

SOFT WOVEN CONSTRUCTION STANDARDS

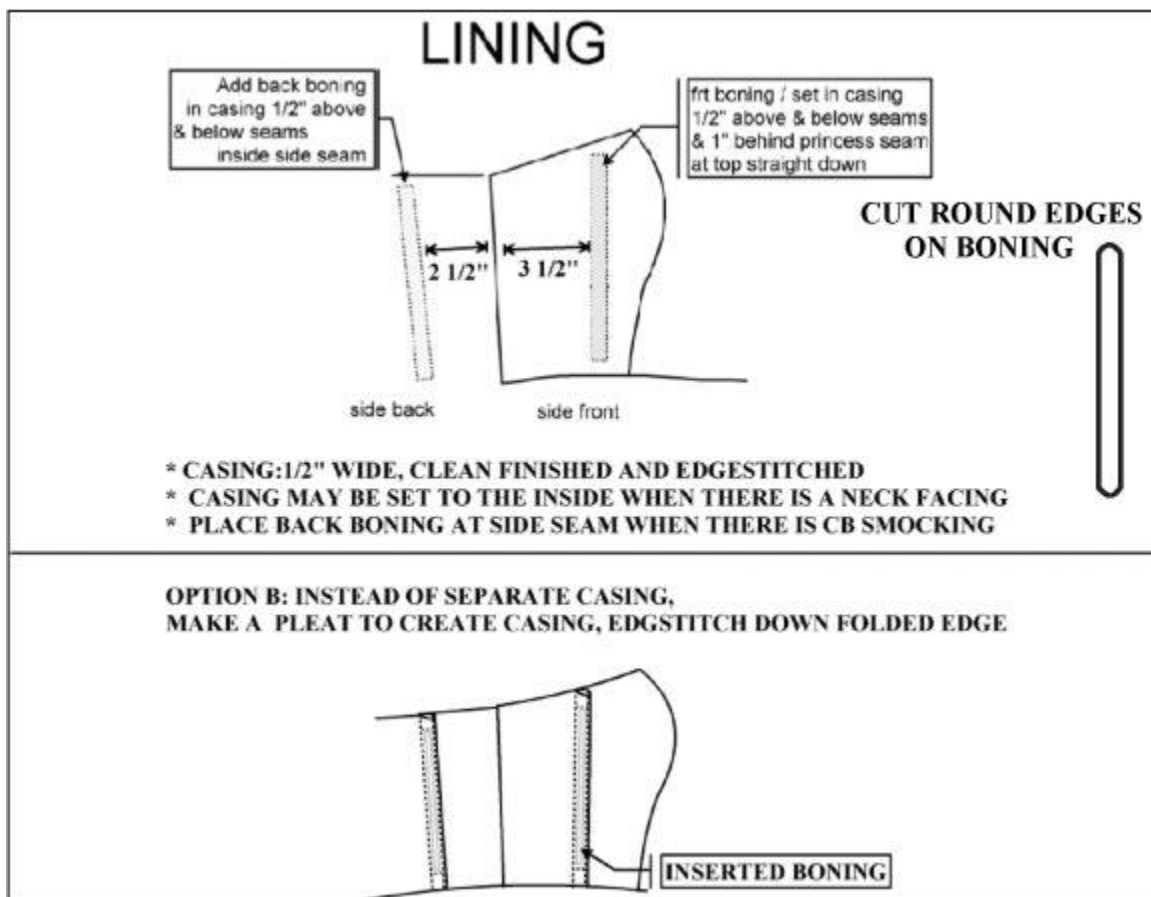
Table of Contents:

BINDINGS	2
BONING	2
DART - SHAPING.....	3
DARTS – COMMON BODICE CORRECTIONS.....	4
EASE.....	5
EDGE FINISHES	5
ELASTIC	6
FABRIC	7
HANGER LOOPS	8
HANGER LOOPS ON STRAPLESS DRESSES AND TOPS	8
HEMS.....	10
LININGS	10
PICOT & PICKSTITCH	10
RUFFLES	10
SEAMS & TOPSTITCH.....	11
SEAMS.....	11
SEAM JOINING	13
SMOCKING.....	14
STRAPS	15
WAISTBAND INSERTS ON TOPS AND DRESSES	16
WAISTBAND PATTERN SHAPE	18
ZIPPERS – APPLICATION FOR BIAS GARMENTS	19
ZIPPERS - INVISIBLE	19
FUSE.....	21

BINDINGS:

1. Straight seams - cut binding on straight grain unless the Technician advises otherwise.
2. Curved seams – cut binding on bias unless the Technician advises otherwise.

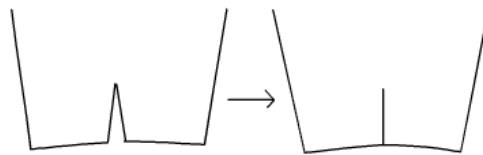
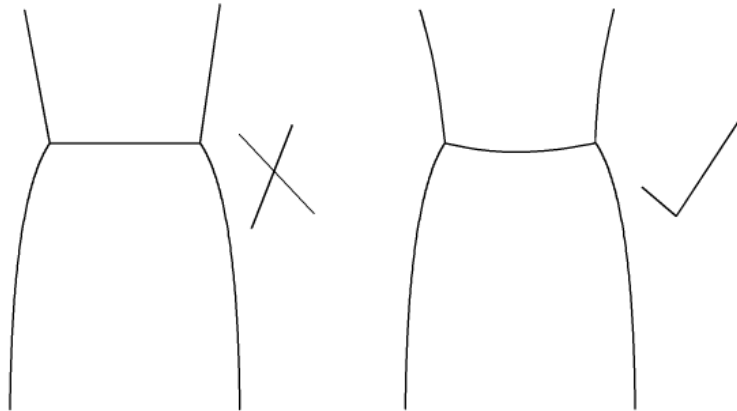
BONING:



DART - SHAPING:

SHAPING THE BODY

THINK OF THE BODY AS ROUND, NO STRAIGHT LINES.



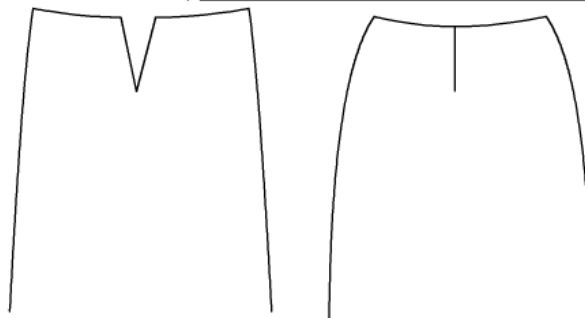
EXAMPLE : BODICE



**CLOSING DARTS THAT TAPER DOWN
MAKES CONVEX CURVE AT WAIST**

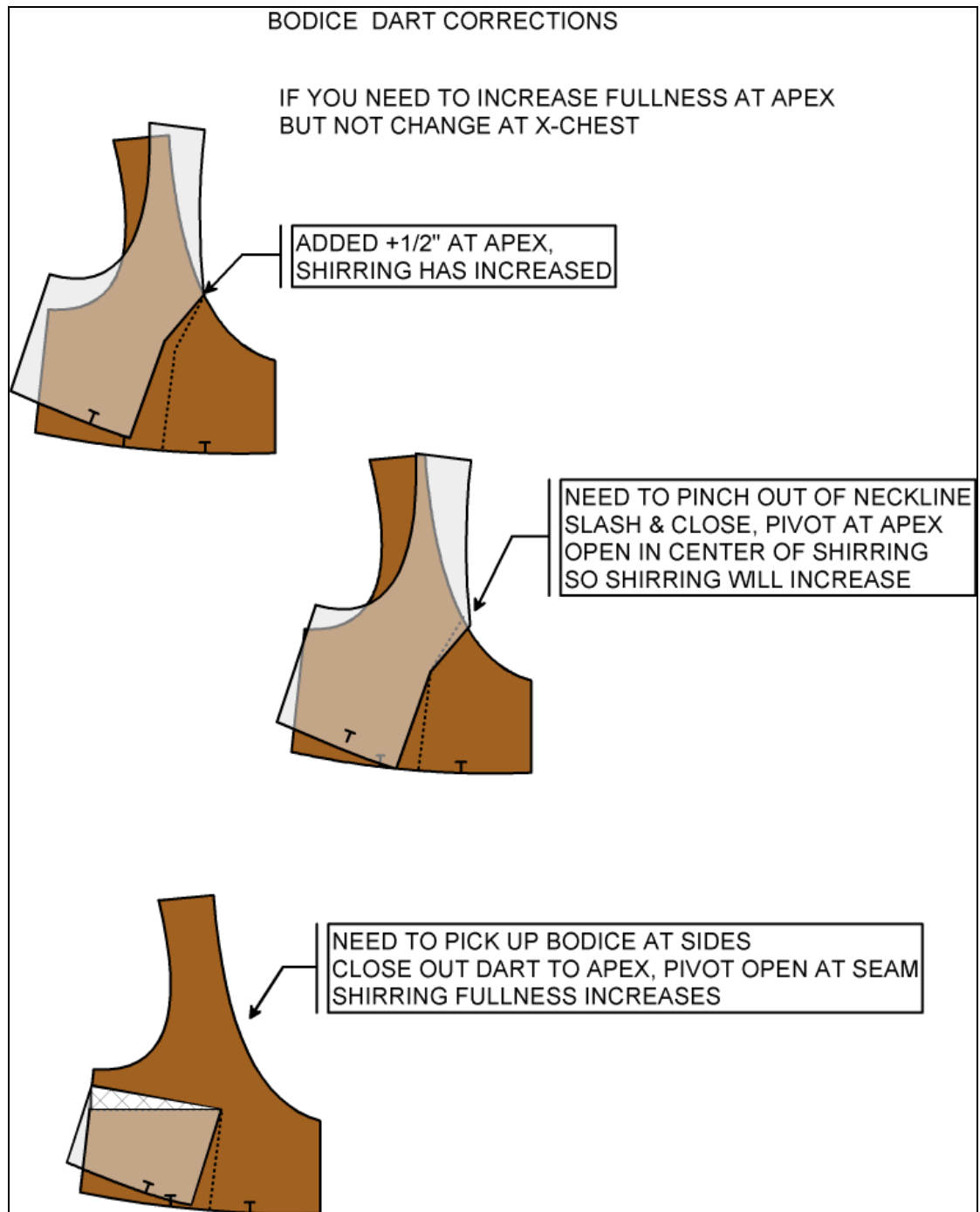


**CLOSING DARTS THAT EXPAND WIDE
MAKES CONCAVE SHAPE AT WAIST**



EAMPLE: SKIRT

DARTS – COMMON BODICE CORRECTIONS:



EASE:

1. Skirts always need to be ½” to ¾” bigger total, depending on the fabric at the waistband for ease. This helps with the curve shape on the high hip, so it is not so flat.
2. Bodice always needs 1/2” to 1” total ease into seam or waistband. This helps with the bust fullness. Bodice seam allowance should be pressed up unless clean finished with waistband.

EDGE FINISHES:

E001: CUT FAGGOTING



E002: 3/8” CLEAN FINISHED HEM WITH TRIM SET ON TOP AT EDGE
(STANDARD FOR ANTHROPOLOGIE LINED GARMENTS WITH TRIM)



FACE SIDE

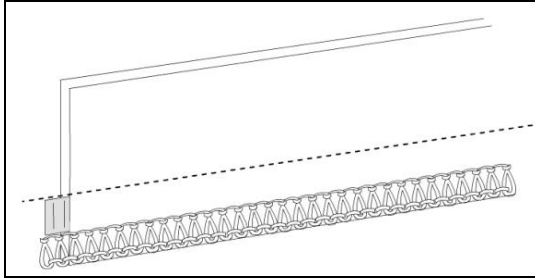


INSIDE

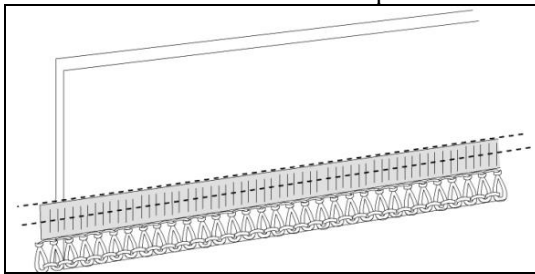
ELASTIC :

1. Sandwich elastic with merrow where applicable instead of tunneling (ex: waist seams & bottom of smocking).

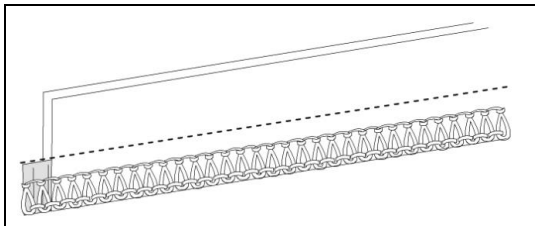
EL001: Elastic Tunneled Inside Seam



EL002: Elastic Set On Top Of Seam



EL003: Elastic Merrowed Into Seam



ELASTIC WITH CASING ON INSIDE OF GARMENT



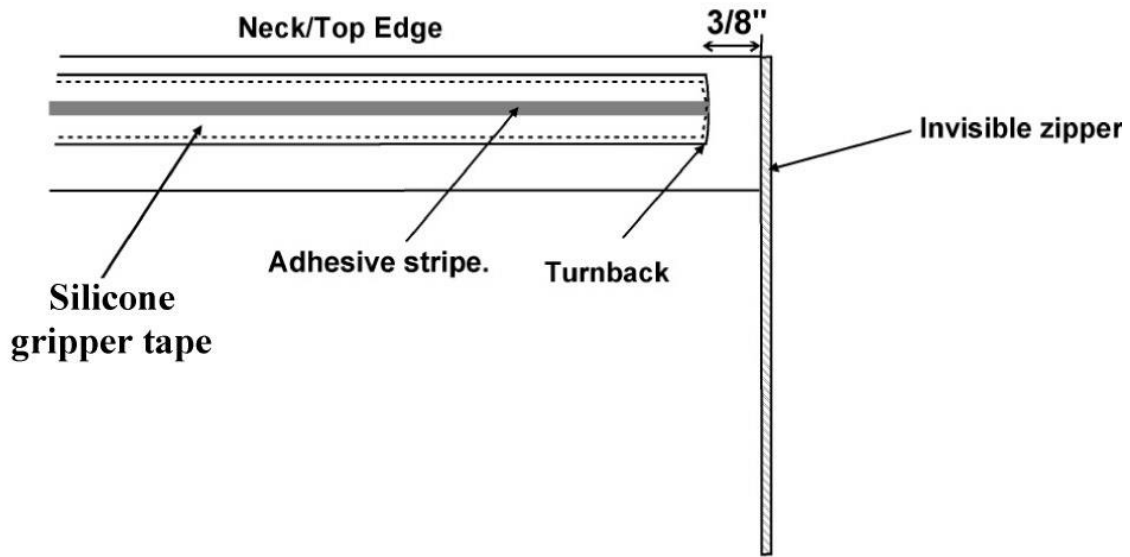
Outside View



Inside View

Silicone Gripper Elastic Tape

- * set to inside ply or facing with ends folded in edgestitch all sides
- * 1/8" minimum placement from top edge minimum



Inside view.

FABRIC:

***ALL FABRIC MUST BE TESTED FOR SEAM SLIPPAGE AT SAMPLING STAGE AND UPON RECEIPT OF BULK FABRIC. IF SEAM SLIPPAGE IS FOUND, ALL SEAMS MUST BE FUSED WITH DTM TRICOT FUSIBLE.

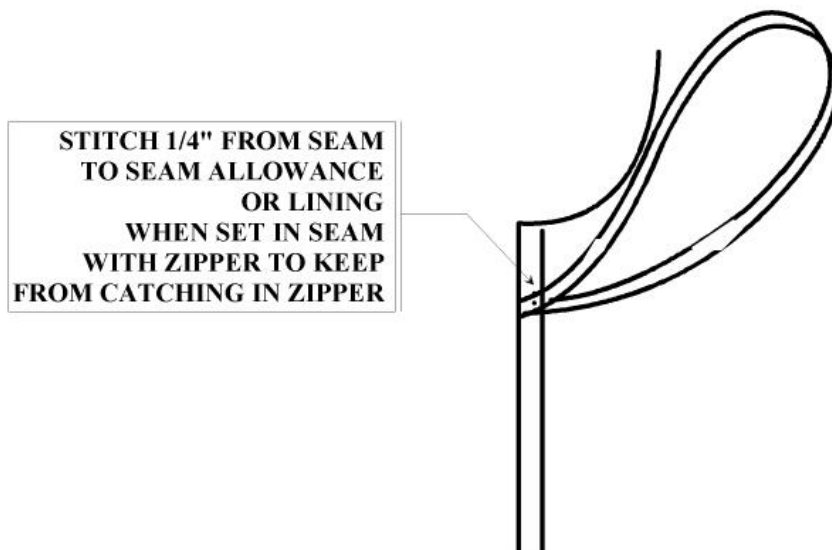
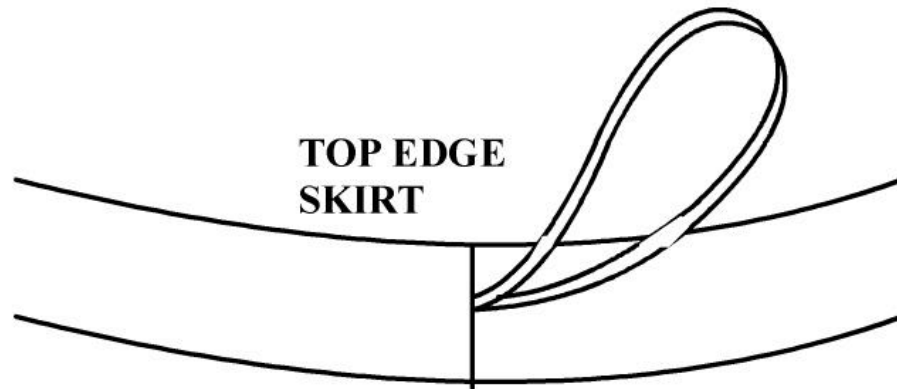
HANGER LOOPS:

Any hanger loop that is set into seam with a zipper must be stitched 1/4" from seam to keep from catching into zipper. Therefore cut 1/4" longer folded.

Blouses & Dresses: Tech will advise due to necklines and armhole changes.

Skirts standard: 4 1/2 " folded set in waistband side seams 1" below top edge.

On the zipper setting side fold ribbon back and stitch 1/4" from setting to keep from getting caught in the zipper.



HANGER LOOPS ON STRAPLESS DRESSES AND TOPS:

LINING

SET CASING ON FACE
SIDE OF LINING
INSERT HANGER LOOP

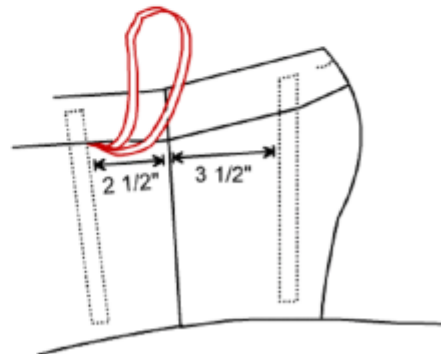
5/8" THREAD CHAINSTITCH
3/4" BELOW NECK EDGE

side back

side front

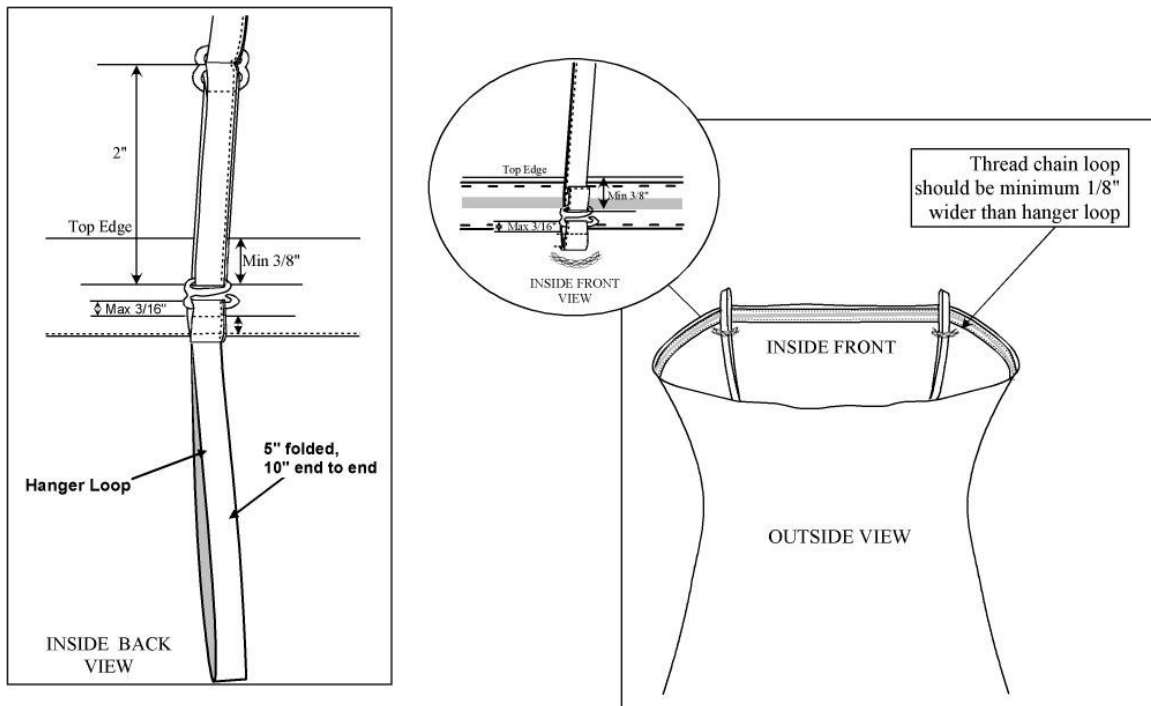
* WHEN THERE IS A NECK FACING THE RIBBON MAY BE INSERTED
IN THE JOINING SEAM OF THE FACING & LINING TO THE OUTSIDE
EDGE OF BONING.

CASING TO THE INSIDE



HANGER LOOPS: 5 1/2" FOLDED

STRAPLESS GARMENTS: HANGER LOOPS WITH DETACHABLE STRAPS



HEMS

BABY HEM:

1/16" FOR LIGHT WEIGHT FABRICS

1/8" FOR HEAVY WEIGHT FABRIC.

***BABY HEM SHOULD NEVER BE MORE THAN 1/8"

LININGS:

1. Add CB seam to all linings on skirts & skirt part of dresses. If the fabric is sheer make a French seam and seam is toward body. Self skirts that have shirring or multiple pleats: lining should have minimal fullness.
 - Shirring 1 1/4:1 ratio
 - Pleats should be reduced to 1 or 2 on each side of CF & CB
 - Lining sweeps should be NO MORE than 34" flat on sample size.

PICOT & PICKSTITCH :

1. Should be made by machine unless the Technician advises otherwise.

RUFFLES:

1. Cut on straight grain, no bias unless the Technician advises otherwise.

SEAMS & TOPSTITCH:

ISO#103: SINGLE THREAD BLINDSTITCH

3.5-4 SPI

ISO#301: SINGLE NEEDLE LOCKSTITCH

10-12 SPI

ISO#304: ZIGZAG

*8 CYCLES PER INCH

ISO#304: BUTTONSEW (4 hole)

16 per button

ISO#304: BUTTONHOLE (1/2")

85-90 total per buttonhole

ISO#304: BARTACK (1/4")

24-28 PER TACK

ISO#401: CHAINSTITCH

10-12 SPI

ISO#502: PURL MERROW

30-34 SPI

ISO#504: COMMON OVEREDGE

12-14 SPI

ISO#516: 5 THREAD SAFETY STITCH

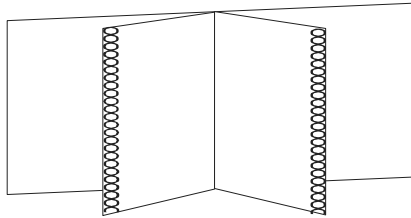
***STANDARD APPLICATION FOR ALL SAFETY SEAMS**

12-14 SPI

***ALL SPI ARE STANDARD REQUIREMENT, UNLESS OTHERWISE REQUESTED IN TECH PACK

SEAMS:

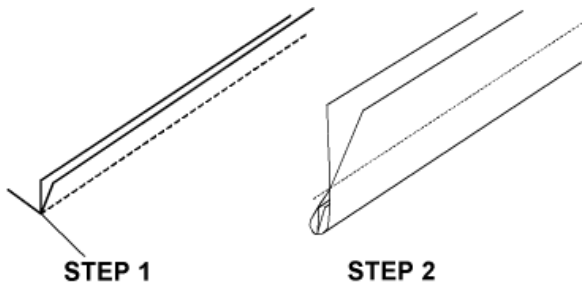
1/2" MERROW PRESS OPEN



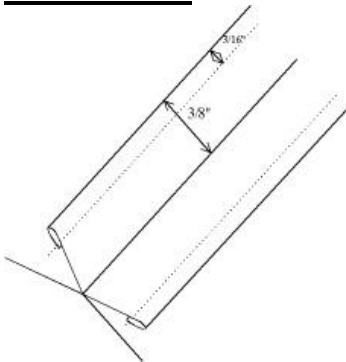
3/8" SAFETY SEAM



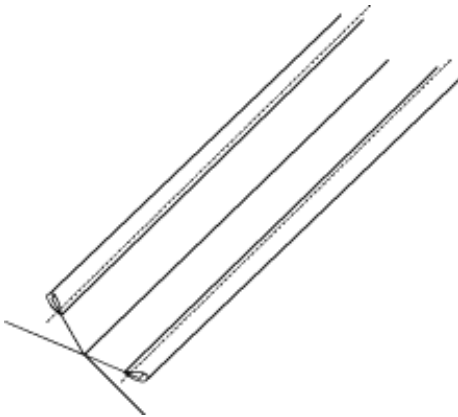
1/4" FRENCH SEAM



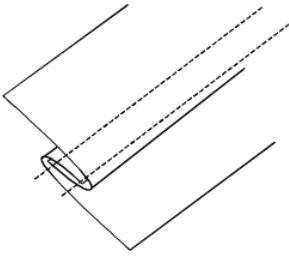
1/4" PIN HEM



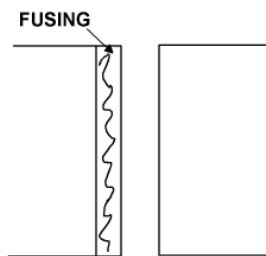
1/2" PRESS OPEN WITH 3/16" BINDING



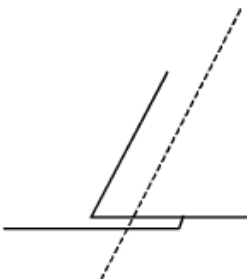
3/8" FLAT FELLED WITH 1/4" DN TS



FUSED SEAM



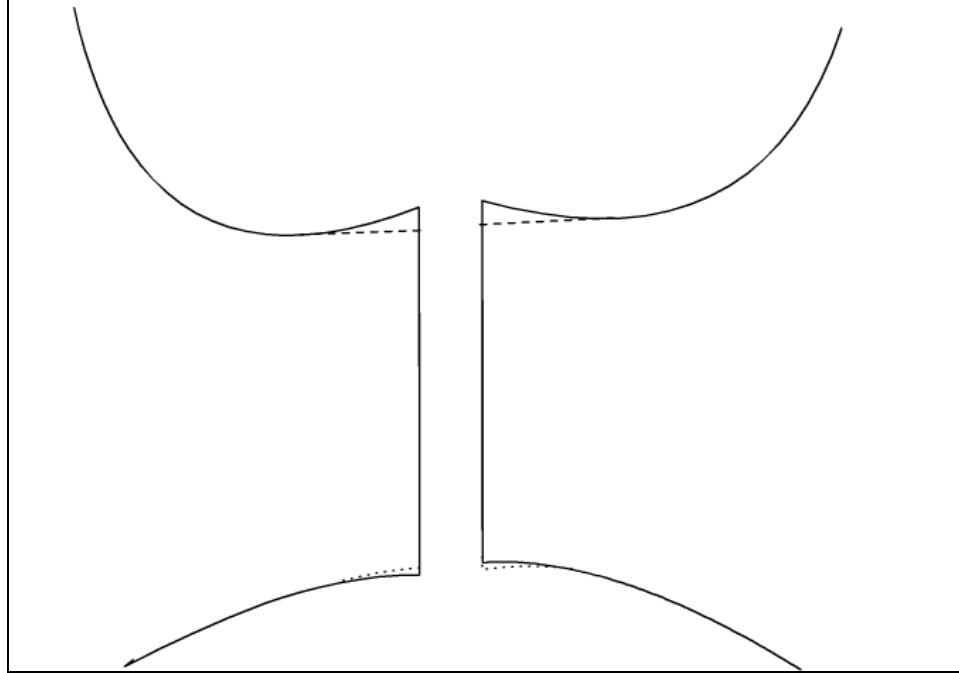
RAW CUT LAPPED SEAM



SEAM JOINING:

JOINING SEAMS

ALWAYS PUT JOINING SEAMS TOGETHER AFTER EACH PATTERN ADJUSTMENT TO ENSURE AN EVEN AND SMOOTH SEWING LINE. SHAVE OFF TO MAKE SMOOTH LINES



SMOCKING:

***ALL SMOCKED BACK OF GARMENTS MUST HAVE WOVEN ELASTIC SET IN TOP EDGE OF FOLD, OR IF THERE IS A RUFFLE AT THE TOP, BETWEEN TOP 2 ROWS OF SMOCKING.

***SMOCKING THAT IS ATTACHED TO A SEAM THAT SHOULD STRETCH WITH SMOCKING, SHOULD HAVE ELASTIC SET IN SEAM

S001:

ELASTIC SMOCKING WITH CHAINSTITCH BACK



S002:

ELASTIC SMOCKING STITCH

*MULTINEEDLE (TAJMAI, TAIS, KANSAI)



STRAPS :

1. Cut on straight grain unless the Technician advises otherwise.

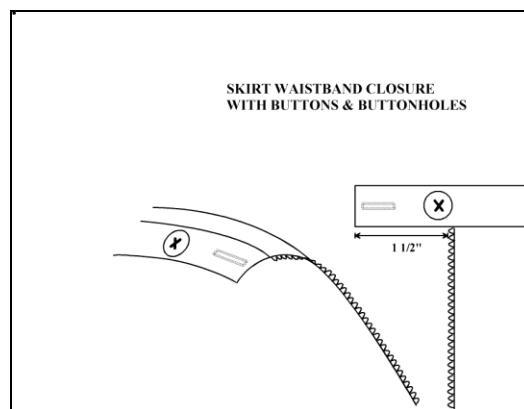
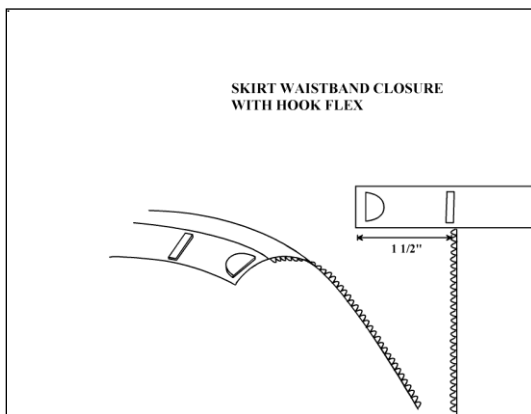
ANTHROPOLOGIE DETATCHABLE STRAPS:

1. Always set at princess seams.
 - a. Set ½" from top edge and tack.
2. If there are no princess seams, set:
 - a. Front strap distance 9 ½". Grade distance ¼" per size.
 - b. Back strap distance 7 ½" (If no smocking) & 6 ½" (If there is smocking at back). Grade distance ¼" per size.



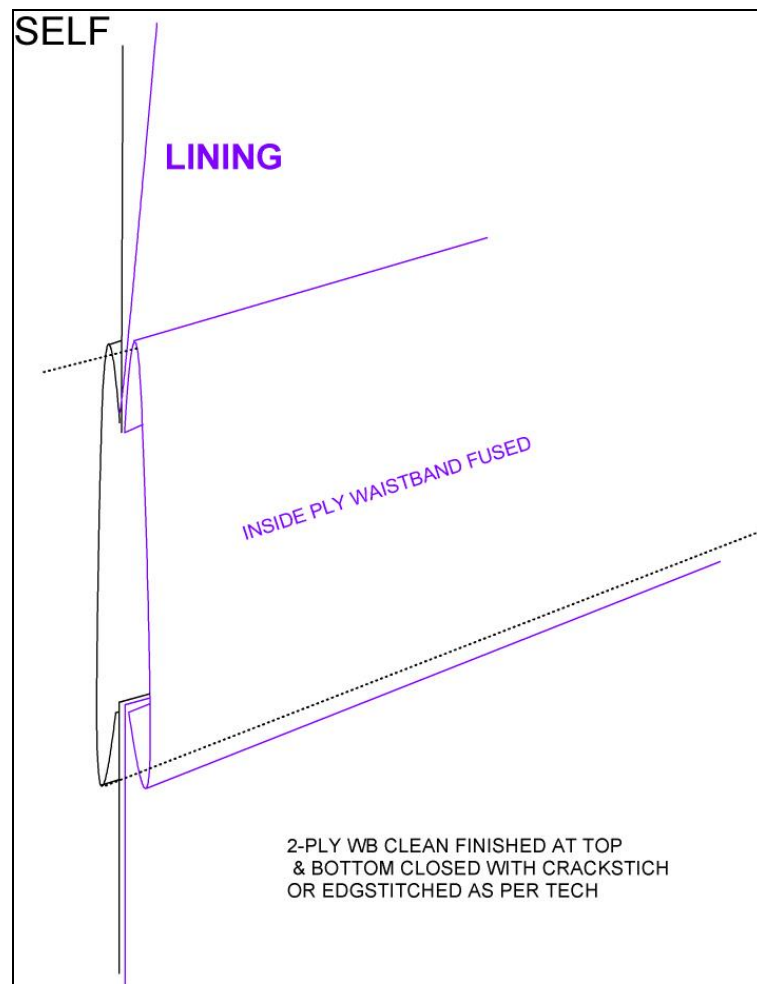
- Fold of loop tacked down.
- Fold of loop 3/8" from top finished edge.
- Hardware should not extend past edge.

WAISTBAND CLOSURES:

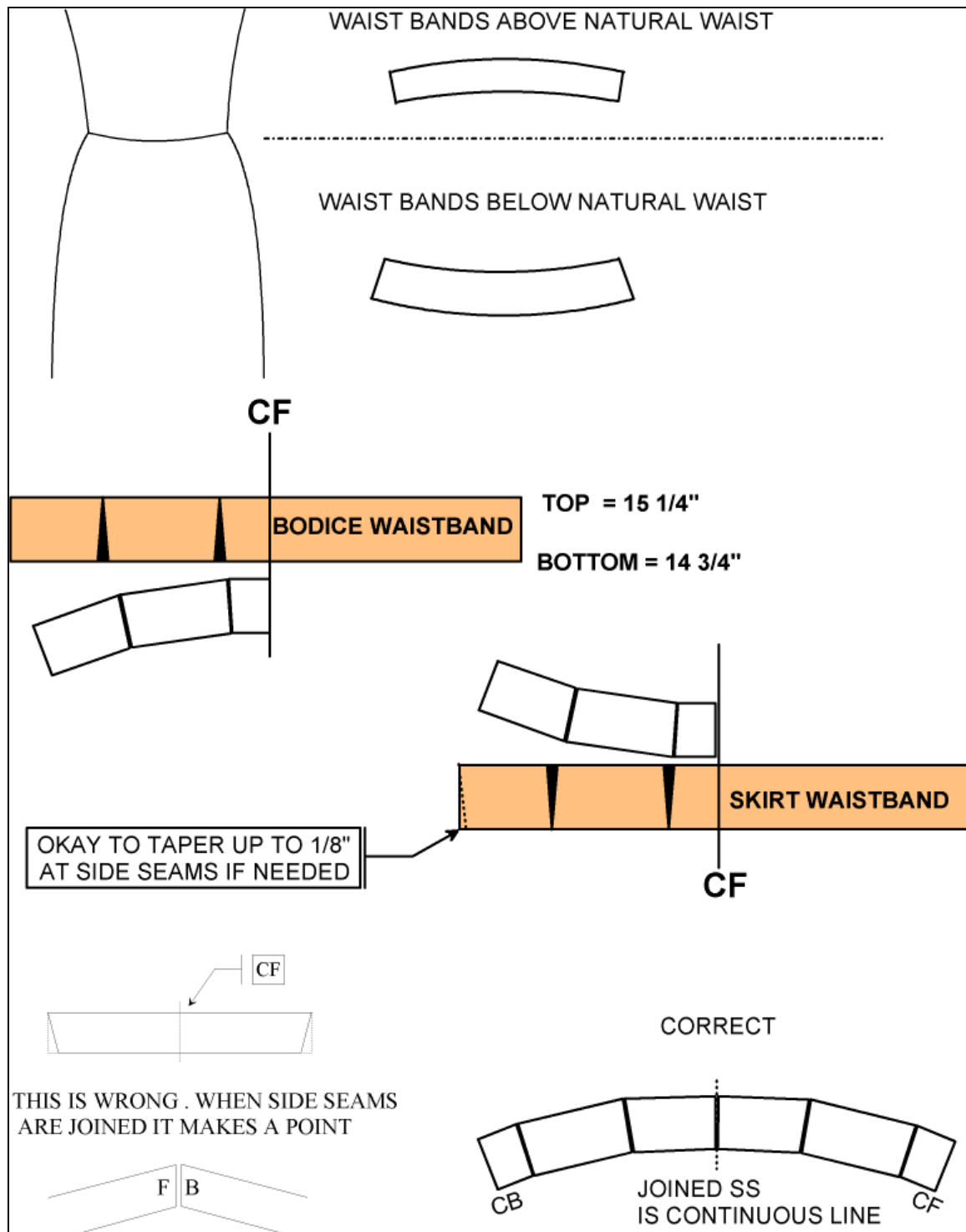


WAISTBAND INSERTS ON TOPS AND DRESSES:

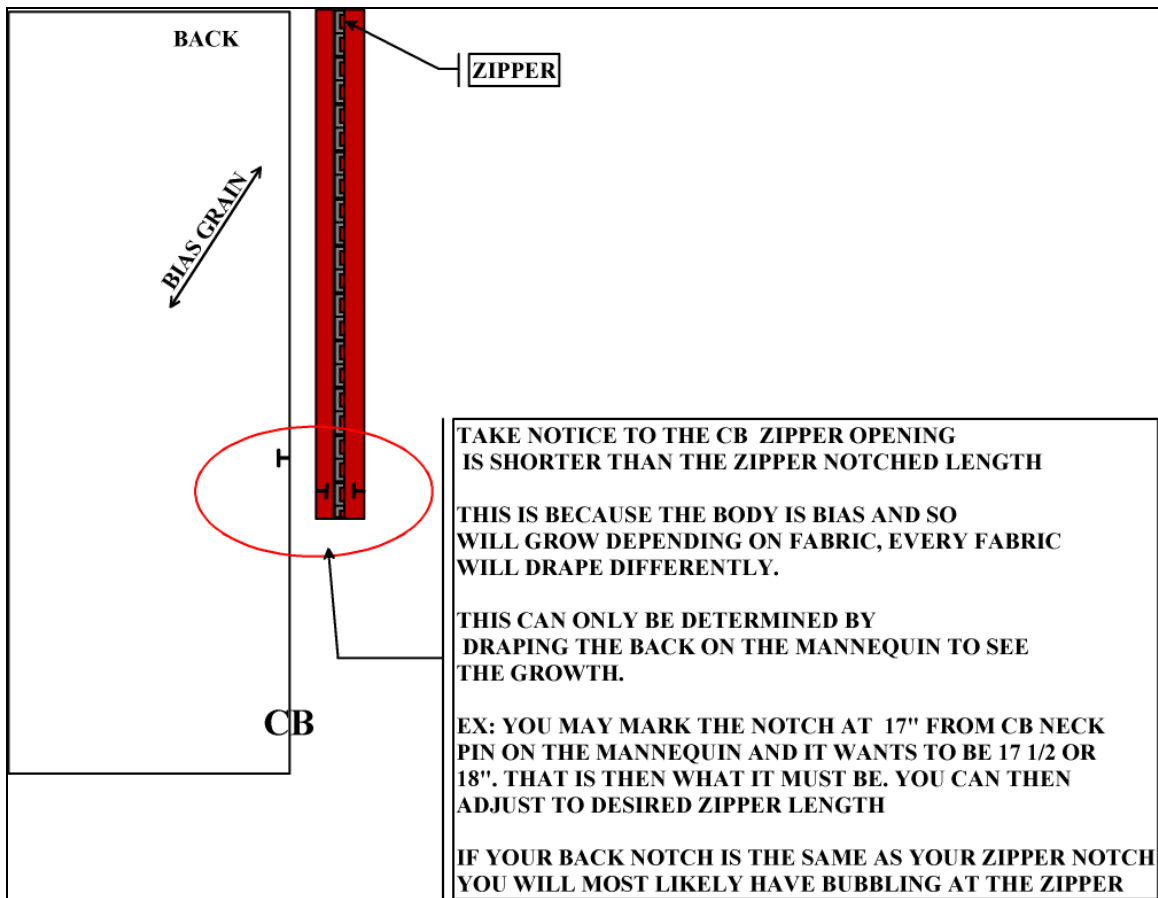
MUST BE SEWN CLOSED AT TOP AND BOTTOM



WAISTBAND PATTERN SHAPE:

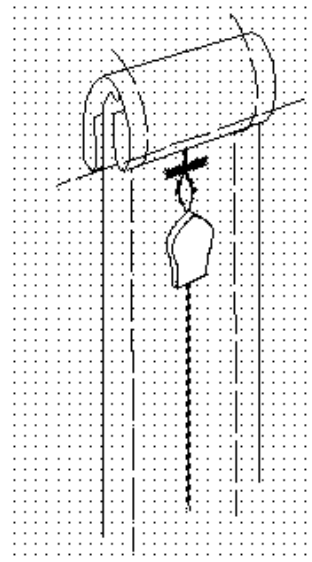


ZIPPERS – APPLICATION FOR BIAS GARMENTS:



ZIPPERS - INVISIBLE:

MUST BE CLEAN FINISHED WITH BINDING AT TOP AND BOTTOM EDGE OF ZIPPER



TO TOP EDGE: MUST HAVE HAND SEWN HOOK AND EYE AT TOP EDGE



STOPS 1" FROM TOP EDGE: BUT BE TACKED AT TOP OF ZIPPER



FUSE:

*WE HAVE SELECTED FUSE OPTIONS FOR SOFT WOVENS: LIGHT WEIGHT, MEDIUM WEIGHT AND HEAVY WEIGHT. THE PCC INFORMATION SHEET FOR EACH WEIGHT IS ATTACHED. ALL SPECIFICATIONS MUST BE FOLLOWED.

*WHITE FUSE SHOULD ONLY BE USED ON WHITE FABRICS. NATURAL AND BLACK SHOULD BE USED TO CLOSEST MATCHING COLOR.

*DTM FUSE SHOULD BE USED ALL ANY TRANSPARENT FABRICS AND FUSED SEAMS

SOFT WOVEN'S STANDARD INTERFACING OPTIONS: *(refer to the Tech Pack for specification)*

- Light Weight Fusible Tricot Knit = PCC style # KF121
- Mid Weight Fusible Tricot Knit = PCC style # KF789
- Heavy Weight Fusible Tricot Knit = PCC style # KF501
- Lightweight Fusible Stretch Woven Option = PCC style # PX313
 - * comes in colors
 - * good choice for fusible strips when having seam slippage
- Light Weight Fusible Non-Woven = PCC style # KF100
- Mid Weight Fusible Non-Woven = PCC style # KF230
- Heavy Weight Fusible Non-Woven = PCC style# KF240

Specification Sheet

GARMENT APPLICATIONS

- | | | | |
|----------------------------------|---------------------------------------|--|--------------------------------------|
| <input type="checkbox"/> Blouses | <input type="checkbox"/> Light Jacket | <input type="checkbox"/> Plackets | <input type="checkbox"/> Stone wash |
| <input type="checkbox"/> Dresses | <input type="checkbox"/> Heavy Jacket | <input type="checkbox"/> Waistbands | <input type="checkbox"/> Garment dye |
| <input type="checkbox"/> Shirts | <input type="checkbox"/> Coats | <input type="checkbox"/> Embroidery | |
| | <input type="checkbox"/> Raincoat | <input type="checkbox"/> Special Applications: _____ | |

TECHNICAL INFORMATION

Width:	60 inches (152 cm)
Put-up:	200 yards (182.88 m)
Colors:	White, Black
Total Weight:	1.60 osy (54 gsm)
Base Fabric	
Construction:	Circular Knit
Fiber content:	Polyester
Adhesive Coating	
Resin type:	Polyamide
Mesh:	22 mesh
Fusing Conditions	
Temperature (Fuseline):	240-290°F (116-143°C)
Time:	12-14 seconds
Pressure:	3-4 bar

CARE INSTRUCTIONS



The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.

ISO 9001 CERTIFIED

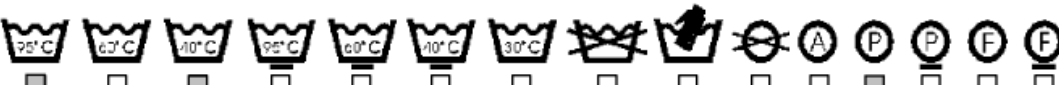
200 MALTESE DRIVE, TOTOWA, NEW JERSEY 07512-1404 • (973) 890-3873 • FAX (973) 785-8180

E-mail: pcc@pcc-usa.com

Date: 3/1/2001

Rev. 0

Specification Sheet

GARMENT APPLICATIONS			
<input type="checkbox"/> Blouses	<input type="checkbox"/> Light Jacket	<input type="checkbox"/> Plackets	<input type="checkbox"/> Stone wash
<input type="checkbox"/> Dresses	<input type="checkbox"/> Heavy Jacket	<input type="checkbox"/> Waistbands	<input type="checkbox"/> Garment dye
<input type="checkbox"/> Shirts	<input type="checkbox"/> Coats	<input type="checkbox"/> Embroidery	
	<input type="checkbox"/> Raincoat	<input type="checkbox"/> Special Applications: _____	
TECHNICAL INFORMATION			
Width:	60 inches (152 m)		
Put-up:	200 yards (182.88 m)		
Colors:	White, Black, Natural		
Total Weight:	2.00 osy (68 gsm)		
Base Fabric			
Construction:	Circular Knit		
Fiber content:	Polyester		
Adhesive Coating			
Resin type:	Polyamide		
Mesh:	17 mesh		
Fusing Conditions			
Temperature (Fuseline):	240-290°F (116-143°C)		
Time:	12-14 seconds		
Pressure:	4-5 bar		
CARE INSTRUCTIONS			
 <p>The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.</p>			

ISO 9001 CERTIFIED

















200 MALTESE DRIVE, TOTOWA, NEW JERSEY 07512-1404 • (973) 890-3873 • FAX (973) 785-8180

E-mail: pcc@pcc-usa.com

Date: 3/1/2001

Rev. 1

Specification Sheet

GARMENT APPLICATIONS			
<input type="checkbox"/> Blouses	<input type="checkbox"/> Light Jacket	<input type="checkbox"/> Plackets	<input type="checkbox"/> Stone wash
<input type="checkbox"/> Dresses	<input type="checkbox"/> Heavy Jacket	<input type="checkbox"/> Waistbands	<input type="checkbox"/> Garment dye
<input type="checkbox"/> Shirts	<input type="checkbox"/> Coats	<input type="checkbox"/> Embroidery	
	<input type="checkbox"/> Raincoat	<input type="checkbox"/> Special Applications: _____	
TECHNICAL INFORMATION			
Width:	60 inches (152 cm)		
Put-up:	200 yards (182.88 m)		
Colors:	White, Black		
Total Weight:	1.80 osy (61 gsm)		
Base Fabric			
Construction:	Circular Knit		
Fiber content:	Polyester		
Adhesive Coating			
Resin type:	Polyamide		
Mesh:	17 mesh		
Fusing Conditions			
Temperature (Fuseline):	240-290°F (116-143°C)		
Time:	12-14 seconds		
Pressure:	4-5 bar		
CARE INSTRUCTIONS			
			
			
			
			
<p>The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.</p>			

ISO 9001 CERTIFIED

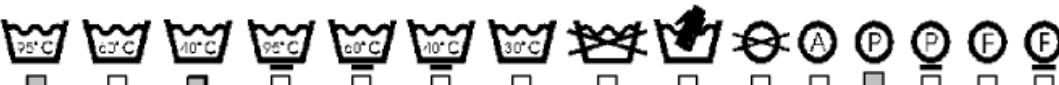
200 MALTESE DRIVE, TOTOWA, NEW JERSEY 07512-1404 • (973) 890-3873 • FAX (973) 785-8180

E-mail: pcc@pcc-usa.com

Date: 3/1/2001

Rev. 205

Specification Sheet

GARMENT APPLICATIONS			
<input type="checkbox"/> Blouses	<input type="checkbox"/> Light Jacket	<input type="checkbox"/> Plackets	<input type="checkbox"/> Stone wash
<input type="checkbox"/> Dresses	<input type="checkbox"/> Heavy Jacket	<input type="checkbox"/> Waistbands	<input type="checkbox"/> Garment dye
<input type="checkbox"/> Shirts	<input type="checkbox"/> Coats	<input type="checkbox"/> Embroidery	
	<input type="checkbox"/> Raincoat	<input type="checkbox"/> Special Applications: _____	
TECHNICAL INFORMATION			
Width:	60 inches (152 cm)		
Put-up:	109.36 yards (100 m)		
Colors:	White, Gray, Black		
Total Weight:	1.05 osy (36 gsm)		
Base Fabric			
Construction:	Thermal-bonded nonwoven		
Fiber content:	Nylon/Polyester		
Adhesive Coating			
Resin type:	Polyamide		
Mesh:	25 mesh		
Fusing Conditions			
Temperature (Fuseline):	240-290°F (116-143°C)		
Time:	12-14 seconds		
Pressure:	4-5 bar		
CARE INSTRUCTIONS			
 <p>The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.</p>			

ISO 9001 CERTIFIED


















200 MALTESE DRIVE, TOTOWA, NEW JERSEY 07512-1404 • (973) 890-3873 • FAX (973) 785-8180

E-mail: pcc@pcc-usa.com


















Date: 3/1/2001

Rev. 1

Specification Sheet

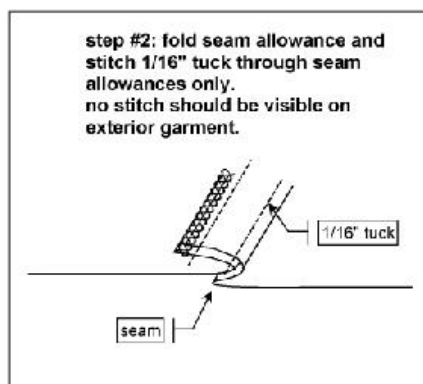
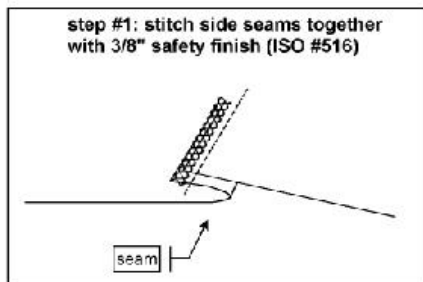
GARMENT APPLICATIONS			
<input type="checkbox"/> Blouses	<input type="checkbox"/> Light Jacket	<input type="checkbox"/> Plackets	<input type="checkbox"/> Stone wash
<input type="checkbox"/> Dresses	<input type="checkbox"/> Heavy Jacket	<input type="checkbox"/> Waistbands	<input type="checkbox"/> Garment dye
<input type="checkbox"/> Shirts	<input type="checkbox"/> Coats	<input type="checkbox"/> Embroidery	
	<input type="checkbox"/> Raincoat	<input type="checkbox"/> Special Applications: _____	
TECHNICAL INFORMATION			
Width:	60 inches (152 cm)		
Put-up:	200 yards (182.88 m)		
Colors:	White, Charcoal		
Total Weight:	1.10 osy (37gsm)		
Base Fabric			
Construction:	Thermal-bonded nonwoven		
Fiber content:	Polyester		
Adhesive Coating			
Resin type:	Polyamide		
Mesh:	17 mesh		
Fusing Conditions			
Temperature (Fuseline):	240-290°F (116-143°C)		
Time:	12-14 seconds		
Pressure:	4-5 bar		
CARE INSTRUCTIONS			
			
			
			
			
			

Specification Sheet

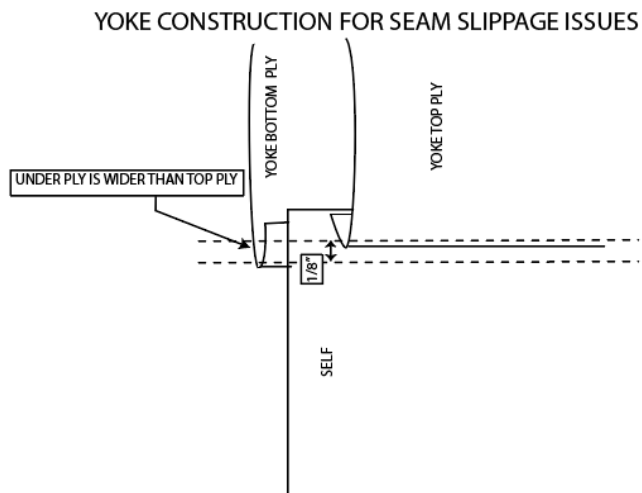
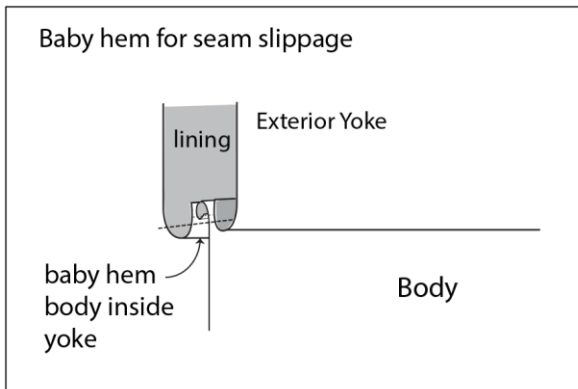
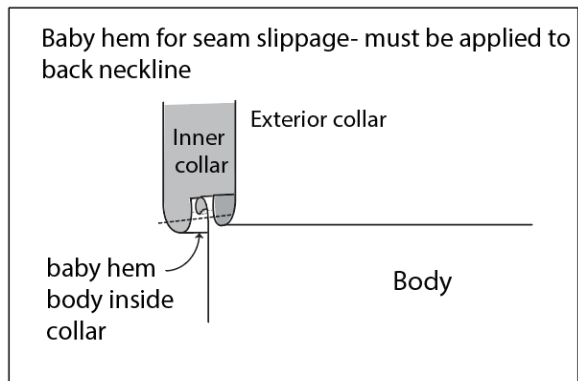
GARMENT APPLICATIONS			
<input type="checkbox"/> Blouses	<input type="checkbox"/> Light Jacket	<input type="checkbox"/> Plackets	<input type="checkbox"/> Stone wash
<input type="checkbox"/> Dresses	<input type="checkbox"/> Heavy Jacket	<input type="checkbox"/> Waistbands	<input type="checkbox"/> Garment dye
<input type="checkbox"/> Shirts	<input type="checkbox"/> Coats	<input type="checkbox"/> Embroidery	
	<input type="checkbox"/> Raincoat	<input type="checkbox"/> Special Applications: _____	
TECHNICAL INFORMATION			
Width:	60 inches (152 cm)		
Put-up:	100 yards (91.44 m)		
Colors:	White, Charcoal		
Total Weight:	1.40 osy (47 gsm)		
Base Fabric			
Construction:	Thermal-bonded nonwoven		
Fiber content:	Polyester		
Adhesive Coating			
Resin type:	Polyamide		
Mesh:	17 mesh		
Fusing Conditions			
Temperature (Fuseline):	240-290°F (116-143°C)		
Time:	12-14 seconds		
Pressure:	4-5 bar		
CARE INSTRUCTIONS			
			
			
			
			
			

Seam slippage construction:

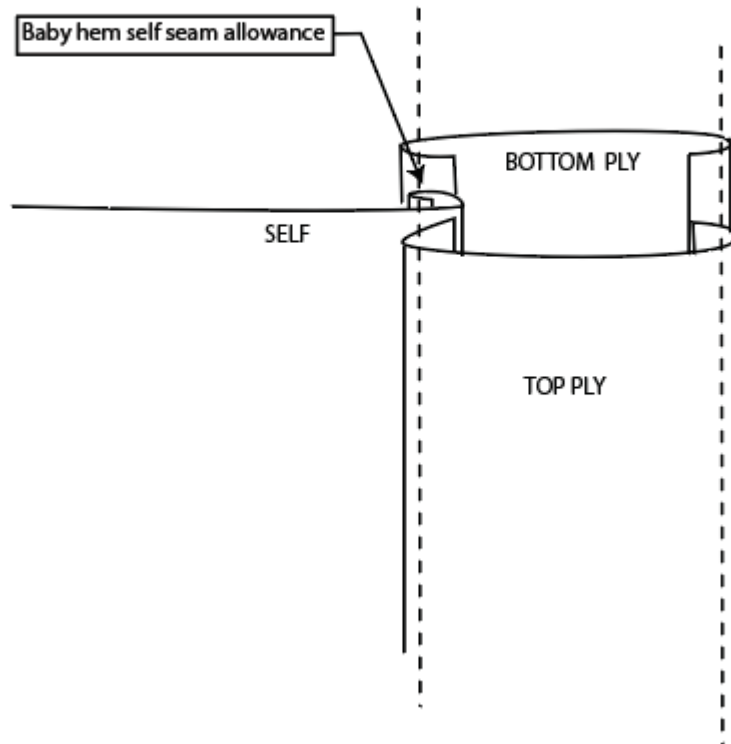
****ADD PINTUCK STITCH CONSTRUCTION FOR JOINING SEAMS TO PREVENT SEAM SLIPPAGE****



Seam slippage construction for collar and yoke seams



SEAM SLIPPAGE CONSTRUCTION FOR PLACKET



PLACKET , NECKBAND OR CUFF CONSTRUCTION FOR SEAM SLIPPAGE ISSUES

