




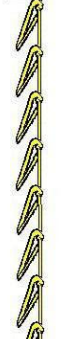

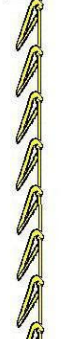







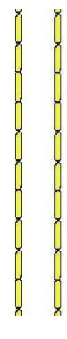

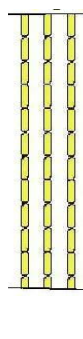



Stitch Drawing		ISO 4915	Common	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn	Number	Application		
 <p>Single Thread Chainstitch</p>  		101	Basting Stitch for Tailored Clothing; Bag Closing	1) Specify SPI	Stitch formed by a needle thread passing through the material and interlooping with itself on the underside of the seam with the assistance of a spreader.
 <p>Single Thread Chainstitch or Lockstitch BS, BH or Bartack</p> 	<p>* 304 Lockstitch is preferred when stitch security is a Must.</p> 	101 or 304	Buttonsew, Buttonhole or Bartack	1) Buttonsew - specify stitches per cycle, ex.16 ; 2) BH - specify length & width; 3) Bartack - specify length & width of Tack	Knit Shirts - Buttonhole length generally is 1/2 inch, is placed horizontally, with approximately 85-90 stitches.
 <p>Single Thread Blindstitch</p>	<p>No stitch visible on the Bottom or Outside of Sewn Product</p> 	103	Blindstitch Hemming, Felling, Belt Loops	1) Specify SPI - typically 3 - 5 spi; 2) Non-Skipped Stitch or 2 to 1 Skipped Stitch on sheer fabrics	Stitch is formed with one needle thread that is interlooped with itself on the top surface of the material. The thread passes through the top ply and horizontally through portions of the bottom ply without completely penetrating it the full depth.
 <p>Single Thread Lockstitch</p>	<p>Bobbin Thread on Bottom</p> 	301	Topstitching, Single Needle Stitching, Straight Stitching	1) Specify SPI	Stitch formed by a needle thread passing through the material and interlocking with a bobbin thread with the threads meeting in the center of the seam. Stitch looks the same top & bottom.
 <p>Zig Zag Lockstitch</p>		304	Intimate Apparel, Athletic wear, Infantwear, Exercisewear	1) Specify SPI; and 2) Specify Throw	Stitch is formed with a needle and a bobbin that are set in the center of the seam and form a symmetrical zig zag pattern. Also used to identify bartacking and lockstitch buttonsewing and buttonholing.
 <p>Chainstitch</p>	<p>Looper Thread on Bottom</p> 	401	Single Ndl Chainstitch - Mainseams on Wovens	1) Specify SPI	Stitch formed by 1 needle thread passing through the material and interlooped with 1 looper thread and pulled up to the underside of the seam.
 <p>2 Ndl. Bottom Coverstitch</p>		406	2 Ndl Hemming, Binding, Elastic Coverseaming, Elastic to Panties, Belt Loops	1) Specify Needle Spacing (1/4", 3/16", 1/8"); and 2) Specify SPI	Stitch formed by 2 needle threads passing through the material and interlooping with 1 looper thread with the stitch set on the underside of the seam. Looper thread interlooped between needle threads providing seam coverage on the bottom side only.
 <p>3 Ndl. Bottom Coverstitch</p>		407	Attaching Elastic to Men's & Boys Knit Underwear	1) Specify Needle Spacing (1/4"); and 2) Specify SPI	Stitch formed by 3 needle threads passing through the material and interlooping with 1 looper thread with the stitch set on the underside of the seam. Looper thread is interlooped between needle threads providing seam coverage on the bottom side only.

Stitch Drawing		ISO 4915	Common	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn	Number	Application		
		503	Serging & Blindhemming	1) Specify Width Bite (Ex. 1/8", 5/32" 3/16"); and 2) Specify SPI	Stitch formed by 1 needle thread and 1 looper thread with purl on edge of seam for Serging or Blindhemming ONLY.
		504	Single Ndl. Overedge Seaming	1) Specify Width Bite (Ex. 1/8", 5/32" 3/16"); and 2) Specify SPI	Stitch formed with 1 needle thread and 2 looper threads with the looper threads forming a purl on the edge of the seam. For Overedge Seaming and Serging.
		505	Serging with Double purl on Edge	1) Specify Width Bite (Ex. 1/8", 5/32" 3/16"); and 2) Specify SPI	Stitch formed with 1 needle thread and 2 looper threads with the looper threads forming a double purl on the edge of the seam for Serging ONLY.
		512	Seaming Stretch Knits, Wovens	1) Specify SPI	Stitch formed with 2 needle threads and 2 looper threads with the looper threads forming a purl on the edge of the seam. 512 - right needle only enters the upper looper loop. Stitch does NOT chain-off as well as 514 Stitch
		514	Seaming Stretch Knits, Wovens	1) Specify SPI	Stitch formed with 2 needle threads and 2 looper threads with the looper threads forming a purl on the edge of the seam. 514 - both needles enter the upper looper loop. Preferred over 512 Stitch because it chains-off better.
		516	Safety Stitch Seaming Wovens & Knits	1) Specify Needle Spacing & Bite - Ex.: 5 1/8", 12 3/16"; 2) Specify SPI	Combination stitch consisting of a single-needle chainstitch (401) and a 3-thread Overedge stitch (504) that are formed simultaneously.
		602	Binding A Shirts, Infants Clothing, etc.	1) Specify Needle Spacing - Ex: 1/8", 3/16"; and 2) SPI	Stitch formed with 2 needle threads, a top cover thread and a bottom looper thread.
		605	Lap Seaming, Coverseaming, Binding on Knits	1) Specify Needle Spacing - Ex: 1/4"; and 2) SPI	Stitch formed with 3 needle threads, a top cover thread and a bottom looper thread.
		606	Flat or Lap Seaming Knit Underwear, Fleece, etc.	1) Specify SPI	Stitch formed with 4-needle threads, a top cover thread, and four bottom looper threads that are interlaced together. Generally, a 607 stitch is preferred because machines are easier to maintain.
		607	Flat or Lap Seaming Knit Underwear, Fleece, etc.	1) Specify SPI	Stitch formed with 4 needle threads, a top cover thread and a bottom looper thread. Preferred over 606 stitch because machines are easier to maintain.