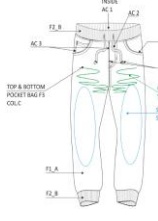
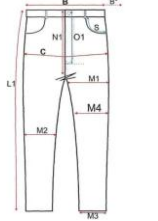

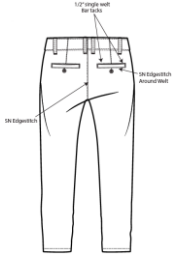


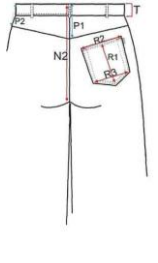

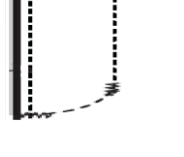

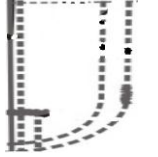


Figure 86: Measurements sheet of Play today buyer.

3.3.2 Table-3 Comparison among 5 Woven Pant buyers

Buyer →	JCPenny	GAP	endo	PEPCO	Play today
Logo					
Origin of the Buyer	Texas, U.S.	California, U.S.	Europe	Europe	Europe
Biggest Market	United States	United States	Europe	Europe	Europe
Product division	Apparel	Apparel	Apparel	Apparel	Apparel
Registered brand	ARIZONA	Old Navy	endo	PEPCO	Play today
Photo sample					
Product user division	Male	Male	Male	Male	Male
Product Category	Bottom	Bottom	Bottom	Bottom	Bottom
Style	Chino Pant	Slim fit	Causal fit	Causal fit	Causal
Fabric placement	Front, back, fly, waist, belt loop	Front, back, fly, waist, belt loop	Front, back, fly	Front, back, fly, waist, belt loop	Front, back, fly, waist, belt loop

Fabric color	Black	Ethan Brown-Casted indigo	Indigo blue, blue	Mid-rise Gray	Toledo & Liver plaid
Fabric density	6.3 OZ	12.25 OZ	10.32 OZ	6.60 OZ	7.37 OZ
Fabric width	57"	57"	55"	55"	55"
Fabric wash	Enzyme Garment Wash	Garment Wash	Enzyme Stone Wash	Garment Wash	Enzyme & Silicon wash
Button material	Poly button (Logo, clear)	Metal (Metal Shank)	N/A	N/A	Metal
Button color	Brown	Shiny Silver Color Round Shaped Shank Button	N/A	N/A	Matt silver
Button size	24L, 28L	27L	N/A	N/A	9,14 mm
Button photo sample			N/A	N/A	
Button Attaching	 4 Hole Buttons: X-Lockstitch for safety	Snap attaching	N/A	N/A	Snap attaching
Rivet	N/A		N/A	N/A	
Rivet Material	N/A	poly	N/A	N/A	metal
Spere buttons	N/A	N/A	N/A	N/A	N/A

Pocket	TC Pocketing	TC Pocketing	TC Pocketing	TC Pocketing	TC Pocketing
Pocket fabric	80% Poly 20% Cotton	65% Poly 35% Cotton	80% Poly 20% Cotton	80% Poly 20% Cotton	100% Polyester
Front pocket					
Back pocket					
Fake pocket	N/A	N/A	N/A	N/A	N/A
Zipper	4.5 Semi Auto Lock Antique Brass	Semi Auto Lock Angular Puller with on logo	Semi Auto Lock	N/A	N/A
Zipper Material	Metal	Metal	Poly	N/A	N/A
Interlining	Non-Woven Fusible	Non-Woven Fusible	N/A	N/A	N/A
Hook & BAR	N/A	Metal Shank	N/A	N/A	N/A
Poly zipper tape	100% Polyester	100% Polyester	100% Polyester	N/A	N/A
Elastic	3/4"	N/A	3"	3/5"	N/A
Waistband Elastic	Buttonhole Elastic	N/A	Elastic	Elastic	N/A

Waistband Elastic Photo sample		N/A			N/A
Belt loop	2"	2 7/8"	N/A	2 7/10"	1 9/2"
Belt loop Photo sample	<p>Belt Loop Details</p>  <p>1/2"</p> <p>bartack</p> <p>Belt loops are set into btm of WB seam, flip up and add bar tacks on both ends</p>		N/A		
Front art work	 				
Back art work	 				
Fly					
Sewing thread	100% Polyester	100% Spun Polyester	100% Spun Polyester	100% Polyester	100% Polyester
Sewing thread count	Tex 105	Tex 105	Tex 105	Tex 105	Tex 105
SPI	8	9/10	8	9	9

Overlock Stitch technique	3 thread overlock stitch, 14 SPI	3 thread overlock stitch, T-60, 14 SPI	3 thread overlock stitch	N/A	N/A
Piping	80% Poly 20% Cotton	65% Poly 35% Cotton	80% Poly 20% Cotton	80% Poly 20% Cotton	85% Poly 15% Cotton
WB Facing	80% Poly 20% Cotton	65% Poly 35% Cotton	80% Poly 20% Cotton	80% Poly 20% Cotton	85% Poly 15% Cotton
Other Trims , Accessories fabric	100% Polyester	100% Polyester	100% Polyester	100% Polyester	100% Polyester
Trims , Accessories color	Gray, White, Black	Gray, White, Black	Gray, White, Black	Gray, White, Black	White, Black
Measurement s	6H, 7H, 8H, 10H, 12H, 14H, 16H, 18H, 20H	36, 38, 40, 42, 44, 46, 48, 50	110, 116, 122, 128, 134, 140, 146, 152	128, 134, 140, 146, 152, 185, 164	98, 104, 110, 116, 122
UOM	Inch	Inch	inch	cm	cm
Conversion UOM	Inch	Inch	Inch	Inch	Inch
Waistband Width Build Up (Bottom)	6H: 1.50 7H: 1.50 8H: 1.50 10H: 1.50 12H: 1.50 14H: 1.50 16H: 1.50 18H: 1.50	36: 1.625 38: 1.625 40: 1.625 42: 1.625 44: 1.625 46: 1.625 48: 1.625 50: 1.625	110: 3.50 116: 3.50 122: 3.50 128: 3.50 134: 3.50 140: 3.50 146: 3.50 152: 3.50	128: 3.50 134: 3.50 140: 3.50 146: 3.50 152: 3.50 185: 3.50 164: 3.50	98: 3.50 104: 3.50 110: 3.50 116: 3.50 122: 3.50

	20H: 1.50				
Waistband Width Build Up (Bottom) Allowance	± 0.125	± 0.125	± 0.125	± 0.00	± 0.00
Waist Top Edge (Bottom)	6H: 24.50 7H: 25.50 8H: 26.50 10H: 27.50 12H: 29.00 14H: 30.00 16H: 31.00 18H: 32.50 20H: 34.00	36: 19.25 38: 20.25 40: 21.25 42: 22.25 44: 23.25 46: 24.25 48: 25.25 50: 26.25	110: 25.00 116: 26.00 122: 27.00 128: 28.00 134: 29.50 140: 31.00 146: 32.50 152: 34.00	128: 31.00 134: 32.00 140: 33.00 146: 34.00 152: 35.00 185: 35.50 164: 35.50	98: 26.80 104: 27.80 110: 28.00 116: 28.50 122: 29.00
Waist Top Edge (Bottom) Allowance	± 0.50	± 0.25	± 0.50	± 0.50	± 0.13
Hip/Seat from Crotch Seam	6H: 30.50 7H: 31.50 8H: 32.50 10H: 34.00 12H: 35.50 14H: 36.50 16H: 38.00 18H: 39.50 20H: 41.00	36: 28.00 38: 29.50 40: 31.00 42: 32.50 44: 34.00 46: 35.50 48: 37.00 50: 38.50	110: 27.20 116: 27.80 122: 28.40 128: 29.00 134: 29.90 140: 30.80 146: 31.70 152: 32.60	128: 33.20 134: 34.90 140: 36.60 146: 38.30 152: 40.00 185: 41.00 164: 42.00	98: 27.00 104: 29.00 110: 30.00 116: 31.00 122: 32.00

Hip/Seat from Crotch Seam Allowance	± 0.50	± 0.50	± 0.50	± 0.85	± 0.50
Thigh	6H: 19.25 7H: 19.75 8H: 20.25 10H: 21.125 12H: 22.00 14H: 22.625 16H: 23.50 18H: 24.375 20H: 25.25	36: 12.75 38: 13.25 40: 13.75 42: 14.25 44: 14.75 46: 15.25 48: 15.75 50: 16.25	110: 19.70 116: 20.20 122: 21.10 128: 22.00 134: 22.90 140: 23.90 146: 24.90 152: 25.90	128: 19.30 134: 20.40 140: 21.50 146: 22.50 152: 23.50 185: 24.00 164: 24.50	98: 16.50 104: 17.00 110: 17.50 116: 18.50 122: 19.50
Thigh Allowance	± 0.375	± 0.25	± 0.375	± 0.50	± 0.25
Knee	6H: 12.00 7H: 12.50 8H: 13.00 10H: 13.75 12H: 14.50 14H: 15.00 16H: 15.625 18H: 16.25 20H: 16.875	36: 8.75 38: 9.125 40: 9.50 42: 9.875 44: 10.25 46: 10.625 48: 11.00 50: 11.375	110: 13.60 116: 14.00 122: 15.50 128: 15.00 134: 15.50 140: 16.00 146: 16.50 152: 17.00	128: 12.00 134: 12.50 140: 13.00 146: 13.50 152: 14.00 185: 14.50 164: 15.00	98: 11.90 104: 12.20 110: 12.50 116: 13.00 122: 13.50
Knee Allowance	± 0.375	± 0.125	± 0.375	± 0.25	± 0.15

Leg Opening (Long) Rel	6H: 10.50	36: 10.50	110: 10.10	128: 11.80	98: 10.90
	7H: 11.00	38: 10.25	116: 10.40	134: 12.10	104: 11.20
	8H: 11.50	40: 12.00	122: 10.70	140: 12.40	110: 11.50
	10H: 12.25	42: 12.75	128: 11.00	146: 12.70	116: 12.0
	12H: 13.00	44: 13.50	134: 11.30	152: 13.00	122: 12.50
	14H: 13.50	46: 14.25	140: 11.60	185: 13.30	
	16H: 14.125	48: 15.00	146: 11.90	164: 13.60	
	18H: 14.75	50: 15.75	152: 12.20		
	20H: 15.625				
Leg Opening (Long) Rel Allowance	± 0.375	± 0.25	± 0.375	± 0.15	± 0.15
Inseam (long)	6H: 20.00	36: 27.50	110: 38.20	128: 53.40	98: 38.80
	7H: 22.00	38: 28.50	116: 41.30	134: 62.30	104: 43.30
	8H: 23.50	40: 29.50	122: 44.40	140: 64.20	110: 47.00
	10H: 25.00	42: 30.50	128: 47.50	146: 66.10	116: 49.80
	12H: 26.50	44: 31.50	134: 50.30	152: 68.00	122: 53.80
	14H: 28.00	46: 33.50	140: 53.10	185: 69.90	
	16H: 29.25	48: 35.50	146: 55.90	164: 70.00	
	18H: 29.75	50: 37.50	152: 58.70		
	20H: 30.25				
Inseam (long) Allowance	± 0.50	± 0.50	± 0.50	± 1.50	± 1.88
Front rise from Top Edge	6H: 7.875	36: 10.50	110: 19.60	128: 17.60	98: 15.60
	7H: 8.25	38: 11.50	116: 19.90	134: 18.70	104: 16.30

	8H: 8.625	40: 12.00	122: 20.20	140: 19.80	110: 17.00
	10H: 9.125	42: 12.75	128: 20.50	146: 20.90	116: 17.90
	12H: 9.625	44: 13.50	134: 21.10	152: 22.00	122: 17.90
	14H: 10.00	46: 14.25	140: 21.70	185: 23.10	
	16H: 10.375	48: 15.00	146: 22.30	164: 24.20	
	18H: 10.75	50: 15.75	152: 22.90		
	20H: 11.00				
Front rise from Top Edge Allowance	± 0.25	± 0.25	± 0.25	± 0.55	± 0.35
Back rise from Top Edge	6H: 11.625	36: 15.25	110: 27.20	128: 23.20	98: 23.20
	7H: 12.00	38: 16.00	116: 27.80	134: 24.40	104: 24.10
	8H: 12.375	40: 16.75	122: 28.40	140: 25.60	110: 25.00
	10H: 12.875	42: 17.50	128: 29.00	146: 26.80	116: 26.10
	12H: 13.375	44: 18.25	134: 29.90	152: 28.00	122: 27.20
	14H: 13.75	46: 19.00	140: 30.80	185: 29.20	
	16H: 14.125	48: 19.75	146: 31.70	164: 29.20	
	18H: 14.50	50: 20.50	152: 32.60		
	20H: 14.75				
Back rise from Top Edge Allowance	± 0.25	± 0.25	± 0.25	± 0.60	± 0.45
Fly Stitch Length from Top Edge	6H: 5.25	36: 6.50	110: 10.50	128: 14.00	98: 10.50
	7H: 5.75	38: 6.50	116: 10.50	134: 14.00	104: 11.00
	8H: 5.75	40: 6.50	122: 11.00	140: 14.00	110: 11.50

	10H: 6.25	42: 7.00	128: 11.00	146: 15.00	116: 12.00
	12H: 6.25	44: 7.00	134: 11.50	152: 15.00	122: 12.50
	14H: 6.75	46: 7.00	140: 11.50	185: 15.00	
	16H: 6.75	48: 7.50	146: 11.50	164: 15.50	
	18H: 7.25	50: 7.50	152: 12.50		
	20H: 7.75				
Fly Stitch Length from Top Edge Allowance	± 0.25	± 0.125	± 0.25	± 0.00	± 0.25
Fly Stitch Width to Outer Stitch	6H: 1.375	36: 1.75	110: 2.00	128: 1.50	98: 2.00
	7H: 1.375	38: 1.75	116: 2.00	134: 1.50	104: 2.00
	8H: 1.50	40: 1.75	122: 2.00	140: 1.50	110: 2.00
	10H: 1.50	42: 1.75	128: 2.00	146: 1.50	116: 2.00
	12H: 1.50	44: 1.75	134: 2.00	152: 1.50	122: 2.00
	14H: 1.50	46: 1.75	140: 2.00	185: 1.50	
	16H: 1.50	48: 1.75	146: 2.00	164: 1.50	
	18H: 1.50	50: 1.75	152: 2.00		
	20H: 1.50				
Fly Stitch Width to Outer Stitch Allowance	± 0.00	± 0.00	± 0.125	± 0.00	± 0.125
Pocket- Front Opening- Top Edge to Out seam	6H: 2.00	36: 2.625	110: 5.40	128: 2.50	98: 2.00
	7H: 2.00	38: 2.625	116: 5.60	134: 2.50	104: 2.00
	8H: 2.00	40: 2.625	122: 5.80	140: 2.50	110: 2.00
	10H: 2.25	42: 2.75	128: 6.00	146: 2.50	116: 2.00

	12H: 2.25 14H: 2.50 16H: 2.50 18H: 2.50 20H: 2.75	44: 2.75 46: 2.75 48: 2.875 50: 2.875	134: 6.20 140: 6.40 146: 6.60 152: 6.80	152: 2.50 185: 2.50 164: 2.50	122: 2.00
Pocket- Front Opening- Top Edge to Out seam Allowance	± 0.25	± 0.125	± 0.125	± 0.00	± 0.125
Pocket- Front Opening- Bottom Edge of WB	6H: 5.50 7H: 5.50 8H: 5.50 10H: 5.75 12H: 5.75 14H: 6.00 16H: 6.00 18H: 6.00 20H: 6.25	36: 5.00 38: 5.00 40: 5.00 42: 5.25 44: 5.25 46: 5.25 48: 5.50 50: 5.50	110: 7.60 116: 7.90 122: 8.20 128: 8.50 134: 8.80 140: 9.10 146: 9.40 152: 9.70	128: 10.00 134: 10.50 140: 11.00 146: 11.50 152: 12.00 185: 12.50 164: 13.00	98: 7.50 104: 8.00 110: 8.50 116: 9.00 122: 9.50
Pocket- Front Opening- Bottom Edge of WB Allowance	± 0.25	± 0.25	± 0.25	± 0.25	± 0.25
Back Pocket Position from Top of Waist	6H: 3.50 7H: 3.50 8H: 3.50	36: 6.75 38: 6.75 40: 6.75	110: 11.00 116: 11.50 122: 12.00	128: 10.50 134: 10.50 140: 11.00	98: 8.90 104: 9.20 110: 9.50

	10H: 3.50	42: 6.75	128: 12.50	146: 11.50	116: 10.00
	12H: 3.50	44: 7.00	134: 13.00	152: 12.00	122: 10.50
	14H: 3.50	46: 7.00	140: 13.50	185: 12.50	
	16H: 3.50	48: 7.00	146: 14.00	164: 13.00	
	18H: 3.50	50: 7.00	152: 14.50		
	20H: 3.50				
Back Pocket Position from Top of Waist Allowance	± 0.125	± 0.125	± 0.125	± 0.25	± 0.15
Pocket Pos from CB Seam	6H: 4.625	36: 2.25	110: 2.00	128: 2.50	98: 2.00
	7H: 4.625	38: 2.50	116: 2.00	134: 2.50	104: 2.00
	8H: 4.625	40: 2.75	122: 2.00	140: 2.50	110: 2.00
	10H: 4.625	42: 3.00	128: 2.00	146: 2.50	116: 2.00
	12H: 4.625	44: 3.25	134: 2.00	152: 2.50	122: 2.00
	14H: 4.625	46: 3.50	140: 2.00	185: 2.50	
	16H: 4.625	48: 3.75	146: 2.00	164: 2.50	
	18H: 4.625	50: 4.00	152: 2.00		
	20H: 4.625				
Pocket Pos from CB Seam Allowance	± 0.125	± 0.125	± 0.125	± 0.00	± 0.125
Pocket- Back-Single Welt Length	6H: -.50	36: N/A	110: N/A	128: N/A	98: N/A
	7H: -.25	38: N/A	116: N/A	134: N/A	104: N/A
	8H: -.25	40: N/A	122: N/A	140: N/A	110: N/A

	10H: 0.00	42: N/A	128: N/A	146: N/A	116: N/A
	12H: 0.00	44: N/A	134: N/A	152: N/A	122: N/A
	14H: .25	46: N/A	140: N/A	185: N/A	
	16H: .25	48: N/A	146: N/A	164: N/A	
	18H: .25	50: N/A	152: N/A		
	20H: .50				
Pocket- Back- Single Welt	± 0.25	N/A	N/A	N/A	N/A
Length Allowance					
Packaging	Poly bag	Poly bag	Poly bag	Poly bag	Poly bag
Fabric	97/3 Cotton Span Twill	99% Cotton, 1% Elastane	95% Cotton, 5% Elastane	Twill, 98% Cotton, 2% Elastane,	100% Cotton
Wash	Enzyme Garment	Garment	Enzyme Stone	Garment	Enzyme & Silicon
GSM	214	415	350	225	250
Fabric price	\$2.50	\$3.25	\$2.65	N/A	N/A
Unit Price	\$9.10	\$9.00-14.00	\$10.90	\$5.50	\$5.80
Delivery Method	FOB (by sea)	FOB (by sea)	FOB (by sea)	FOB (by sea)	FOB (by sea)
Payment Method	L/C	L/C	L/C	L/C	L/C
Order Quantity	60000 pieces	50000- 150000 pieces	15000-20000 pieces	20000 pieces	15000 pieces

4 Discussion of Results

4.1 Comparison of Knit T-Shirt buyers

This study can be discussed in four section. Fabric, Design & Making, Measurements and Costing & Others.

4.1.1 Fabric

It can be seen in the figures 3, 11, 15, 17, 20 and table 1 that, the GSM of the fabrics vary to some extent. The reported data showed that the GSMs were 160 to 200. C&A preferred 180 GSM, zLabels preferred 160 GSM, KiK preferred 180 GSM, NAFTA preferred 160 GSM & NEWWORKER preferred 200 GSM. Most of the fabrics used by the buyers were dyed to various shades. It was found the number of shades vary widely, most of the buyers were found to use 2/4 shades while a buyer NAFTA ordered for as many 28 different shades. It may be mentioned that their order quantity was also very high (7, 00,000 pieces per 3 months).

4.1.2 Design & Making

The differences among various T-Shirts buyers had been shown in figures 1-7, 12, 15, 17, 19 and table 1. It is seen in the table that there were variations among different buyers based on category, body parts design, button, pocket, zipper, SPI and print.

Some of the specifications were fixed to specific category & style. It was also found that the buyer's requirements vary depending on construction and elements. It can be seen in the table 1 that choice of Colors are different among buyers. The Body parts are mostly same but have different designs. Most of the buyers used buttons made of plastic, but one buyer (NEWWORKER) had zipper. One of the buyer (C&A) adopted latest technological development e.g. their product had a heat sealed print on chest. Buyers preferred the range of SPI from 8-9.

4.1.3 Measurements

The differences of measurements are seen in the figures 8, 13, 16, 17, 21 and table 1. Differences are significant among the buyers. Size differences varied from XS to 3XL. Only one of the buyer preferred the size from XXS to 2XL. UOM was founded in difference measures (cm & Inches). Their measurements differed in a specific size e.g. body length of these t-shirts for the (M) size C&A preferred 72 cm, zLabels preferred 79 cm, KiK preferred 73 cm, NAFTA preferred 73.66 cm & NEWWORKER preferred 78 cm. These differences were caused for buyers origin & their market base. American & Germany market based products were bigger aspect to the other European market based products.

4.1.4 Costing & Others

The differences of costing & others were seen in the table 1. It is seen that, four major criteria differentiate the business portion. Unit price, Delivery method, Oder quantity and the Payment method.

Unit price vary from \$1.80 to \$2.70. The unit price of C&A was \$2.30, zLabels was \$2.39, KiK was \$1.80, NAFTA was \$2.10 & NEWWORKER was \$2.70. C&A had a lower GSM of 160 fabric, though the price was high because of using latest printing technology. KiK used 180 GSM fabric, but the unit price was lower than zLabels & NAFTA while they used 160 GSM fabric. NEWWORKER made its unit price tag at \$2.70 because of using higher 200 GSM fabric & zipper. Payment Method & Delivery method was L/C & FOB (free on board to Chittagong sea port). If the delivery faced late or delay then the delivery method shifted to air to cover up time. Order quantity was (1000 to 70000) pieces per two or three months. Within these buyers zLabels ordered a very small quantity of 1000 pieces that costs \$2390, C&A ordered 650000 pieces that costs \$1495000, KiK ordered 650000 pieces that costs \$1170000, NAFTA ordered 700000 pieces that costs \$1470000 & NEWWORKER ordered 300000 pieces that costs \$810000.

4.2 Comparison of Woven Shirt buyers

This study can be discussed in four section. Fabric, Design & Making, Measurements and Costing & Others.

4.2.1 Fabric

It can be seen in the figures 22-24, 35-36, 40, 44, 52 and table 2 that, Most of them preferred 100% cotton fabric. Fabric differences were on its weave from. Most of them found to use plain weave while one buyer (H&M) preferred 2/2 Z twill from. Two of them (H&M, MINA) also preferred printed fabric for the product others didn't. Fabric finishing was also significant as to the buyer's preference as well as the fabric GSM. GSM ranges varied from 135-155. H&M preferred 140±5% GSM, MINA preferred 150±5% GSM, WiK preferred 150 GSM, LiDL preferred 150±5% GSM, ZOLA Times preferred 150 GSM. Testing of the H&M product along with fabric was very much strict to its in-house lab and testing standards like dimensional stability, color fastness to dry/ household/ rubbing/ perspiration/ saliva/ water/ ozone/ artificial light, flammability, stretch & recovery, pile loss, seam slippage, pilling resistance and appearance after wash. But the other buyers was not strict that much, they followed standard testing method and a standard quality. Different colors choice was also very aspectual to find out the differences between the buyers.

4.2.2 Design & Making

The differences among various woven shirts buyers had been shown in figures 25-31, 33-34, 41, 45, 50-51 and table 2. It is seen in the table that there were variations among different buyers based on product category, style, body parts design, button, pocket, SPI, print, finishing & accessories.

It is seen that, most of the buyer preferred to have basic style while H&M and LiDL preferred Western style. Different body parts designs were found in different buyers preference. Some had bigger buttons respected to the others. LiDL preferred 20L, H&M & Zola times preferred 18L where else MINA & WiK preferred 16L & 14L size buttons. One of them (H&M) had snap buttons and metal plate button others had poly buttons. Two of them (MINA, WiK) got no pocket but others had pocket. One of them (H&M) got dual pocket. SPI range was 10-11 but most of the buyers preferred 11. Accessories differences were also very significant among the buyers.

4.2.3 Measurements

The differences of measurements are seen in the figures 32, 37, 43, 49, 53 and table 2. It is seen that, the sizes range were found from ZS to XXL. Two of among buyers (H&M, MINA) preferred

XS to XXL, two of them (WiK, LiDL) preferred M to XXL and one of them (ZOLA Times) preferred S to XXL. Different parts of the products were also different in measurements on the basis of style and buyers preference e.g. bottom length of these shirts for the size (M) H&M preferred 108 cm, MINA preferred 106 cm, WiK preferred 89.50 cm, LiDL preferred 89.50 cm, Zola Times preferred 89.50 cm. It was found that, their measurements were differed for the buyers origin. Swedish origin based products were bigger aspect to the European origin based products.

4.2.4 Costing & Others

The differences of costing & others were seen in the table 2. It is seen that, the major elements were unit pricing, delivery method, payment method and the order quantity to differentiate the buyers.

Unit prices vary from \$4.9 to \$6. The unit price of H&M was \$5.80, MINA was \$4.90, WiK was \$5.90, LiDL was \$6, ZOLA Times was \$6. It can be seen that, pricing varied because of fabric finishing and the uses of dye substance. MINA preferred pigment dyed fabric with soft finish, H&M & LiDL preferred reactive dyes with brush finish, WiK & ZOLA Times preferred reactive dyes with Garments Washing finish. It can be seen that one of the buyer (H&M) having lower GSM than others was also priced high (\$5.80) because of various testing purpose. Payment method was L/C and delivery method was free on board to Chittagong sea port. Order quantity range of the buyers was (100000 to 200000) pieces. H&M ordered 120000 pieces that costs \$696000, MINA ordered 100000 pieces that costs \$490000, WiK ordered 150000 pieces that costs \$885000, LiDL & ZOLA Times both ordered 200000 pieces that costs \$1200000 & \$1200000 each.

4.3 Comparison of Woven Pants buyers

This study can be discussed in four section. Fabric, Design & Making, Measurements and Costing & Others.

4.3.1 Fabric

It can be seen in the figures 57, 61, 76, 80, 85 and table 3 that, the fabric choice was different from buyer to buyer. Generally cotton % was over 95. Three of them (GAP, endo, PEPCO) used elastane (1, 5, 2) % with the cotton. It is seen that, fabric density was extremely difference from one to

another, density was found from 6.3 OZ to 12.25 OZ. JCPenny preferred 214 GSM, GAP preferred 415 GSM, endo preferred 350 GSM, PEPCO preferred 225 GSM, Play today preferred 250 GSM. Washing differences was significant. Three of the buyers (JCPenny, endo, Play today) preferred Enzyme garments wash (stone/silicon) others (GAP, PEPCO) preferred regular garments wash. Different colors choice was also very aspectual to find out the differentiation between them.

4.3.2 Design & Making

The differences among various woven pants buyers had been shown in figures 54-58, 67-75, 77-78, 81, 84 and table 3. It is seen in the table that there were variations among different buyers based on product category, style, parts of the product, zipper/button, SPI, waist band elastic, rivet & the size of the product with its body parts design.

In the Category, different buyer designed the product with different design. Three of them (endo, PEPCO, Play today) preferred casual fit, GAP preferred slim fit JCPenny preferred Chino style design. Different parts like pocket, fly etc. were also different in design aspect from one buyer to another. Three of them (JCPenny, GAP, endo) preferred zipper, others (PEPCO, Play today) preferred to had button closed fly. JCPenny, GAP preferred metal zipper & endo preferred plastic made zipper. PEPCO & endo don't have waist button & button hole, they preferred elastic waist band. There was also differences in button size and elements of buttons in those products. GAP preferred 27L, JCPenny preferred 28L & 24L, Play today preferred 22L & 14L size button. GAP, Play today preferred metal button, JCPenny preferred plastic made buttons. SPI range was 8-10. 9 was mostly used by the buyers. Two of them (GAP, Play today) had metal rivet on the pockets others (JCPenny, endo, PEPCO) didn't want rivet in their products.

4.3.3 Measurements

The differences of measurements are seen in the figures 59, 64-65, 79, 81, 86 and table 3. Measurements were found in different sizes from buyer to buyer. JCPenny preferred 6H to 20H, GAP preferred 36 to 50, endo preferred 110 to 152, PEPCO preferred 128 to 164 & Play today preferred 98 to 122. UOM was founded in difference measures (cm & Inches). It can be seen that same parts of the products differed in measurements e.g. average thigh measurements of JCPenny was 22 inches, GAP was 14.50 inches, endo was 22.575 inches, PEPCO was 22.25 inches & Play today was 17.70 inches. Within these buyers one of them (GAP) was very much strict to its appropriate measurements and gave less allowances on each body part.

4.3.4 Costing & Others

The differences of costing & others were seen in the table 3. It is seen that, the major elements were unit pricing, delivery method, payment method and the order quantity to differentiate the buyers.

Unit prices vary from \$5.50 to \$14. The unit price of JCPenny was \$9.10, GAP was \$9-14, endo was \$10.90, PEPCO was \$5.50 & Play today was \$5.80. The pricing of pants vary from buyer to buyer in the basis of fabric GSM, trims/accessories & washing. JCPenny sets its product unit price \$9.10 with 214 GSM (97/3 cotton) span twill fabric treated with enzyme garments wash, GAP sets its product unit price \$9-14 with 415 GSM (99% cotton, 1% of elastane) fabric treated with regular garments wash, endo sets its product unit price \$10.90 with 350 GSM (95% cotton, 5% elastane) fabric treated with enzyme stone wash, PEPCO sets its product unit price \$5.50 with 225 GSM (98% cotton, 2% elastane) twill fabric treated with regular garments wash, Play today sets its product unit price \$5.80 with 250 GSM (100% cotton) fabric treated with enzyme & silicon wash. Payment method was L/C and delivery method was free on board to Chittagong sea port. Order quantity range of the buyers was (15000 to 150000) pieces. JCPenny ordered 60000 pieces that costs \$546000, GAP ordered 50000-150000 pieces that costs \$450000-\$2100000, endo ordered 15000-20000 pieces that costs \$163500-\$218000, PEPCO ordered 20000 pieces that costs \$110000 & Play today ordered 15000 pieces that costs \$87000. It also can be seen that, Gap & endo changed their order quantity time to time.

5. Conclusions

This study achieved many consequential differences and business culture of different foreign buyers which are well known for importing apparel goods from the textile industry of Bangladesh. This study differentiates the buyer's individual preference & their working culture. For knit-t-shirt; GSM ranges varied from 160-200 & color shades were found 1-28, designs with trims & accessories differences were significant, SPI ranges varied from 8-9, measurements varied from XS-3XL & for same size products there were differences due to buyers origin and different geographical market based products. Costing varied from \$1.80-\$2.70 with variable order quantity of 1000-70000 pieces. For woven shirts; GSM ranges varied from 135-155 with different construction & color shades were found 2-5, designs with trims & accessories differences were significant, SPI ranges varied from 10-11, measurements varied from XS-XXL & also for same size products there were differences due to buyers origin and different geographical market based products. Costing varied from \$4.9-\$6 with variable order quantity of 100000-200000 pieces. For woven pants; GSM ranges varied from 214-415 & single color shade was found, designs with trims & accessories differences were significant also, SPI ranges varied from 8-10, measurements were found in (6H-20H, 36-50, 110-152, 128-168, 98-122). Costing varied from \$5.50-\$14 with variable order quantity of 15000-150000 pieces. This study enables a garments manufacturer to manage its operations suitable for the working format of these buyers. Thus the textile industry will get more dynamic interests from the buyers & they are going to place more order because of the advantages & very short lead time process. This study can be a sample for preparing production, quality, R&D, workforce, machine, supply chain and communication department for a starter garments manufacturing personals. This study also can be very beneficial for the textile students to understand, how much differences are there within these buyers & their preferred goods. As fashion trend is a continuous process, this study should be open for future development with more advance & technological facts that will differentiate the apparel buyers with more details.

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