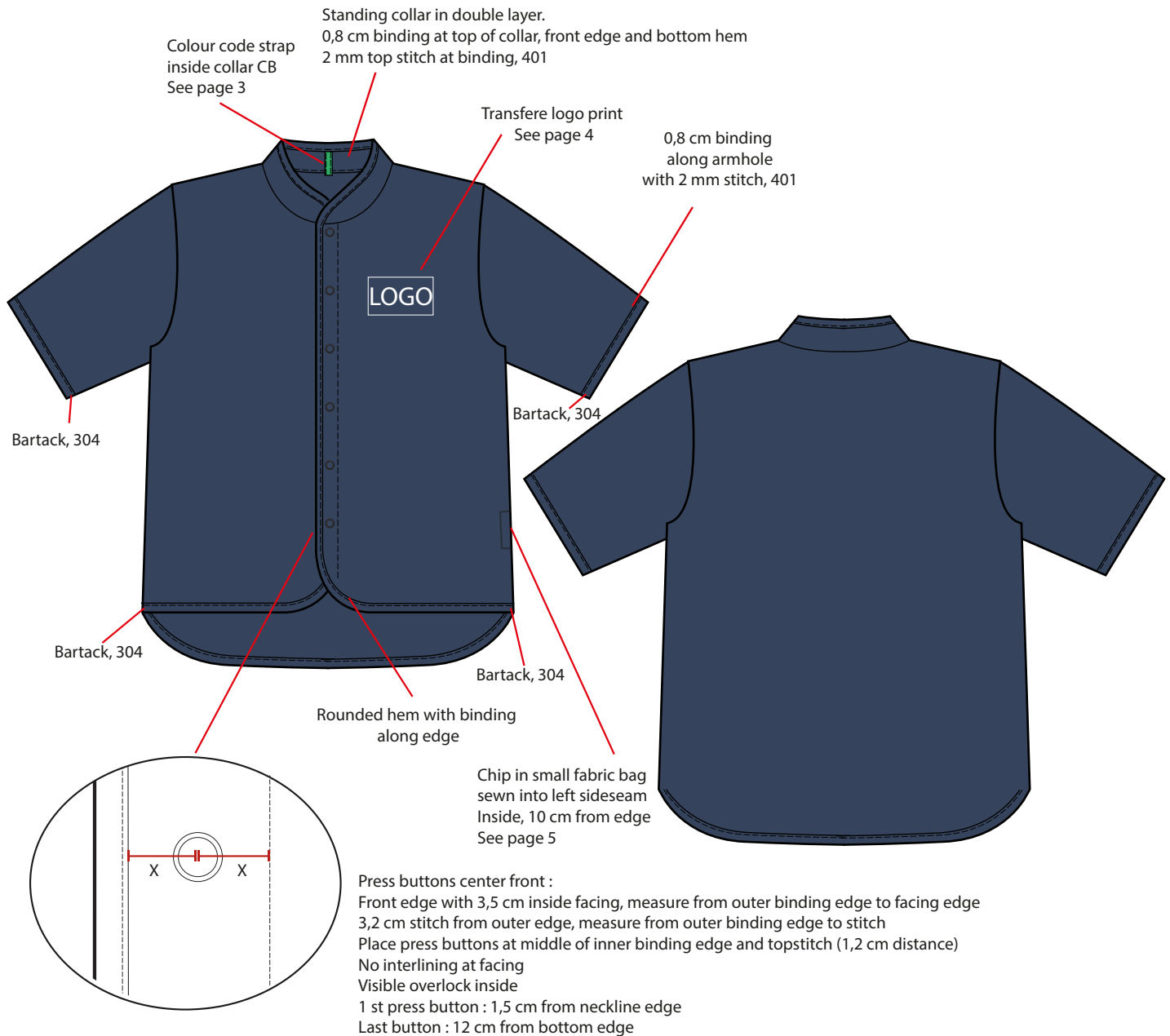


	<b>Technical sketch and info</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 1 of 9	
	Product type: <b>OP-Varmejakke</b>	 	

Not to scale



### Description:


Jacket with 3/4 sleeves  
Press buttons center front  
Binding along all edges  
logo at left front part  
Size indication strap inside at collar  
Chip inside left sideseam  
All color tone in tone

4-thread overlock at all seams, 514 :  
sideseam, armhole, shoulder, sleeve seam


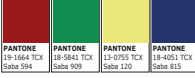




2 mm top stitch at all bindings, 504

Bartcks at sleeve opening and bottom  
of sideseam

Very important : tension at all binding edges must be correct.  
Plain and flat. Binding may not pull

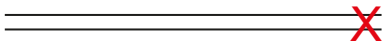
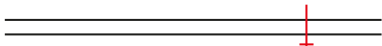
	<b>Material, trim, mashine</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 25.09.2024 io	
	Quality: 100% polyester	Page: 2 of 9	
	Product type: <b>OP-Varmejakke</b>		

## Material and trim table

Description	Article	Composition	Applied	Consumption
Fabric Pantone 19-4118 TCX	Quilted jaquard	100% Polyester * 275 gr/m2	Body and sleeves	
Colour code neck strap	Fine rib Colour: See page 3	100% Polyester	Inside neck to indicate size	
Press button	PRYM Ring press buttons	10 mm	Center front	6-7 pcs Silver 
Chip		Rubber chip	Inside left sideseam	1 pc
Thread	Tex 24 / TKT 120 Color tone in tone	100% Polyester	Top and bottom looper thread	
Thread	Tex ___ / TKT 100 Color tone in tone	100% Polyester	Topstitches, needle threads	
Logo Print	Color white	Transfer print	Left front	1 pc 

\* Polyester can be complete or partial replaced with recycled polyester rPET from textile waste systems if it still complies with the minimum requirement for the functional properties.




## Machine type requirements

Machine type	Stitch type	Applied	Technical drawing
4-thread overlock	514 8-9 st/2 cm	Assembling 7 mm width	
Chain stitch	401 7 st/2 cm	Topstitches at band	
Bar tack	304 15 st/1 cm	Sleeve opening, lower sideseam	
Steam Pressing	-	Intermediate pressing of all seams, finish press	-

## Needle system:

<b>301 + 304</b>	<b>= Canu: 20:05 1NM : 80 size : 12 (134 (R), 135x5, SY 1955, DPx5)</b>
<b>514</b>	<b>= Canu: 03:36 1NM : 80 size : 12 (B27, MY1023, UY 191 GS, DCx27)</b>

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	<b>Style description</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 3 of 9	
	Product type: <b>OP-Varmejakke</b>	 	

## Material and trim table

### Sizerange

XS/S, M/L, XL/2XL, 3XL/4XL

### General Seam allowance/tolerance:

All seams must not break by pulling or used.

Assambling : 10 mm +/- 1 mm

Topstitch: Single chain stitch at binding, 401 : 2 mm from edge, +/- 1 mm  
 Single chain stitch at size colour strap, 401 : 2 mm from edge, +/- 1 mm  
 Single stitch center front : 32 mm from front edge, +/- 1 mm

### Placement of pattern parts:

Grainline: Each pattern part must be placed on the fabric according to the grainline showing orientation and direction on the pattern part to avoid product from twisting in wash. Tolerance +/- 2 mm.

### Print:

Logo print : Left front part, see page 4

Size indication : Inside at neck, see below

### Size color strap, inside at neck :

Color as beside info

Strap width 1,2 cm

Strap length : match collar heighth

Sew on inner collar with 2 mm stitch

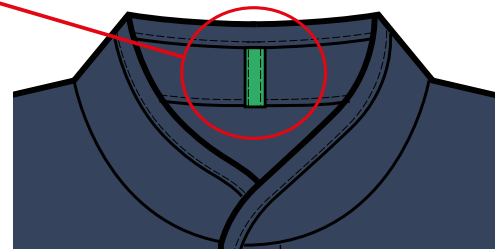
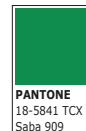
Place center back inside



XS/S

M/L

XL/2XL

3XL/4XL



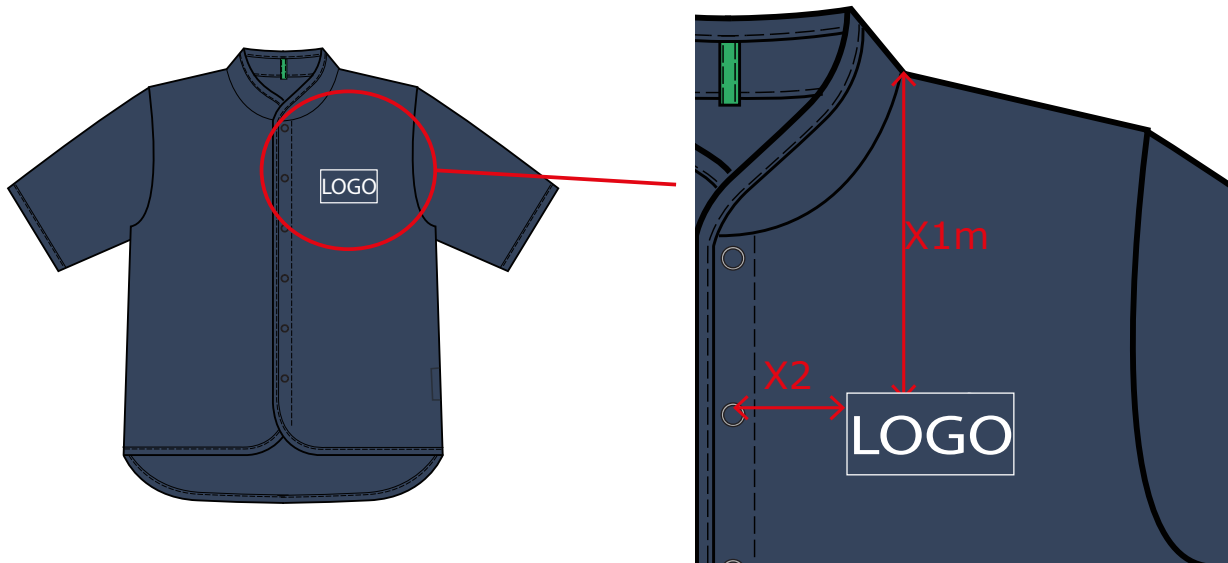
	<b>Logo Print instructions</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 4 of 9	
	Product type: <b>OP-Varmejakke</b>	 	

**Logo print :**  
Size 1:1, Transfer  
Color : White



**Logo print Placement, left front :**

Distance from high point shoulder to start of print : follow below mmc X1  
Distance from center of button to start of print : follow below mmc X2  
See sketch



	Measurements	Tol/cm	XS/S	M/L	XL/XXL	3/4XL	5/6XL
X1	HPS to top of print	0,5	18	20	21	22	23
X2	Center front to print start	0,2	6	6,5	7	7	7,5

**Applied:** Please use as small print press plate as possible, to avoid big flat area at fabric.  
Suggested size for print plate if possible: 5 cm x 8,5 cm.

**Print:** Transfer print technique: 210 degrees celsius, 12 sec., 4,6 bar.  
Print must not fade in industrial wash, tumbledry or bleach.

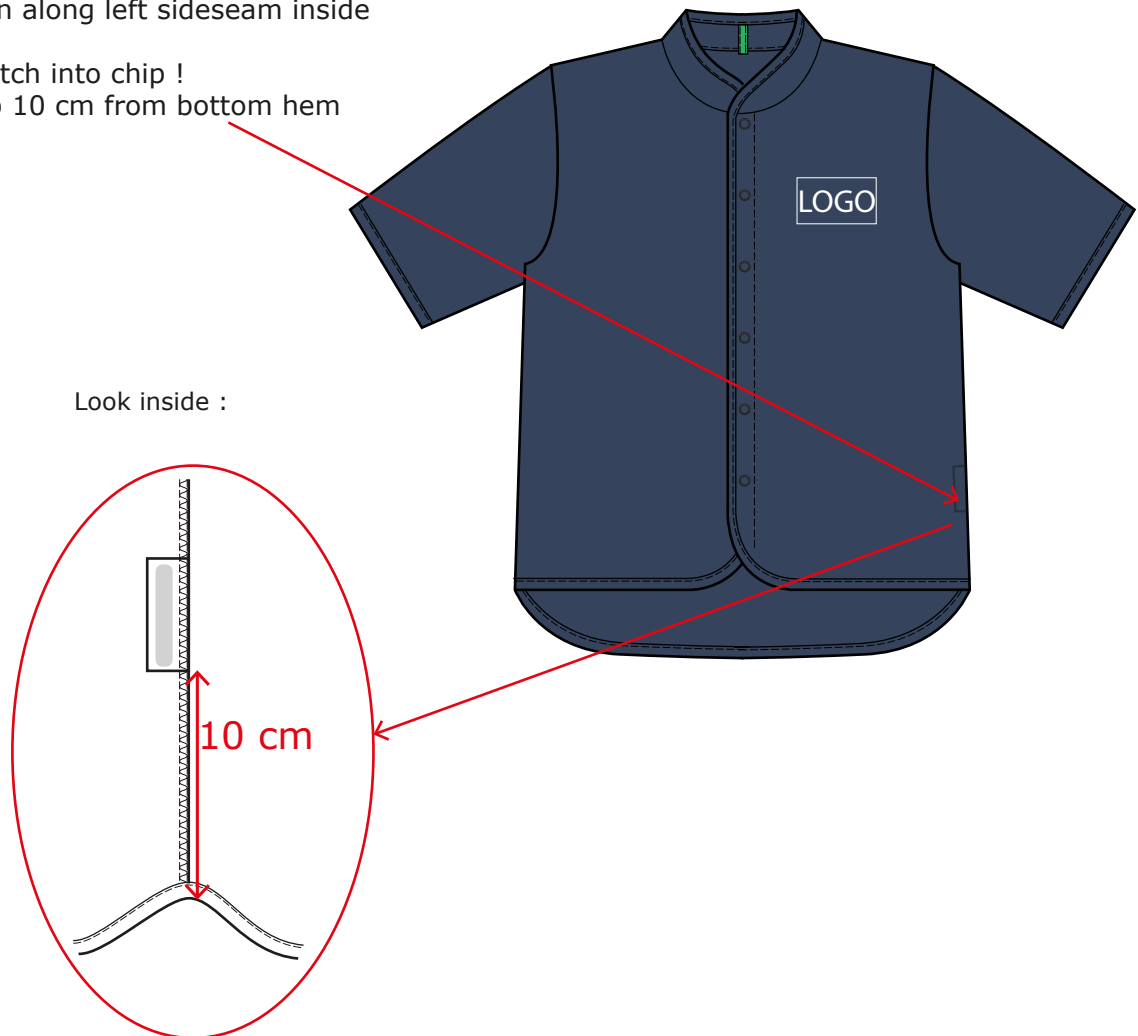
	<b>Chip placement</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 5 of 9	
	Product type: <b>OP-Varmejakke</b>	 	


### Chip placement


Chip placed inside at left sideseam

Place in a small fabric bag  
And fasten along left sideseam inside

Do not stitch into chip !  
Place chip 10 cm from bottom hem






	<b>Material Requirements</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 25.09.2024 io	
	Quality: 100% polyester	Page: 6 of 9	
	Product type: <b>OP-Varmejakke</b>		

Fabric	Test methods	Min. requirements
Knitting	Quilted jacquard	
Fiber content: 100% polyester *		Blended fibers tol. +/- 3% Max. shrinkage 5%
Certification:	Oko-tex	
Color:	Pantone 19-4118 TCX Dark Denim	
Mas per unit area Deviation of g/m2		300 g/m2
Surface fuzzing and pilling tendency Martindal	EN ISO 12945-1 3600 revs	4 (1-5 scale, 5 best value)
Bursting strength	DS/EN ISO 13938-1:1999	Strength kPa:670 / Heigth 60 mm
<b>Color fastness to</b>		
Perspiration	EN ISO 105 E-04 Staining: Change of shade :	4 4 (1-5 scale, 5 best value)
Washing (60 C)	EN ISO 105-C06:C2S Staining : Change of shade :	4 4 (1-5 scale, 5 best value)
Rubbing Dry	ISO 105-X12	4 (1-5 scale, 5 best value)
Rubbing Wet	ISO 105-X12	4 (1-5 scale, 5 best value)

\* Polyester can be complete or partial replaced with recycled polyester rPET from textile waste systems if it still complies with the minimum requirement for the functional properties.

**The textile has to meet the REACH directives**

**All materials must resist industrial washing 60 degrees, industrial steam pressure and tumbledry.  
Minimum wash : 100  
Antistatic. Brethable.**

	<b>Product instructions</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 7 of 9	
	Product type: <b>OP-Varmejakke</b>		
		 	

## Finish

### The following is not accepted:

No tacks/corrections are allowed on stitches.  
Broken stitches and open seams.  
Holes made by needles or other damages.  
Uneven stitches must not exceed the tolerances.  
Incorrect thread tension.  
Seam-ends longer than 0.2 cm.  
Seam assembling must not exceed the tolerance +/- 1 mm.

### Finish:

Control according to the measurement chart and for broken seams, fabric spots, dirt and faults.  
Remove loose thread ends and stickers.

## Washing, tumbledry and bleach

### General:

All materials must resist industrial washing and industrial tumbledry.  
No chemical acids known to cause allergy-substance or similar nuisance are allowed in the garments.

### Washing:

The product must resist washing at 60 degrees temperature in at least 15 min.

### Tumbledry:

The product must resist tumbledry at 80 degrees temperature in at least 20 min.  
180 degrees in the start up drying process

### Chemestry in washing:

The product must resist a treatment with PH up to 9,5.




## Size, look and shrinkage

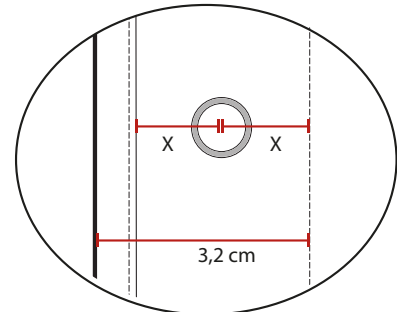
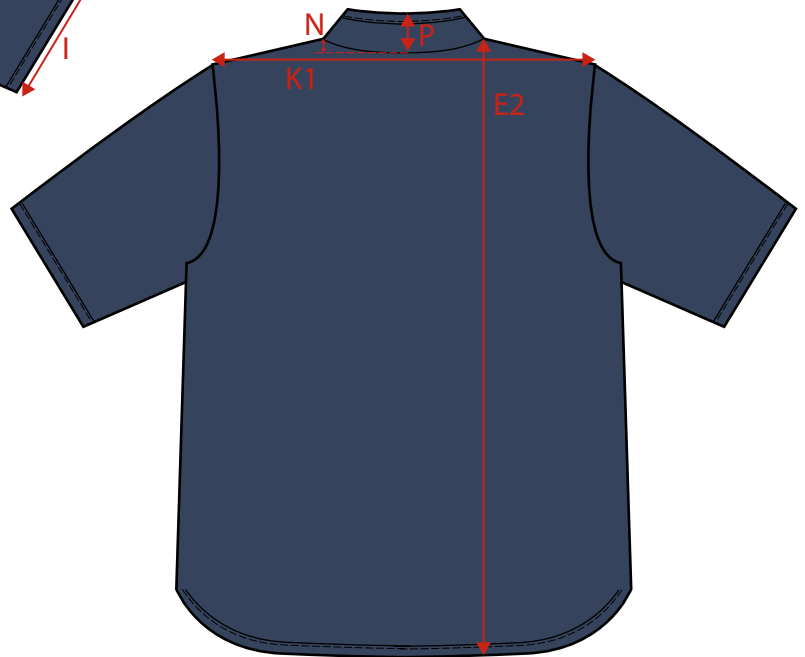
### General:

The appearance of the product must overall remain the same after wash, drying and in use.  
Please make sure the stitches do not break in use or by hard pulling.  
Stitches at waist and leg opening must be very stretchable and may not break by pulling  
Durability of the product is a very important factor for us.

Supplier is obliged to manufacture according to the style description

No alterations are permitted without a written agreement

	<b>How to measure</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 8 of 9	
	Product type: <b>OP-Varmejakke</b>	 	



Press buttons center front :

Front edge with 3,5 cm inside facing, measure from outer binding edge to facing edge

3,2 cm stitch from outer edge, measure from outer binding edge to stitch

Place press buttons at middle of inner binding edge and topstitch (1,2 cm distance)

No interlining at facing

Visible overlock inside

1 st press button : 1,5 cm from neckline edge

Last button : 12 cm from bottom edge





	<b>Measurements</b>	Style no : ?	
	Size: XS/S, M/L, XL/XXL, 3/4XL	Date: 29.04.2024 io	
	Quality: 100% polyester	Page: 9 of 9	
	Product type: <b>OP-Varmejakke</b>	 	

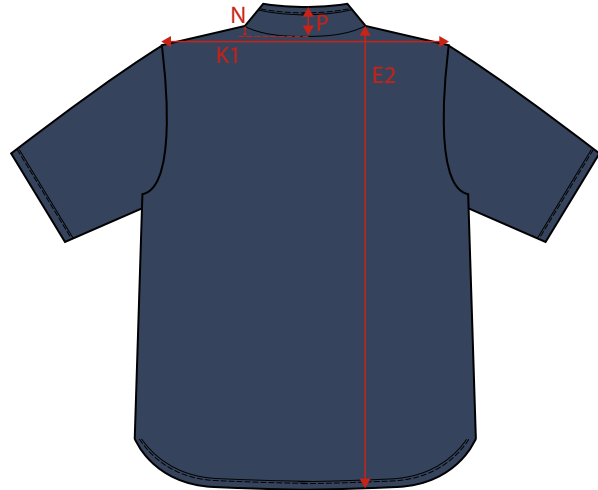
MEASUREMENTS FOR JACKET		BEFORE WASH, incl shrink					SHRINK
		Tol/cm	XS/S	M/L	XL/XXL	3/4XL	
A	½ Chest	1	59,4	66,6	73,7	80,9	10%
D	½ Bottom	1	59,4	66,6	73,7	80,9	10%
E1	Front length HPS	1	69,7	73,8	77,9	82,0	-2,5%
E2	Back length HPS	1	80,0	84,1	88,2	92,3	-2,5%
F	Sleeve length	1	32,3	32,8	33,3	33,8	-2,5%
G	Armpit	0,5	26,1	27,7	29,7	31,8	-2,5%
T	Sleeve cap heigth	0,5	13,3	14,4	15,4	16,4	-2,5%
H	½ Sleeve across	0,5	23,7	25,3	27,5	29,7	10%
I	½ sleeve opening	0,5	17,6	19,3	21,5	23,7	10%
J	Neck opening	0,5	20,9	22,0	23,1	24,2	10%
K1	Full shoulder, straight	1	47,3	51,7	56,1	60,5	10%
M	Neckdrop CF	0,5	10,5	10,5	10,5	11	0%
N	Neckdrop CB	0,5	1,5	1,5	1,5	2	0%
P	Collar heigth CB incl tape	0,2	5,5	5,5	5,5	5,5	0%
R	Tape heigth	0,2	0,8	0,8	0,8	0,8	0%
S	Chip inside at left sideseam	0,5	10	10	10	10	0%
	Buttons center front	0	6	6	6	7	0%
X1	HPS to top of print	0	18,5	20,5	21,5	22,6	-2,5%
X2	Center front to print start	0	6	6,5	7	7	0%

MEASUREMENTS FOR JACKET		AFTER WASH				
		Tol/cm	XS/S	M/L	XL/XXL	3/4XL
A	½ Chest	1	54	60,5	67	73,5
D	½ Bottom	1	54	60,5	67	73,5
E1	Front length HPS	1	68	72	76	80
E2	Back length HPS	1	78	82	86	90
F	Sleeve length	1	31,5	32	32,5	33
G	Armpit	0,5	25,5	27	29	31
T	Sleeve cap heigth	0,5	13	14	15	16
H	½ Sleeve across	0,5	21,5	23	25	27
I	½ sleeve opening	0,5	16	17,5	19,5	21,5
J	Neck opening	0,5	19	20	21	22
K1	Full shoulder, straight	1	43	47	51	55
M	Neckdrop CF	0,5	9,5	10,5	11,5	12,5
N	Neckdrop CB	0,5	1,5	1,5	1,5	2
P	Collar heigth CB incl tape	0,2	5,5	5,5	5,5	5,5
R	Tape heigth	0,2	0,8	0,8	0,8	0,8
S	Chip inside at left sideseam	0,5	10	10	10	10
	Buttons center front	0	6	6	6	7
X1	HPS to top of print	0,5	18	20	21	22
X2	Center front to print start	0,2	6	6,5	7	7

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	<b>Intern test side</b>	<b>OP-Varmejakke</b>	Testen er udført af :
	<b>FØR VASK</b> XS/S, M/L, XL/XXL, 3/4XL	Date: 18.04.2024	
		 	Dato :

Measurements	Tol/cm	XS/S	XS/S	XS/S	M/L	M/L	M/L	XL/XXL	XL/XXL	XL/XXL	3/4XL	3/4XL	3/4XL	SHRINK
½ Chest	1	59,4			66,6			73,7			80,9			10%
½ Bottom	1	59,4			66,6			73,7			80,9			10%
Front length HPS	1	69,7			73,8			77,9			82,0			-2,5%
Back length HPS	1	80,0			84,1			88,2			92,3			-2,5%
Sleeve length	1	32,3			32,8			33,3			33,8			-3%
Armpit	0,5	26,1			27,7			29,7			31,8			-3%
½ Sleeve across	0,5	23,7			25,3			27,5			29,7			10%
½ sleeve opening	0,5	17,6			19,3			21,5			23,7			10%
Neck opening	0,5	20,9			22,0			23,1			24,2			10%
Full shoulder, straight	1	47,3			51,7			56,1			60,5			10%
Neckdrop CF	0,5	10,5			10,5			10,5			11,0			0%
Neckdrop CB	0,5	1,5			1,5			1,5			2			0%
Collar heigth CB incl tape	0,2	5,5			5,5			5,5			5,5			0%
Tape heigth	0,2	0,8			0,8			0,8			0,8			0%
Chip inside at left sideseam	0,5	10			10			10			10			0%
Buttons center front	0	6			6			6			7			0%
HPS to top of print	0	18,5			20,5			21,5			22,6			-3%
Center front to print start	0	6			6,5			7			7			0%



**Test type : sæt X**



- Første gangs prøve / first sample
- Godkendelses prøve / approval sample
- Alle størrelser / Size set
- Før produktions prøve / PP sample
- Afskibnings prøve / Shipment sample
- Lager kontrol / Stock control
- Andet \_\_\_\_\_

- Prøven er vasket / washed
- Prøven er ikke vasket / unwashed

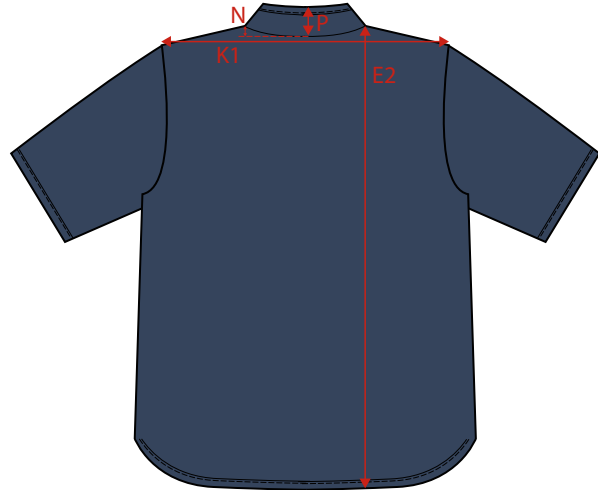
**Test : sæt X**

- 1 : Opmål prøven og indtast i skemaet herunder, indtast udfor anviste størrelser
- 2 : Er båndet langs kanterne glat / flat og flot
- 3 : Er der løse tråde
- 6 : Er der chip indvendig i venstre sidesøm
- 7 : Er der print på venstre forstykke
- 8 : Er der størrelses farve markering i nakken
- 9 : Bemærkninger \_\_\_\_\_

- |                             |                              |
|-----------------------------|------------------------------|
| <input type="checkbox"/> Ja | <input type="checkbox"/> Nej |
| <input type="checkbox"/> Ja | <input type="checkbox"/> Nej |
| <input type="checkbox"/> Ja | <input type="checkbox"/> Nej |
| <input type="checkbox"/> Ja | <input type="checkbox"/> Nej |
| <input type="checkbox"/> Ja | <input type="checkbox"/> Nej |

	<b>Intern test side</b>	<b>OP-Varmejakke</b>	Testen er udført af :
	<b>EFTER VASK</b> XS/S, M/L, XL/XXL, 3/4XL	Date: 18.04.2024	
		 	Dato :

Measurements	Tol/cm	XS/S			M/L			XL/XXL			3/4XL		
		XS/S	XS/S	XS/S	M/L	M/L	M/L	XL/XXL	XL/XXL	XL/XXL	3/4XL	3/4XL	3/4XL
A ½ Chest	1	54			60,5			67			73,5		
D ½ Bottom	1	54			60,5			67			73,5		
E1 Front length HPS	1	68			72			76			80		
E2 Back length HPS	1	78			82			86			90		
F Sleeve length	1	31,5			32			32,5			33		
G Armpit	0,5	25,5			27			29			31		
H ½ Sleeve across	0,5	21,5			23			25			27		
I ½ sleeve opening	0,5	16			17,5			19,5			21,5		
J Neck opening	0,5	19			20			21			22		
K1 Full shoulder, straight	1	43			47			51			55		
M Neckdrop CF	0,5	9,5			10,5			11,5			12,5		
N Neckdrop CB	0,5	1,5			1,5			1,5			2		
P Collar heigth CB incl tape	0,2	5,5			5,5			5,5			5,5		
R Tape heigth	0,2	0,8			0,8			0,8			0,8		
S Chip inside at left sideseam	0,5	10			10			10			10		
Buttons center front	0	6			6			6			7		
X1 HPS to top of print	0,5	18			20			21			22		
X2 Center front to print start	0,2	6			6,5			7			7		



**Test type : sæt X**

- Første gangs prøve / first sample
- Godkendelses prøve / approval sample
- Alle størrelser / Size set
- Før produktions prøve / PP sample
- Afskibnings prøve / Shipment sample
- Lager kontrol / Stock control
- Andet \_\_\_\_\_

- Prøven er vasket / washed
- Prøven er ikke vasket / unwashed

**Test : sæt X**

- 1 : Opmål prøven og indtast i skemaet herunder, indtast udfor anviste størrelser
- 2 : Er båndet langs kanterne glat / flat og flot
- 3 : Er der løse tråde
- 6 : Er der chip indvendig i venstre sidesøm
- 7 : Er der print på venstre forstykke
- 8 : Er der størrelses farve markering i nakken
- 9 : Bemærkninger \_\_\_\_\_

- Ja                       Nej
- Ja                       Nej
- Ja                       Nej
- Ja                       Nej
- Ja                       Nej