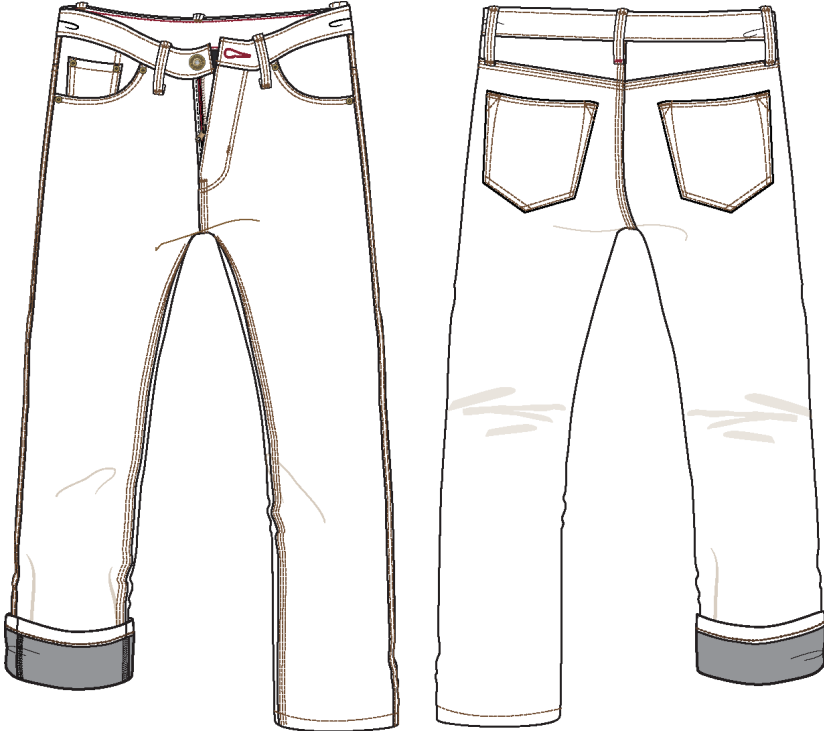


MS Apparel Technical Package				Date Created	1.8.2025
				Revised	3.20.2025
				Revised	6.16.25
Brand :		BUCKHORN RIVER		Style Name : Zone	
Division :		Men's Bottoms		Agent/Office :	
		Style # : BRP-E0835		Sewing Fty :	
		Proto # :		Vendor :	
				Garment COO :	
TECHPACK		MS APPAREL			
GARMENT INFORMATION		Sketch: 			
Category:	Men's				
Designer:	Roger				
Tech Designer:	Andy / Design Works / Roger				
Fabric Content:	Body: 98% Cotton, 2% Spandex Lining: 100% Polyester				
Fabric weight:	270 gsm				
Season:	2025				
Garment Description: (for catalog) -Straight Leg -Men's Fit -Fleece Lined -Classic 5 Pocket - -					
Comments: Most Recent Update 6.16.25 for PP sample					

Brand :	BUCKNORN RIVER	Style Name :	Zone	Agent/Office :	0	Sewing Pky :	10/00
Division :	Men's Bottoms	Style # :	BRP-E0835	Proto # :	0	Garment COO :	10/00

FABRICS											COLORWAY	COLORWAY	COLORWAY	
ITEM					CONTENT	DESCRIPTION	FINISHES	WEIGHT	PLACEMENT	QUANTITY	SIZE	1	2	3
Construction	Fabric	Vendor	Ref #	COO										
Woven	Canvas		W-1171		98% Cotton, 2% Spandex			270 gsm	Body	X	X	Duck 17-1044	Gravel 18-0403	
Woven	Fleece				100% Polyester Polar Fleece	Trouser Lining		140 gsm	Lining	X	X	Gravel 18-0403	Black 19-4007	
										X	X			
										X	X			

TRIMS															COLORWAY	COLORWAY	COLORWAY
ITEM					CONTENT	DESCRIPTION	FINISHES	WEIGHT	PLACEMENT	QUANTITY	SIZE	1	2	3			
Item	Fabrics	Vendor	Ref #	COO													
Thread		A&E			Poly-Wrapped Poly-Core	Perma Core		135 tex	All seams		SPI +/- 9						
Zipper		YKK	#5		Metal	Closed-End			CF Zipper Fly	1		Red 19-1656	Red 19-1656	DTM			
Zipper Pull		YKK	GS&JNS		#520 Teeth				CF Zipper Fly	1		DTM	DTM	DTM			
Button		Marito Scovill	BS- E0006_Logo_Don utShank_Button_v01		Metal / Brass Duramark Tack Button, Division 71		Finish: 4911 or Finish: 4134		CF Waistband	1	27 L	Antique Brass	Antique Brass	Antique Brass			
Rivits		Vendor to Source			Metal / Brass					6	15L	Antique Brass	Antique Brass	Antique Brass			
Thread									Button Hole			Red 19-1656	Red 19-1656				
																	

LABELS / HANGTAGS												COLORWAY	COLORWAY	COLORWAY
ITEM					CONTENT	DESCRIPTION	FINISHES	WEIGHT	PLACEMENT	QUANTITY	SIZE	1	2	3
Item	Material	Vendor	Ref #	COO										
Main Label (Bottoms)		Local	608- BR_BOTTOMS_MainLabel_v02		Woven Polyester Damask		End-Fold (Side Stitch ONLY)	SEE ART	CB	1	1" x 1.625"	Silver Birch	Silver Birch	Silver Birch
Main Hangtag		Local	BR- E0801_HangTag_v01		Paper		(C2S) Aqueous Gloss Coating / Varnish	300g 300g	Wearer's Left Side Waistband Seam	1	4.625" x 3"	See File	See File	See File
Cord		Local	BR- E0801_HangTag_v01		Cotton		SEE ART	SEE ART	Used to Attach Hangtag	1	8" length 1.5mm thick	Natural	Natural	Natural
Safety Pin		Local	BR- E0801_HangTag_v01		Metal		Bulb, Pear, or Gourd Shaped	SEE ART	Used to Attach Hangtag	1	22mm	Bronze	Bronze	Bronze
Square Label		Local	174- BR_SquareLabel_v04		Woven Polyester Damask		4-side sew on	SEE ART	TBD as Needed / See Art	1	1.25" x 1.25"	Silver Birch	Silver Birch	Silver Birch
Joker Tag		Local	BR- E04_NUMERIC_W-L_Sized_Joker_Tag_v02		Paper		Aqueous Gloss Coating / Varnish	300g C1S	Wearer's Back Right Waistband	1	4.75" x 1.8049"	See File	See File	See File
Jacron Patch		Local	BR- E0107_Debossed_Jacron_PU_Waistband_Patch_v01		Jacron or PU (Synthetic Leather)		Sewn On	SEE ART	Wearer's Back Right Waistband	1	1.875" x 2.875"	Black	Black	Black
Size Tag		Local	BR- E0113_NUMERIC_NUMERIC_BOTTOMS_Wash-Looph_Sue-COO_LOOP_WovenLabel_v01		Woven Polyester Damask		Loop Sewn into Seam	SEE ART	CB	1	1.75" x .5"	Silver Birch	Silver Birch	Silver Birch
CO / COO Label		Local	WENS_CC_BANGLADESH_BCOtton-20gsm-100Poly-BONDED-BOTTOMS_Label_v01		Satin		Laser Cut	SEE ART	Wearer's Left Side Seam	1	2.75" x 1.625"	White	White	White
Tracking Label		Local	Info- Tracking_Label_v01		Satin		Laser Cut	SEE ART	Wearer's Left Side Seam	1	1.375" x .75"	White	White	White

DATE:	REVISIONS:	REVISED BY:
1.8.2025	ORIGINAL DEVELOPMENT	ARB
3.18.25	took BRP-E0835 miniCAD and put into standard TechPack format	
	most questions can probably be answered in the miniCAD tab of the TechPack	

Date Issued	1.8.2025
Revised	3.20.2025

Brand : BUCKHORN RIVER	Style Name: Zone	0	Agent/Office :	0	Sewing Fty:	1/0/00
Division : Men's Bottoms	Style #: BRP-E0835	0	Vendor:	0	Garment COO :	1/0/00

T135; SPI +/-10

Zipper, Slider & Pull:
#5 YKK YZP Zipper, GS6/NS Slider,
"H" Light Antique Brass Teeth,
SNTS, 1/16" margin
See miniCAD for Tape Color

Coin Pocket —
Spoon Shape Double turn back
Clean finish Hem with
301 DNTS 3/8" Margin
Set to facing with
301 DNTS, 1/16" margin 1/4" gg

Scoop Pocket:
Clean set pocket bag to scoop
301 DNTS, 1/16" margin 1/4" gg
at Pocket Opening
Nipple Rivets at Ends

Inseam:
3N Flat Fell
1/16" margin,
1/16" gg
between stitch rows

27L Scoffed Duramark® Tack Button
(Division 71) Open Top, Finish 4134

Keyhole Button Hole:
304 Lockstitch
Add Gimp Filament to Eliminate Fraying
See miniCAD for Thread Color

Set-On Waistband:
401 SN Chainstitch
1/16" margin, Top & Bottom
Bobbin Thread: Contrast A&E W44119 Mars Red

Fly J-Stitch:
301 DNTS
1/16" Margin, 1/4" gg
Horizontal
304 Lockstitch Bartack

Front Rise:
512 Mock Safety Stitch
w/ DN 301,
1/16" margin, 1/4" gauge
to bottom of J-Stitch

Forward Side Seam:
512 Mock Safety Stitch
w/ 301 SNTS
1/16" margin,
1/4" gauge

CB Beltloop ONLY:
Contrast 304 Lockstitch
Bartack at Bottom

Yoke:
Back OVER Yoke
3N Flat Fell
1/16" margin,
1/16" gg
between
stitch rows

Back Rise:
3N Flat Fell
1/16" margin,
1/16" gg
between
stitch rows

Bottom Hem:
1" Clean Finish
Double Turn Back & 301 SNTS

Leather Patch:
301 SNTS, 1/16" Margin (All 4 Sides)

(2) Beltloops:
0.75 in W x 2.375 in H
4 at front & 3 at back
Use Beltloop Folder Machine (if possible)
406, DNTS 1/4" gg
304 Lockstitch Bartack at Top & Bottom

Back Patch Pockets
See Page 2

Stickers
See Put-Up
Instructions

Style Number: E0835

Season: 2025

Date: 09.02.2021

Fit: Released

Customer: See miniCAD

Product: Scoop Pocket Pant

Brand: See miniCAD

Inspiration: Customer Rugged Patch Released PB Duck Dungarees, Style #103279

Thermal Stability: T135, SPI +/-10

Gender: Male

Public Weight: See miniCAD

Designer: Roger

Public Content: See miniCAD

Tech Designer: Roger

Version: 01

changed style number from 0321 to 0835, changed button to BR

Date: 3.12.25

Initials: AB

BACK POCKET & DECORATIVE STITCHING DETAIL/S
(ACTUAL SIZE for SIZES 28-38 – Grade Accordingly)

Style Number: E0835

Season: 2025

Date: 09.02.2021

Fit: Released

Customer: See miniCAD

Product: Scoop Pocket Pant

Brand: See miniCAD

Inspiration: Customer Rugged Patch Released PB Duck Dungarees, Style #103279

Thermal Stability: T135, SPI +/-10

Gender: Male

Public Weight: See miniCAD

Designer: Roger

Public Content: See miniCAD

Tech Designer: Roger

Version: 01

Patch Pocket:
1. Hem Double Turn DNTS 1/16" margin, 1/4" gg
2. Clean Set w/ 301 SNTS, 1/16" margin
3. Decorative 301 SNTS, 3/4" gg at Top
curves down pocket to 1/4" gg
4. (2) Horizontal Bartacks (304 Lockstitch)
at Each Side Top Corners of Pocket

Woven Patch:
1. Set 2.00 in Down from Pocket Top Edge
Center Side-to-Side on Panel
Sew Woven Patch with 301 SNTS, 1/16" margin

Pg 2 of 3

INSIDE FRONT PANT DETAIL/S

Style Number: E0835

Season: 2025

Date: 09.02.2021

Fit: Released

Customer: See miniCAD

Product: Scoop Pocket Pant

Brand: See miniCAD

Inspiration: Customer Rugged Patch Released PB Duck Dungarees, Style #103279

Thermal Stability: T135, SPI +/-10

Gender: Male

Public Weight: See miniCAD

Designer: Roger

Public Content: See miniCAD

Tech Designer: Roger

Version: 01

Care/Content/BN Label Placement:
Set into Side Seam
0.50 in Up from
Puckering Side Bottom Edge

Pg 3 of 3

Date:	Reason for Revision:	Revised By:
1.8.2025	Concept Phase / Original Development	ARB

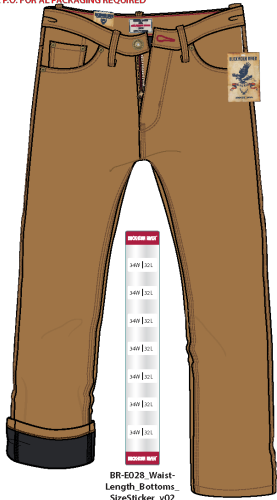
6/16/25E0835 TechPack.xlsx

Date Issued	1.8.2025
Revised	3.20.2025

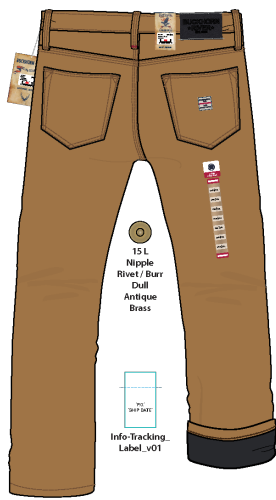
Brand :	BUCKHORN RIVER	Style Name:	Zone	Agent/Office :	0	Sewing Fty:	1/0/00		
Division :	Men's Bottoms	Style #:	BRP-E0835	Proto #:	0	Vendor:	0	Garment COO :	1/0/00

miniCAD / Catalog Copy

SEE P.O. FOR ALL PACKAGING REQUIRED



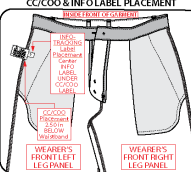
(Ref: E0321)



- T135 thread; SPI +/- 8
- DTM body
- contrast thread: ABEW44119 mars red
- set on waist band
- contrast red cf keyhole button hole
- add gimp filament
- red contrast inside waist band stitching
- TN Fell @ inseam, back rise & yoke
- DNTS @ side seam
- fly zipper:
- #5 closed-end; metal;
- J stitch: 301 DNTS: 1/4" gg
- Rise/Opening: 301 SNTS: 1/16" margin
- IDEAL:
- slider: M595Q; tape color: Red #F519
- teeth: Antique Brass "P50"
- YKK (YG zipper);
- slider: G56JNS; tape color: Red #520
- teeth: "P" Light Antique Brass Teeth
- front scoop pockets
- dnts 1/4" gg
- (2) 15L nipple rivets/burrs at top & side
- spade coin pocket at wearer's right side
- dnts 1/4" gg; 0.50 in clean finish hem
- (2) 15L nipple rivets/burrs at top
- 27L Scovill Duramark® Tack Button (Division 71) Open Top, Finish 4134
- 5 belt loops
- (2) at front & (1) & cb
- dimensions: 1/2"W x 2 1/2"H
- (2) at sides
- dimensions: 1/2"W x 2 3/4"H
- red bartack at cb belt loop bottom only
- 0.50 in clean finish leg opening hem
- 2 back patch pockets
- dnts 1/4" gg (decorative stitch set)
- back yoke (back over yoke)
- logo woven patch on wearer's right side
- back spoede pocket; centered, 1/3rd down
- faux leather logo patch - wearer's back right side wb



"Zone"
MSRP \$00.00
BRP-E0835
Body: 270 gsm, 98% Cotton/2% Spandex
Canvas
Lining: 140 gsm; 100% Poly;
Polar Fleece (BONDED)



Date:	Reason for Revision:	Revised By:
01.09.2025		
	USE COLORS SPECIFIED IN PO SHEET	

1st Fit Comments for: BRP-E0835 Men's Lined Pants AS								
POM Code	DESCRIPTION	Tolerance	Size Measured 34x32	Actual Garment Measurements	Difference	Out of Tolerance by	Revised Spec (if any)	Comments
								Pls see "E0835 Graded Specs updated 3.18.25.pdf" for New Spec
1	Waist, Relaxed HALF	1/2	17 5/8	17 1/4	- 3/8		17 3/8	New Spec
2	Waistband Height	1/8	1 5/8	1 1/2	- 1/8			
3	Front Rise - frm WB seam	1/4	11 1/4	10 3/4	- 1/2		12	New Spec
4	Back Rise - frm WB seam	1/4	14 1/8	15	7/8		15 3/4	New Spec
5	Form Fly / J stitch length - frm WB seam	1/4	7 1/4	6 1/2	- 3/4		6 1/2	Will use spec taken from Sample Garment
6	Functional Fly Opening	1/4	6	6	0			
7	Fly Stitch Width	1/8	1 1/2	1 1/2	0			
8	Low Hip Pposition frm WB seam	0	7 1/2	7 1/2	0			
9	Hip - 3pt measure	1/2	22 3/8	23 5/8	1 1/4		22 3/4	New Spec
10	Thigh - 1" below crotch	3/8	13 1/2	14 1/2	1		14	New Spec
11	Leg Opening	1/2	7 1/2	8 3/4	1 1/4		9	New Spec
12	Hem Height	1/8	1/2	1/2	0			
13	Knee Placement (Short Length)	1/4	13	13	0			
14	Knee Placement (Medium Length)	3/8	14	14	0			
15	Knee Placement (Long Length)	1/2	15	15	0			
16	Knee HALF	1/2	10	10	0			
17	Inseam (Short Length)	5/8	30	30	0			
18	Inseam (Medium Length)	5/8	32	32	0			
19	Inseam (Long Length)	5/8	34	34	0			
20	Forward Side Seam	1/8	1/2	1/2	0			
21	Belt Loop Width	1/8	1/2	5/8	1/8			
22	Belt Loop Length	1/8	2 3/8	2 1/2	1/8			
23	Front Scoop Pocket opening along WB	1/8	4 5/8	4 1/2	- 1/8			
24	Front Scoop Pocket Opening along SS	1/8	3 1/4	3 1/4	0			
25	Front Pocket Bag Width at Top	1/8	6 3/8	6	- 3/8			
26	Front Pocket Bag Length (longest)	1/8	13	11 3/4	-1 1/4			
27	Coin Pocket Position in frm SS	1/8	7/8	3/4	- 1/8			
28	Coin Pocket Position below WB seam	1/8	3/4	1	1/4			
29	Coin Pocket Width at Top Edge	1/4	3 1/8	3 3/4	5/8			
30	Coin Pocket Length at Center	1/4	3	4 3/8	1 3/8			
31	Coin Pocket Lenth at Sides	1/4	2 1/2	3 5/8	1 1/8			
32	Back Pocket Position Down frm WB seam	1/8	1 5/8	3	1 3/8			
33	Back Pocket Position frm CB Rise seam	1/8	2 3/8	1 3/4	- 5/8			
34	Back Patch Pocket Width at Top	1/4	6 3/4	7	1/4			
35	Back Patch Pocket Width at Bottom	1/4	5 1/2	5 3/4	1/4			
36	Back Patch Pocket Length at Center	1/4	6 7/8	7	1/8			
37	Back Patch Pocket Length at Side	1/4	5 3/4	6	1/4			



03.18.2025 - 1st FIT is **REJECTED** - ARB

Overall Appearance

Overall Appearance is amazing in regards to the construction. Garement has been *rejected* do to too many Specs out of tolerance.

Please note the highlighted specs are way out of tolerance and note the Revised Specs givin bolded in **PURPLE**.

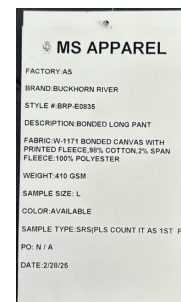
I have updated spec sheet within this TechPack to reflect the new measurements and have also sent it via email with this first fit rejection

Please see "E0835 Graded Specs updated 3.18.25.pdf" for New updated Specs

Materials/Trims

Fabric Content = W-1171 410gsm
Color = available was used
Labeling = good
Packaging/Hangtag = good

Image below for Reference:



2nd Fit Comments for: BRP-E0835 Men's Lined Pants								AS
POM Code	DESCRIPTION	Tolerance	Size Measured 34x32	Actual Garment Measurements	Difference	Out of Tolerance by	Revised Spec (if any)	Comments
								Used "E0835 Graded Specs updated 3.20.25.pdf"
1	Waist, Relaxed HALF	1/2	17 3/8	17	- 3/8			
2	Waistband Height	1/8	1 5/8	1 5/8	0			
3	Front Rise - frm top WB edge	1/4	12	12	0			10.5 from WB seam
4	Back Rise - frm top WB edge	1/4	15 3/4	15 3/4	0			14.25 from WB seam
5	Form Fly / J stitch length - frm WB seam	1/4	6 1/2	6 1/2	0			
6	Functional Fly Opening	1/4	6	6	0			
7	Fly Stitch Width	1/8	1 1/2	1 1/2	0			
8	Low Hip Position frm WB seam	0	7 1/2	7 1/2	0			
9	Hip - 3pt measure	1/2	22 3/4	23	1/4			
10	Thigh - 1" below crotch	3/8	14	14 1/2	1/2	1/8		
11	Leg Opening	1/2	9	9	0			
12	Hem Height	1/8	1/2	1/2	0			
13	Knee Placement (Short Length)	1/4	13	13	0			
14	Knee Placement (Medium Length)	3/8	14	14	0			
15	Knee Placement (Long Length)	1/2	15	15	0			
16	Knee HALF	1/2	10	10	0			
17	Inseam (Short Length)	5/8	30	30	0			
18	Inseam (Medium Length)	5/8	32	31 3/4	- 1/4			
19	Inseam (Long Length)	5/8	34	34	0			
20	Forward Side Seam	1/8	1/2	3/4	1/4	1/8		
21	Belt Loop Width	1/8	1/2	1/2	0			
22	Belt Loop Length	1/8	2 3/8	2 1/2	1/8			
23	Front Scoop Pocket opening along WB	1/8	4 5/8	4 5/8	0			
24	Front Scoop Pocket Opening along SS	1/8	3 1/4	3 1/4	0			
25	Front Pocket Bag Width at Top	1/8	6 3/8	6 1/2	1/8			
26	Front Pocket Bag Length (longest)	1/8	13	13	0			
27	Coin Pocket Position in frm SS	1/8	7/8	7/8	0			
28	Coin Pocket Position below WB seam	1/8	3/4	3/4	0			
29	Coin Pocket Width at Top Edge	1/4	3 1/8	3 1/8	0			
30	Coin Pocket Length at Center	1/4	3	3	0			
31	Coin Pocket Lenth at Sides	1/4	2 1/2	2 3/8	- 1/8			
32	Back Pocket Position Down frm yoke seam	1/8	1 5/8	1 5/8	0			
33	Back Pocket Position frm CB Rise seam	1/8	2 3/8	2 3/8	0			
34	Back Patch Pocket Width at Top	1/4	6 3/4	6 3/4	0			
35	Back Patch Pocket Width at Bottom	1/4	5 1/2	5 5/8	1/8			
36	Back Patch Pocket Length at Center	1/4	6 7/8	6 3/4	- 1/8			
37	Back Patch Pocket Length at Side	1/4	5 3/4	5 1/2	- 1/4			



4.3.2025 - 2nd FIT is **APPROVED** - ARB / ANS

Overall Appearance

Overall Appearance is great. This sample had much more accurate specs we are pleased with. Please proceed.

-Please Note:

-Zipper Pull/Slider does not seem like an auto lock or semi auto lock though intention seems as such

-Pull seems too small for Men's hands

Materials/Trims

Fabric Content = 98% Cotton / 2% Spandex
 Color = available was used
 Labeling = good
 Packaging/Hangtag = good

Image below for Reference:



