

Construction (Stitch & Seam) Terminology

CONSTRUCTION ABBREVIATIONS:

A/H	Armhole
BH	Button Hole
Bk	Back
BND	Back Neck Drop
Btm/Bttm	Bottom
CB	Center Back
CD	Construction Details
CF	Center Front
Circ.	Circumference
DBL	Double
Emb	Embroidery
FF Shaping	Full Fashion Shaping
FND	Front Neck Drop
FNR	Full Needle Rib
Frt	Front
GG/gg	Gauge
H/S	Head Stretch
HF Shaping	Hidden Fashion Shaping
HPS	High Point Shoulder
Nk	Neck
OS	Outseam
Pkt	Pocket
Plkt	Placket
Pt	Point
SA	Seam Allowance
SS	Side Seam
Shldr	Shoulder
Slv	Sleeve
UA	Upper Arm
WB	Waistband
X	Across

ABBREVIATIONS FOR STITCH & SEAM TYPES:

LS	Lockstitch (301)
CS	Chainstitch (401)
FF	Flat Felled Seam
MF	Mock Felled Seam
SN	Single Needle
2N	Double Needle (Two Needle)
3N	Three Needle (Triple Needle)
4N	Four Needle
TS	Topstitch
SPI	Stitches per inch

Examples using abbreviations above:

SN/LS	Single needle lockstitch (301)
SN/CS	Single needle chainstitch (401)
1/8" 2N/LS	Double needle lockstitch (301-2)
1/8" 2N/CS	Double needle chainstitch (401-2)
1/4" 2N	Bottom Coverstitch (ISO 406)
1/4" 3N/CS	3 needle chainstitch (401-3)
1/4" 4N/CS	4 needle chainstitch (401-4)
FF/CS	Flat felled chainstitch (include # stitchlines to front ex: 3FF/CS)
MF/LS	Mock felled seam with lockstitch

OTHER ABBREVIATIONS:





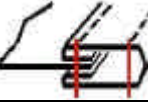





Add'l	Additional
Apx/Approx	Approximately
I/O, i/o	Instead of
Rcvd, Rec'd	Received
S/B, s/b	Should be
WB	Waistband
WS,W/S	Worksheet


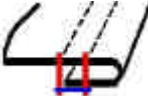



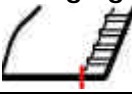



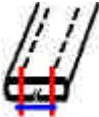

Please note, this sheet does not include all types of stitches and seams, just those that are commonly abbreviated. Please refer to Stitch and Seam Matrix for all types of stitches and seams along with the corresponding Federal / ISO number.



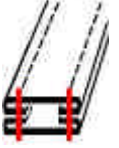




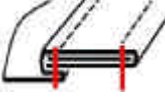


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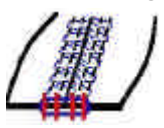
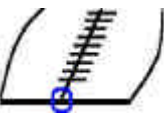

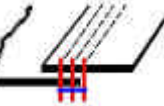







Operation	Seam	Pg. #
Attach & Edgestitch (Usually 301 Stitch)	SSae	7
Bag Seaming - 401	SSd	8
Bagging Welt Pockets On Trousers (Usually 301)	SSc	8
Binding (2 Needle - Clean Finish - 301 Or 401)	BSe	2
Binding (2 Needle - Selvedge Edge - 301 Or 401)	BSd	2
Binding (Bottom Coverstitch - 406 Stitch)	BSb	2
Binding (Clean Finish - Usually 301)	BSc	2
Binding (Coverstitch - 602 Or 605)	BSa	2
Binding (Mock Clean Finish Binding - 2 Operations)	BSg	2
Binding (Mock Clean Finish Binding - 2 Operations)	BSj	2
Binding (Selvedge Edge Binding - 301 Or 401)	BSa	2
Bolt-End Seaming (501 - Single Thread Overedge)	FSf	4
Butt Seam & Tape - Generally 301 Lockstitch	SSf	8
Centerplait (Cut-On Centerplait - 401/ 301 Stitch)	EFv	7
Centerplait (Set-On - Generally 401 Stitch)	LSm	6
Cord Seam Only - Generally 301 Or 401 Stitch	LSq (b)	6
Coverseaming Only (Straddle Stitch - 406 Stitch)	SSh (b)	8
Crotch Seam (Flatseaming With 607 Stitch)	FSa	5
Crotch Seam (Flatlock Seaming With 606 Stitch)	LSa	5
Crotch Seam On Jeans - Usually 301 Stitch	LSas	5
Darting (Panel Not Cut - Generally 301 Stitch)	OSf	7
Deco Stitching	OSa	7
Elastic Attaching - 3 Or 4 Needle 401 Stitch	SSt	9
Elastic Attaching - 406 Or 407 Stitch - Underwear	LSa	5
Facing To Front With Zipper	SSj	9
Felling (Mock Felled Seam)	SSw	9
Felling Or Felled Seam (2 Or 3 Needle 401 Stitch)	LSc	5
Flatlock Seaming (With 606 Stitch)	FSa	5
Flatseaming (With 607 Stitch)	FSa	5
French Seam	SSae	7
General Seaming Hem Seaming (Clean Finish)	SSa	7
Hem Seaming (Raw Edges)	SSp	9
Hem Serging	SSn	9
Hem With Elastic	EFe	3
Hem With Elastic (2 Needle)	EFf	3
Hem With Elastic (2 Needle)	EFg	3
Hem With Piping	EFq	4
Hemming - 2 Needle Hemming On Knits	LSn	6
Hemming - Blindhemming With Overedge	EFa Inv.	3
Hemming - Blindstitch Hemming (Clean Finish)	EFc	3
Hemming - Blindstitch Hemming (Serged Or Pinked)	EFm	4
Hemming - Tunneled Elastic (2 Needle)	EFI	4
Hemming (Clean Finish)	EFr	4
Hemming (Selvedge Edge)	EFb	3
Join & Tape Front (Flatseamer)	EFa	3

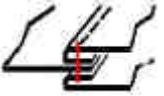
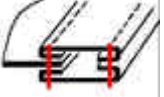
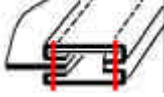


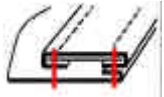



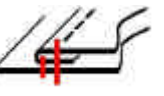
Operation	Seam	Pg. #
Joining Bib To Overall	LSar	5
Joining Bib To Overall	LSI	6
Joining Plies	SSv	8
Lap Seaming	LSa	5
Lap Seaming - Top Edge Turned Under	LSb	5
Lining Cuffs For Dress Shirts	SSbc	8
Making Belt Loops (For Jeans, Chinos)	EFh	3
Making Spaghetti	EFu	4
Making Strap Or Belt (1 Needle)	EFj	3
Making Strap Or Belt (1 Needle)	EFp	4
Making Strap Or Belt (1 Needle)	EFy	4
Making Strap Or Belt (1 Needle)	EFz	4
Making Strap Or Belt (2 Needle - 2 Piece)	EFad	3
Making Strap Or Belt (2 Needle - 2 Piece)	EFn	4
Making Straps, Belts (Hidden Stitch W Interlining)	SSaz	8
Patch Pocket Setting - 301 Stitch	LSd	5
Pocket Set (Hem & Set Front Pocket - Jeans)	SSI	9
Pocket Set (Patch Pkt. - 2 Operations)	LSs	6
Runstitch & Topstitch - Generally 301 Stitch	SSe	8
Seam & Cord Seam	LSq	6
Seam & Topstitch Seam	LSq	6
Seam With Piping	SSk	9
Seam With Piping & Topstitch	SSaw	8
Seam With Piping & Topstitch	SSav	8
Seaming & Coverseaming	SSh	8
Seaming (1st Part Of 2 Part Operation)	SSa	7
Seaming (General)	SSa	7
Seaming Then Taping Seam	SSag	7
Seaming With Stay Tape	SSab	7
Serging - Generally With 503, 504 Or 505 Stitch	EFd	3
Sleeve Set (2 Operations)	LSr	6
Stripes Attaching - 2 Needle - Either 301 Or 401	SSat	7
Taping Edge - Generally 301	SSaa	7
Taping Only - 2nd Part Of 2 Part Operation	SSag (b)	7
Topstitch Only - 2nd Part Of 2 Part Operation	SSe (b)	7
Waistbanding (1 Piece - Binding - Jeans)	BSc	2
Waistbanding (1 Piece)	LSk	6
Waistbanding (2 Piece Band)	LSg	6
Waistbanding (2 Piece W Interlining)	LSj	6
Waistbanding (With Elastic - 3 Or 4 Needle)	SSt	9
Waistbanding (With Elastic - 406 / 407 Stitch)	LSa	5
Waistbanding (With "Stitch-In-A-Ditch" Topstitching)	BSf mod	2
Yoking (1 Operation - W Folder)	LSe	5
Yoking (1 Operation - Wo Folder)	LSf	9
Yoking (2 Operations)	SSq	9
Mock Felled Seam	SSw	9

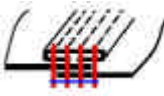
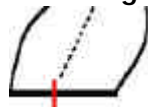





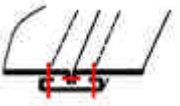
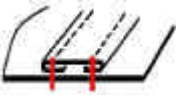
Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
	BSa	3.01.01	Binding carpets, etc. with selvedge edge binding.	Specify binding finished width.
	BSa	3.01.01	Setting collarettes & sleeve binding on undershirts, etc. Usually sewn with a 602 or 605 coverstitch.	Specify 1) Needle spacing if 602 or 605 stitch is used and 2) Binding finished width.
	BSb	3.03.01	Setting collarettes on tee shirts; binding legs and fly on knit briefs, etc. Usually sewn with a 406 bottom coverstitch.	Specify 1) Needle spacing if 406 stitch is used (Ex: 1/8", 3/16") and 2) Binding finished width.
	BSc	3.05.01	For setting sleeve facings to shirts, piping edges of outerwear, etc. Can be sewn with a 301 lockstitch or 401 Chainstitch.	1) Specify binding width (Ex.: 1/2" Binding.); and 2) Requires a binding folder.
Waistbanding on Jeans 	BSc	3.05.01	For setting waistbands to jeans, etc. Can be sewn with a 401 chainstitch or 301 lockstitch.	1) Specify needle spacing and binding width. (Ex.: 1- 3/8" and 1- 5/8" binding.); and 2) Requires a binding folder.
	BSd	3.01.02	Seaming with selvedge edge binding on outerwear.	1) Specify needle spacing and width binding (Ex.: 3/8" needle spacing and 1/4" binding.); and 2) Requires a binding folder.
	Bse	3.05.05	Seaming and binding on outerwear.	1) Specify needle spacing and binding width (Ex.: 3/8" needle spacing and 1/4" binding.); and 2) Requires a binding folder.
Topstitch hidden in seam line 	BSf mod		"Stitch in a Ditch" - Topstitching waistband with stitch line on top of previous seam line.	May require special PF with guide so stitch is totally hidden.
Sewn in 2 Operations 	BSg	3.14.01	Mock clean, finish binding.	Specify binding width.
Sewn in two operations 	BSj	3.05.06	Mock clean, finish binding.	Specify binding width. (Ex.: 1/2" binding.)










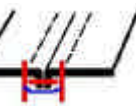
Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
	EFa	6.02.01	Hemming selvedge edge, shirtfront.	Specify hem width.
2 Needle Hem 	EFa Inv.	6.02.07	Hemming tee shirts, polo shirts, etc. Generally, sewn with a 406 stitch.	Specify 1) Hem width and 2) Needle spacing. (Ex. 1" hem with 1/4" needle spacing.)
	EFad	8.17.01	Making straps or belts with clean finish with interlining.	Specify strap width.
Clean Finish Hem 	EFb	6.03.01	Hemming shirts, jeans, shorts, etc.	1) Specify hem width; and 2) Generally, a hemming folder is required or a hemming PF.
Blindhemming 	EFc	6.06.01	Hemming bottoms of tee shirts, undershirts, etc. usually sewn with a 503 Stitch.	1) Specify hem width (Ex. 1" hem.); and 2) Generally, a hemming guide is required.
Serging 	EFd	6.01.01	Serging pants panels, flys, facings, etc.	Specify width bite. (Ex. 3/16".)
Serge & Hem 	EFe		Serging edges of napkins, sheer curtains, etc.	1) Specify width bite (Ex. 3/32".); and 2) A hemming P.F. is required.
Hem & insert 	EFf	7.24.02	Hem and insert elastic to infant panties, etc.	Specify hem width.
	EFg	7.24.03	Hem and insert elastic to infant panties, etc.	1) Specify needle spacing and hem width (Ex. 1/4" needle spacing and 1/2" hem width.); and 2) Requires hemming folder & elastic guide.
Belt Loops 	EFh		Making belt loops for jeans and casual pants, shorts, etc. usually sewn with 406 stitch.	1) Specify needle spacing and width of belt loop (Ex. 1/4" needle spacing and 3/8" width belt loops.); and 2) Requires belt loop folder.
	EFj	8.05.01	Making straps or belts with clean finish.	1) Specify strap width.









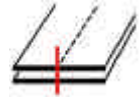

Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
Blindstitch Hem 	EFi		Hemming dresses, slacks, coats, and bedspreads. Generally, sewn with 103 blindstitch.	Specify hem width.
Blindstitch Hem 	EFm		Hemming Dresses, slacks, coats, and bedspreads. Generally, sewn with 103 blindstitch.	Specify hem width.
	EFn	8.19.01	Making straps or belts with clean finish.	Specify 1) Needle spacing and 2) Strap width.
	EFp	8.06.01	Making straps or belts with clean finish.	Specify strap width.
	EFq	7.26.05	Hem and insert elastic to infant panties, etc.	1) Specify needle spacing and hem width (Ex. 1/4" needle spacing and 1/2" hem width.); and 2) Requires hemming folder & elastic guide.
Tunneled Elastic 	EFr	7.26.05	Hem and insert elastic to infant panties, etc.	1) Specify needle spacing and hem width (Ex. 1/4" needle spacing and 1/2" hem width.); and 2) Requires hemming folder & elastic guide.
Making Spaghetti 	EFu	8.07.01	Making straps. Stitch is hidden and not visible.	Specify strap width.
Centerplaiting 	EFv		Cut-on centerplait. Generally, sewn with 2 rows of 401 stitch. (See also LSM - set-on centerplait.)	1) Specify needle spacing and centerplait width. (Ex. 1" needle spacing & 1 1/2" centerplait.); and 2) Requires centerplait folder.
	EFy	8.03.03	Making straps or belts with clean finish.	Specify strap width.
	EFz	8.03.04	Making straps or belts with clean finish.	Specify strap width.




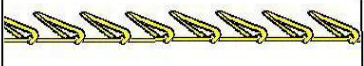


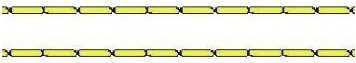
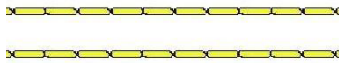




Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
Flatseaming 	FSa	4.01.01	Flatseaming underwear, fleece, exercisewear, etc. Generally, sewn with a 607 stitch. Sometimes a 606 Flatlock Stitch.	
Bolt End Seaming 	FSf		Bolt-end seaming with a 501 Stitch.	
Lap Seaming 	LSa	2.01.01	Attaching knitted cuffs - generally sewn with a coverstitch - 605 or 607.	1) A seaming guide or trimmer is used to keep edges even; and 2) Specify needle spacing. (Ex.- 1/4" needle spacing.)
Attaching Elastic 	LSa	2.01.01	Setting elastic to panties or briefs - 406 or 407 stitch; Attaching knitted cuffs - generally, sewn with a coverstitch - 605 or 607.	1) A seaming guide or trimmer is used to keep edges even; and 2) Specify needle spacing. (Ex.- 1/4" needle spacing.)
	LSar		Joining bib to pants of bib overall in 1 operation.	Needle spacing and strip width are required.
	Lsas		Crotch seaming on jeans & chinos.	Specify needle spacing. (Ex. 1/4".)
	LSb	2.02.01	Not as common as LSq where piece is attached and then corded or topstitched.	Specify dimension from stitching to edge of top ply. (Ex.: 1/8" header.)
	LSbj	5.30.01	Facing front pockets on jeans.	Facing should be serged prior to being set.
Felled Seam 	LSc	2.04.06	Seaming jeans, shirts, jackets, etc. Generally, with a two or three needle 401 Chainstitch.	1) Specify needle spacing & seam width. (Ex: 1/4 needle spacing with 3/8" seam width.); and 2) A felling folder with correct capacity is required.
Patch Pocket Setting 	LSd	5.31.01	For setting patch pockets, flaps, pocket facings, etc., generally, with a 301 Lockstitch.	1) Specify margin (Ex.: 1/16" or 3/32".); and 2) A pressure foot with a yielding section is used to maintain a uniform margin from stitch to edge.
Yoking 	Lse	1.22.01	Seaming yokes to back on shirts or blouses in one operation. Not as common as SSq.	1) Specify margin (Ex.: 1/16" or 3/32".); and 2) A folder consisting of upper and lower scrolls are required.

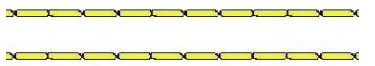

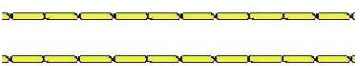

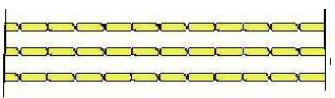
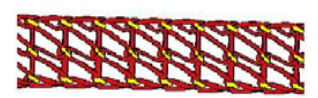
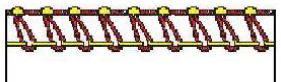

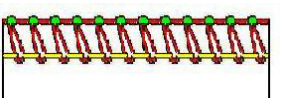

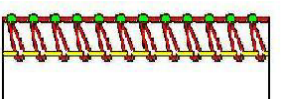
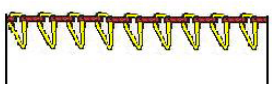
Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
Yoking 	LSf		Seaming yokes to back on shirts or blouses in one operation.	Specify margin from stitch line to edge. (Ex.: 1/16" or 3/32".)
Two piece Waistband 	LSg	7.57.01	Attaching a waistband to chinos or work pants.	1) Specify needle spacing and waistband width; and 2) A folder consisting of an upper strip folder and lower strip folder is required.
Two piece Waistband 	LSj	7.76.01	Attaching a waistband to chinos or work pants.	1) Specify needle spacing and waistband width; and 2) A folder consisting of an upper strip folder with guide for interlining, and lower strip folder is required.
	LSk	7.32.03	Waist banding on pajamas; making rod pocket. on curtains & shower curtains, etc.	1) Specify needle spacing and tape width; and 2) A folder combining a turn down folder and strip folder is required.
	LSI	2.28.03	Joining bib to pants of bib overall in 1 operation.	Needle spacing and strip width are required.
Set-On Center Plait 	LSm	7.62.01	Attaching set-on centerplaits to shirts and blouses.	1) Specify needle spacing (Ex. 1".); 2) Specify width of centerplait (Ex. 1 1/2".); and 3) Requires a folder with top strip folder width.
	LSn		Not common.	
Seam & Cord Seam 	LSq	2.02.03	Sideseam on jeans; chinos; jackets, etc.	1) 1st Operation - specify seam width; and 2) 2nd Operation - specify number of needles (1, 2, 3) and needle spacing.
Sleeve Set 	LSr	2.06.02	Setting sleeves on dress shirts or blouses.	1) 1st Operation - specify seam width - a folder may be required; and 2) 2nd Operation - specify topstitch margin.
Patch Pocket Setting 	LSs	2.05.02	For setting large patch pockets on suit coats, overcoats, and jackets.	1) 1st Operation - highly skilled operation; and 2) Specify margin. (Ex.: 1/16" or 3/32".)




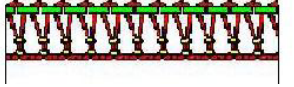
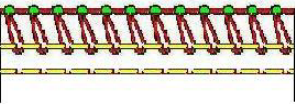

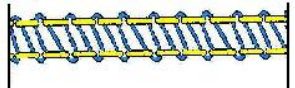
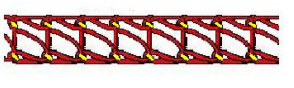
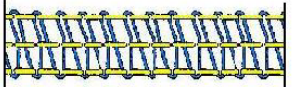
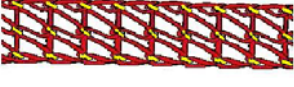
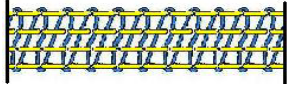

Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
Joining & Taping 	LSz	2.14.02	Joining & taping fronts of knit briefs & thermal underwear.	1) Generally, done on a 607 Flatseaming machine width or with upper spreader thread; and 2) Requires an upper Taping Folder.
Decorative Stitching 	OSa	5.01.01	Decorative stitch back pockets on jeans; saddle stitching.	Specify design pattern with dimensions of stitch location.
Sewing Darts 	OSf	6.05.01	Dart panel on slacks, chinos, blouses, etc.	Specify Dart width and length. (Ex. 3/8" wide and 3" long.)
General Seaming 	SSa	1.01	Most common seam construction for both wovens & knits.	1) Seam margin must be specified to maintain fit; and 2) A seaming guide or trimmer is used to keep edges even.
Attaching Tape to Edge 	SSaa		Attaching a zipper tape to fly facing; attaching stay tape to armhole.	Specify 1) Tape width and 2) Seam margin.
Seaming & Taping 	SSab		Joining shoulders with stay tape; attaching facing to jacket front with stay tape.	Specify 1) Stay tape width and 2) Seam margin.
French Seaming 	SSae	1.06.03	For edge stitching front facings on jackets and dresses.	1) Seam margin must be specified on both 1st & 2nd operations; 2) A seaming guide is used to keep edges even; and 3) There is a turning process between 1st & 2nd process.
Seaming, then Taping Seam 	SSag	4.10.02	For taping shoulder and neck of tee shirts.	1) Finished tape width; 2) needle spacing on taping operation is generally required; and 3) A taping folder is required fold and guides tape on to seam.
Setting Stripes Shirts, Shorts, etc. 	SSat	5.06.01	For attaching stripes to shirtfronts, etc.	Specify 1) Tape finished width and 2) Needle spacing. (Ex.: 3/4" tape with 1/2" needle spacing.)











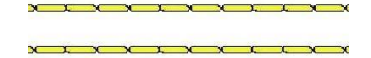

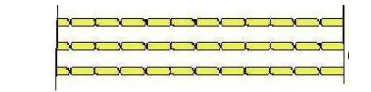
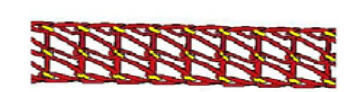
Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
Seam, Fold, & Topstitch 	SSav	1.18/ 1.19	For seaming and piping edges of pillow, pajama tops, etc.	1) Specify seam margin; 2) Topstitch heading / margin; and 3) Folder may be used to make piping with or without cord.
Seam, Fold, & Topstitch 	SSaw	2.19.02	For seaming and piping edges of cushions, pillows, attaching yokes to backs on casual shirts, dresses, etc.	Specify 1) Seam margin and 2) Topstitch heading/margin.
	SSaz	8.11.01	Making straps, belts, etc.	1) Specify finished width; and 2) This seam is made on a special "spaghetti" machine.
	SSb	1.04	Not common.	
Lining Cuffs 	SSbc	1.03.01	Attaching lining to cuffs for shirts & blouses.	Specify hem width, if necessary.
	SSc	1.06.01	Not common. SSe is more common.	
	SSd	1.07	Not common.	
Runstitch & Topstitch 	SSe	1.06.02	For making collars & cuffs on shirts; attaching front pockets, bagging front pockets, setting fly on chinos, etc.	1) Seam margin must be specified on both 1st & 2nd operations; 2) A seaming guide is used to keep edges even; and 3) There is a turning process between 1st & 2nd process.
Butt Seam & Tape 	SSf	4.08.02	For butt seaming & taping heel seams on shoes, etc.	1) Seam margin must be specified on 1st Operation; and 2) Needle spacing and tape width specified on 2nd operation.
Seaming & Coverseaming 	SSh	4.04.01	For coverseaming knit tops, undergarments to reinforce seam and give it a decorative appearance.	1) Suggest using a 504 for 1st operation and 406 with 1/4" needle spacing for 2nd operation; and 2) Seaming guide on Coverseaming machine.

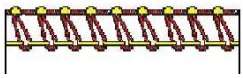

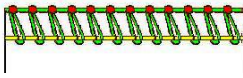

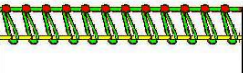





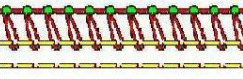

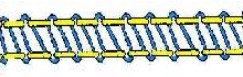

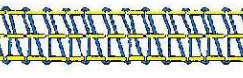
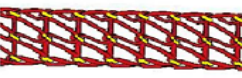
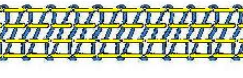

Seam Drawing	751a Number	ISO 4916 Number	Common Application	Requirements
	SSj	1.11	For attaching a zipper tape between shell and facing.	1) Seam margin must be specified to maintain fit; 2) A seaming guide is used to keep edges even; and 3) A zipper foot may be required.
Seam with Piping 	SSk	1.12	For seam apparel, furniture with piping in seam.	1) Seam margin must be specified to maintain fit; 2) A seaming guide is used to keep edges even; and 3) May require a foot with grooved bottom if cord is used in piping.
	SSI	1.08	For setting front pockets on jeans.	1) A hemming folder is used to hem bottom ply uniformly; 2) Hem width should be specified; and 3) If more than one needle, specify needle spacing. (Ex. 1/4".)
Hem Seam 	SSn	1.20.01	For seaming fabrics that may be susceptible to seam slippage.	1) A hemming folder or guide is generally used; and 2) Hem width should be specified. (Ex.: 3/8" hem.)
Hem Seam 	SSp	1.21.01	For seaming fabrics that may be susceptible to seam slippage.	1) A hemming folder is generally required; and 2) Hem width should be specified. (Ex.: 3/8" hem.)
Seam, Fold & Cord 	SSq	2.42.04	For attaching yokes to back or shoulder joining on shirts, blouses, etc. Similar to LSe but done in 2 steps.	1) A swing out margining guide is required along with a Yielding Presser Foot; and 2) Correct PF with preferred margin guide should be used. (Ex.: 1/16" or 3/32").
	SSs	7.09.01	Hemming and attaching zipper tape.	Specify 1) Tape width and 2) Seam margin.
Attaching Elastic 	SSt	7.09	For seaming knitted or woven elastic to boxers and gym shorts.	1) Specify elastic width; and 2) Usually 2, 3, or 4 rows of 401 chainstitch are used to make this seam - Specify needle spacing. (Ex.: 1 1/4" elastic with 4 rows, 1/4" needle spacing.)
	SSv	5.01	Not common.	
Mock Felled Seam 	SSw	2.04.06	For side seaming shirts, blouses, dresses, etc.	1) Manual method for making a felled seam; 2) Specify hem width; and 3) Heading/topstitch margin.

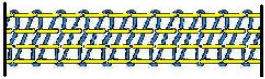

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
Single Thread Chainstitch 		101	Basting Stitch for Tailored Clothing; Bag Closing	Specify SPI.	Stitch formed by a needle thread passing through the material and interlooping with itself on the underside of the seam with the assistance of a spreader.
Single Thread Chainstitch or Lockstitch BS, BH or Bartack 	* 304 Lockstitch is preferred when stitch security is a Must.	101 or 304	Buttonsew, Buttonhole or Bartack	1) Buttonsew - specify stitches per cycle (Ex. 16); 2) BH - specify length & width; and 3) Bartack - specify length & width of tack.	Knit Shirts - Buttonhole length generally is 1/2 inch, is placed horizontally, with approximately 85-90 stitches. Note: Sometimes buttonhole machine set for approximately 40- 45 stitches per buttonhole, and then run two cycles on the same buttonhole. This gives better coverage on the knit fabric so there are fewer fibers protruding from under the thread.
Single Thread Blindstitch 	No stitch visible on the Bottom or Outside of Sewn Product	103	Blindstitch Hemming, Felling, Belt Loops	Specify 1) SPI - typically 3 - 5 SPI and 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.
Lockstitch - Most Common of All Stitches 	Bobbin Thread on Bottom 	301	Topstitching, Single Needle Stitching, Straight Stitching	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.
Twin Needle Lockstitch 		301	Twin Needle	Specify 1) Needle spacing and 2) SPI.	Same as 301 except two rows of stitch are formed. Typical needle spacing is 1/4" but machines are available from 3/16" up to 1"
Zig Zag Lockstitch 		304	Intimate Apparel, Athletic wear, Infantwear, Exercisewear	Specify 1) SPI and 2) 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.
Chainstitch 	Looper Thread on Bottom 	401	Single Needle Chainstitch - Mainseams on Wovens	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.

Stitch Drawing		751a Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
Twin Needle Chainstitch 		401	Twin Needle Chainstitch for Felled Seams on Jeans, Shirts, etc.	Specify 1) Needle spacing and 2) SPI.	Stitch formed by 2-needle threads passing through the material and interlooped with 2-looper threads forming 2 independent rows of stitch set on the underside of the seam.
2 Needle Bottom Coverstitch 		406	2 Needle Hemming, Binding, Coverseaming, Elastic to Panties, Belt Loops	Specify 1) Needle spacing (1/4", 3/16", 1/8") and 2) 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.
3 Needle Bottom Coverstitch 		407	Attaching Elastic to Men's & Boys Knit Underwear	Specify 1) Needle spacing (1/4") and 2) 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.
2 Thread Overedge 	Single "purl" on Edge 	503	Serging & Blindhemming	Specify 1) Width Bite (Ex. 1/8", 5/32" 3/16") and 2) SPI.	Stitch formed by 1-needle thread and 1-looper thread with purl on edge of seam for serging or blindhemming ONLY.
3 Thread Overedge 	Most Common Overedge Stitch 	504	Single Needle Overedge Seaming	Specify 1) Width bite (Ex. 1/8", 5/32" 3/16") and 2) 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.
3 Thread Overedge 	Double "purl" on Edge 	505	Serging with Double purl on Edge	Specify 1) Width bite (Ex. 1/8", 5/32" 3/16") and 2) 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.

Stitch Drawing		751a Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
Mock Safety Stitch 	2 Needle Overedge 	512	Seaming Stretch Knits, Wovens	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
2 Needle 4 Thread Overedge 	2 Needle Overedge 	514	Seaming Stretch Knits, Wovens	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.
5 Thread Safety Stitch 		516	Safety Stitch Seaming Wovens & Knits	Specify 1) Needle spacing & bite - Ex.: 5 1/8", 12 3/16" and 2) SPI.	Combination stitch consisting of a single-needle chainstitch (401) and a 3-thread Overedge stitch (504) that are formed simultaneously.
2 Needle 4 Thread Coverstitch 		602	Binding A Shirts, Infants Clothing, etc.	Specify 1) 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.
3 Needle 5 Thread Coverstitch 		605	Lap Seaming, Coverseaming, Binding on Knits	Specify 1) Needle spacing (Ex: 1/4") and 2) SPI.	Stitch formed with 3-needle threads, a top cover thread and a bottom looper thread.
4 Needle 6 Thread Coverstitch 	Flatseamer/Flatlock 	607	Flat or Lap Seaming Knit Underwear, Fleece, etc.	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.

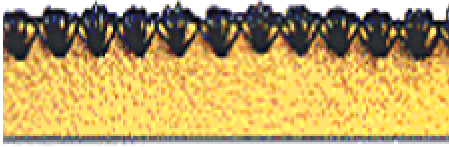
針步圖		ISO 4915	一般用途	要求	針步之描述
正面圖	反面圖	號碼			
 <p>單線鏈狀線</p>		101	假縫針步是用於西裝樣的服裝,袋之封口	1) 指定的每英寸針步	此針步是由一條接縫線穿過物料,加上配線器的幫助,自我纏結所形成。
 <p>單線鏈狀或連鎖式釘鈕,開鈕門或加固針縫(打棗/套結)</p>	<p>* 如需要牢固接縫,一定要使用304針步</p>	101 or 304	釘鈕,開鈕門或加固針縫(打棗/套結)	1) 釘鈕 - 指定的每循環針步,例如16; 2) 開鈕門 - 指定長度及闊度; 3) 加固針縫(打棗/套結) - 指定(棗/結)長度及闊度	針織襯衫 - 鈕門長度一般為1/2英寸針步約為85-90步。
 <p>單針暗縫(挑腳)</p>	<p>接縫反面或完成品正面是看不見接縫線的</p>	103	暗縫衣腳,折縫,褲耳	1) 指定的每英寸針步 - 一般是每英寸3-5針步; 2) 接縫十分薄的布料時,應該使用不跳針或跳一針的針步	此針步是由一條接縫線形成,接縫線於布之表面(完成品之底面)自我纏結,接縫線穿過面層布料,但是沒有完全通過底層物料。
 <p>平車針步 - 最普遍的針步</p>	<p>線軸線於反面</p> 	301	面線,單針平車線步,直線針步	1) 指定的針步	此針步是由一條接縫線穿過物料,與線軸線於接縫中間產生連鎖而形成,此針步之布面及布底外觀是一樣的。
 <p>人字形(之字形)的平車針步</p>		304	內衣褲,運動服,嬰兒服,練習服	1) 指定的針步; 2) 指定的線步寬度	此針步是由一條接縫線與一條線軸線於接縫中心位置組成對稱的之字型的針步,此外還可以用作識別加固針縫以及釘鈕與開鈕門。
 <p>鏈狀針步</p>	<p>底勾線於接縫反面</p> 	401	單針鏈狀針步,梭織產品主要接縫	1) 指定的針步	此針步是由一條接縫線穿過物料,在接縫底部與底勾線互相纏結而成。
 <p>雙針底部覆蓋針步</p>		406	雙針衣腳接縫,滾邊條,覆蓋接縫,彈性褲頭帶,褲耳	1) 指定的針距 (1/4", 3/16", 1/8"); 2) 指定的針步	此針步是由兩條接縫線穿過物料,於物料底部與一條線圈線產生纏結而成,而線圈線會在布料底部兩條接縫線之間組成覆蓋線步。
 <p>三針底部繡縫針步</p>		407	於男裝及男童裝的內褲上加上彈性帶	1) 指定的針距 (1/4"); 2) 指定的針步	此針步是由三條接縫線穿過物料,於物料底部與一條勾線產生纏結而成,而勾線會在布料底部三條接縫線之間組成繡縫線步。

針步圖		ISO 4915	一般用途	要求	針步之描述
正面圖	反面圖	號碼			
 兩線包邊	 單"流蘇"於布邊	503	包邊以及暗縫邊	1) 指定的切刀之距離-例如:1/8",5/32",3/16"; 以及2) 每英寸針步	此針步是由一條接縫線與一條勾線於布邊形成流蘇,此類接縫用於毛邊處理以及暗縫衣腳。
 三線包邊	 最普遍之包邊針步	504	單針包邊接縫	1) 指定的切刀之距離-例如:1/8",5/32",3/16"; 以及2) 每英寸針步	此針步是由一條接縫線與兩條勾線於布邊形成流蘇,此類接縫用於包邊接縫及毛邊處理。
 三線包邊	 雙"流蘇"於布邊	505	包邊於布邊雙流蘇	1) 指定的切刀之距離-例如:1/8",5/32",3/16"; 以及2) 每英寸針步	此針步是由一條接縫線與兩條勾線於布邊形成流蘇,此類接縫只用於毛邊處理。
 模擬保險線	 兩針包邊	512	彈性針織與梭織之接縫	1) 指定的每英寸針步	此針步是由一條接縫線與兩條勾線於布邊形成流蘇。512針步只是右方接縫針會穿過上線圈,此針步比514針步較難造成無布車縫。
 兩針四線包邊	 兩針包邊	514	彈性針織與梭織之接縫	1) 指定的每英寸針步	此針步是由兩條接縫線與兩條線圈線組成,兩條線圈線於布邊形成流蘇。514針步是兩條接縫針會穿過上線圈,建議使用此針步因為它比512針步較易難造成無布車縫。
 五針包邊安全線	 針織與梭織的安全線接縫	516	針織與梭織的安全線接縫	1) 指定的針與針之距離和切刀之距離-例如:5 1/8",12 3/16"; 以及2) 每英寸針步	同時結合一條單針鏈狀縫線(401)及三線包邊(504)針步。
 兩針四線繡縫(三本)針步	 襯衫與嬰兒服裝的鑲邊等等	602	襯衫與嬰兒服裝的鑲邊等等	1) 指定的針與針之距離-例如:1/8",3/16"; 以及2) 每英寸針步	此針步是由兩條接縫線,一條表面繡縫(三本)線與一底勾線組成。
 三針五線繡縫(三本)針步	 搭(接)縫,繡縫(三本)接縫,針織物之鑲邊	605	搭(接)縫,繡縫(三本)接縫,針織物之鑲邊	1) 指定的針與針之距離-例如:1/4"; 以及2) 每英寸針步	此針步是由三條接縫線,一條表面繡縫(三本)線與一底勾線組成。
 四針九線平式接縫針步	 平式接縫	606	平式或搭接縫,針織內衣,衛衣等等	1) 指定的每英寸針步	此針步是由四條接縫線,一條表面繡縫(三本)線與四條底勾線組成。建議使用607針步,因為機器較為容易保養。

針步圖 正面圖	反面圖	ISO 4915 號碼	一般 用途	要求	針步之描述
 <p>四針六線平式接縫繡縫(三本)針步</p>	 <p>平式接縫</p>	<p>607</p>	<p>平式或搭接縫,針織內衣,衛衣等等</p>	<p>1) 指定的每英寸針步</p>	<p>此針步是由四條接縫線,一條表面繡縫(三本)線與一底勾線組成。建議使用607針步,因為機器較為容易保養。</p>

Special Decorative Stitches

SHELL STITCH

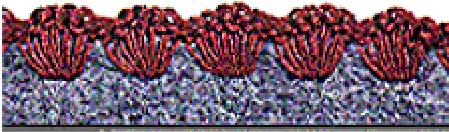


DESCRIPTION: Made with an Overedge Machine with a special set-up that forms the thread around the edge of the fabric in a shell appearing configuration.

RECOMMENDED THREAD: T-21 - T-40 Spun Poly or PW Core.

COMMON APPLICATION: Serge edge stitching of women's, girls, and infants' clothing.

WIDE SHELL STITCH

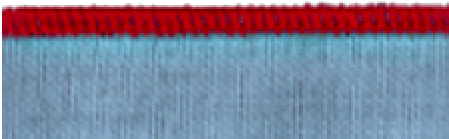


DESCRIPTION: Made with an Overedge Machine with a special set-up that forms the thread around the edge of the fabric in a shell appearing configuration.

RECOMMENDED THREAD: T-40 - T-60 Spun Poly, No. 30 - No. 20 Signature - High Sheen.

COMMON APPLICATION: Serging the edges of napkins & table clothes. Serge edge on light-weight women's apparel.

PURL EDGE STITCHES



DESCRIPTION: 502 or 503 Overedge Stitch formation with 18 to 26 stitches per inch.

RECOMMENDED THREAD: Needle Thread: T-24 PW Core or T-27 Spun Poly; Loopers: T-35 - T-50 Textured Polyester.

COMMON APPLICATION: Serging the edges of napkins, table clothes. Serge edge on light-weight women's apparel.



DESCRIPTION: 502 or 503 Overedge Stitch formation with 14 to 18 stitches per inch.

RECOMMENDED THREAD: High Luster - No. 3004 Signature.

COMMON APPLICATION: Serging the edges of appliqués, labels, etc.

LETTUCE EDGE SURGING



DESCRIPTION: 504 or 505 stitch formation with reverse differential feeding action to uniformly stretch the fabric as it is being sewn.

RECOMMENDED THREAD: Same as seaming thread.

COMMON APPLICATION: Serging edges of women's, children's, infants' clothing.

BLANKET STITCH



DESCRIPTION: 502 stitch formation with 4 stitches per inch. Seam width usually 1/2" or 12.7mm.

RECOMMENDED THREAD: T-180 to T-350 Spun Polyester.

COMMON APPLICATION: Serging edges of blankets, sweaters, polar fleece, etc.

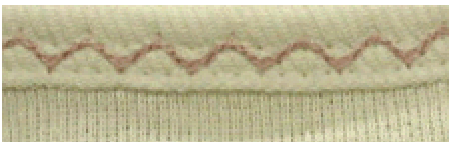
PICOETTA STITCH



DESCRIPTION: ISO 411 Two thread Multi-Step Chainstitch generally formed just off the edge of the seam.

RECOMMENDED THREAD: T-24 PW Core or T-27 Spun Poly.

COMMON APPLICATION: Pico edging of women's, children's, infants' clothing.



DESCRIPTION: ISO 411 Two thread Multi-Step Chainstitch used to topstitch a seam.

RECOMMENDED THREAD: T-24 PW Core or T-27 Spun Poly.

COMMON APPLICATION: Picoetta decorative stitching of women's, children's, infants' clothing

TWO NEEDLE FAGOTING

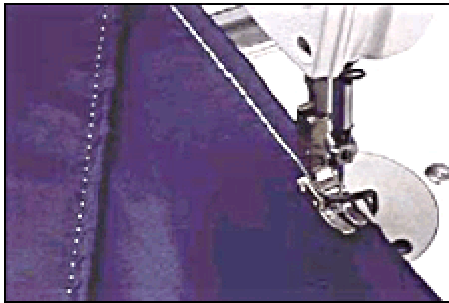


DESCRIPTION: Fagoting units the finished edges of two pieces of fabric with a space between the edges using a decorative chainstitch. In this case, a Duplex (double needle) ISO 411 stitch is used.

RECOMMENDED THREAD: T-24 PW Core or T-27 Spun Poly.

COMMON APPLICATION: Duplex fagoting of women's, children's, and infant's clothing.

PIN OR SADDLE STITCH



DESCRIPTION: ISO 108 Single Thread Chainstitch. Formed when a needle carries a loop of thread through the fabric that is then picked up by a hook needle that brings the needle loop back to the topside. The distance between the needle and hook needle determine the length of the pin or saddle stitch. The Length of the showing stitch varies from 1/16" to 7/32" or 1.5 to 5.5mm. The pin or saddle stitch is actually formed on the underside of the seam as it is sewn. Generally, 2.5 to 5.5 stitches per inch.

RECOMMENDED THREAD: T-24 to T-60 PW Core or Spun Poly.

COMMON APPLICATION: Decorative topstitching of coats, jackets, dresses, etc.