

FIG. 1

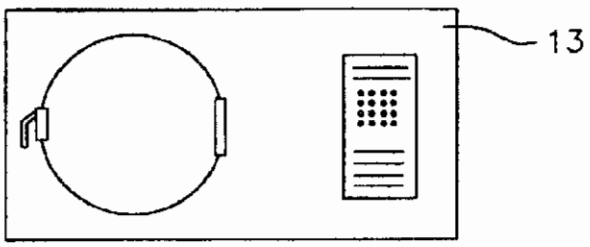


FIG. 2

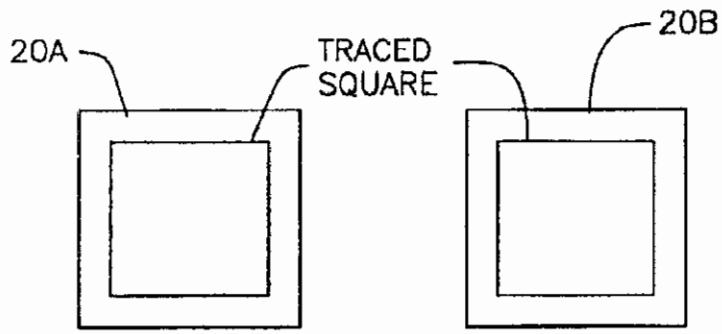


FIG. 3

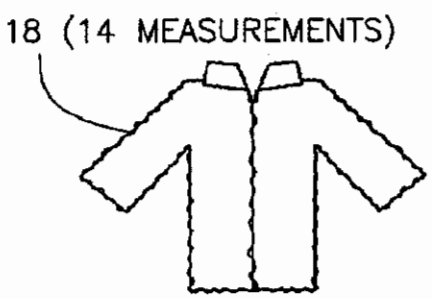


FIG. 4A

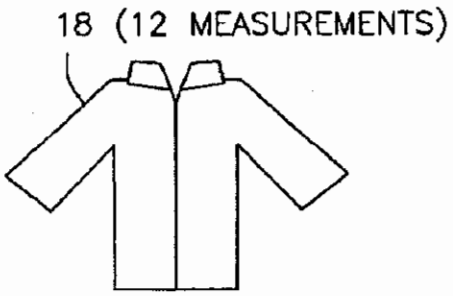


FIG. 4B

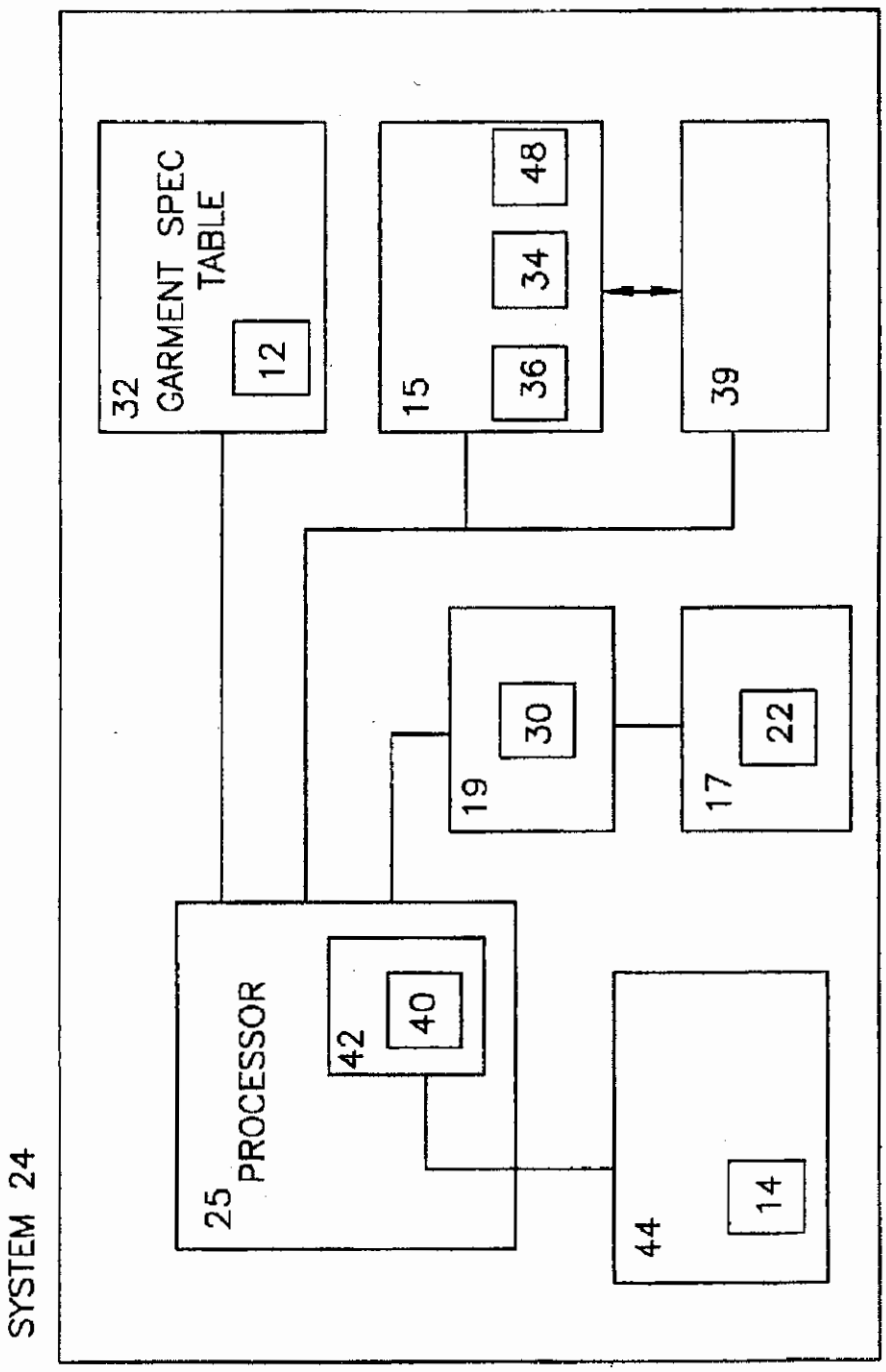

SYSTEM 24
32
GARMENT SPEC TABLE
12
15
48
34
36
39
19
30
17
22
25
PROCESSOR
42
40
44
14

FIG. 5

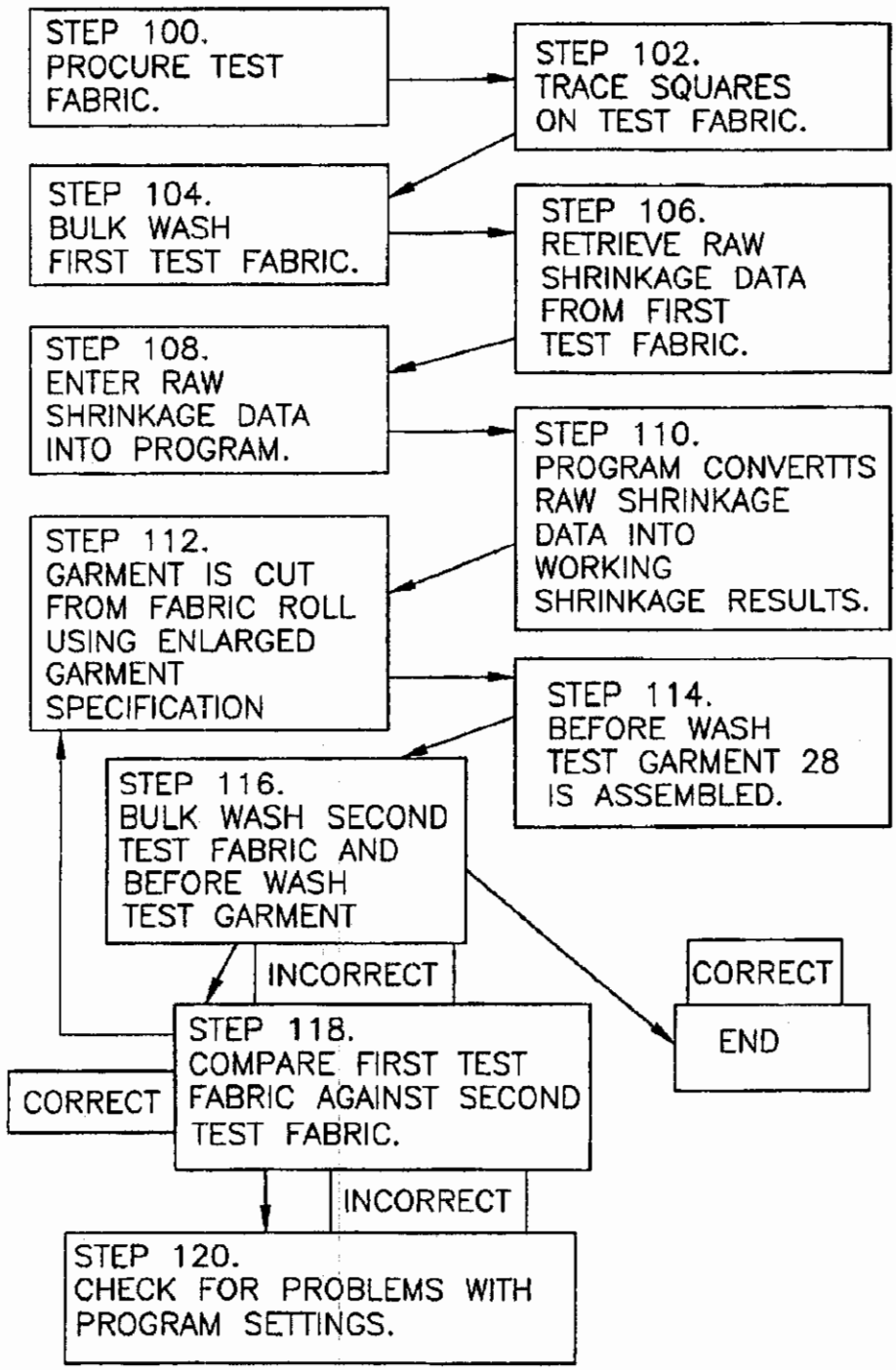

STEP 100.
PROCURE TEST FABRIC.
STEP 102.
TRACE SQUARES ON TEST FABRIC.
STEP 104.
BULK WASH FIRST TEST FABRIC.
STEP 106.
RETRIEVE RAW SHRINKAGE DATA FROM FIRST TEST FABRIC.
STEP 108.
ENTER RAW SHRINKAGE DATA INTO PROGRAM.
STEP 110.
PROGRAM CONVERTTS RAW SHRINKAGE DATA INTO WORKING SHRINKAGE RESULTS.
STEP 112.
GARMENT IS CUT FROM FABRIC ROLL USING ENLARGED GARMENT SPECIFICATION
STEP 114.
BEFORE WASH TEST GARMENT 28 IS ASSEMBLED.
STEP 116.
BULK WASH SECOND TEST FABRIC AND BEFORE WASH TEST GARMENT
INCORRECT
CORRECT
END
STEP 118.
COMPARE FIRST TEST FABRIC AGAINST SECOND TEST FABRIC.
CORRECT
INCORRECT
STEP 120.
CHECK FOR PROBLEMS WITH PROGRAM SETTINGS.

FIG. 6

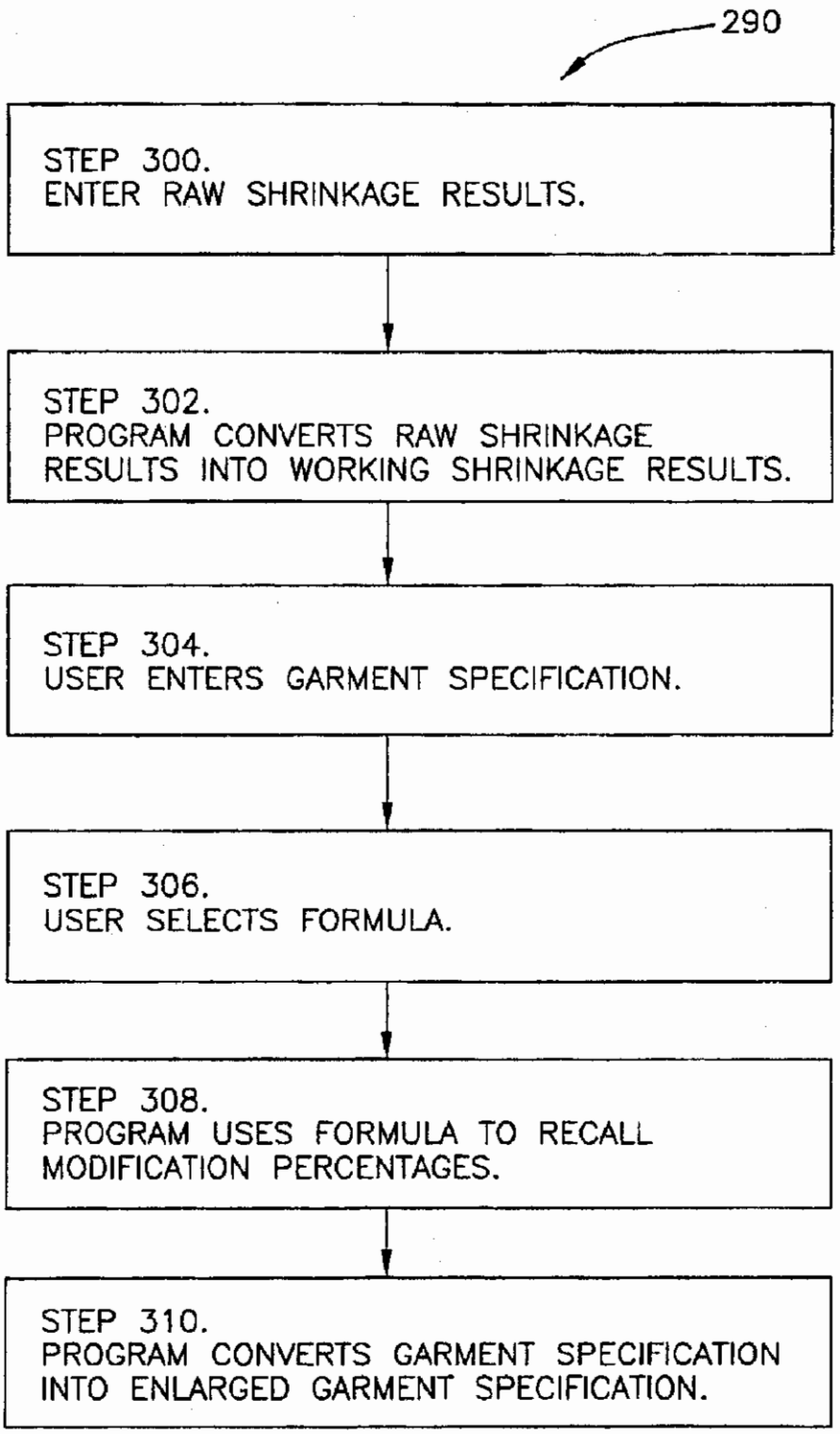

290
STEP 300.
ENTER RAW SHRINKAGE RESULTS.
STEP 302.
PROGRAM CONVERTS RAW SHRINKAGE RESULTS INTO WORKING SHRINKAGE RESULTS.
STEP 304.
USER ENTERS GARMENT SPECIFICATION.
STEP 306.
USER SELECTS FORMULA.
STEP 308.
PROGRAM USES FORMULA TO RECALL MODIFICATION PERCENTAGES.
STEP 310.
PROGRAM CONVERTS GARMENT SPECIFICATION INTO ENLARGED GARMENT SPECIFICATION.

FIG. 7

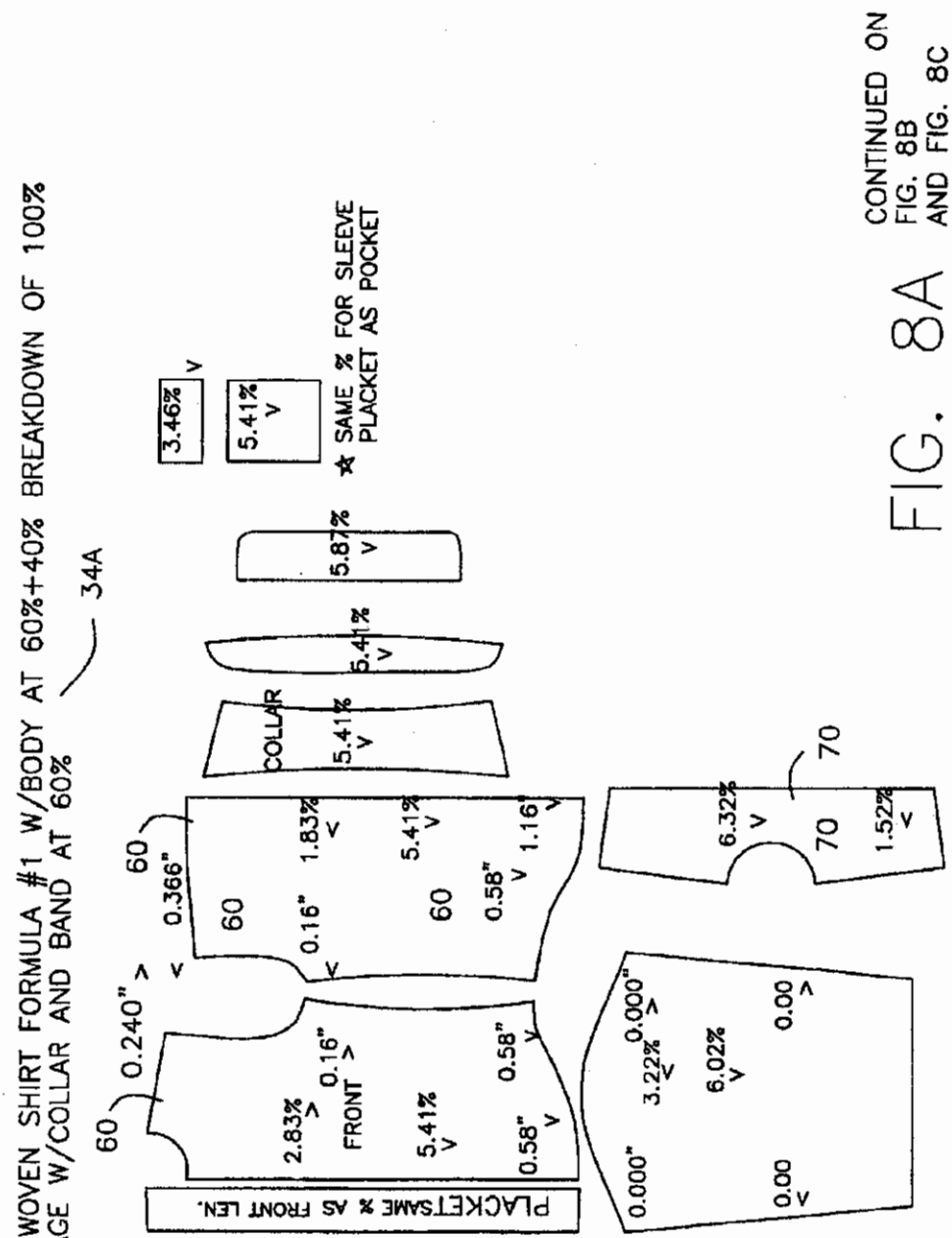
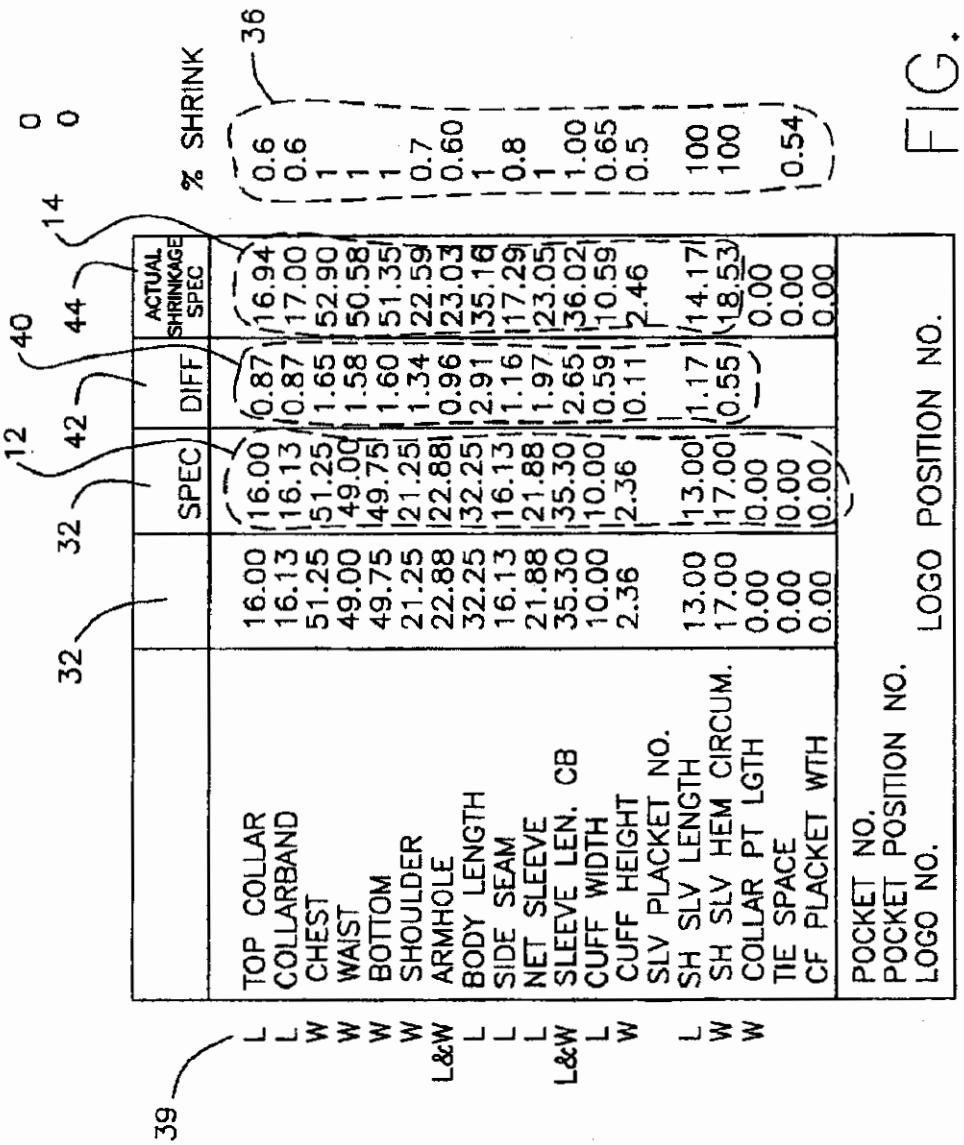


FIG. 8A

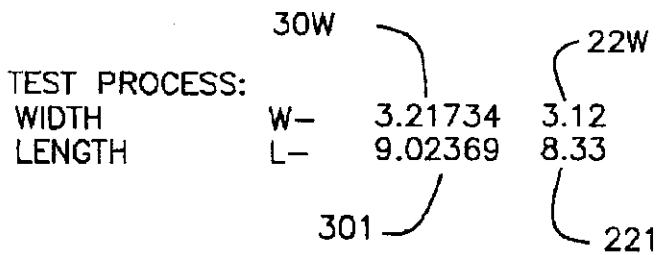
CONTINUED ON FIG. 8B AND FIG. 8C



			SPEC	DIFF	ACTUAL SHRINKAGE SPEC	% SHRINK
L	TOP COLLAR	16.00	16.00	0.87	16.94	0.6
L	COLLARBAND	16.13	16.13	0.87	17.00	0.6
W	CHEST	51.25	51.25	1.65	52.90	1
W	WAIST	49.00	49.00	1.58	50.58	1
W	BOTTOM	49.75	49.75	1.60	51.35	1
W	SHOULDER	21.25	21.25	1.34	22.59	0.7
L&W	ARMHOLE	22.88	22.88	0.96	23.03	0.60
L	BODY LENGTH	32.25	32.25	2.91	35.16	1
L	SIDE SEAM	16.13	16.13	1.16	17.29	0.8
L	NET SLEEVE	21.88	21.88	1.97	23.05	1
L&W	SLEEVE LEN. CB	35.30	35.30	2.65	36.02	1.00
L	CUFF WIDTH	10.00	10.00	0.59	10.59	0.65
W	CUFF HEIGHT	2.36	2.36	0.11	2.46	0.5
	SLV PLACKET NO.					
L	SH SLV LENGTH	13.00	13.00	1.17	14.17	100
W	SH SLV HEM CIRCUM.	17.00	17.00	0.55	18.53	100
W	COLLAR PT LGTH	0.00	0.00		0.00	
	TIE SPACE	0.00	0.00		0.00	0.54
	CF PLACKET WTH	0.00	0.00		0.00	
	POCKET NO.					
	POCKET POSITION NO.					
	LOGO NO.		LOGO POSITION NO.			

FIG. 8B

CONTINUED ON FIG. 8C



FRONT CALC	NEW M	DIFF	1X3 M	%
F&B NECK (W)	2.00	0.05	2.75	60
SHOULDER (L)	9.09	0.47	0.025	60
SHOULDER (W)	8.79	0.17	0.025	60
F ARMHOLE (L)	7.91	0.41	7.5	60
F CHEST (W)	13.03	0.41	12.03	100
SIDE SEAM (L)	19.30	1.30	10	80
FRONT (L)	28.95	1.95	27	80

FRONT CALC	NEW M	DIFF	1X3 M	%
HALF YOKE (L)	11.83	0.70	11.125	70
HALF YOKE (W)	11.21	0.21	11	60
HALF TOP BACK	11.47	0.22	11.25	60
B ARM HOLE (L)	9.49	0.49	9	60
B CHEST (W)	14/97	0.47	14.5	100
SLV HEAD (L)	6.72	0.47	6.25	100
SLEEVE (W)	9/81	0.31	9.5	100
NET SLV (L)	24.12	2.00	22.125	100

FIG. 8C

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MASTER WOVEN SHIRT FORMULA #2 W/BODY AT 60%+40% BREAKDOWN OF 100%
SHRINKAGE W/COLLAR AND BAND AT 65%

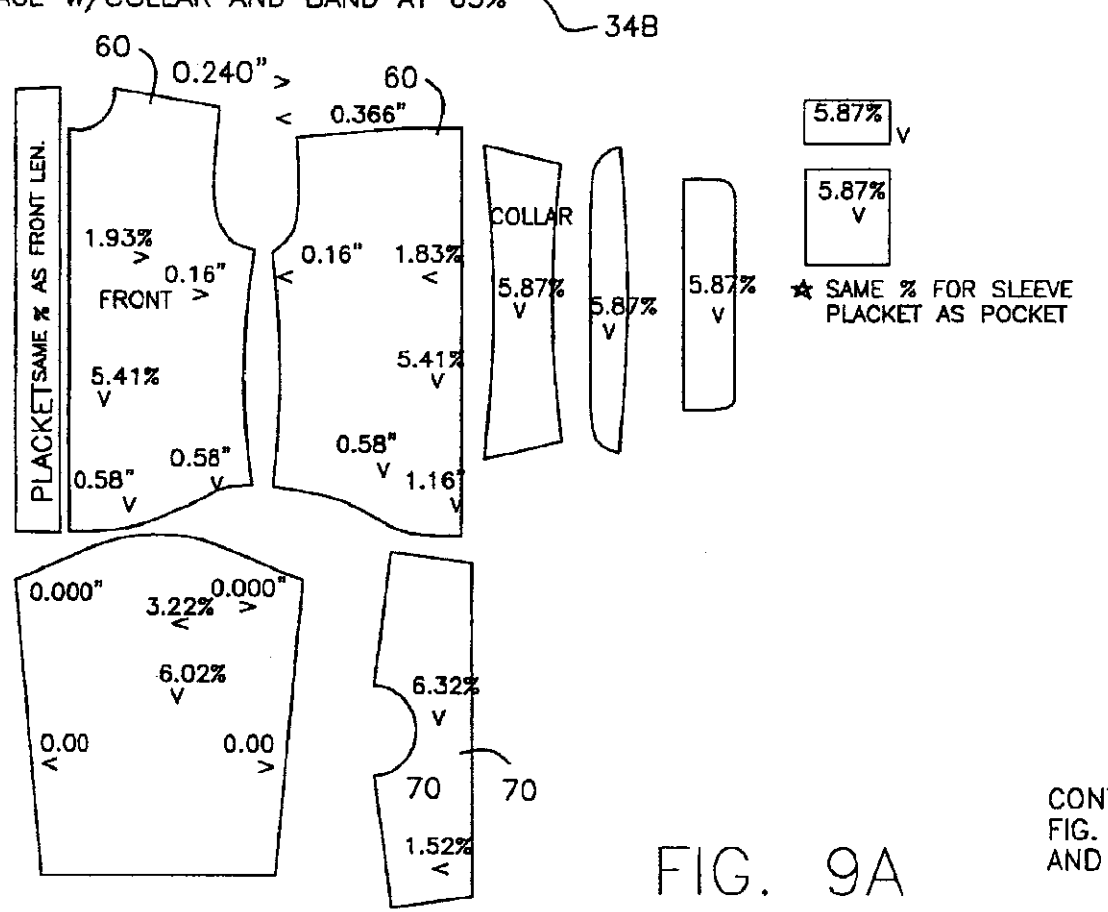


FIG. 9A

CONTINUED ON
FIG. 9B
AND FIG. 9C

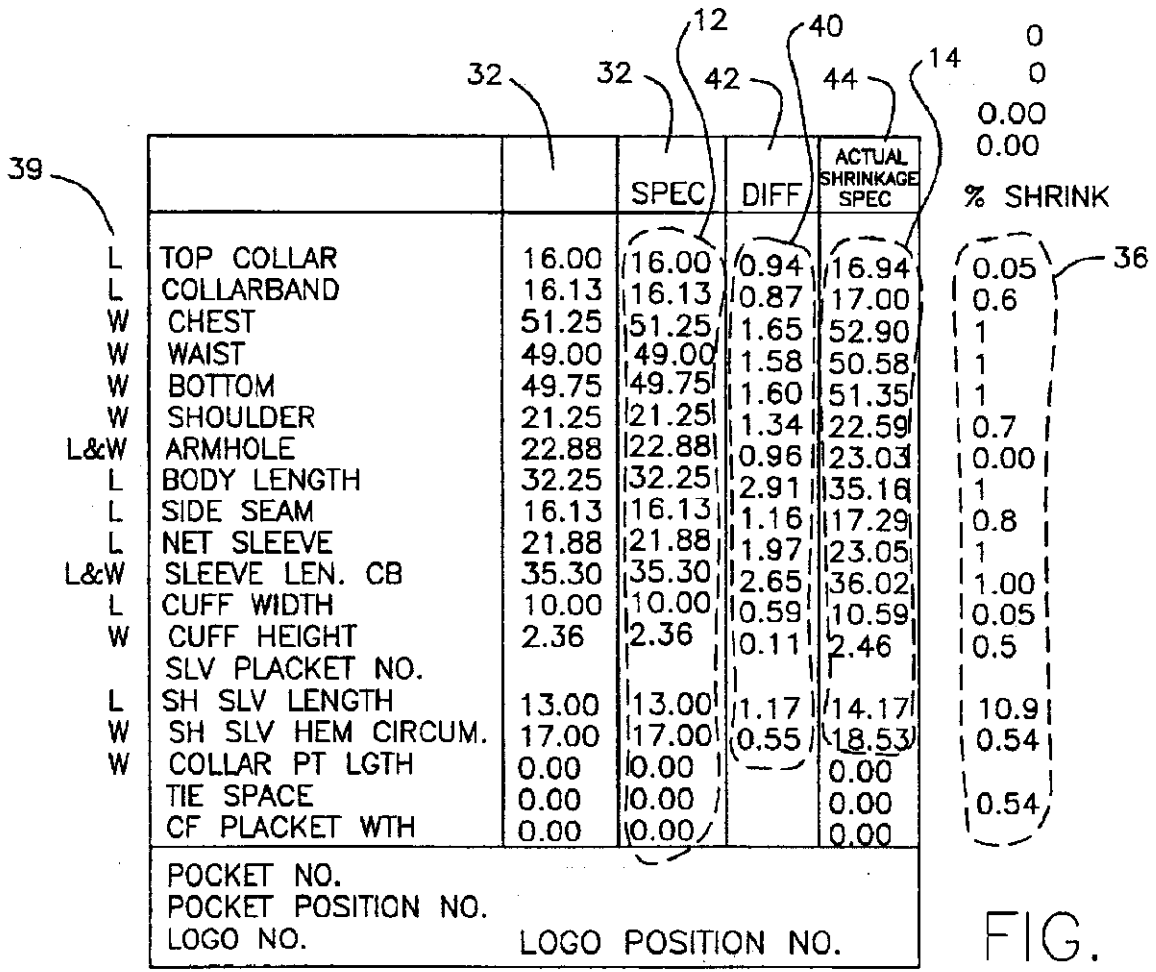
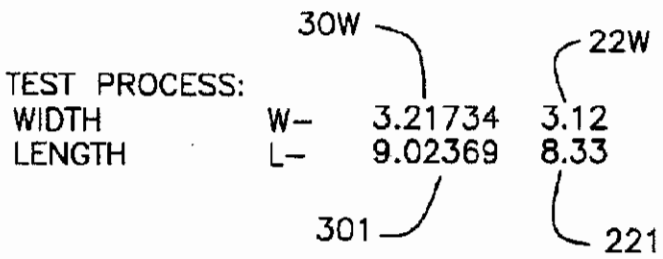


FIG. 9B

CONTINUED ON FIG. 9C



FRONT CALC	NEW M	DIFF	1X3 M	%
F&B NECK (W)	2.00	0.05	2.75	90
SHOULDER (L)	9.09	0.47	0.025	40
SHOULDER (W)	8.79	0.17	0.025	90
F ARMHOLE (L)	7.91	0.41	7.5	90
F CHEST (W)	13.03	0.41	12.03	106
SIDE SEAM (L)	19.30	1.30	10	90
FRONT (L)	28.95	1.95	27	90

FRONT CALC	NEW M	DIFF	1X3 M	%
HALF YOKE (L)	11.83	0.70	11.125	70
HALF YOKE (W)	11.21	0.21	11	60
HALF TOP BACK	11.47	0.22	11.25	60
B ARM HOLE (L)	9.49	0.49	9	60
B CHEST (W)	14/97	0.47	14.5	100
SLV HEAD (L)	6.72	0.47	6.25	100
SLEEVE (W)	9/81	0.31	9.5	100
NET SLV (L)	24.12	2.00	22.125	100

FIG. 9C

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MASTER WOVEN SHIRT FORMULA #3 W/BODY AT 60%+40% BREAKDOWN OF 100%
SHRINKAGE W/COLLAR AND BAND AT 70%

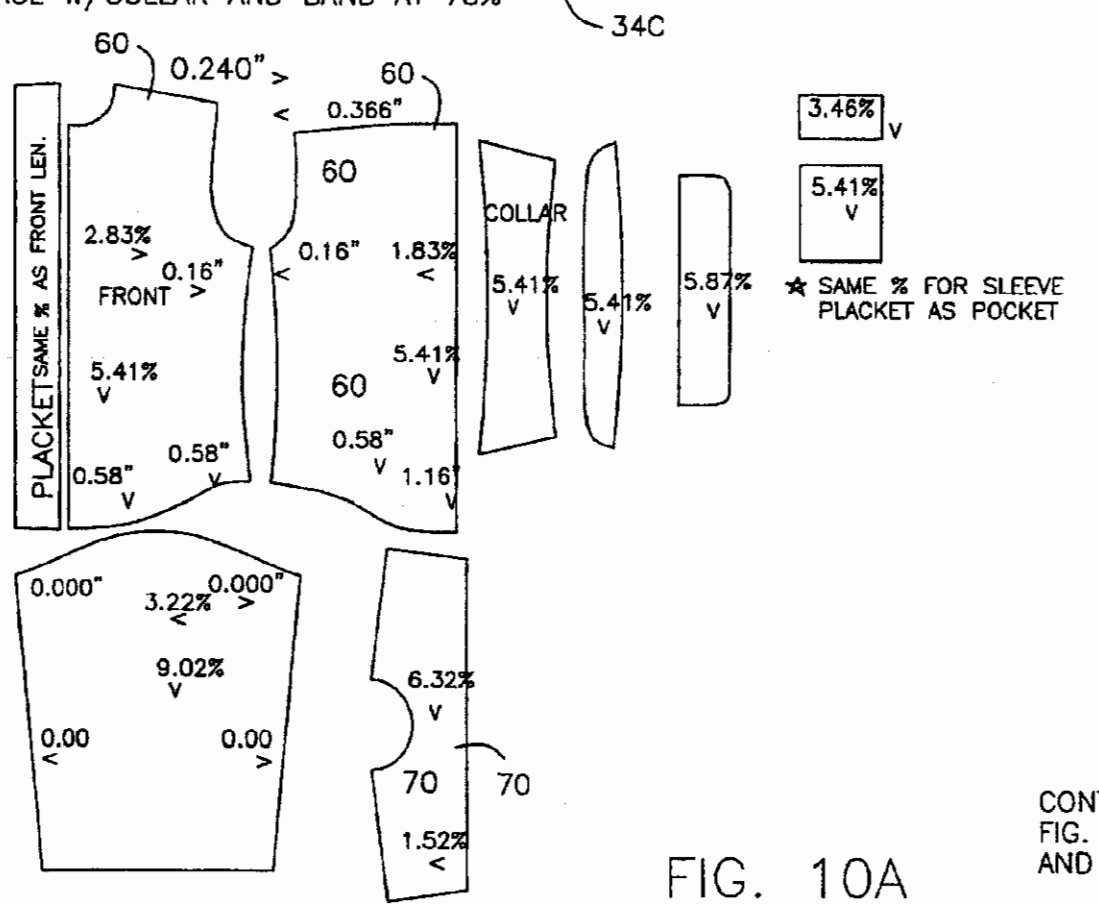


FIG. 10A

CONTINUED ON
FIG. 10B
AND FIG. 10C

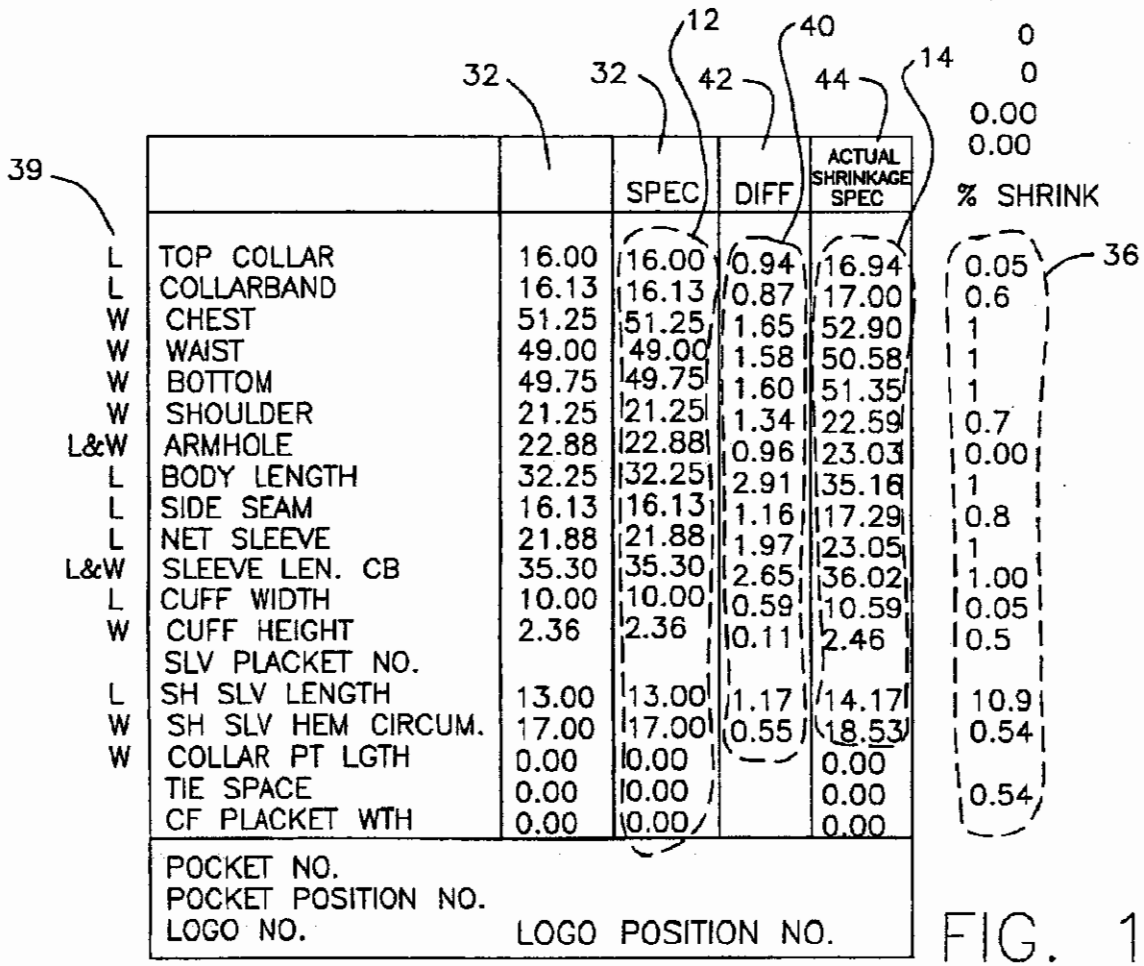
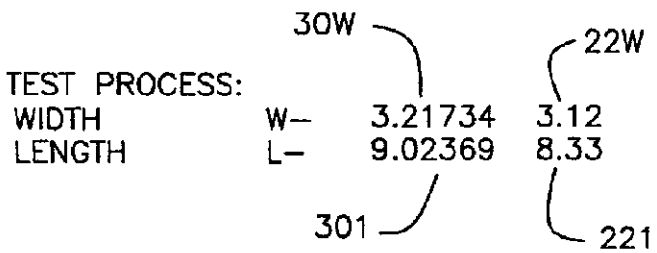


FIG. 10B

CONTINUED ON FIG. 10C



FRONT CALC	NEW M	DIFF	1X3 M	%
F&B NECK (W)	2.00	0.05	2.75	60
SHOULDER (L)	9.09	0.47	0.025	60
SHOULDER (W)	8.79	0.17	0.025	60
F ARMHOLE (L)	7.91	0.41	7.5	60
F CHEST (W)	13.03	0.41	12.03	100
SIDE SEAM (L)	19.30	1.30	10	80
FRONT (L)	28.95	1.95	27	80

FRONT CALC	NEW M	DIFF	1X3 M	%
HALF YOKE (L)	11.83	0.70	11.125	70
HALF YOKE (W)	11.21	0.21	11	60
HALF TOP BACK	11.47	0.22	11.25	60
B ARM HOLE (L)	9.49	0.49	9	60
BCHEST (W)	14/97	0.47	14.5	100
SLV HEAD (L)	6.72	0.47	6.25	100
SLEEVE (W)	9/81	0.31	9.5	100
NET SLV (L)	24.12	2.00	22.125	100

FIG. 10C

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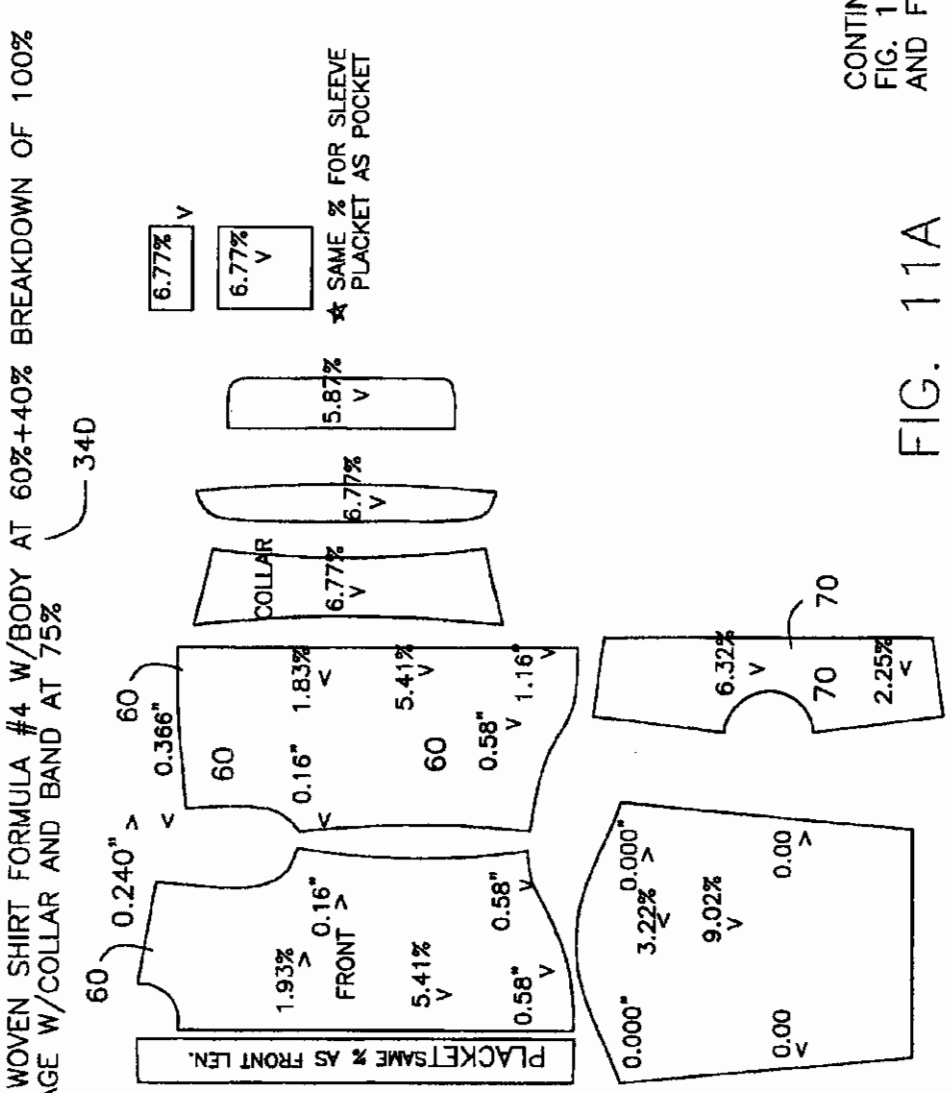


FIG. 11A

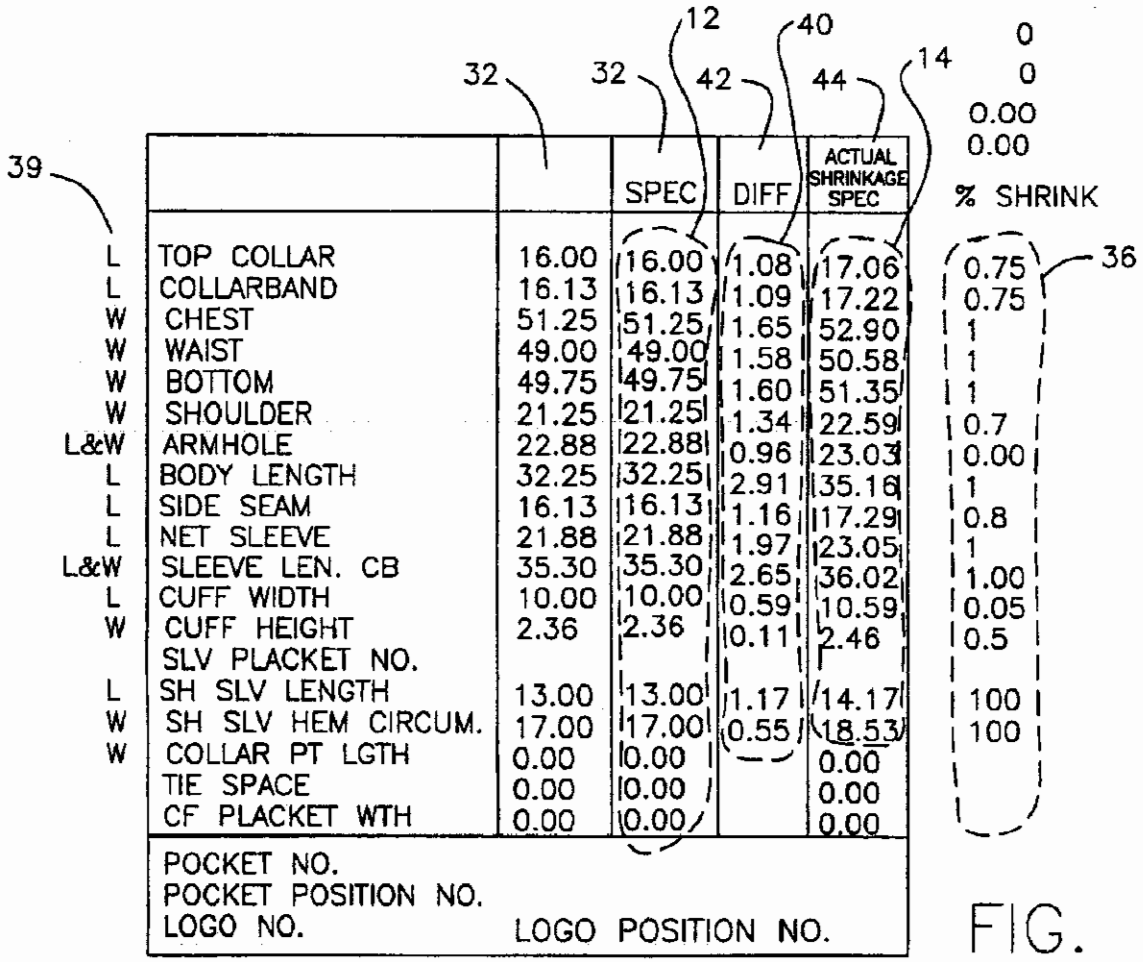
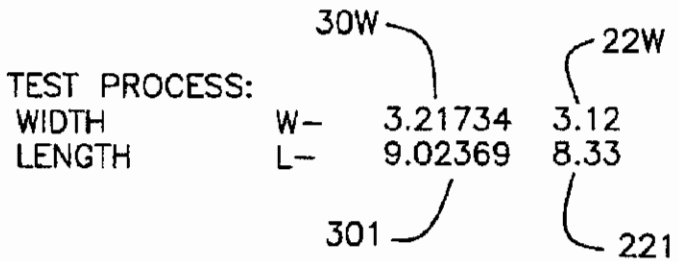


FIG. 11B

CONTINUED ON FIG. 11C



FRONT CALC	NEW M	DIFF	1X3 M	%
F&B NECK (W)	2.00	0.05	2.75	60
SHOULDER (L)	9.09	0.47	0.025	60
SHOULDER (W)	8.79	0.17	0.025	60
F ARMHOLE (L)	7.91	0.41	7.5	60
F CHEST (W)	13.03	0.41	12.03	100
SIDE SEAM (L)	19.30	1.30	10	80
FRONT (L)	28.95	1.95	27	80

FRONT CALC	NEW M	DIFF	1X3 M	%
HALF YOKE (L)	11.83	0.70	11.125	70
HALF YOKE (W)	11.21	0.21	11	60
HALF TOP BACK	11.47	0.22	11.25	60
B ARM HOLE (L)	9.49	0.49	9	60
BCHEST (W)	14/97	0.47	14.5	100
SLV HEAD (L)	6.72	0.47	6.25	100
SLEEVE (W)	9/81	0.31	9.5	100
NET SLV (L)	24.12	2.00	22.125	100

FIG. 11C

17 OCT 2005

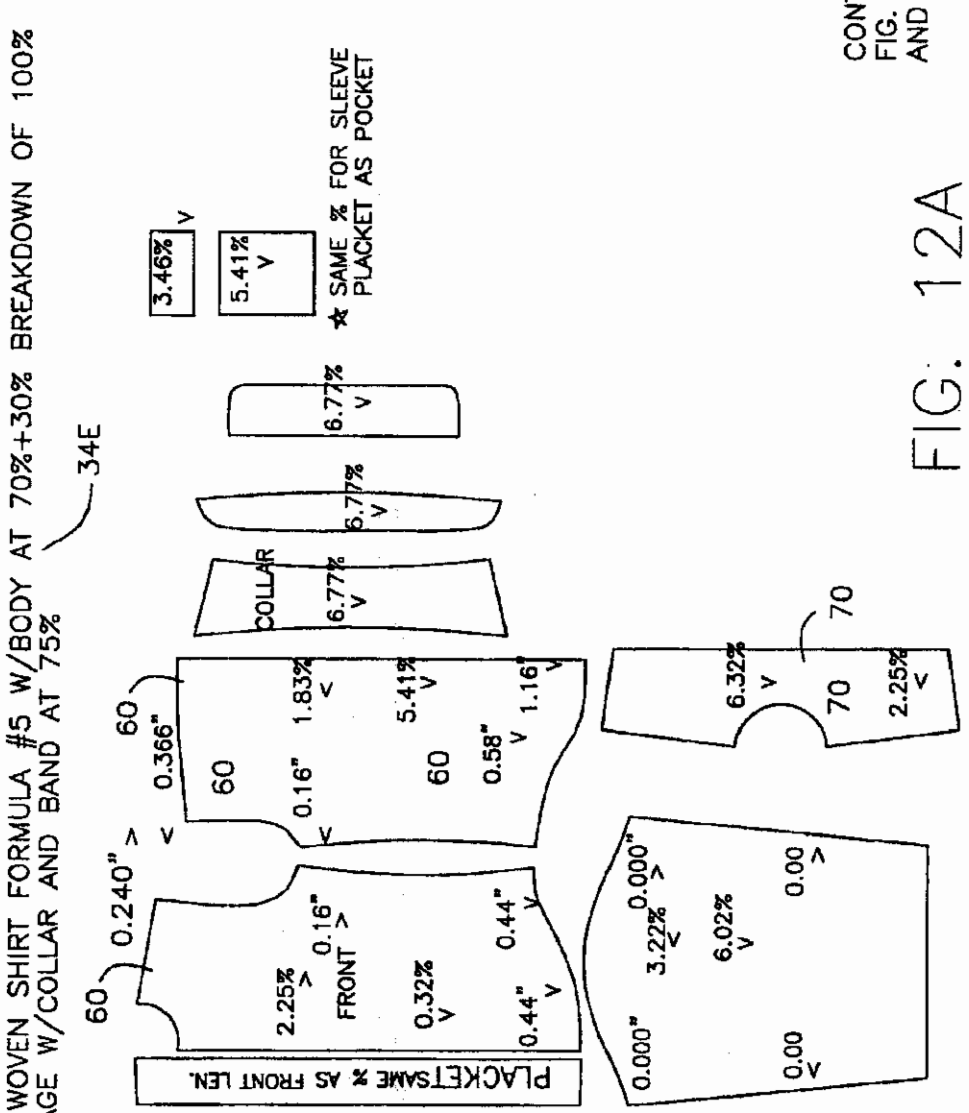

MASTER WOVEN SHIRT FORMULA #5 W/BODY AT 70%+30% BREAKDOWN OF 100%
SHRINKAGE W/COLLAR AND BAND AT 75%
34E
3.46%
5.41%
★ SAME % FOR SLEEVE PLACKET AS POCKET
6.77%
6.77%
COLLAR
6.77%
60
0.366"
60
0.16"
1.83%
5.41%
60
0.58"
1.16"
0.240"
60
0.16"
FRONT
2.25%
0.32%
0.44"
0.44"
PLACKET SAME % AS FRONT LEN.
0.000"
3.22%
6.02%
0.00
0.000"
0.00
6.32%
70
70
2.25%
CONTINUED ON
FIG. 12B
AND FIG. 12C

FIG. 12A

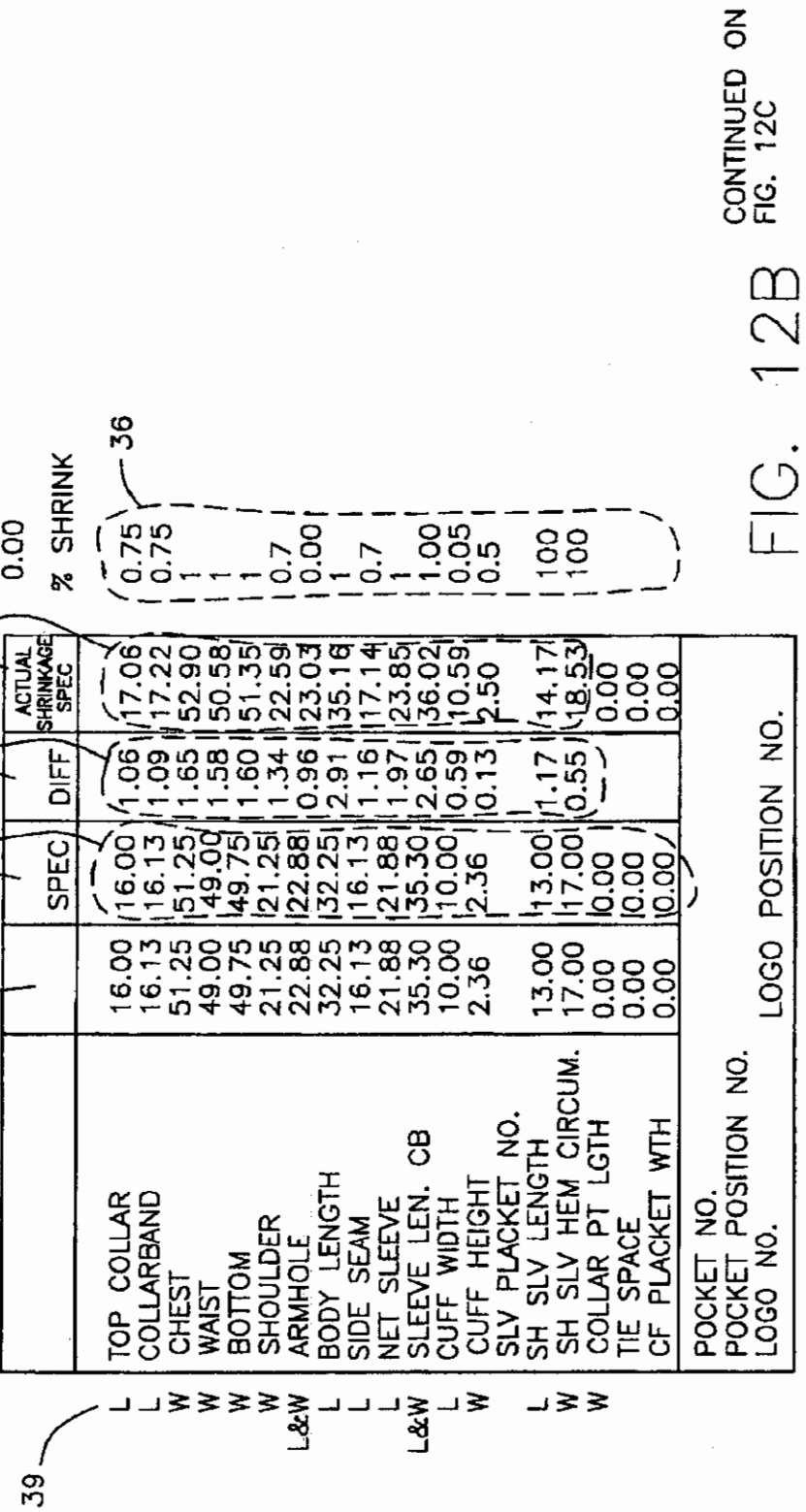
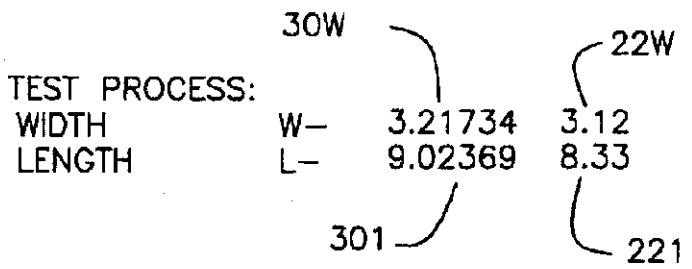


FIG. 12B

CONTINUED ON FIG. 12C



FRONT CALC	NEW M	DIFF	1X3 M	%
F&B NECK (W)	2.81	0.06	2.75	70
SHOULDER (L)	9.17	0.54	8.625	70
SHOULDER (W)	8.02	0.19	8.625	70
F ARMHOLE (L)	7.97	0.47	7.5	70
F CHEST (W)	13.03	0.41	12.03	100
SIDE SEAM (L)	19.30	1.36	18	85
FRONT (L)	28.07	1.95	27	85

FRONT CALC	NEW M	DIFF	1X3 M	%
HALF YOKE (L)	11.83	0.70	11.125	70
HALF YOKE (W)	11.25	0.25	11	70
HALF TOP BACK	11.50	0.25	11.25	70
B ARM HOLE (L)	9.57	0.51	9	70
BCHEST (W)	14.97	0.47	14.5	100
SLV HEAD (L)	5.72	0.47	6.25	100
SLEEVE (W)	9/81	0.31	9.5	100
NET SLV (L)	24.12	2.00	22.125	100

FIG. 12C

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MASTER KNIT FORMULA #1 W−100% L−100% SL−100% USING 80%+20%
BREAKDOWN OR 100% SHRINKAGE

34F

TABLE 1 FOR KNIT SHIRT W/SELF COLLAR & CUFF

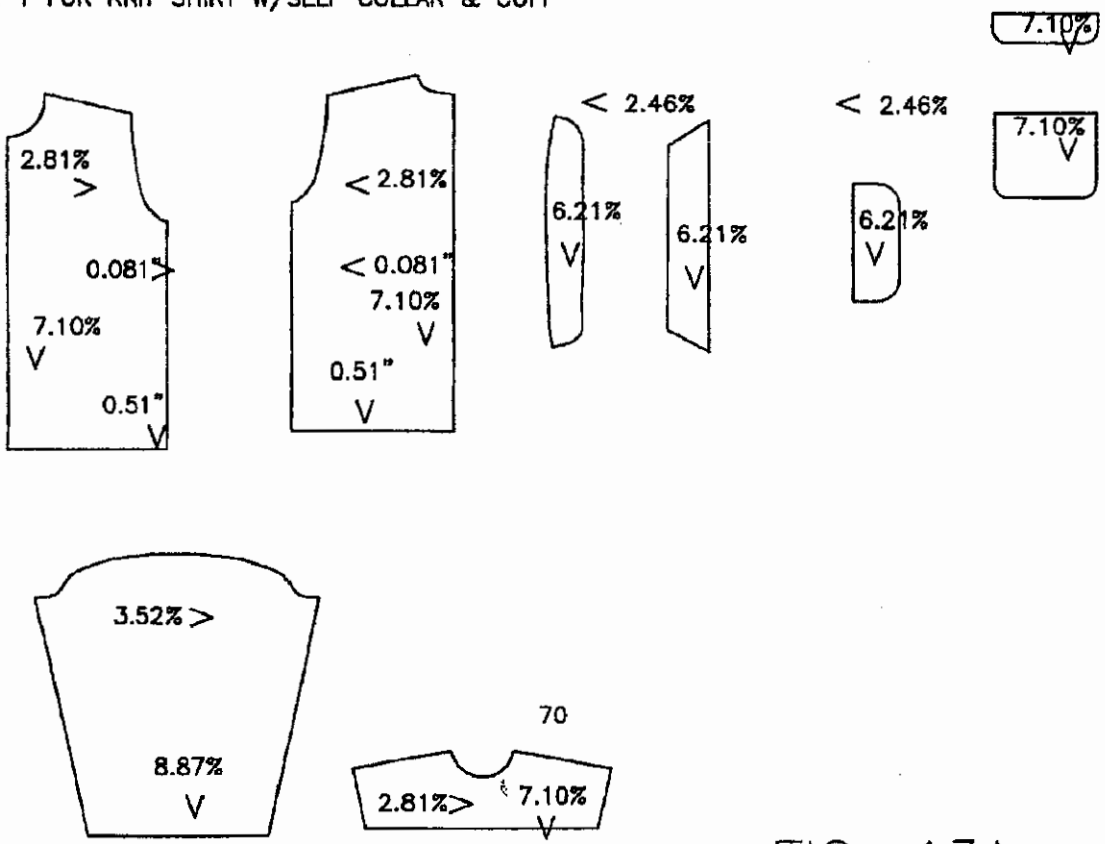

FIG. 13A

CONTINUED ON
FIG. 13B
AND FIG. 13C

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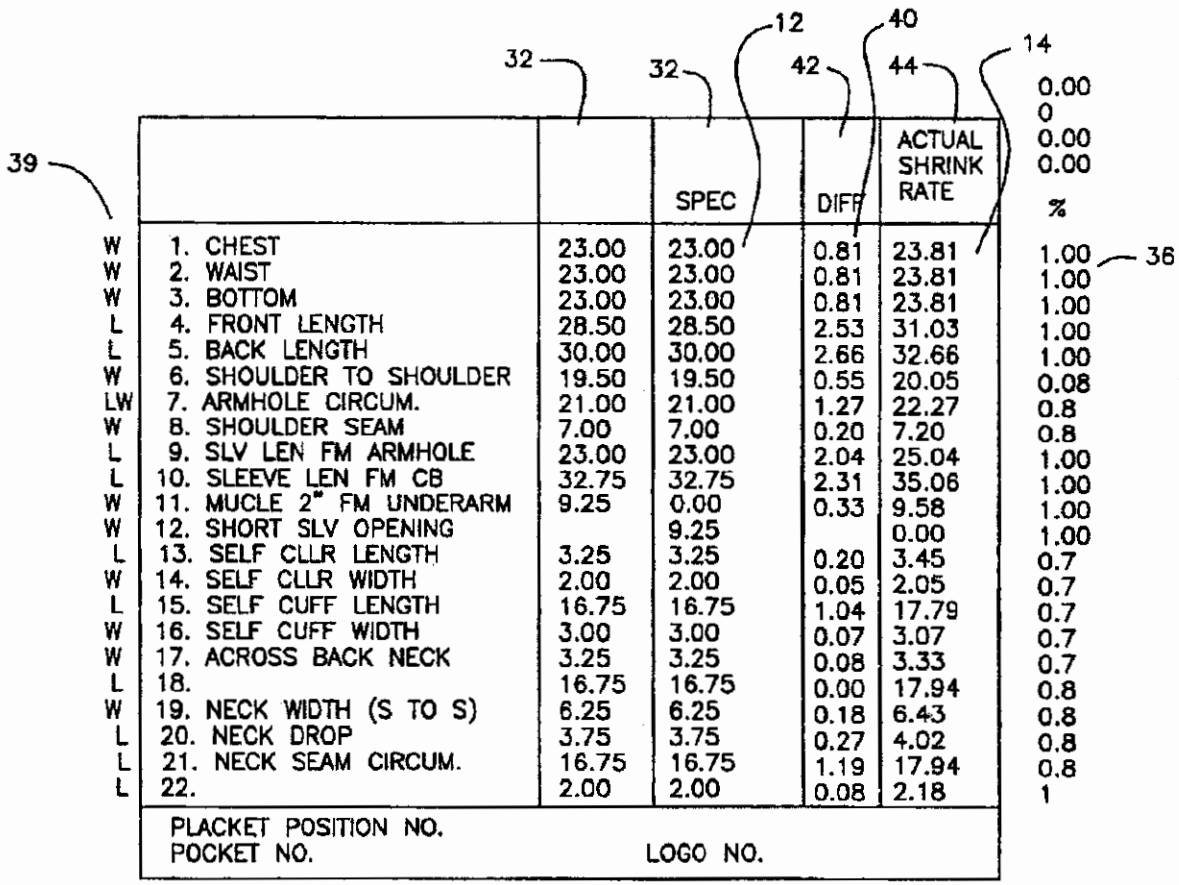
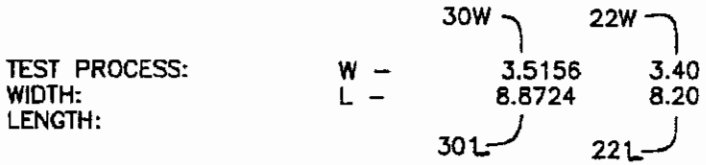


FIG. 13B

CONTINUED ON FIG. 13C



FRONT CALC	BEFORE	DIFF	OXO SPEC	%
FRONT NECK (W)	15.42	0.42	15	80
F NECK (L)	0.00	0.00	0	80
SHOULDER (W)	0.00	0.00	0	80
F ARMHOLE (L)	10.71	0.71	10	80
ARM–STR. (L)	10.71	0.71	10	100
F CHEST (W)	0.00	0.00	0	100
SIDE SEAM (L)	0.00	0.00	0	100
FRONT (L)	0.00	0.00	0	

BACK CALC	ACTUAL	DIFF	OXO SPEC	% 80	
BACK NECK (W)	15.42	0.42	15.00	80	67–88–58"
BACK NECK (L)	0.00	0.00	0.00	80	00–31–3/4"
SHOULDER (W)	0.00	0.00	0.00	80	82–93–7/8"
B ARMHOLE (L)	0.00	0.00	0	100	94–1.0–1"
B CHEST (W)	0.00	0.00	0	100	
SLV HEAD (L)	0.00	0.00	0	100	
SLEEVE (W)	0.00	0.00	0	100	
NET SLV (L)	0.00	0.00	0	100	

YOKE (W)	10.26	0.28	9.98	80
YOKE (L)	4.57	0.30	4.27	80
TOP BACK (W)	8.72	0.24	8.48	80

FIG. 13C

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MASTER KNIT FORMULA #2 W–100% L–100% USING 80%+20%
BREAKDOWN OR 100% SHRINKAGE

TABLE 1 FOR KNIT SHIRT W/SELF COLLAR & CUFF

34G

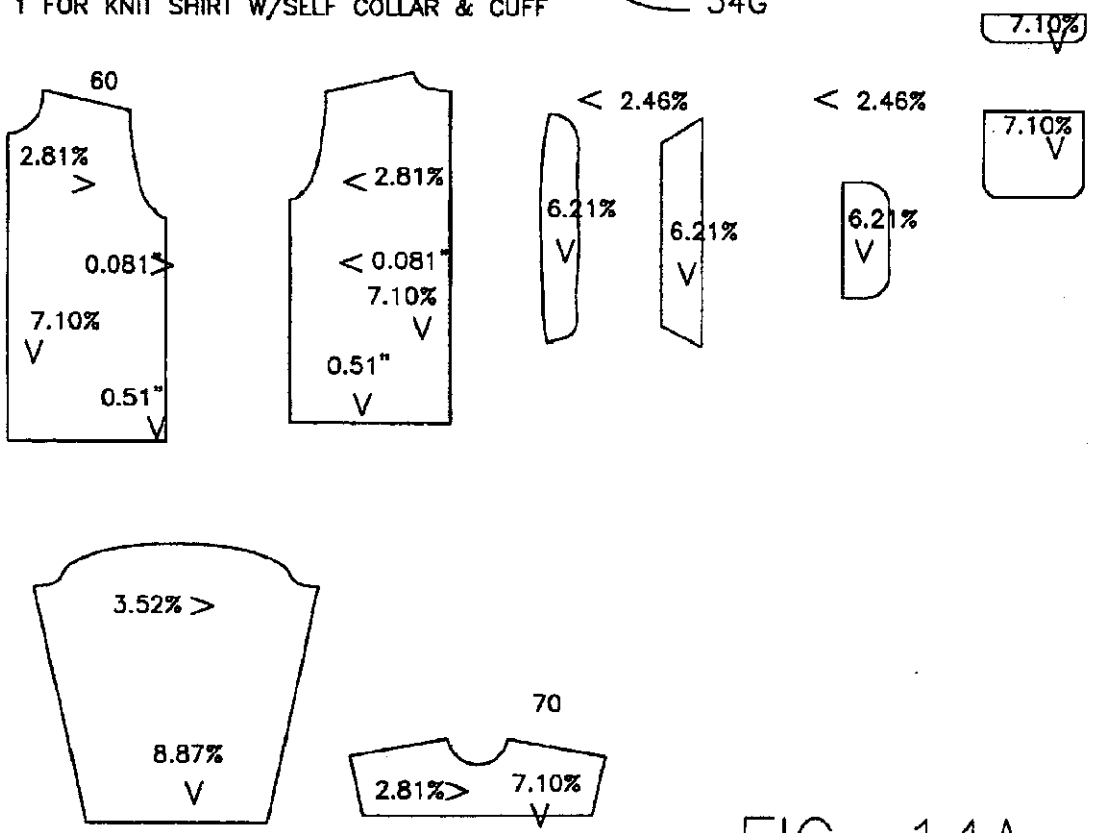

FIG. 14A

CONTINUED ON FIG. 14B AND FIG. 14C

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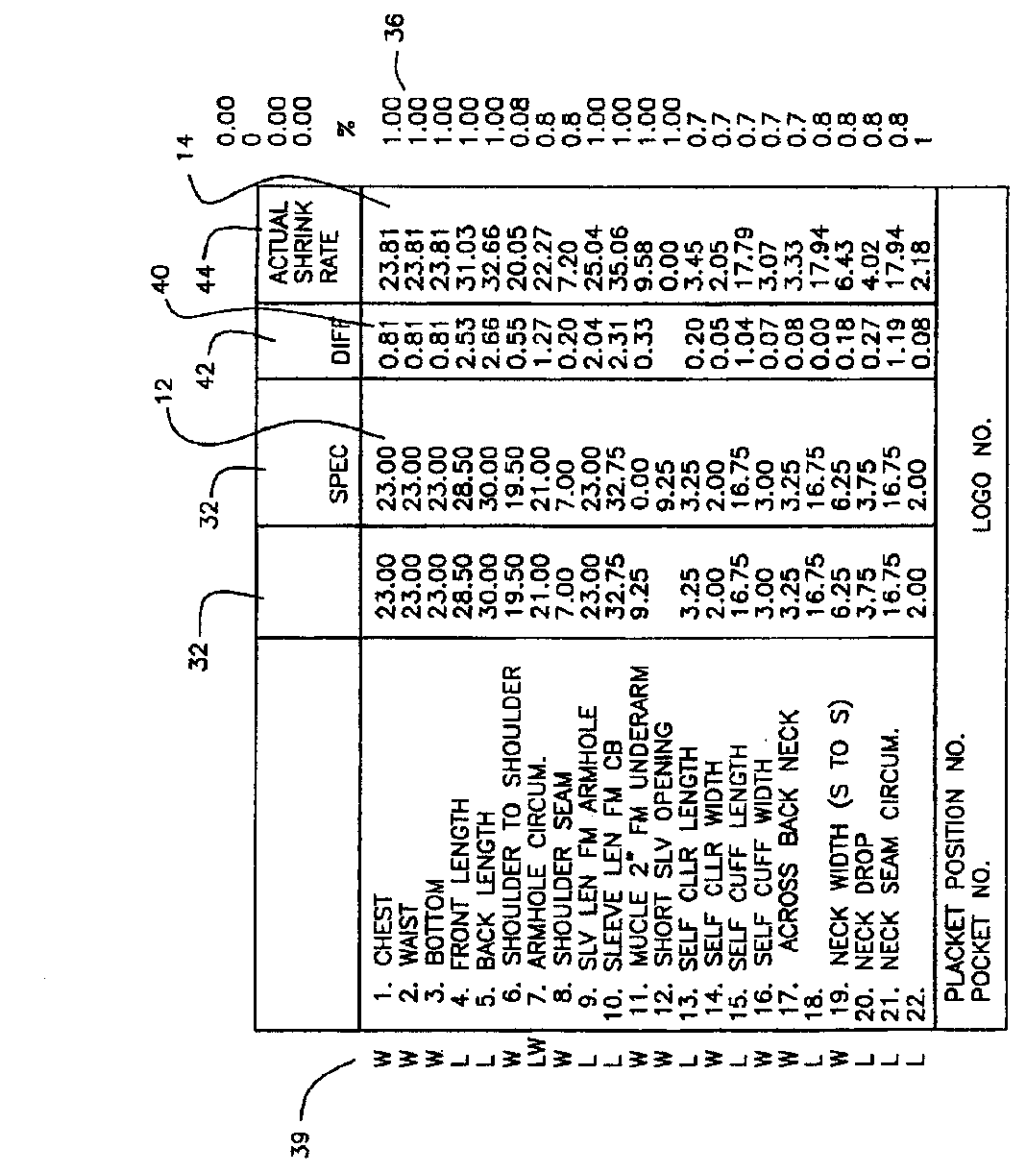

FIG. 14B

CONTINUED ON FIG. 14C

TEST PROCESS:		30W	22W
WIDTH:	W –	3.5156	3.40
LENGTH:	L –	8.8724	8.20
		30L	22L

FRONT CALC	BEFORE	DIFF	OXO SPEC	%
FRONT NECK (W)	15.42	0.42	15	80
F NECK (L)	0.00	0.00	0	80
SHOULDER (W)	0.00	0.00	0	80
F ARMHOLE (L)	10.71	0.71	10	80
ARM-STR. (L)	10.71	0.71	10	100
F CHEST (W)	0.00	0.00	0	100
SIDE SEAM (L)	0.00	0.00	0	100
FRONT (L)	0.00	0.00	0	

BACK CALC	ACTUAL	DIFF	OXO SPEC	% 80	
BACK NECK (W)	15.42	0.42	15.00	80	67-88-58"
BACK NECK (L)	0.00	0.00	0.00	80	00-31-3/4"
SHOULDER (W)	0.00	0.00	0.00	80	82-93-7/8"
B ARMHOLE (L)	0.00	0.00	0	100	94-1.0-1"
B CHEST (W)	0.00	0.00	0	100	
SLV HEAD (L)	0.00	0.00	0	100	
SLEEVE (W)	0.00	0.00	0	100	
NET SLV (L)	0.00	0.00	0	100	

YOKE (W)	10.26	0.28	9.98	80
YOKE (L)	4.57	0.30	4.27	80
TOP BACK (W)	8.72	0.24	8.48	80

FIG. 14C

17 OCT 2005

MASTER KNIT FORMULA #3 W−100% L−100% SL−100% USING 80%+20%
BREAKDOWN OR 100% SHRINKAGE

34H

TABLE 1 FOR KNIT SHIRT W/SELF COLLAR & CUFF

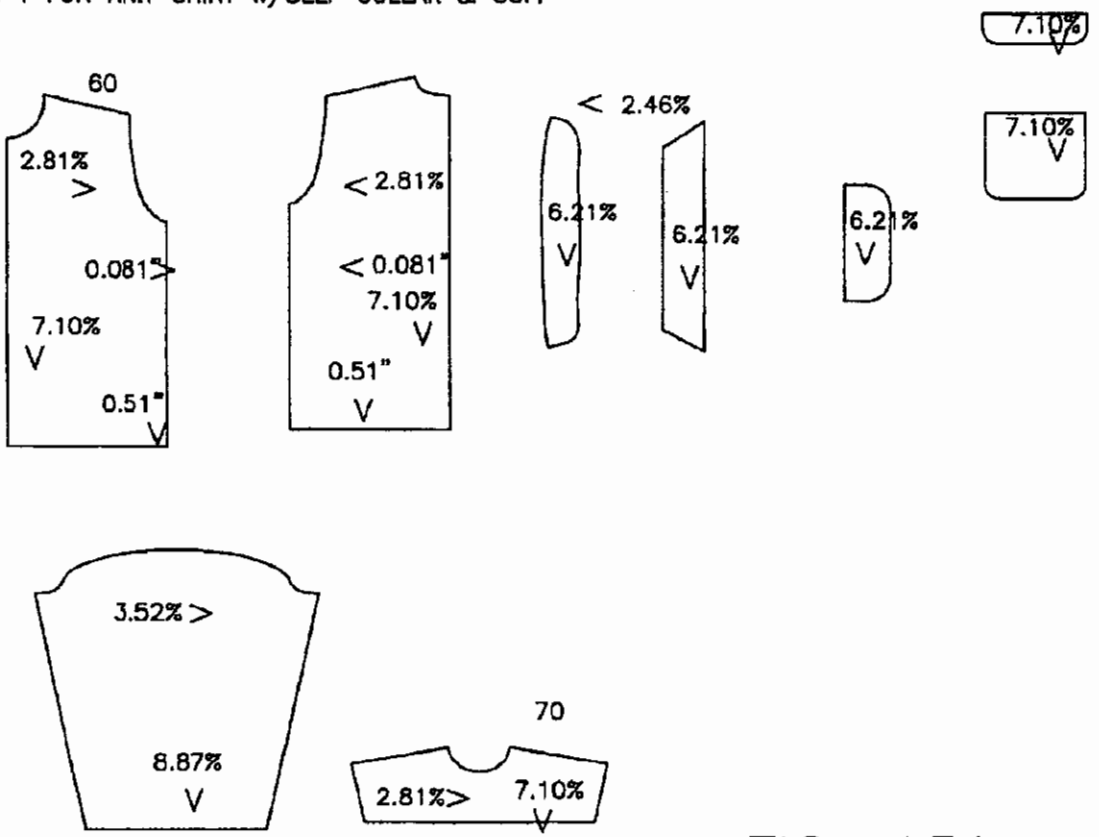

FIG. 15A

CONTINUED ON
FIG. 15B
AND FIG. 15C

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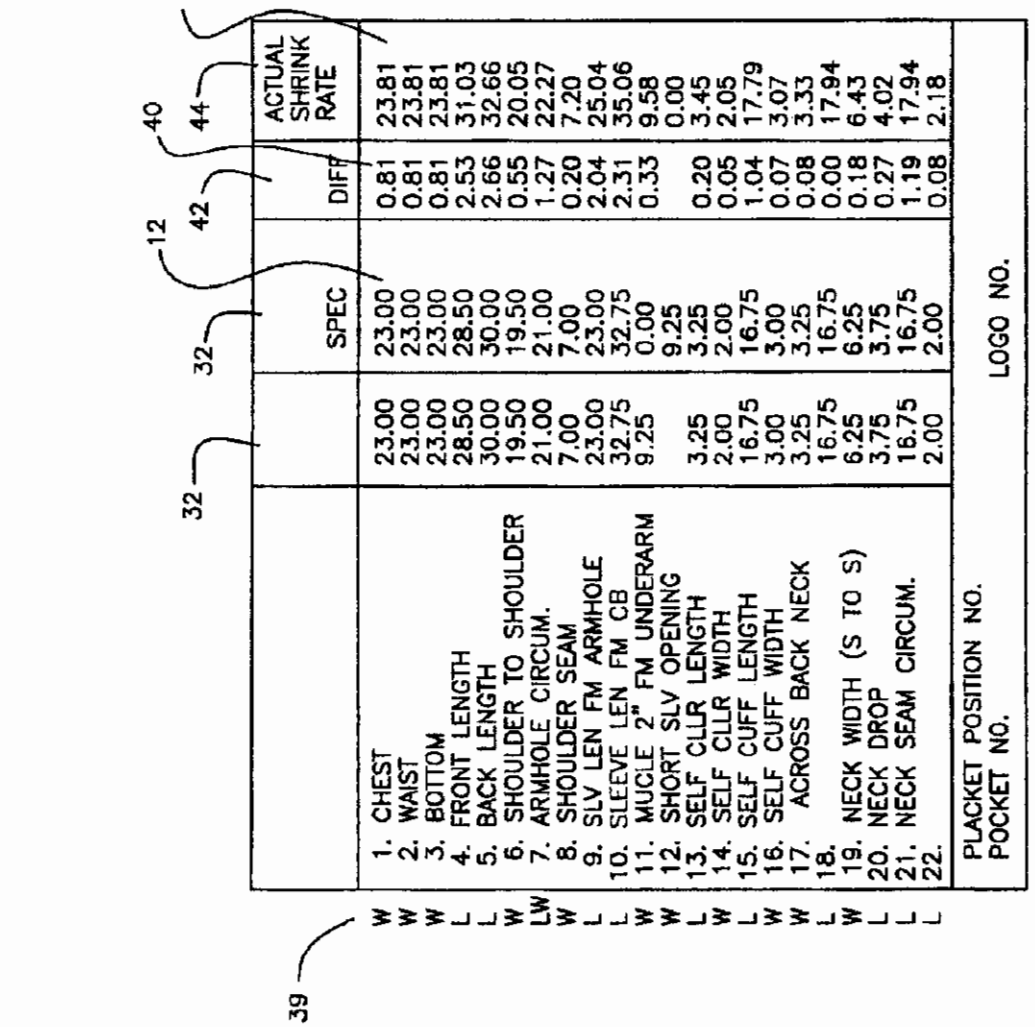
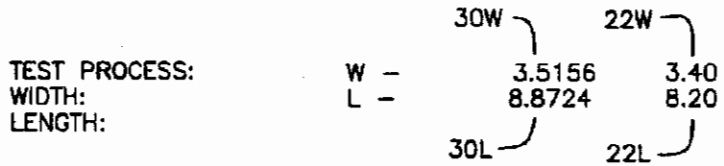


CONTINUED ON FIG. 15C

FIG. 15B



FRONT CALC	BEFORE	DIFF	OXO SPEC	%
FRONT NECK (W)	15.42	0.42	15	80
F NECK (L)	0.00	0.00	0	80
SHOULDER (W)	0.00	0.00	0	80
F ARMHOLE (L)	10.71	0.71	10	80
ARM-STR. (L)	10.71	0.71	10	100
F CHEST (W)	0.00	0.00	0	100
SIDE SEAM (L)	0.00	0.00	0	100
FRONT (L)	0.00	0.00	0	

BACK CALC	ACTUAL	DIFF	OXO SPEC	% 80
BACK NECK (W)	15.42	0.42	15.00	80
BACK NECK (L)	0.00	0.00	0.00	80
SHOULDER (W)	0.00	0.00	0.00	80
B ARMHOLE (L)	0.00	0.00	0	100
B CHEST (W)	0.00	0.00	0	100
SLV HEAD (L)	0.00	0.00	0	100
SLEEVE (W)	0.00	0.00	0	100
NET SLV (L)	0.00	0.00	0	100

YOKE (W)	10.26	0.28	9.98	80
YOKE (L)	4.57	0.30	4.27	80
TOP BACK (W)	8.72	0.24	8.48	80

67-88-58"
00-31-3/4"
82-93-7/8"
94-1.0-1"

FIG. 15C

17 OCT 2005

MASTER KNIT FORMULA #1 W-100% L-100% USING 80%+20%
BREAKDOWN OR 100% SHRINKAGE

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TABLE 1 FOR KNIT SHIRT W/SELF COLLAR & CUFF

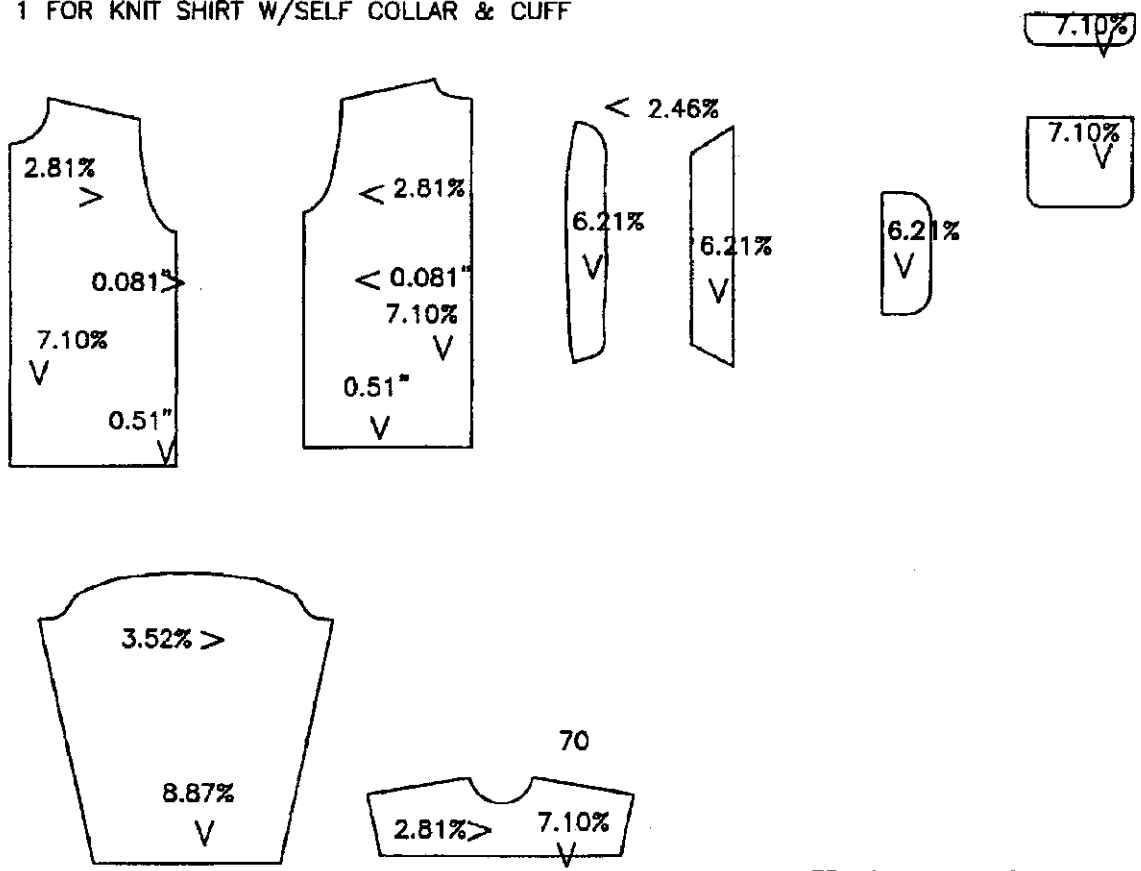


FIG. 16A

CONTINUED ON
FIG. 16B
AND FIG. 16C

17 OCT 2005

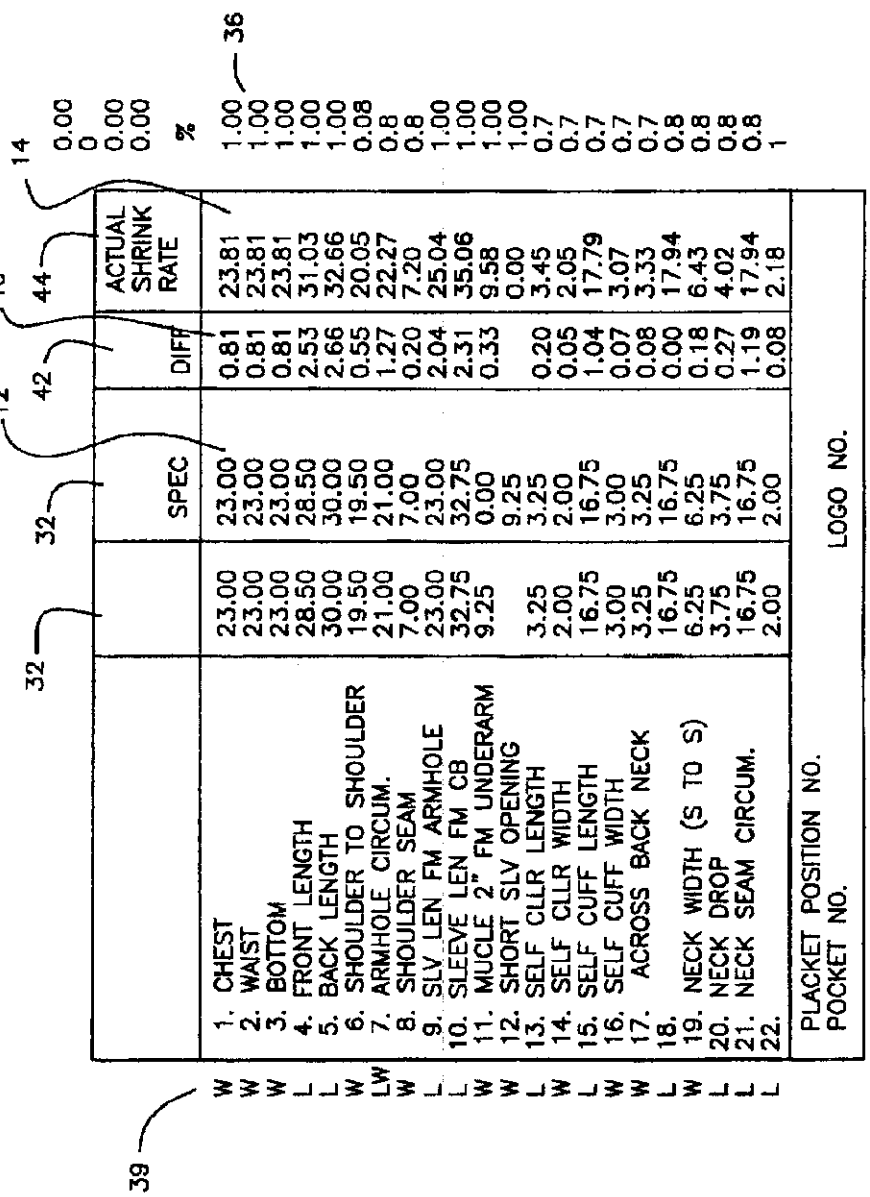
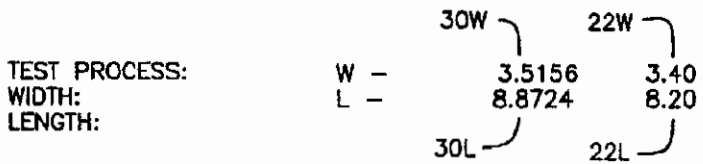


FIG. 16B

CONTINUED ON FIG. 16C

17 OCT 2005

		30W	22W
TEST PROCESS:	W –	3.5156	3.40
WIDTH:	L –	8.8724	8.20
LENGTH:		30L	22L



FRONT CALC	BEFORE	DIFF	OXO SPEC	%
FRONT NECK (W)	15.42	0.42	15	80
F NECK (L)	0.00	0.00	0	80
SHOULDER (W)	0.00	0.00	0	80
F ARMHOLE (L)	10.71	0.71	10	80
ARM–STR. (L)	10.71	0.71	10	100
F CHEST (W)	0.00	0.00	0	100
SIDE SEAM (L)	0.00	0.00	0	100
FRONT (L)	0.00	0.00	0	

BACK CALC	ACTUAL	DIFF	OXO SPEC	% 80
BACK NECK (W)	15.42	0.42	15.00	80
BACK NECK (L)	0.00	0.00	0.00	80
SHOULDER (W)	0.00	0.00	0.00	80
B ARMHOLE (L)	0.00	0.00	0	100
B CHEST (W)	0.00	0.00	0	100
SLV HEAD (L)	0.00	0.00	0	100
SLEEVE (W)	0.00	0.00	0	100
NET SLV (L)	0.00	0.00	0	100

YOKE (W)	10.26	0.28	9.98	80
YOKE (L)	4.57	0.30	4.27	80
TOP BACK (W)	8.72	0.24	8.48	80

67–88–58"
00–31–3/4"
82–93–7/8"
94–1.0–1"

FIG. 16C

MASTER KNIT FORMULA #6 W-100% L-100% USING 80%+20%
BREAKDOWN OR 100% SHRINKAGE

TABLE 1 FOR KNIT SHIRT W/SELF COLLAR & CUFF

34J

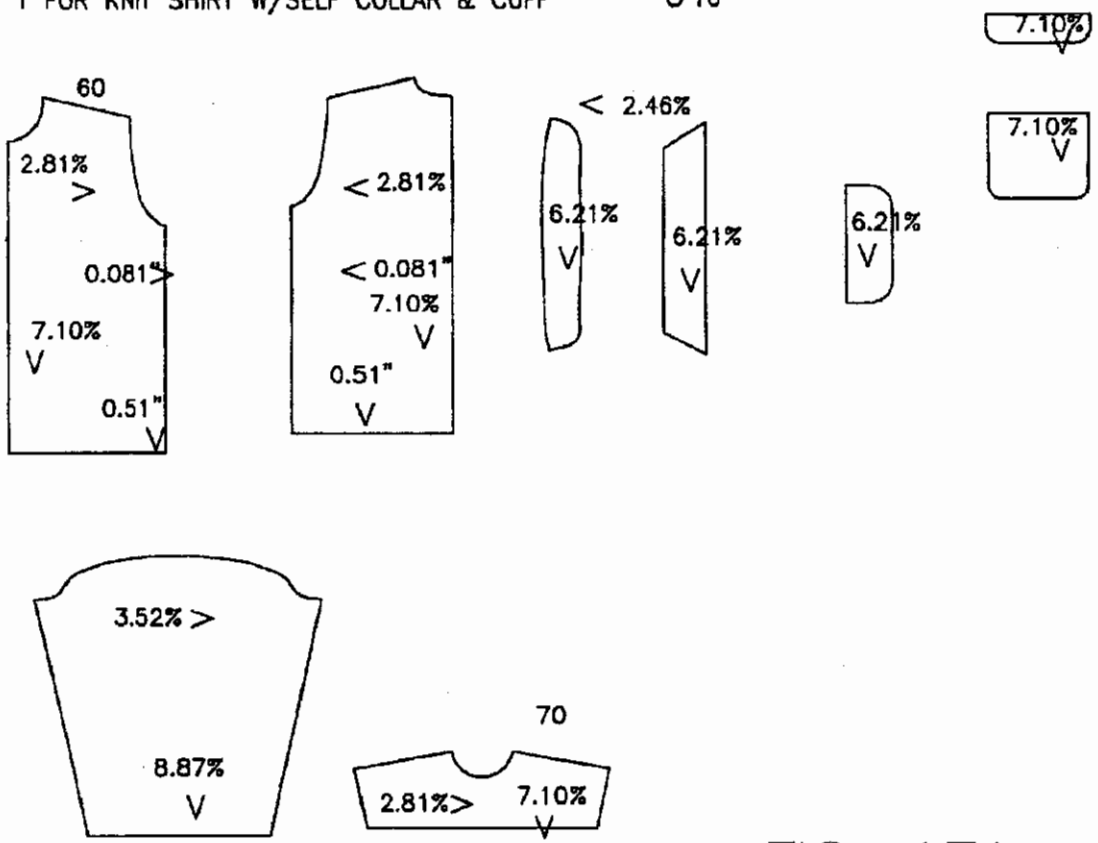
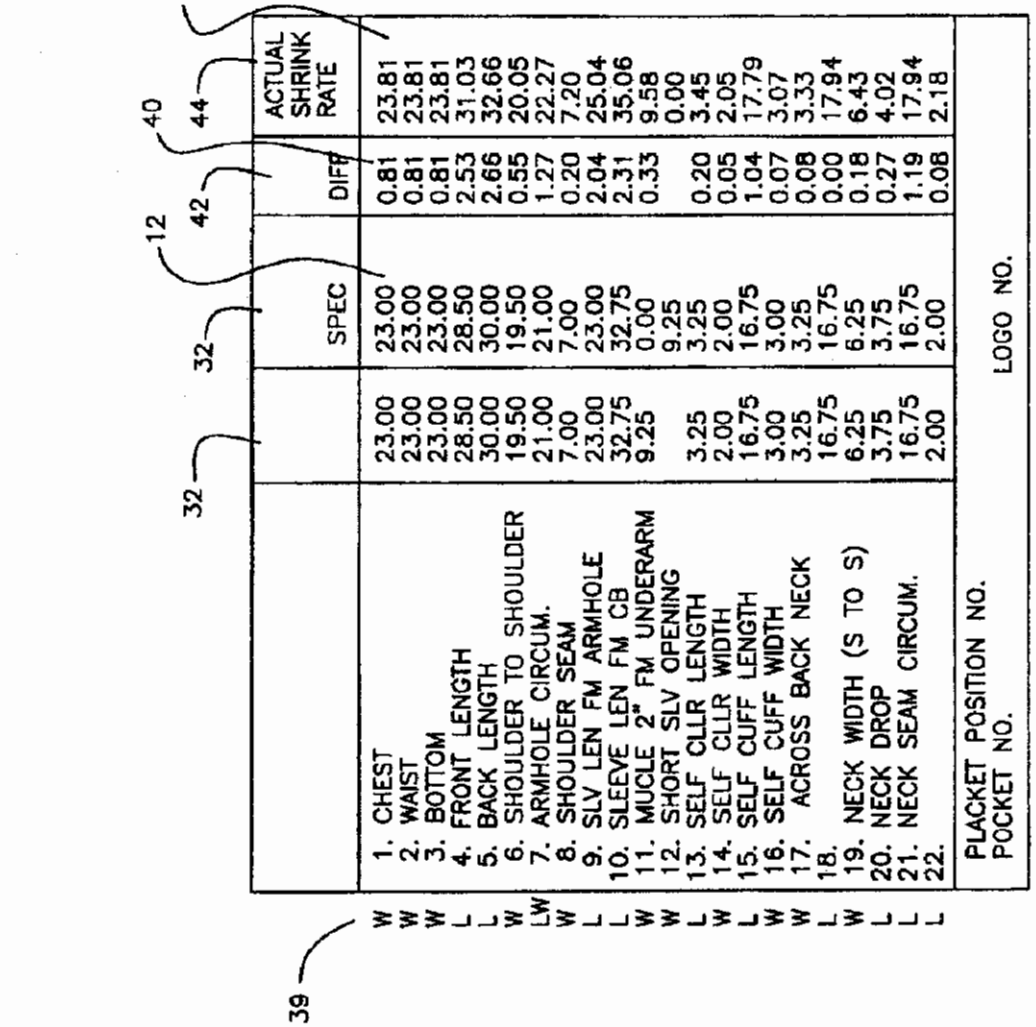


FIG. 17A

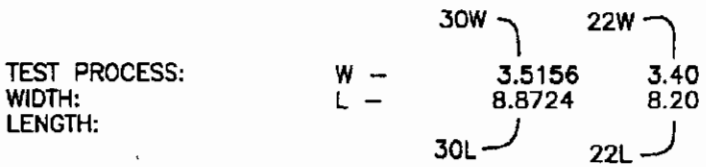
CONTINUED ON
FIG. 17B
AND FIG. 17C



			SPEC	DIFF	ACTUAL SHRINK RATE	%
W	1. CHEST	23.00	23.00	0.81	23.81	1.00
W	2. WAIST	23.00	23.00	0.81	23.81	1.00
W	3. BOTTOM	23.00	23.00	0.81	23.81	1.00
L	4. FRONT LENGTH	28.50	28.50	2.53	31.03	1.00
L	5. BACK LENGTH	30.00	30.00	2.66	32.66	1.00
W	6. SHOULDER TO SHOULDER	19.50	19.50	0.55	20.05	0.08
LW	7. ARMHOLE CIRCUM.	21.00	21.00	1.27	22.27	0.8
W	8. SHOULDER SEAM	7.00	7.00	0.20	7.20	0.8
L	9. SLV LEN FM ARMHOLE	23.00	23.00	2.04	25.04	1.00
L	10. SLEEVE LEN FM CB	32.75	32.75	2.31	35.06	1.00
W	11. MUCLE 2" FM UNDERARM	9.25	0.00	0.33	9.58	1.00
W	12. SHORT SLV OPENING		9.25		0.00	1.00
L	13. SELF CLLR LENGTH	3.25	3.25	0.20	3.45	0.7
W	14. SELF CLLR WIDTH	2.00	2.00	0.05	2.05	0.7
L	15. SELF CUFF LENGTH	16.75	16.75	1.04	17.79	0.7
W	16. SELF CUFF WIDTH	3.00	3.00	0.07	3.07	0.7
W	17. ACROSS BACK NECK	3.25	3.25	0.08	3.33	0.7
L	18.	16.75	16.75	0.00	17.94	0.8
W	19. NECK WIDTH (S TO S)	6.25	6.25	0.18	6.43	0.8
L	20. NECK DROP	3.75	3.75	0.27	4.02	0.8
L	21. NECK SEAM CIRCUM.	16.75	16.75	1.19	17.94	0.8
L	22.	2.00	2.00	0.08	2.18	1
	PLACKET POSITION NO.					
	POCKET NO.		LOGO NO.			

CONTINUED ON FIG. 17C

FIG. 17B



FRONT CALC	BEFORE	DIFF	OXO SPEC	%
FRONT NECK (W)	15.42	0.42	15	80
F NECK (L)	0.00	0.00	0	80
SHOULDER (W)	0.00	0.00	0	80
F ARMHOLE (L)	10.71	0.71	10	80
ARM-STR. (L)	10.71	0.71	10	100
F CHEST (W)	0.00	0.00	0	100
SIDE SEAM (L)	0.00	0.00	0	100
FRONT (L)	0.00	0.00	0	

BACK CALC	ACTUAL	DIFF	OXO SPEC	% 80
BACK NECK (W)	15.42	0.42	15.00	80
BACK NECK (L)	0.00	0.00	0.00	80
SHOULDER (W)	0.00	0.00	0.00	80
B ARMHOLE (L)	0.00	0.00	0	100
B CHEST (W)	0.00	0.00	0	100
SLV HEAD (L)	0.00	0.00	0	100
SLEEVE (W)	0.00	0.00	0	100
NET SLV (L)	0.00	0.00	0	100

YOKE (W)	10.26	0.28	9.98	80
YOKE (L)	4.57	0.30	4.27	80
TOP BACK (W)	8.72	0.24	8.48	80

67–88–58"
00–31–3/4"
82–93–7/8"
94–1.0–1"

FIG. 17C

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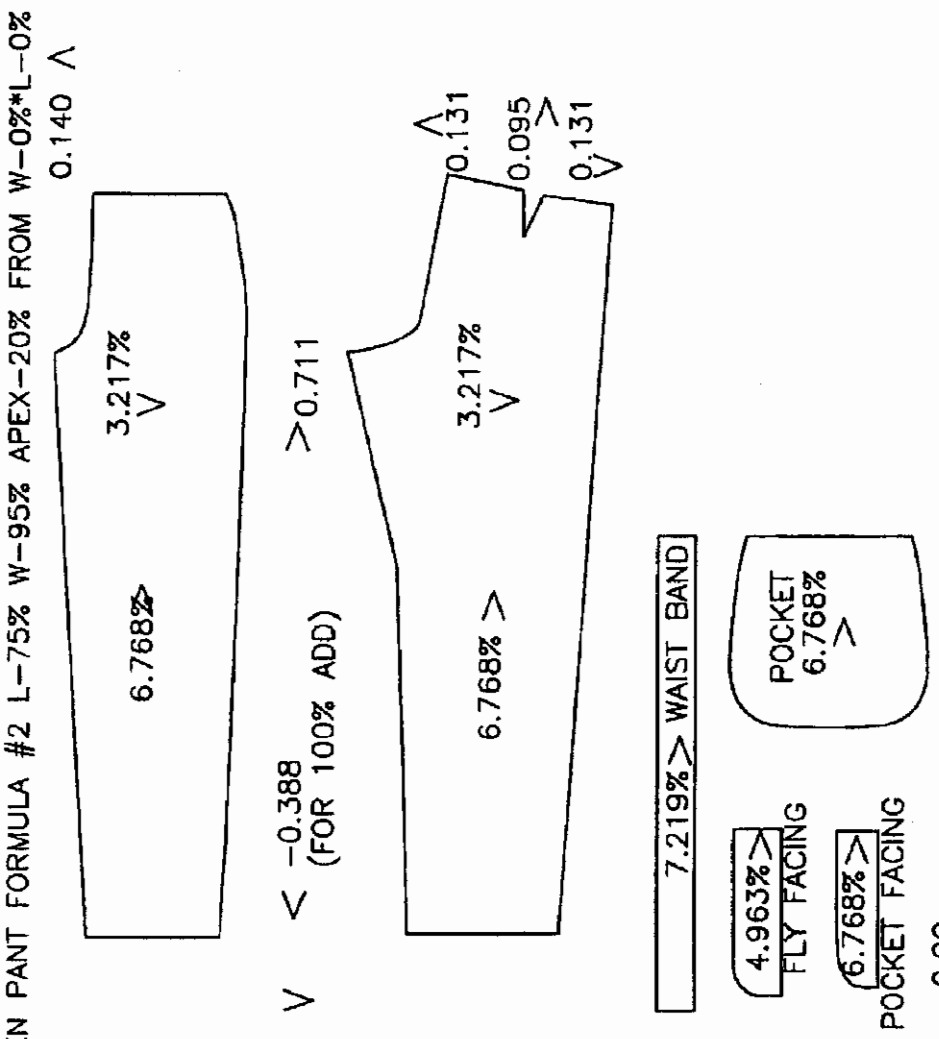
MASTER WOVEN PANT FORMULA #2 L-75% W-95% APEX-20% FROM W-0%*L-0%
34K
0.140
3.217%
6.768%
-0.388
(FOR 100% ADD)
0.711
0.131
0.095
0.131
3.217%
6.768%
7.219% WAIST BAND
4.963%
FLY FACING
6.768%
POCKET FACING
POCKET
6.768%
0.00
CONTINUED ON
FIG. 18B
AND FIG. 18C

FIG. 18A

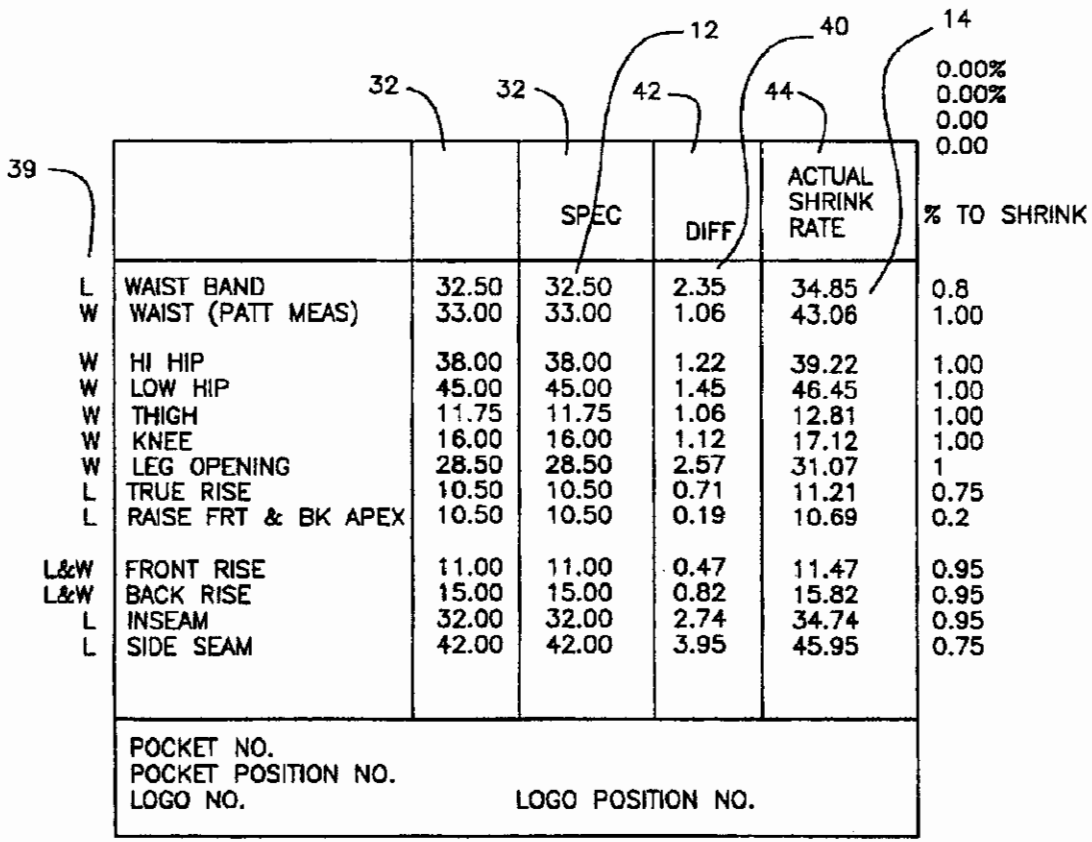

FIG. 18B

CONTINUED ON FIG. 18C

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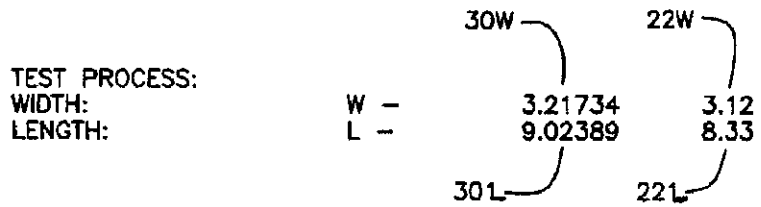

	FRONT CALC	NEW M	DIFF	
L	WAIST BAND	0.00	0.00	0
W	WAIST (FRT)	0.00	0.00	0
W	HI HIP (FRT)	0.00	0.00	0
W	LO HIP (FRT)	0.00	0.00	0
L	TRUE RISE	0.00	0.00	0
L	INSEAM	0.00	0.00	0
L	SIDE SEAM (L)	0.00	0.00	0

	BACK CALC	NEW M	DIFF
L	FRT & BK APEX	11.16	10.5
L&W	FRT RISE	0.00	0
L&W	BACK RISE	15.29	15

57-90-84"
00-01-34"
22-39-79"
11-10-1"

FIG. 18C

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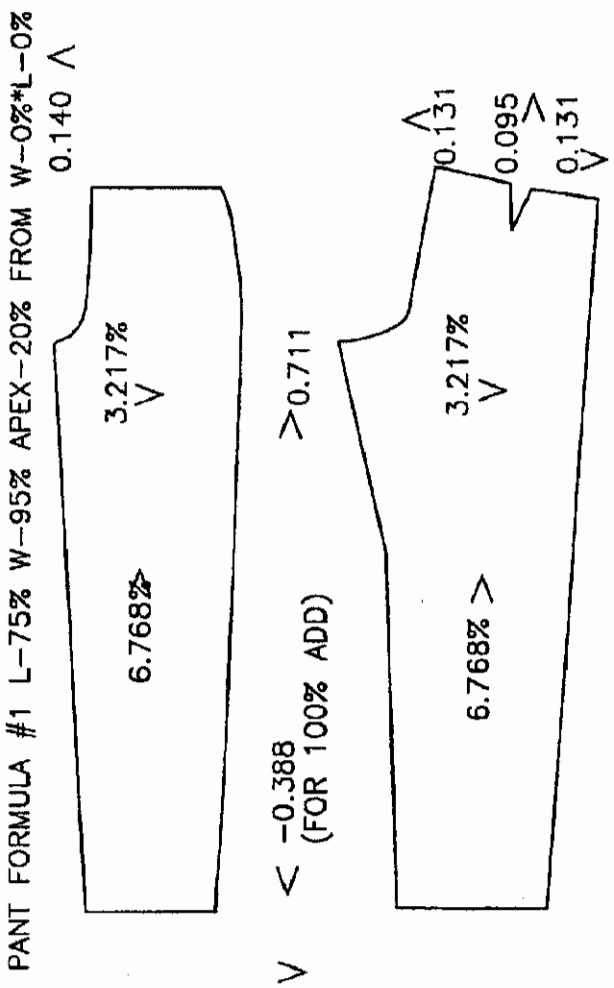
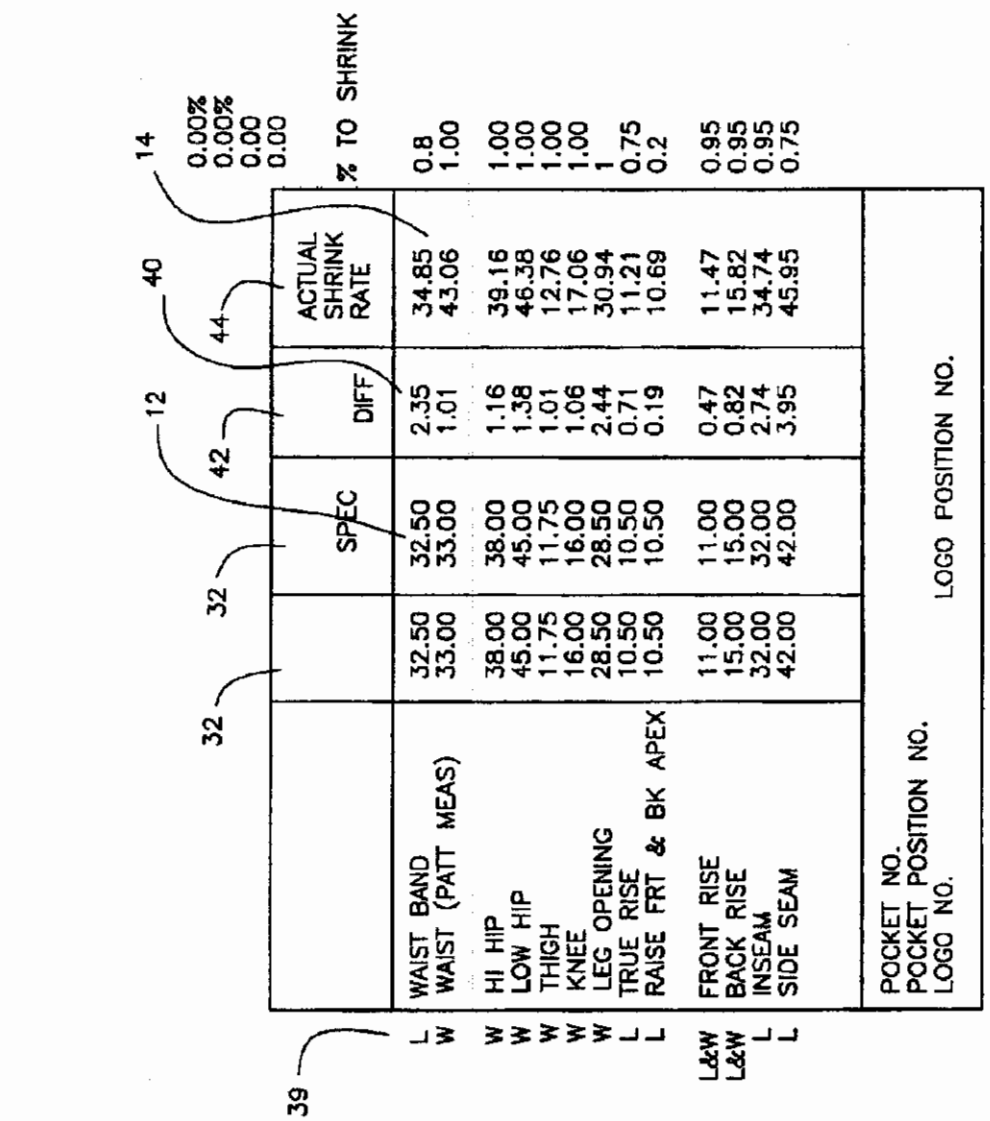


CONTINUED ON FIG. 19B AND FIG. 19C

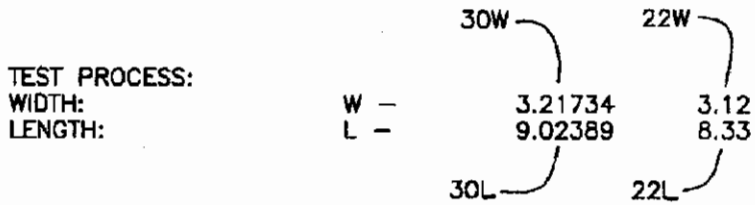
FIG. 19A



			SPEC	DIFF	ACTUAL SHRINK RATE	% TO SHRINK
L	WAIST BAND	32.50	32.50	2.35	34.85	0.8
W	WAIST (PATT MEAS)	33.00	33.00	1.01	43.06	1.00
W	HI HIP	38.00	38.00	1.16	39.16	1.00
W	LOW HIP	45.00	45.00	1.38	46.38	1.00
W	THIGH	11.75	11.75	1.01	12.76	1.00
W	KNEE	16.00	16.00	1.06	17.06	1.00
W	LEG OPENING	28.50	28.50	2.44	30.94	1
L	TRUE RISE	10.50	10.50	0.71	11.21	0.75
L	RAISE FRT & BK APEX	10.50	10.50	0.19	10.69	0.2
L&W	FRONT RISE	11.00	11.00	0.47	11.47	0.95
L&W	BACK RISE	15.00	15.00	0.82	15.82	0.95
L	INSEAM	32.00	32.00	2.74	34.74	0.95
L	SIDE SEAM	42.00	42.00	3.95	45.95	0.75
	POCKET NO.					
	POCKET POSITION NO.					
	LOGO NO.				LOGO POSITION NO.	

CONTINUED ON FIG. 19C

FIG. 19B



	FRONT CALC	NEW M	DIFF	
L	WAIST BAND	0.00	0.00	0
W	WAIST (FRT)	0.00	0.00	0
W	HI HIP (FRT)	0.00	0.00	0
W	LO HIP (FRT)	0.00	0.00	0
L	TRUE RISE	0.00	0.00	0
L	INSEAM	0.00	0.00	0
L	SIDE SEAM (L)	0.00	0.00	0

	BACK CALC	NEW M	DIFF
L	FRT & BK APEX	11.16	10.5
L&W	FRT RISE	0.00	0
L&W	BACK RISE	15.29	15

57–90–84"
00–01–34"
22–39–79"
11–10–1"

FIG. 19C

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WOVEN SHIRT SHRINKAGE FORMULA SELECTION DATABASE

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SHIRT WOVEN	SHRINKAGE BREAKSOWN	COLLAR SHRINKAGE PERCENT	DURATION (MINUTES)	WASH TEMP (CENT)	FABRIC CONSTRUCTION	FABRIC WEIGHT
A–1 A–2 A–3	60–40–60 60–40–70 60–40–75		20–40	30–40	HIGH COUNT 100/2 OR ABOVE	LIGHT
			2.5	2	1.5	1.5
B–1 B–2 B–3	65–35–65 65–35–70 65–35–75		40–70	40–50	MED COUNT 80s TO 100/2	MED
			5	4	3	3
C–1 C–2 C–3	70–30–65 70–30–75 70–30–80		70–100	50–60	LOW COUNT 55s TO 75s	MED TO HEAVY
			7.5	6	4.5	4.5
D–1 D–2 D–3	75–25–75 75–25–80 75–25–85		100–58	60–70	30s TO 55s	HEAVY
			10	8	6	6
E–1 E–2 E–3	80–20–75 80–20–80 80–20–85		150–300	70–80		
			12.5	10	7.5	6

FIG. 20A

CONTINUED ON FIG. 20B

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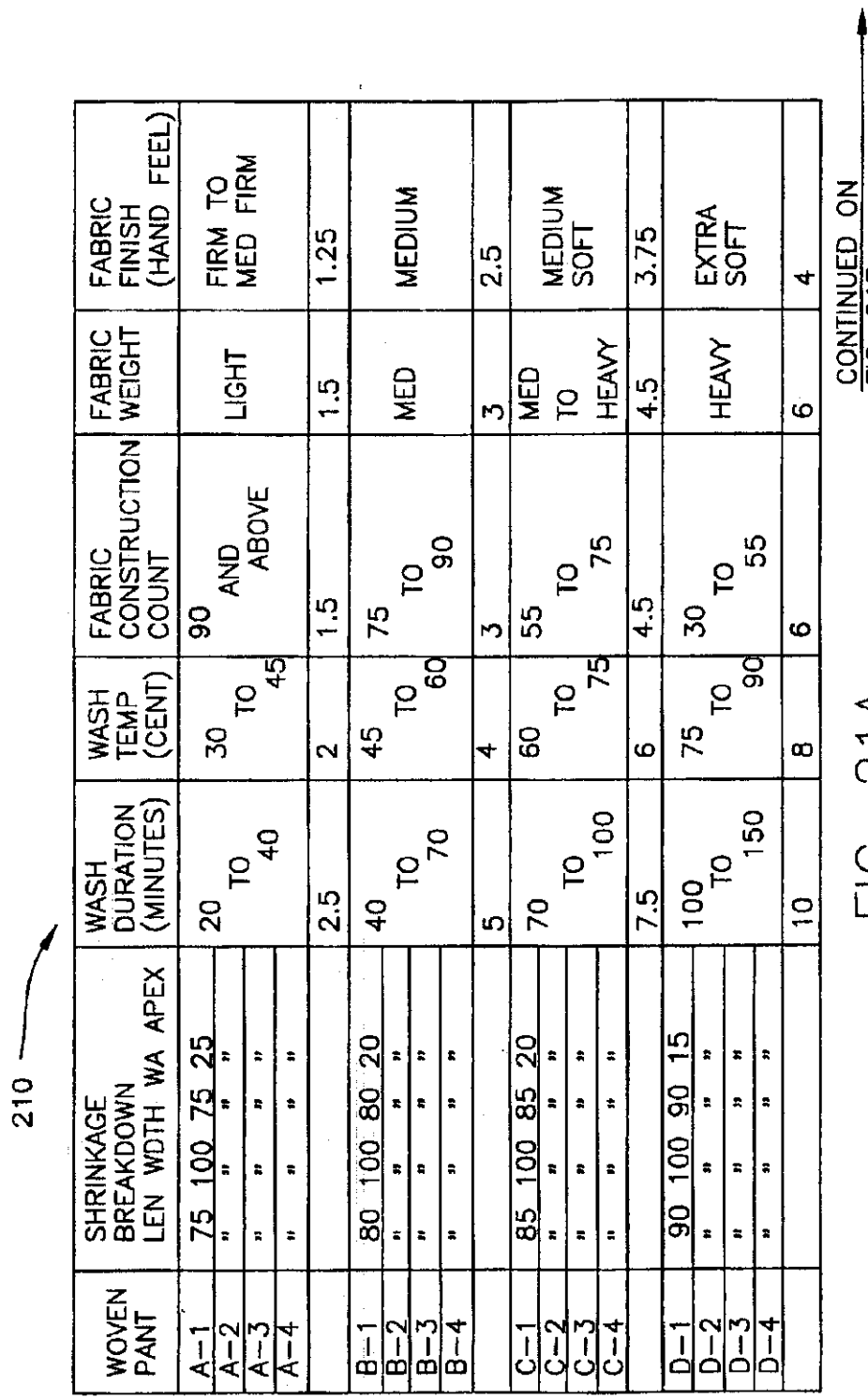
FABRIC FINISH (HAND FEEL)	TYPE OF WASH	CATEGORY	LINING LAY
FIRM TO MED FIRM	LIGHT GMT WASH/GMT WASH /HVY GMT WASH /SILICON WASH	A SCORE 0 TO 10	STRAIGHT 9 D BIAS 45 D BIAS
1.25	1		
MED TO MED SOFT	SAND WASH/ENZYME WASH/ BIO WASH/CHEMICAL WASH/ CHEMICAL WASH/GREEN BALL WASH	B SCORE 10 TO 20	STRAIGHT 9 D BIAS 45 D BIAS
2.5	2		
MED SOFT TO SOFT	HVY ENZYME WASH /HVY STONE WASH HVY ENZYME STONE WASH/HVY SAND WASH/ HVY CHEMICAL STONE/CHEMICAL STONE WASH	C SCORE 20 TO 30	STRAIGHT 9 D BIAS 45 D BIAS
3.75	3		
EXTRA SOFT	DESTROY WASH/RALPH TEE WASH	D SCORE 30 TO 37	STRAIGHT 9 D BIAS 45 D BIAS
4	4		
	TEA STAIN/OVER DYE/ CLOUDY DYE/CROSS DYE/GMT DYE	E SCORE 37 TO 43	STRAIGHT 9 D BIAS 45 D BIAS
5.25	5		

CONTINUED FROM FIG. 20A

FIG. 20B

17 OCT 2005



WOVEN PANT	SHRINKAGE BREAKDOWN LEN WDTH WA APEX	WASH DURATION (MINUTES)	WASH TEMP (CENT)	FABRIC CONSTRUCTION COUNT	FABRIC WEIGHT	FABRIC FINISH (HAND FEEL)
A–1	75 100 75 25	20 TO 40	30 TO 45	90 AND ABOVE	LIGHT	FIRM TO MED FIRM
A–2	" " " "					
A–3	" " " "					
A–4	" " " "					
		2.5	2	1.5	1.5	1.25
B–1	80 100 80 20	40 TO 70	45 TO 60	75 TO 90	MED	MEDIUM
B–2	" " " "					
B–3	" " " "					
B–4	" " " "					
		5	4	3	3	2.5
C–1	85 100 85 20	70 TO 100	60 TO 75	55 TO 75	MED TO HEAVY	MEDIUM SOFT
C–2	" " " "					
C–3	" " " "					
C–4	" " " "					
		7.5	6	4.5	4.5	3.75
D–1	90 100 90 15	100 TO 150	75 TO 90	30 TO 55	HEAVY	EXTRA SOFT
D–2	" " " "					
D–3	" " " "					
D–4	" " " "					
		10	8	6	6	4

CONTINUED ON FIG. 21B

FIG. 21A

TYPE OF WASH	CATEGORY	6.6 LE TEST (MIN)
LIGHT GMT WASSH/GMT WASH /HEAVY GMT WASH /SILICON WASH	A 0 TO 10	2 TO 5 6 TO 9 10 TO 13 14 TO 18
1		
SAND WASH/ENZYME WASH/ BIO WASH/CHEMICAL WASH CHEMICAL WASH/GREEN BALL WASH	B 10 TO 20	2 TO 5 6 TO 9 10 TO 13 14 TO 18
2		
HVY ENZYME WASH/HVY STONE WASH HVY ENZYME WASH/HVY ENZYME SONE WASH/ HVY SAND WASH/HVY CHEMICAL STONE/ CHEMICAL STONE WASH	C 20 TO 30	2 TO 5 6 TO 9 10 TO 13 14 TO 18
3		
DESTROY WASH/RALPH TEE WASH/ TEA STAIN/OVER DYE	D 30 TO 40	2 TO 5 6 TO 9 10 TO 13 14 TO 18
4	4	

CONTINUED FROM FIG. 21A

FIG. 21B

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PANTS		0 POCKETS	2 POCKETS	4 POCKETS	WASH TEST
ABCD	1	1/2"	3/8"	1/4"	2–5
ABCD	2	3/4"	5/8"	9/16"	6–9
ABCD	3	1 1/4"	1 1/16"	7/8"	10–13
ABCD	4	1 3/4"	1 1/2"	1 1/4"	14–17

FIG. 22