FC VASLUI / ALIS Short-sleeve football shirt	**STYLE** FCV-FB-001 **COLOURWAY** Grey / black	**DATE** 08 november 2020 **BASE SIZE** M / Medium	**REVISION** 02 **STAGE** Development / sample

TECH PACK / MEDIUM SAMPLE



FRONT



BACK

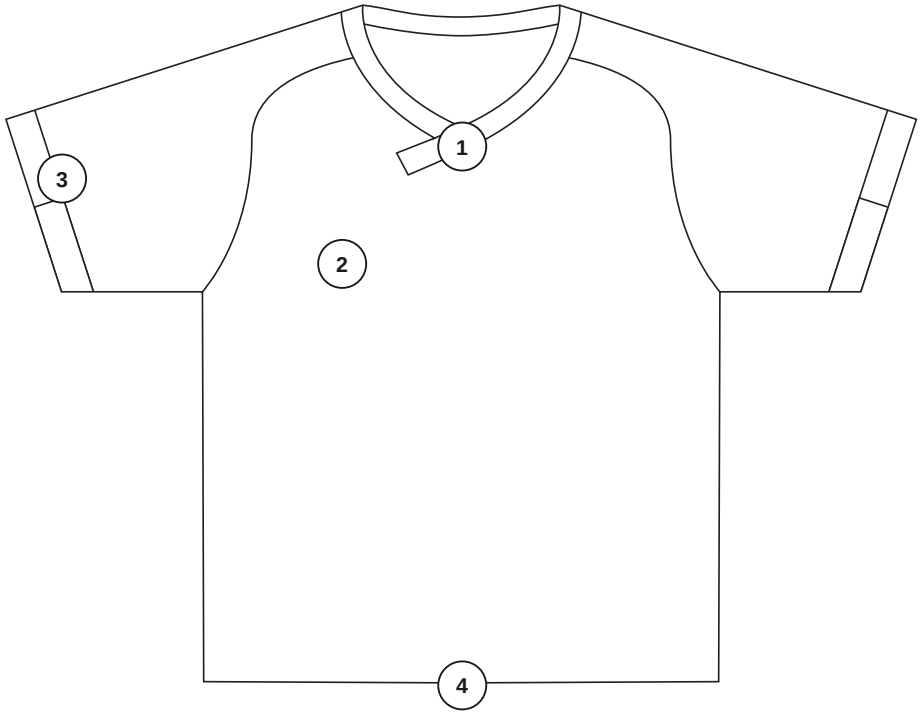
Raglan football shirt with all-over checkerboard sublimation, crossover rib collar, two-material cuffs, embroidered branding and a separate ribbed back-hem panel.

Sample issue. M confirmed by Alex. Bulk release requires closure of the production items on page 18.

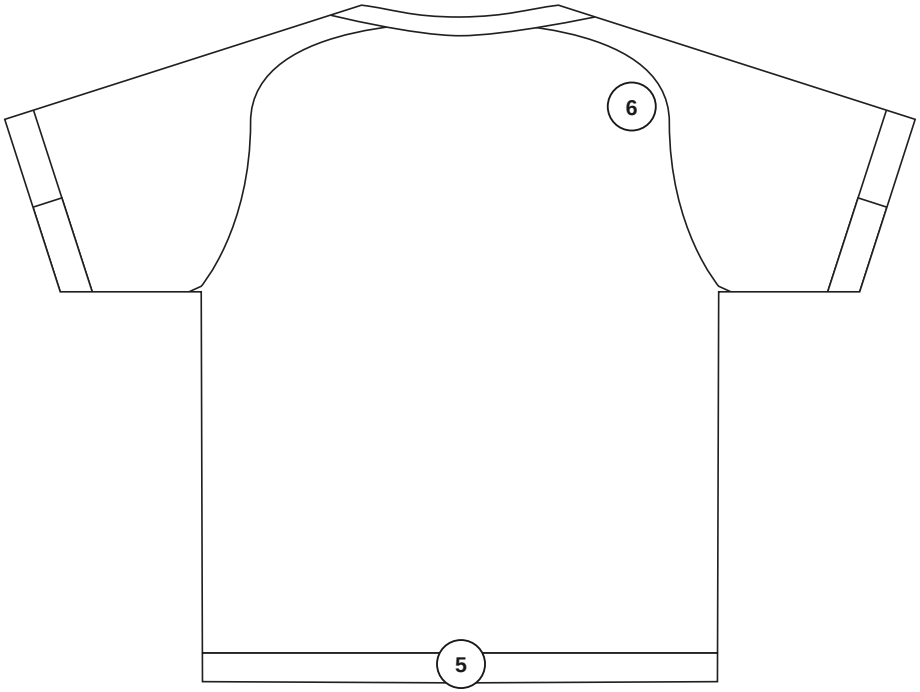
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TECHNICAL FLATS / DESIGN DETAILS

FRONT



BACK



ID	Construction / design requirement
1 / 2	Black crossover rib collar. ALIS at wearer right chest; club crest at wearer left chest.
3 / 4	Each cuff: black outer section is rib; grey inner section is body-quality bird eye. Front hem is self fabric.
5 / 6	Black back hem is a separate cut-and-sewn rib panel. Raglan sleeves; checkerboard and motifs are sublimated.

BILL OF MATERIALS / FABRIC MAP

ID	Item / placement	Specification	Quantity / shirt	Status
F01	Front, back, both sleeves; grey inner cuff sections	Bird-eye knit, 150-160 gsm. Proposed composition: 100% polyester suitable for sublimation. Printed body/sleeves; solid grey cuffs.	6 visible panels	Bird eye + weight confirmed; composition / mill article to approve
F02	Crossover collar; black outer cuff sections; black back hem	Black rib knit. Proposed 1 x 1 polyester/elastane rib; firm recovery, soft hand. Match all three rib applications.	4 visible panels	Rib applications confirmed; blend, gsm and stretch to approve
T01	Assembly thread	Polyester sewing thread; colour matched to visible ground. Proposed Tex 24-30 needle thread with soft textured looper thread.	Factory consumption	Proposed / sewing trial
T02	Back neckline seam covering	Soft self-fabric or compatible polyester neck tape; proposed finished width 1.0 cm.	1 length	Proposed
E01	ALIS embroideries	Two-colour embroidery, black outline / grey fill, supplied artwork.	3 applications	Confirmed method / areas
E02	Club crest embroidery	Multitone monochrome embroidery; retain supplied crest details.	1 application	Confirmed method / area
T03	Embroidery support	Soft permanent stabiliser suitable for lightweight knit; protective soft backing where needed.	4 areas	Trial and approve
L01 / L02	Size and care / composition labels	Soft labels; content and dimensions require approval. See page 16.	1 of each	Pending
P01	Individual packaging	Clear protective bag, size sticker and carton identification.	1 set	Proposed

No fabric consumption is approved. Supplier must cost from the final production pattern, usable width, shrinkage and marker yield.

MATERIAL & CONSTRUCTION REFERENCES



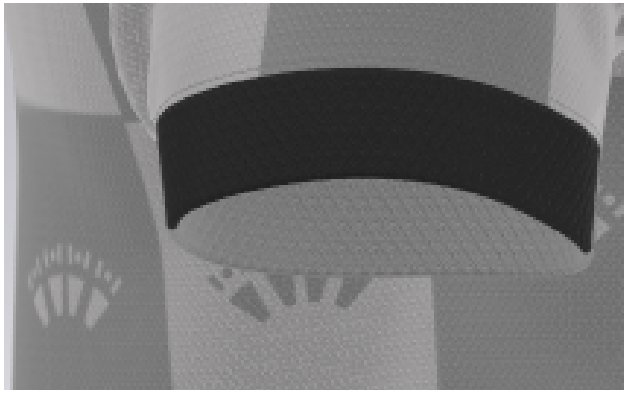
Bird-eye texture / physical fabric reference

Reference image: Global Fabric Wholesale, article 7002, 150 gsm polyester bird eye. Texture reference only; this mill/article is not nominated. Submit the actual 150-160 gsm quality.



Crossover collar / design reference

Detail from supplied CLO render. Rib follows the V and crosses at centre front. Copy the overlap direction shown; approve the physical overlap and neck recovery.



Two-material cuff / design reference

Detail from supplied CLO render. Only the black outer section is rib. Grey inner section is bird eye. The material boundary is a sewn join; no open slit is specified.



1 x 1 rib structure - schematic



Stitched ALIS appearance - CLO render

Reference photographs and CLO textures establish appearance. The BOM and approved physical swatches establish production materials.

COLOUR STANDARD / PROPOSED PANTONE MATCHES



C01 / Light grey
PANTONE 14-4102 TCX
Glacier Gray



C02 / Mid grey
PANTONE 16-5803 TCX
Flint Gray



C03 / Black
PANTONE 19-0303 TCX
Jet Black

Application	Colour assignment / approval
Checkerboard & repeated motif	C01 and C02 in alternating fields; motif reverses tone against each field. Preserve supplied artwork tones and panel mapping during strike-off.
Grey inner cuffs	C02, colour matched to the mid-grey body field after sublimation.
All rib panels	C03: collar, both black outer cuff sections, black back-hem panel.
ALIS / crest threads	Black and grey thread shades matched to supplied vector art. Crest contains additional charcoal and pale details; supplier to submit a full numbered thread card and sew-out. Do not flatten the crest to two colours.

Approval method: The Pantone codes above are proposed visual starting points, not measured matches. Swatches shown reproduce approximate source artwork/CLO tones, not certified Pantone standards. Compare physical TCX chips, rib lab dips, printed bird-eye strike-offs and embroidery thread together under consistent daylight lighting.

Production colour master = signed physical strike-off + rib lab dip + thread card. Screen RGB values are not a dye recipe.

DETAIL A / RIBBED CROSSOVER COLLAR



Reference: supplied CLO front view

Feature	Specification
Material	F02 black rib. Proposed 1 x 1 construction; ribs run across the band depth, stretch runs along neck circumference.
Visible width	2.50 cm development target, based on the 2.50 cm virtual strip. Measure perpendicular to seam away from the V. Proposed tolerance +/- 0.2 cm.
Overlap direction	Wearer left band passes over wearer right at centre front, as shown in the front reference. Retain the slanted visible tip.
Attachment	Proposed folded two-ply rib, both raw edges enclosed in the neckline overlock seam. Secure overlap through both layers without visible bulky stitching.
Inside finish	Cover back-neck seam with soft tape. Keep V junction flat; no exposed raw edges or scratchy tails.
Sample checks	Neck must pass over head, recover after stretch and lie flat. Confirm overlap depth, cut length, rib recovery and seam allowance on the first sewn sample.

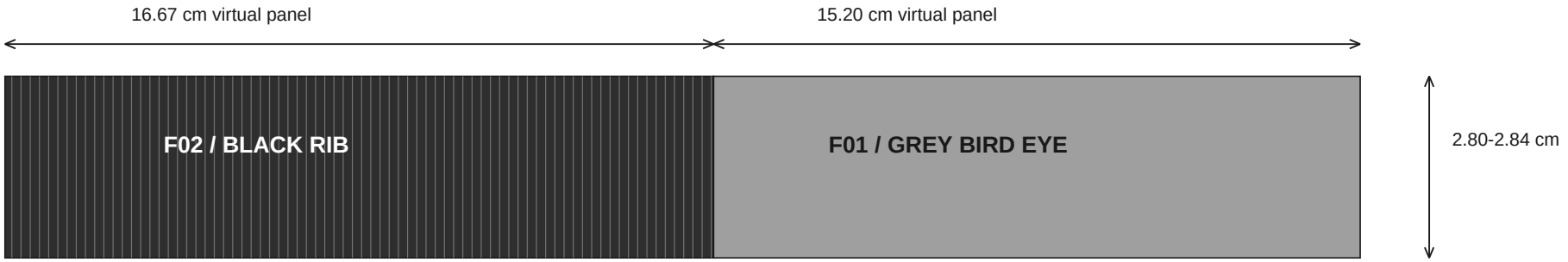
Pattern development note

CLO / supplied pattern strip: **45.16 x 2.50 cm**. This is virtual panel geometry, not a verified two-ply cutting dimension. A folded 2.50 cm band needs two face depths plus seam allowances; factory must develop the cutting width accordingly.

Do not cut the 2.50 cm virtual strip and fold it in half. The finished visible collar width must be preserved.

DETAIL B / SPLIT-MATERIAL CUFFS

Unrolled cuff - outside face, schematic



Join short ends to form cuff loop. Black section sits on outer arm; grey section sits on inner arm. Mirror left/right.

Construction point	Requirement
Material division	Two distinct sewn sections per cuff. Approximate half / half appearance. Model lengths are unequal; retain outer/inner orientation, do not replace both with rib.
Finished depth	Proposed 2.80 cm visible depth around the cuff, +/- 0.2 cm after relaxation. Source virtual outer edge varies from 2.80 to 2.84 cm.
Assembly	Proposed two-ply folded band. Join black and grey sections at both ends, align fold levels, then attach to sleeve with stretch overlock. Conceal raw edges.
Fit / ease	Virtual sleeve opening is 35.97 cm; combined cuff segments are 31.87 cm before seam treatment. Do not stretch both materials equally: validate grey self section length and distribute only appropriate ease into rib.
Acceptance	No twisting, roping or open cuff gap; both cuffs have matching depth, orientation and colour boundaries. Confirm finished opening circumference on the M sample.

DETAIL C / CUT-AND-SEWN RIBBED BACK HEM



Feature	Requirement
Material	F02 black rib, matching collar and black outer cuffs. This construction specification takes precedence over the CLO surface texture.
Location	Separate panel across back hem only; extends from left side seam to right side seam. Front bottom remains bird-eye self fabric.
Visible depth	Proposed 2.80 cm finished rib depth, +/- 0.2 cm. Virtual pattern reads 48.61 x 2.80 cm.
Construction	Proposed folded two-ply rib band. Attach to back body lower edge with stretch overlock; press seam allowance upward and topstitch if sample confirms a flat finish.
Side transition	Catch rib ends into side seams. Finish front self hem cleanly at both transitions. Preserve the back/front silhouette shown; confirm any step at side seam on M fitting.
Pattern preparation	Develop doubled cut width plus seam allowance for folded construction. Agree rib length/recovery so the back does not gather or pull the side seams rearward.



Black rib band: across back only

Back-hem rib is a sewn component, not a black sublimated stripe. Do not continue the rib around the front.

ASSEMBLY / STITCH & SEAM SCHEDULE

Operation	Proposed seam / stitch	Development setting	Quality requirement
Raglan seams; sleeve and body side seams	4-thread stretch overlock / 514	0.7 cm seam allowance; 4-5 stitches per cm	Stretch without thread break; balanced feed, no puckering or skipped stitches.
Collar-to-neck join	4-thread stretch overlock / 514	0.7 cm seam allowance; 4-5 stitches per cm	Enclose both rib plies; secure V overlap. Validate neck stretch.
Cuff joins and cuff-to-sleeve	4-thread stretch overlock / 514	0.7 cm seam allowance; 4-5 stitches per cm	Match cuff folds and segment joins. Avoid differential shrinkage.
Back rib-to-body	4-thread stretch overlock / 514	0.7 cm seam allowance; 4-5 stitches per cm	Keep rib flat without gathering the back.
Front self hem	2-needle coverstitch / 406	Proposed turnback 2.0 cm; needle gauge 0.6 cm	Catch raw edge; keep hem level. Verify finished body length.
Back-neck tape / optional seam topstitch	Coverstitch / 406, or approved stretch finish	Gauge and offset established by sewn sample	Smooth against skin. Visible thread colour matched to ground.
Label attachment	Lockstitch / 301	Small ballpoint needle; secure start/end	Soft, clean reverse; no label corners lifting.
Logo embroidery	Digitised satin / fill / running stitches as artwork requires	Polyester embroidery thread; density, needle and stabiliser determined by sew-out	No holes, puckering, stiff patch effect, exposed jumps or illegible crest lettering.

Suggested operation order: approve fabric and strike-off; print/heat-set panels; stabilise and embroider flat panels; join raglan seams; close sleeves/body; prepare collar and cuffs; attach back rib; finish front hem; attach labels; inspect, measure and pack.

These sewing settings are proposed, not extracted from the CLO simulation. Factory must verify them on the actual fabric before release.

ARTWORK / EMBROIDERED LOGOS



E01 / ALIS
3 applications per shirt
20 cm^2 per application



E02 / CLUB CREST
1 application per shirt
60 cm^2 per application

Artwork masters
ALIS - LOGO.ai
LOGO.ai

Use the supplied outlines and wording. The crest reads SPORTING JUNIORUL / VASLUI / 2009. Preserve all internal details; do not redraw from the render.

Sizing interpretation	Provisional outer bounding size	Required approval
ALIS: 20 cm2 bounding rectangle	6.19 W x 3.23 H cm	Approve whether stated area means bounding rectangle or filled embroidery area.
Crest: 60 cm2 bounding rectangle	7.54 W x 7.96 H cm	Approve final dimensions and complete sew-out at actual size.

Areas are supplied; width/height above are calculated using vector aspect ratio and a stated bounding-box assumption. They are not approved dimensions.

LOGO PLACEMENT / WEARER ORIENTATION



Wearer right chest

Wearer left chest



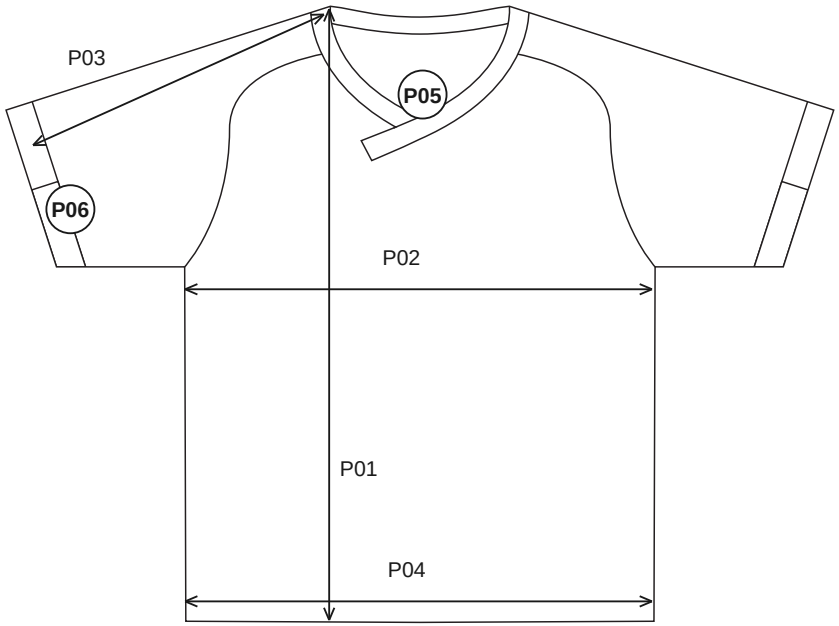


Factory placement proof required: supplied files identify locations and areas but no finished seam-to-logo offsets. CLO graphic extents include transparent margins. Submit a 1:1 placement proof with offsets to actual stitched artwork, not the PNG box. Proposed final placement tolerance: +/- 0.3 cm.

ID / location	Application	Placement control
A / wearer right chest	ALIS, 20 cm2	Place on front panel as reference. Record horizontal centre from CF and vertical top edge from HPS after size/area approval.
B / wearer left chest	Club crest, 60 cm2	Place on front panel as reference. Set top/centre alignment intentionally; do not assume same bounding-box height as ALIS.
C / both outer sleeves	ALIS, 20 cm2 each	Centre on outer upper arm. Define top edge from raglan neck point along sleeve centreline; verify both sleeves in worn orientation.

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POINTS OF MEASUREMENT / METHOD



POM	Measurement method
P01 / shirt length	Proposed definition: high point shoulder (HPS) at neck/raglan junction, vertically to front finished hem. Exclude collar. Confirm definition with 69 cm target.
P02 / chest width	Lay garment flat, smooth without stretch; measure straight across body 2.5 cm below underarm junction. Half circumference.
P03 / raglan sleeve length	Proposed definition: from neck/raglan junction along sleeve upper centreline to finished cuff edge, including cuff. Confirm against 30 cm source value.
P04 / bottom width	Straight across front at finished bottom, garment relaxed.
P05 / neck & collar	Record neck width between inner collar seams; front drop from HPS line to lowest neckline seam; rib depth perpendicular to join.
P06 / cuff opening	Measure closed cuff laid flat at finished opening without stretch. Also record full relaxed circumference.

Measure a fully finished, conditioned sample laid flat without tension. Raw pattern dimensions and 3D render proportions are not finished measurements.

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MEDIUM SPECIFICATION / FIT & GRADING

POM	Finished garment dimension	M target (cm)	Tolerance +/-	Evidence / status
P01	Shirt length	69.0	1.0 proposed	SIZES.csv; measurement endpoints to confirm
P02	Chest width, laid flat	49.0	1.0 proposed	SIZES.csv; proposed method on page 12
P03	Raglan sleeve length	30.0	0.7 proposed	SIZES.csv; inclusion of cuff to confirm
P04	Bottom opening width	To establish	1.0 proposed	Virtual front lower edge 48.61; not a finished target
P05a	Neck opening width / front & back drops	To establish	0.5 proposed	Measure M sewn sample and approve head passage
P05b	Visible collar rib depth	2.50 proposed	0.2 proposed	Source virtual strip depth 2.50
P06a	Cuff opening, flat / circumference	To establish	0.5 proposed	Source segments total 31.87 around; ease/ply treatment unresolved
P06b	Visible cuff depth	2.80 proposed	0.2 proposed	Source virtual depths 2.80-2.84
P07	Visible back-hem rib depth	2.80 proposed	0.2 proposed	Source virtual depth 2.80
P08	Across back; bicep; raglan seam lengths	To establish	Factory proposal	Needed to lock fit and grading
P09	Back finished length / side hem step	To establish	1.0 proposed	Virtual back body plus separate rib differs from front; fit review required

Sample size: M. No other production sizes or grade rules have been supplied. Factory to return a measured M prototype and proposed graded spec for any requested size range; do not infer grading from the quotation's generic size list.

PATTERN INVENTORY / DEVELOPMENT GEOMETRY

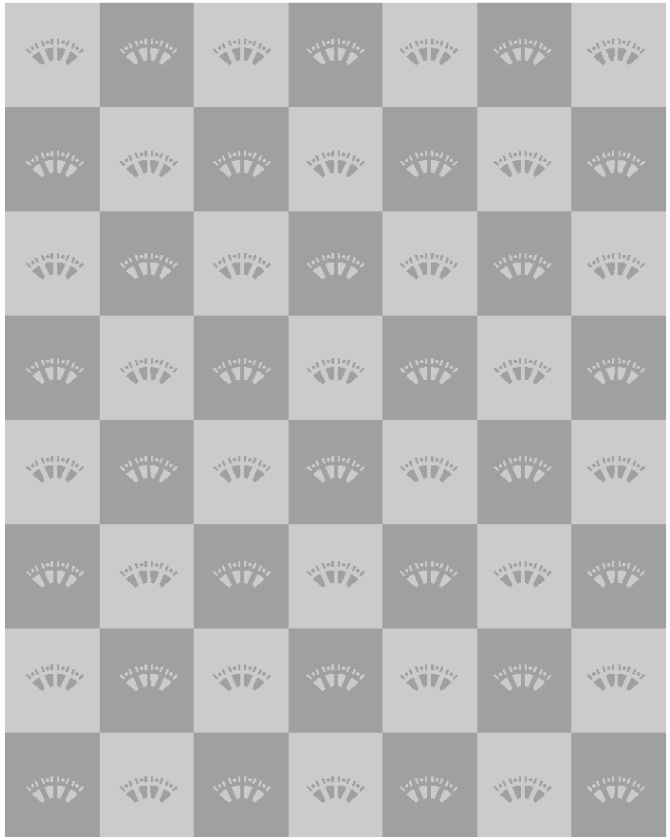
Piece	Qty	Material	Virtual reference dimensions (cm)	Production interpretation
Front	1	F01	Lower edge 48.61; side edge 47.12	Full front panel; raglan opening and V as pattern
Back	1	F01	Lower edge 48.60; side edge 44.32	Back panel above separate rib band
Right / left sleeve	1 each	F01	Bottom edge 35.97; raglan edges 32.28 / 29.08	Handed pieces; preserve seam matching and print direction
Collar	1	F02	45.16 long x 2.50 deep	Virtual face strip; develop folded cutting pattern
Outer right / left cuff	1 each	F02	16.67 long x 2.80-2.84 deep	Black rib half; mirrored placement
Inner right / left cuff	1 each	F01	15.20 long x 2.84 deep	Solid grey self-fabric half
Back hem	1	F02	48.61 long x 2.80 deep	Separate black rib panel; develop folded cutting pattern

10 visible panels in the CLO model. Physical cutting count changes if separate underlayers, facings or tape are developed. Strip depths describe the virtual surface and do not include the additional depth required for two-ply folded bands.

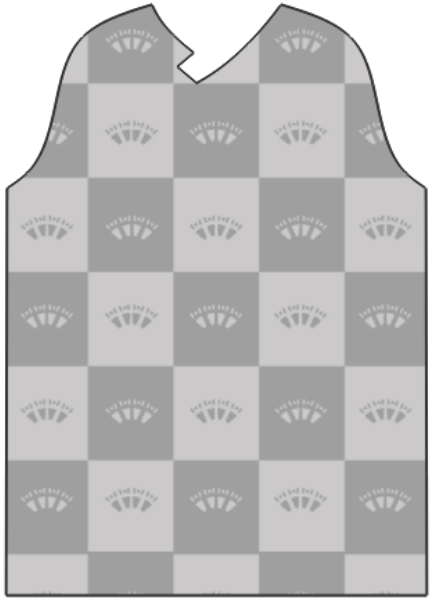
DXF supplied: ASTM, ungraded, exported at 100% with Millimeter selected. Import in millimetres: collar long edge must read **451.58 mm**. The DXF header is unitless; this scale check is mandatory. Pattern blocks identify size M.

Factory to verify cut/sew lines, seam allowances, notches, grainlines and rib ease. The exported DXF is a development reference, not a released cutting marker.

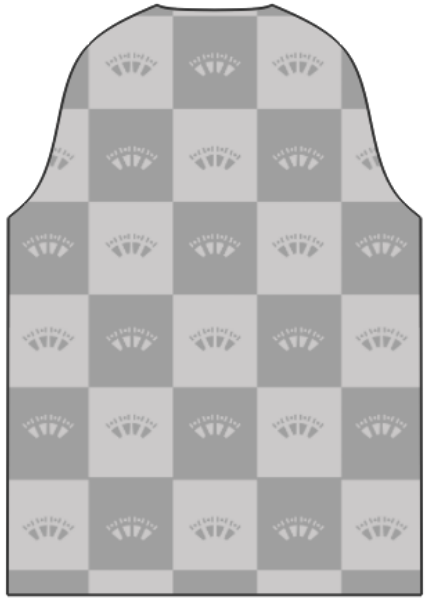
SUBLIMATION / PANEL ARTWORK CONTROL



REPEAT ARTWORK



FRONT MAP



BACK MAP

Print on F01 body and sleeves. Preserve checkerboard placement and alternating reversed motifs. Grey inner cuffs are solid grey; F02 rib is solid black. Four branding logos are embroidery and must be excluded from the sublimation artwork.

Use PATTERN.ai for vector repeat art and the exported CLO mapped panel images as placement references. CLO applies different texture scaling to body and sleeves; approve the mapped result before preparing production print panels. Allow print bleed beyond the final cutting edge.

Approve full-size front, back and both sleeve print proofs. Do not print miniature tech-pack images or use their page scale for production.

LABELS / FOLDING & PACKAGING

Item	Proposed specification	Approval needed
Size label	M. Soft woven or printed label at inside centre back neck, positioned clear of rib overlap and skin pressure.	Final dimensions, artwork and exact seam position.
Care / composition label	Soft printed label in wearer left side seam; proposed 10 cm above finished front hem. Declare body and rib composition separately if different.	Actual fibre percentages, country of manufacture, market/languages and verified care instructions.
Care development	Trial gentle washing at 30 C, inside out; no bleach, line dry, avoid direct heat on embroidery. This is a test proposal, not approved consumer label copy.	Validate against the finished fabric, sublimation, thread and trims before printing labels.
Hangtag	No hangtag design specified. If requested, attach through label with soft loop; do not pierce garment or embroidery.	Artwork, size, cord and quantity.
Individual pack	One dry, inspected shirt per clear protective bag. Size and style sticker readable externally. Bag dimension to suit approved fold without compression.	Bag material / thickness and required destination warnings.
Carton	Group by style, colour and size. Mark carton number, contents, quantity, gross/net weight and order reference.	Order quantity, size breakdown and carton specification.

Folding sequence

1. Lay front down on a clean surface. 2. Fold sleeves inward without creasing the logos. 3. Fold sides symmetrically. 4. Fold lower body upward, avoiding hard creases across embroidery. 5. Turn front up and insert into bag with size identification visible.

QUALITY CONTROL / SAMPLE APPROVAL

Gate	Submission / inspection	Release criterion
Material	Actual bird-eye swatch, composition and gsm report; rib swatch with blend, gsm and stretch/recovery.	Body within 150-160 gsm; approved rib recovery and handle.
Colour / print	Printed body/sleeve strike-off plus grey cuff, black rib and full embroidery thread card.	Signed physical colour set; no migration, banding or unintended colour cast.
Embroidery	All logo designs sewn at final dimensions on actual printed bird eye with proposed support.	Legible details; correct logo areas and positions; soft reverse and no fabric damage.
M fit prototype	Measure every POM, mark actual values and deviations; provide front/back/side photos and pattern revisions.	69 / 49 / 30 cm source targets reconciled with agreed methods; collar/cuff ease and hem transition approved.
Wash / wear trial	Test complete shirt with all rib and embroidery. Proposed development target: dimensional change within 3% after 3 agreed wash cycles.	Agree test method and record results; no objectionable puckering, dye transfer, print loss or rib distortion.
Pre-production sample	Final materials, patterns, print, embroidery, labels and packaging.	Signed sealed sample and completed spec; all page 18 items closed.
Bulk inspection	Inspect seam quality, four logos, cuff orientation, back rib, print alignment, measurements, labels and packing.	Agreed inspection plan and defect limits; no unauthorised substitutions.

No lab testing is represented as completed. Akilex quotation excludes testing fees; agree the required tests and cost before bulk approval.

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PRODUCTION RELEASE / SOURCES & OPEN ITEMS

Open item	Required factory / buyer decision
Pattern & M measurements	Approve POM endpoints, remaining fit dimensions, folded rib cutting widths, seam allowances and rib ease. Reconcile DXF with finished targets.
Artwork & placement	Confirm logo area convention, outer width/height and seam-to-artwork offsets. Approve digitising, thread card and full-size print maps.
Materials & colour	Approve body composition, rib specification and physical Pantone/print/thread matching.
Order / labels	Confirm any sizes beyond M, grading, quantity split, legal label content, packaging and inspection plan.

Akilex quotation context: Guangzhou Akilex Sporting Goods Co. Ltd; source date 11 November 2020. Cross-V football shirt, full sublimation, 150-160 gsm, 50 pieces at USD 8.41 EXW (USD 420.50). Sample lead time 10-14 working days. Rib/embroidery inclusion is not explicit; obtain a revised scope-confirmed quotation. The requested tech-pack date remains 08 november 2020.

Source hierarchy: Alex's shirt specifications (including M and ribbed back hem) control this pack; then shirt-specific dimensions/artwork and inspected CLO model. Glass Factory is a layout/content example only. Its cotton, long sleeves, dates, flock print and labels do not apply to this shirt.

Local sources: SIZES.csv; LOGO PLACEMENT - DIMENSIONS.txt; SHIRT - DETAILS.pdf/.ai; ALIS - LOGO.ai; LOGO.ai; PATTERN.ai; supplied 1-4.png; FC_VASLUI_FRONT.pdf / FC_VASLUI_BACK.pdf (replacement flats); current 13.zpac exported as FCV-M-CLO.zpac and development DXF. Original commercial/payment details are not part of the factory artwork bundle.

External references: Pantone 14-4102 TCX; 16-5803 TCX; 19-0303 TCX. Bird-eye photo: Global Fabric Wholesale, 7002. Coats T-shirt stitch guidance. External references were researched for this compilation; they do not establish historical supplier availability.

Bulk production status: NOT RELEASED. Factory / buyer approval: _____ Date: _____