

FR DENIM WORK SHIRT

Jeanswear | Western and Specialty(5) |Production|0|XXX  
Finished Product

FR3W5DN

Created By: aydelep 02-06-2008 02:22 PM  
Modified By: aydelep 02-18-2008 03:26 PM



Page Type : Product Summary		Page Name : Product Summary		PG Modified By: aydelep 02-13-2008 12:35 PM	
MERCHANDISER	017-GERALD GUILIANO	SHIP LOT NUMBER			
IRREGULAR MATERIAL NUMBER	005XIRG	TEAM CONTACT	PHILLIP AYDELETTE		
PROTO NUMBER	FR3W5DN				
COMMENTS					



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Page Type : Finished Goods GridPage Name :FGGPG Modified By: aydelep 02-18-2008 03:26 PM

Color : W-XXX-Care Code : H

JSL	REG	TAL	BIG																							
JNK																										
M	X																									
L	X																									
XL	X																									
XXL	X																									
LT		X																								
XLT		X																								
2XT		X																								
3XT		X																								
3X			X																							
4X			X																							

X - Active SKU  
A - Approved SKU

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Page Type : BOM

Page Name :MWO 600

Plant: GLOBAL SOURCING

PG Modified By: aydelep 02-06-2008 03:57 PM

No.	Item Code	Qty	Description Vendor  Content	Alt For	Use	Image	Est	Rt Ind	Doc Type	Comp Type	Cost Rel	Fab No.
1	WSF-8189 5	0.000	81895-7.0oz-FR CHAMBRAY-100CTN-7.7 ATPV   MOUNT VERNON MILLS		BODY FABRIC						Y	
2	WS00049	0.000	T40 NOMEX THREAD   A & E PRODUCTS		BODY THREAD						Y	
3	7182713	0.000	RIGGS FR LBL ORG/BLK 50X60MM   AVERY DENNISON		INSIDE BACK YOKE						Y	
4	7182313	0.000	RIGGS MENS FR RSR LBL ORG/BLK 11.5X38 SC   AVERY DENNISON		LEFT SLEEVE AT CUFF SEAM						Y	
5	7182513	0.000	RIGGS MENS FR SHIRT LBL ORG/BLK 19X19MM   AVERY DENNISON		LEFT CHEST POCKET ON FLAP AT PENCIL SLOT						Y	
6	7655701	0.000	WEST SHIRTS FR WARN LBL WHI/BLK 58X102   AVERY DENNISON		INSIDE WEARERS RIGHT SHIRT TAIL						Y	

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No.	Item Code	Qty	Description Vendor  Content	Alt For	Use	Image	Est	Rt Ind	Doc Type	Comp Type	Cost Rel	Fab No.
7	7972824	0.000	RIGGS MENS FR WORKSHIRT HT   AVERY DENNISON		ATTACH TO FRONT PLACKET BETWEEN 2ND & 3RD BUTTON						Y	
8	7647592	0.000	RIGGS FR SHIRT CALLOUT STKR   AVERY DENNISON		LEFT CHEST ABOVE POCKET						Y	
9	5SRW183	0.000	RW183>WRANGLER KABEL B/C H.T.(1.5X4")*   AVERY DENNISON		SET TO PLACKET WITH HANGTAG						Y	
10	7835600	0.000	UPC TICKET FORMAT/HANGDBL (SHIRTS)		FORMAT ONLY						Y	
11	7245808	0.000	RIGGS FLAME RESISTANT SHIRT SS   AVERY DENNISON		LEFT CHEST POCKET						Y	
12	000S841	0.000	S841 SIZE STRIP FORMAT 		FORMAT ONLY						Y	
13	CARETAPE	0.000	CARE LABEL TAPE - 1.5" WIDE - WHITE		UNDER BOTTOM EDGE OF MAIN LABEL AT CENTER BACK YOKE						Y	

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No.	Item Code	Qty	Description Vendor  Content	Alt For	Use	Image	Est	Rt Ind	Doc Type	Comp Type	Cost Rel	Fab No.
14	CARE022	0.000	CARE022, FLAME RESIST CARE, SHIRT, ENGL		FORMAT						Y	
15	WS00054	0.000	PT118BK - TOP HANGER BLACK   PLASTIFORM		HANGER; NOTE SIZE CLIPS ON TALL WILL NOT HAVE THE "T" INDICATOR AND 4X WILL NOT HAVE A SIZE CLIP						Y	
16	TOPSPOLY	0.000	TOPS CLEAR POLYBAG - WARNING ON BACK		INDIVIDUAL POLY BAG PER GARMENT						Y	
17	CARTON1	0.000	CARTON -13W x 24-3/4L x 11-1/2T		SHIPPING CARTON						Y	

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Page Name : MWO 600

**Plant : GLOBAL SOURCING**

**PG Modified By:**aydelep 02-06-2008 03:57 PM

No.	Operation Code	Operation Description	Comments
1	FR3W5	CONSTRUCTION DETAILS FOR FR3W5xx	
2	CARE022	FLAME RESIST CARE, SHIRT, ENGLISH ONLY	SEE FABRIC DESCRIPTION ON BOM FOR ATPV RATING
3	CAREHE	CARE CODE H - ENGLISH ONLY CARE INSTRUCTIONS -BACK	
4	FDT01	TRI-FOLD TOP - HANGER AND INDIVIDUAL POLYBAG	
5	890401	TOPS - STD PACK & CARTON INFO - INDIVIDUAL POLYBA	

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## CONSTRUCTION

FR3W5xx - RIGGS FR-SHIRT - Based off VFI SLU2KH (10/16/2007)

PART	CONSTRUCTION
COLLAR MAKE:	Stitch-Turn-Stitch with 1N TPST Button Down Collar Points with Button & Button Hole
COLLAR BAND:	1N Edge stitch collar band
PLACKET -LEFT FRONT: -RIGHT FRONT:	Center Fold Set Placket; 2N Set (Bulwark standard placket make) Double turn Hem - 1N TPST
SHOULDER SEAMS:	Safety Stitch and 1N Edgestitch
BACK YOKE :	Set with 1-NEEDLE TPST (Bulwark standard method)
SLEEVES SET:	Safety Stitch and 2N TPST
SIDE SEAMS:	Safety Stitch
CUFFS: - CUFF MAKE: - CUFF SET: - CUFF PLEAT: - CUFF PLACKET:	Stitch-Turn-Stitch with 1N TPST (Bulwark standard) 2N Set (Bulwark standard) 2 on each sleeve 1" Wide Cuff Placket on each cuff with Button Closure (Bulwark standard cuff placket)
POCKETS: - HEM - SET - CLOSURE - PENCIL SLOT	Hex Bottom Pockets on Left and Right Chest (Bulwark standard hex pocket) 1N - 3/4" Double turn hem (Bulwark standard hem) 1N set and bartack top corners of pockets (Bulwark standard set) Button and Button Hole Left and right chest pocket flap
BOTTOM HEM:	1/4" Double Turn Hem; 1N (Bulwark standard)
EXTRA BUTTONS:	NONE

## CARE LABEL FORMAT

## FRONT

CARE022

RN 130273

MADE IN \_\_\_\_\_

English Fiber Content \*

ARC RATING  
(RATING) ATPVLOT #  
ALIAS LOT  
ENG SIZE  
ADDITIONAL SIZE  
Plant-YYM-PO #  
UPC NUMBER

ENGLISH	SPANISH
COTTON	ALGODON
DACRON	DACRON
POLYESTER	POLIESTER
RAMIE	RAMINA
RAYON	RAYON
SPANDEX	SPANDEX

YY = YEAR (EX. 2010 = 10)  
M = MONTH OF SCHEDULED  
DELIVERY TO DC

## MONTH OF DELIVERY CODES

A = JANUARY      G = JULY  
B = FEBRUARY    H = AUGUST  
C = MARCH        I = SEPTEMBER  
D = APRIL         J = OCTOBER  
E = MAY           K = NOVEMBER  
F = JUNE           L = DECEMBER

\*Refer to the Bill of Materials for Fiber Content

Op FR3W5 Des CONSTRUCTION DETAILS FOR FR3W5xx

Op CARE022 Des FLAME RESIST CARE, SHIRT, ENGLISH ONLY

SEE FABRIC DESCRIPTION ON BOM FOR ATPV RATING



CARE CODE H - ENGLISH ONLY

CARE LABEL LAYOUT - BACK



MACHINE WASH WITH LIKE  
COLORS, TUMBLE DRY,  
REMOVE PROMPTLY, NO  
CHLORINE BLEACH, NO  
STARCH OR FABRIC  
SOFTENERS, NO PRODUCTS  
CONTAINING HYDROGEN  
PEROXIDE, FAILURE TO  
LAUNDER PROPERLY COULD  
AFFECT THE FLAME  
RESISTANCE

FABRIC CODE  
FOR FABRIC  
USED TO  
MAKE  
GARMENT

FABRIC CODE

TOPS - Tri-fold Packing Method (10/12/2007)

1. ATTACH SIZE CLIP TO HANGER AND INSERT HANGER INTO SHIRT. WOVEN SHIRTS SHOULD HAVE A CARDBOARD STRIP PLACED UNDER THE COLLAR TO MAINTAIN APPEARANCE. FASTEN ALL BUTTONS. DO NOT USE ANY PINS, CLIPS, FOAM, OR ADDITIONAL CARDBOARD.
2. FOLD LEFT & RIGHT SLEEVES TO REAR AND PUT SHIRT INTO A CLEAR POLBAG. HANGER HOOK WITH SIZE CLIP SHOULD EXTEND OUT OF THE TOP OF THE POLYBAG WITH THE POINT OF HOOK FACING TO WEARER'S RIGHT.
3. FOLD BOTTOM 1/3 OF SHIRT AND POLYBAG UP TO THE REAR. DO NOT SEAL OR TAPE THE BOTTOM OPENING OF THE POLYBAG.
4. FOLD ANOTHER 1/3 OF THE SHIRT AND POLYBAG TO THE REAR. AT THE SHOULDERS OF THE SHIRT, TAPE THE POLYBAG IN THE FOLDED POSITION USING TWO PIECES OF TAPE.
5. TOTAL FOLDED SIZE OF SHIRT (INCLUDING HANGER) MUST FIT INSIDE A 13" WIDE x 20" LONG SHIPPING CARTON. UPC TICKET SHOULD BE ATTACHED TO GARMENT PER MANUFACTURING SPEC PLACEMENT INSTRUCTIONS AND LOT NUMBER, SIZE, AND UPC BARCODE SHOULD FACE UP SO THAT THEY ARE VISIBLE.

FINAL GARMENT APPEARANCE AFTER FOLD



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10/09/07

## VF JEANSWEAR - TOPS

## STANDARD PACKING GUIDELINES – WITH INDIVIDUAL POLY BAGS

- CLOSE ALL BUTTONS, ZIPPERS, SNAPS, ETC. – NO PINS, JET CLIPS, FOAM, OR EXTRA CARDBOARD IN SHIPPING CARTON,
- UPC TICKET TO BE FACE UP AFTER GARMENT IS IN POLYBAG AND FOLDED.
- MAKERS TO FOLLOW VF JEANSWEAR PACKING INSTRUCTIONS FOR PROPER FOLD AND PLACEMENT IN THE SHIPPING CARTON. SEE MANUFACTURING SPEC FOR PROPER FOLD AND GARMENT PUT-UP.
- INDIVIDUAL POLY BAG IS REQUIRED FOR EACH GARMENT IN BOX.
- GARMENTS TO BE PACKED BY SOLID SIZE AND COLOR. MIXING OF SKU's NOT PERMITTED.
- CASE LINER REQUIRED – SEE BOM FOR DESCRIPTION AND BELOW FOR INSTRUCTIONS.
- INDIVIDUAL POLY BAGS MUST HAVE THE FOLLOWING WARNING:

**"WARNING: To avoid danger of suffocation, keep this bag away from babies and children. Do not use in cribs, beds, carriages, or playpens. THIS BAG IS NOT A TOY.**

**AVISO: Para evitar peligro de asfixia, mantener fuera del al cance de los niños y de los bebés. No usar en cunas, camas, carritos, o corrales. ESTA BOLSA NO ES UN JUGUETE.**

**MISE EN GARDE: Pour éviter tout danger de suffocation, gardez ce sac hors de la portée des bébés et des enfants. Ne l'utilisez pas dans les poussettes, les lits, ni les parcs d'enfants. CE SAC N'EST PAS UN JOUET."**

Font size is dependent on length of polybag:

- 60" or more - 24 point
- 40" - 59" - 18 point
- 30" - 39" - 14 point
- 29" or less - 10 point

**SPECIAL INSTRUCTIONS FOR PACKING USING CASE LINER:**

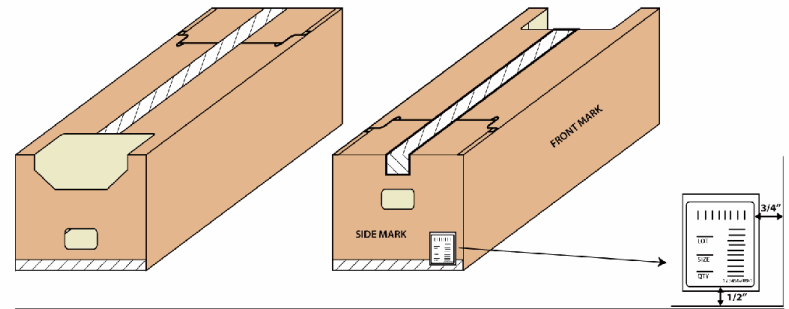
CLOSE AND TAPE TOP OF SHIPPING CARTON. TURN CARTON OVER SO IT REST ON ITS TOP AND PLACE CASE LINER INTO CARTON. LOAD GARMENTS INTO BOTTOM OPENING OF SHIPPING CARTON MAINTAINING PROPER FOLD AND ORIENTATION. ALL UPCs TO BE FACE DOWN WHEN PLACED INTO CARTON. THIS WILL ALLOW UPCs TO BE VISIBLE AFTER SHIPMENT WHEN THE TOP OF THE CARTON IS OPENED TO REMOVE GARMENTS. ONCE CARTON IS FULL, FOLD EXCESS CASE LINER OVER TO COVER GARMENTS ON BOTTOM. DO NOT TAPE OR TIE CASE LINER CLOSED. TAPE BOTTOM OF BOX AS INSTRUCTED ON STANDARD CARTON PAGE. FLIP BOX OVER SO IT REST ON THE BOTTOM AND PREPARE TO SHIP.

10/09/07

## VF JEANSWEAR - TOPS

## STANDARD CARTON TAPE &amp; MARK GUIDELINES

- OUTSIDE CARTON DIMENSIONS: **13" WIDE x 20" LONG x 11 ½" TALL.**
- PERFERRED PACKED WEIGHT = 33 LBS. PER BOX (NOT TO EXCEED 35 LBS.)
- CARTON STRENGTH = 40 ECT (EDGE CRUSH TEST) MINIMUM.



CASE LABEL (#20050091) PLACEMENT - These placements **MUST** be exact so the label can be scanned properly at the DC. Place label inside marked area on side of box that is opposite the open side.

TAPE MUST BE APPLIED AS SHOWN TO OPEN END AND END WITH CASE LABEL.  
TAPE MUST NOT COVER CASE LABEL. NO STRAPS TO BE USED.

**Side Mark:**

LOT NO.:  
COLOR:  
SIZE:  
QTY:  
GROSS WEIGHT:  
NET WEIGHT:

**Front Mark:**

VF JEANSWEAR  
PO NUMBER: \_\_\_\_\_  
DESTINATION: \_\_\_\_\_  
MADE IN: \_\_\_\_\_  
SHIPPING ADDRESS: \_\_\_\_\_

SEE PO FOR  
PROPER SHIPPING  
INFORMATION  
USA

Op 890401 Des TOPS - STD PACK &amp; CARTON INFO - INDIVIDUAL POLYBA

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Page Type: Measurement Specification

Page Name: Measurement Spec Page

PGModified By: clappj 02-12-2008 09:08 AM

## Finished

No.	POM	Description Variation	REG/M	[REG/L]	REG/XL	REG/XXL	TAL/LT	TAL/XLT	TAL/2XT	TAL/3XT	BIG/3X	BIG/4X	
1	FTLH	FRONT LENGTH- CENTER	28 1/2	28 3/4	29 1/8	29 3/8	30 1/4	30 5/8	30 7/8	31 1/4	29 3/4	30	
2	BKLH	BACK LENGTH - CENTERBACK	33 5/8	34	34 3/8	34 3/4	35 1/2	35 7/8	36 1/4	36 5/8	35 1/8	35 1/2	
3	CHST	CHEST - CIRCUMFERENCE	51 3/8	55 3/8	59 3/8	63 3/8	55 3/8	59 3/8	63 3/8	67 3/8	67 3/8	71 3/8	
4	WAST	WAIST - CIRCUMFERENCE @ NARROWEST POINT	48 3/8	52 7/8	57 3/8	61 3/8	52 7/8	57 3/8	61 3/8	65 3/8	65 3/8	69 3/8	
5	SWEP	SWEEP - CIRCUMFERENCE	50	54	58	62	54	58	62	66	66	70	
6	SHLD	WIDTH AT NATURAL SHOULDER	20 1/2	22	23 1/2	25	22	23 1/2	25	26 1/2	26 1/2	28	
7	ARMD	ARMHOLE CIRCUMFERENCE	22 3/8	23 3/8	24 3/8	25 3/8	23 3/8	24 3/8	25 3/8	26 3/8	26 3/8	27 3/8	
8	SLLH	SLEEVE LENGTH- CTR BACK TO END OF SLEEVE	34 5/8	35 1/8	35 5/8	36 1/8	37 1/8	37 1/8	37 1/8	37 1/8	36 1/8	36 1/8	
9	NECK	NECK OPENING (COLLAR AND COLLARBAND)	16 1/4	17 1/4	18 1/4	19 1/4	17 1/4	18 1/4	19 1/4	20 1/4	20 1/4	21 1/4	
10	CFLH	CUFF LENGTH	10 1/4	11	11	11 3/4	11	11	11 3/4	11 3/4	11 3/4	11 3/4	
11	SDSM	SIDSEAM	18 5/8	18 5/8	18 5/8	18 5/8	20 1/8	20 1/8	20 1/8	20 1/8	18 5/8	18 5/8	

### Remarks :

CUFF WIDTH: ALL SIZES 2 1/2"

HEX POCKET: ALL SIZES 5 1/2 X 5 1/2

FLAP: ALL SIZES 5 3/4 X 2 1/4

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No.	Date	User Id	Change Log
1	2/18/2008	aydelep	ADDED CARE CODE H TO FGG. WAS NOT AVAILABLE IN STRIDE ORIGINALLY
2	2/13/2008	aydelep	Stage of Development changed to Production from Development
3	2/6/2008	aydelep	Create Product Folder