


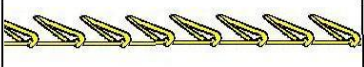








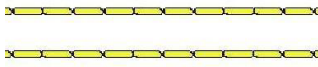

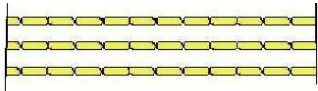
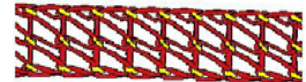
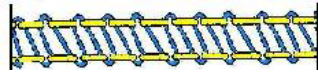



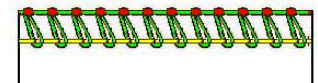

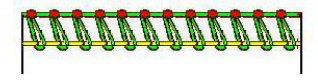

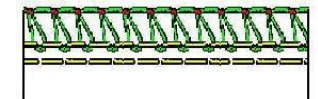

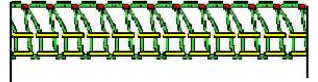
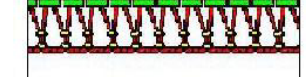
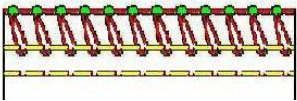

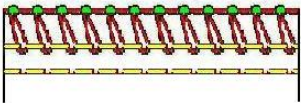

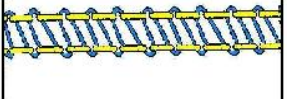

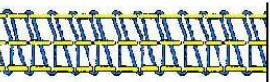
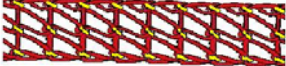
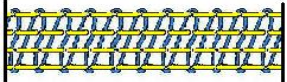

















Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
<b>Single Thread Chainstitch</b> 		101	Basting Stitch for Tailored Clothing; Bag Closing	Specify SPI.	Stitch formed by a needle thread passing through the material and interlooping with itself on the underside of the seam with the assistance of a spreader.
<b>Single Thread Chainstitch or Lockstitch Buttonsew, Buttonhole or Bartack</b> 	<b>* 304 Lockstitch is preferred when stitch security is a Must.</b>	101 or 304	Buttonsew, Buttonhole, or Bartack	1) Buttonsew - specify stitches per cycle (Ex. 8, 16, 32) 2) BH - specify length & width (1/2", etc.) 3) Bartack - specify length & width of tack.	Knit Shirts - Buttonhole length generally is 1/2 inch, is placed horizontally, with approximately 85-90 stitches
<b>Single Thread Blindstitch</b> 	<b>No stitch visible on the Bottom or Outside of Sewn Product</b>	103	Blindstitch Hemming, Felling, Making Belt Loops	Specify 1) SPI 3 - 5 SPI 2) Non-skip or 2 to 1 skipped stitch	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.
<b>Lockstitch - Most Common of All Stitches</b> 	<b>Bobbin Thread on Bottom</b> 	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.
<b>Zig Zag Lockstitch</b> 		304	Intimate Apparel, Athletic wear, Infantwear, Exercisewear	Specify 1) SPI 2) Throw or width Zig-Zag (1/8", 3/16", 1/4")	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.
<b>Chainstitch</b> 	<b>Looper Thread on Bottom</b> 	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.
<b>Zig Zag Chainstitch</b> 	<b>Looper Thread on Bottom</b> 	404	Zig-Zag Chainstitch for Infantwear and Childrenswear: Binding, Topstitching, etc.	Specify 1) SPI 2) Throw or width Zig-Zag (1/8")	Stitch is formed with a needle and a looper that are set on the underside of the seam and form a symmetrical zig-zag pattern.

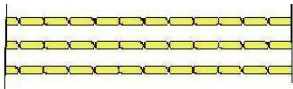
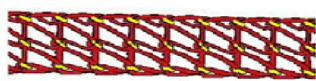
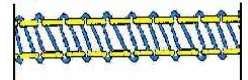
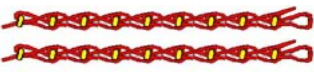
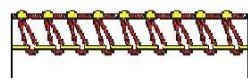

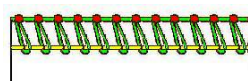

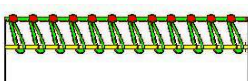



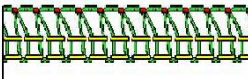

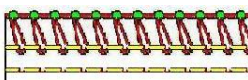
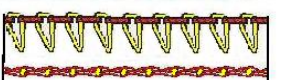
Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
<b>2 Needle Bottom Coverstitch</b> 	<b>Looper Thread on Bottom</b> 	406	Hemming, Attaching, Elastic, Binding, Coverseaming, Making Belt Loops	Specify 1) Needle spacing (1/8", 3/16", 1/4") 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.
<b>3 Needle Bottom Coverstitch</b> 	<b>Looper Thread on Bottom</b> 	407	Attaching Elastic to Men's & Boys Knit Underwear	Specify 1) Needle spacing (1/4") 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.
<b>2 Needle Chainstitch with Cover Thread</b> 	<b>Looper Thread on Bottom</b> 	408	Attaching Pocket Facings to Jeans & Chino Casual Pants		Stitch formed by 2-needle threads passing through the material and interlooping with 2-looper threads with the stitches set on the underside of the seam. A top spreader thread is interlaced on the top side of the seam between the two needle threads.
<b>2 Thread Overedge</b> 	<b>Single "purl" on Edge</b> 	503	Serging & Blindhemming	Specify 1) Width Bite (Ex. 1/8", 3/16", 1/4") 2) SPI.	Stitch formed by 1-needle thread and 1-looper thread with purl on edge of seam for serging or blindhemming ONLY.
<b>3 Thread Overedge</b> 	<b>Common Overedge Stitch</b> 	504	Single Needle Overedge Seaming	Specify 1) Width Bite (Ex. 1/8", 3/16", 1/4") 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.
<b>3 Thread Overedge</b> 	<b>Double "purl" on Edge</b> 	505	Serging with Double purl on Edge	Specify 1) Width Bite (Ex. 1/8", 3/16", 1/4") 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.
<b>Mock Safety Stitch</b> 	<b>2 Needle Overedge</b> 	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
<b>2 Needle 4 Thread Overedge</b> 	<b>2 Needle Overedge</b> 	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.

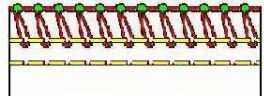

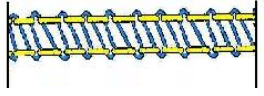

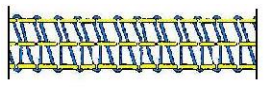
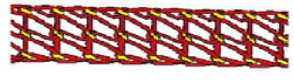
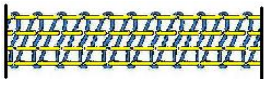

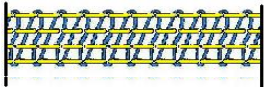

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
<b>4 Thread Safetystitch</b> 		<b>515</b> <b>(401+503)</b>	Safetystitch Seaming Wovens & Knits	Specify 1) Needle spacing & bite - Ex.: 1/8"-1/8", 3/16"- 3/16" 3/16" – 1/4" 2) SPI	Combination stitch consisting of a single-needle chainstitch (401) and a 2-thread Overedge stitch (503) that are formed simultaneously. Uses less thread than a 516 stitch; however, many manufacturers prefer a 516 stitch.
<b>5 Thread Safetystitch</b> 		<b>516</b> <b>(401+504)</b>	Safety Stitch Seaming Wovens & Knits	Specify 3) Needle spacing & bite - Ex.: 1/8"-1/8", 3/16"- 3/16" 3/16" – 1/4" 4) SPI	Combination stitch consisting of a single-needle chainstitch (401) and a 3-thread Overedge stitch (504) that are formed simultaneously.
<b>2 Needle 4 Thread Coverstitch</b> 		<b>602</b>	Binding A Shirts, Infants Clothing, etc.	Specify 1) Needle spacing (Ex: 1/8", 3/16", 1/4") 2) SPI	Stitch formed with 2-needle threads, a top cover thread and a bottom looper thread.
<b>3 Needle 5 Thread Coverstitch</b> 		<b>605</b>	Lap Seaming, Coverseaming, Binding on Knits	Specify 1) Needle spacing (Ex: 1/4") 2) SPI	Stitch formed with 3-needle threads, a top cover thread and a bottom looper thread.
<b>4 Needle 6 Thread Coverstitch</b> 	<b>Flatseamer/Flatlock</b> 	<b>607</b>	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.

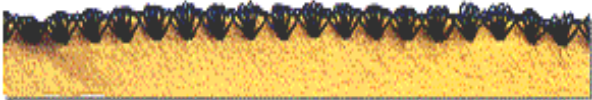

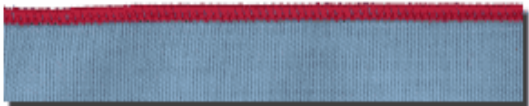






針步圖		ISO 4915 號碼	一般 用途	要求	針步之描述
正面圖	反面圖				
 單線鏈狀線		101	假縫針步是用於西裝樣的服裝,袋之封口	1) 指定的每英寸針步	此針步是由一條接縫線穿過物料,加上配線器的幫助,自我纏結所形成。
 單線鏈狀或連鎖式釘鈕,開鈕門或加固針縫(打棗/套結)	* 如需要牢固接縫,一定要使用304針步	101 或 304	釘鈕,開鈕門或加固針縫(打棗/套結)	1) 釘鈕 - 指定的每循環針步,例如16; 2) 開鈕門 - 指定長度及闊度; 3) 加固針縫(打棗/套結) - 指定(棗/結)長度及闊度	針織襯衫 - 鈕門長度一般為1/2英寸針步約為85-90步。
 單針暗縫(挑腳)	接縫反面或完成品正面是看不見接縫線的	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。
 平車針步 - 最普遍的針步	 線軸線於反面	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。
 人字形(之字形)的平車針步		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。
 鏈狀針步	 底勾線於接縫反面	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。
 人字形(之字形)的鏈狀針步	 底勾線於接縫反面	404	人字形(之字形)的鏈狀針步用於嬰兒服,童裝:滾邊條及面線等等。	1) 指定的每英寸針步; 2) 指定的人字(之字)線步寬度	此針步是由一條針線穿過物料,在接縫底部與底勾線互相纏結,形成對稱的人字圖案。
 雙針底部繡縫(三本)針步	 底勾線於接縫反面	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。





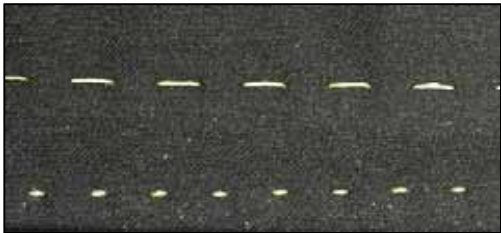



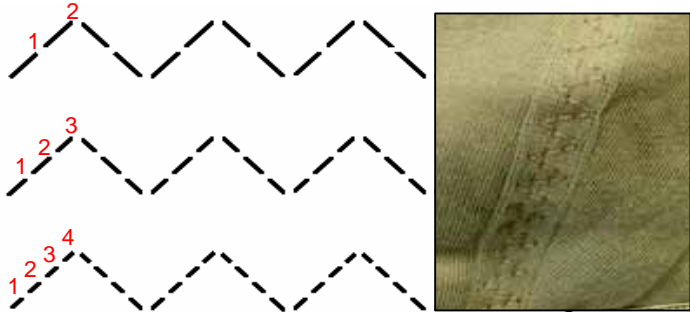

針步圖		ISO 4915 號碼	一般 用途	要求	針步之描述
正面圖	反面圖				
 三針底部繃縫針步	 底勾線於接縫反面	407	於男裝及男童裝的內褲上 加上彈性帶	1) 指定的針距 (1/4"); 2) 指定的針步	此針步是由三條接縫線穿過物料,於物料底部與一條勾線產生 纏結而成,而勾線會在布料底部三條接縫線之間組成繃縫線步 。
 雙針鏈狀針步連表面覆蓋線	 底勾線於接縫反面	408	車縫貼邊於牛仔褲及西褲 的袋口。		此針步是由兩條針線穿過物料,在接縫底部與兩條底勾線互相纏 結,同時一個表面配線器把一條縫線於兩條面針線之間穿梭, 形成表面覆蓋縫線。
 兩線包邊	 單"流蘇"於布邊	503	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) 每英吋針步	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) 每英吋針步	此針步是由一條接縫線與兩條勾線組成,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) 每英吋針步	此針步是由一條接縫線與兩條勾線組成,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) 指定的每英吋針步	此針步是由一條接縫線與兩條勾線組成,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) 指定的每英吋針步	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。
 四線包邊安全線	 兩針包邊	515 (401 + 503)	梭織及針織物	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) 每英吋針步	同時結合一條單針鏈狀縫線(401)及三線包邊(503)針步,用 線量比516針步少,可是現大多數廠商都寧願採用516針步。

針步圖		ISO 4915 號碼	一般 用途	要求	針步之描述
正面圖	反面圖				
 五線包邊安全線		516 (401 + 504)	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) 每英吋針步	同時結合一條單針鏈狀縫線(401)及三線包邊(504)針步。
 兩針四線繃縫(三本)針步		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) 每英吋針步	此針步是由兩條接縫線,一條表面繃縫(三本)線與一底勾線組成。
 三針五線繃縫(三本)針步		605	搭(接)縫,繃縫(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) 每英吋針步	此針步是由三條接縫線,一條表面繃縫(三本)線與一底勾線組成。
 四針九線平式接縫針步	 扁平接縫	606	平式或搭接縫,針織內衣, 衛衣等等	1) 指定的每英吋針步	此針步是由四條接縫線,一條表面繃縫(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。
 四針六線平式接縫繃縫(三本)針步	 平式接縫	607	平式或搭接縫,針織內衣, 衛衣等等	1) 指定的每英吋針步	此針步是由四條接縫線,一條表面繃縫(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。

SPECIAL STITCH PHOTO & COMMON NAME	THREAD RECOMMEND.	COMMON APPLICATION	STITCH DESCRIPTION
 <p>SHELL STITCH</p>	T-21 - T-40 Spun Poly or PW Core	Serge Edge Stitching of Womens, Girls and Infants Clothing	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. Generally 5 shells per inch. Standard seam width = 3/16" or 5mm.
 <p>LARGE SHELL STITCH</p>	T-40 - T-60 Spun Poly, No. 30 - No. 20 Signature - high sheen	Serge Edge Stitching of Womens, Girls and Infants Outerwear; Shell Stitching Blankets	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. Standard seam width - 3/8" to 1/2" or 9.5 to 12.7mm. Generally 2 Shells per inch.
 <p>PURL EDGE STITCH</p>	Ndl. Thd. - T-24 PW Core or T-27 Spun Poly; Loopers - T-35 - T-50 Textured Polyester	Serging the edges of napkins, Table clothes. Serge edge on light weight womens apparel.	<u>502 Overedge Stitch</u> Formation with 18 to 26 Stitches Per Inch. Standard seam width = 1/16" = 1.5mm.
 <p>PURL EDGE STITCH</p>	Ndl. Thd. - T-24 PW Core or T-27 / T-30 Spun Poly; Upper Looper - High Luster - No. 3004 Signature	Serging the edges of appliques, labels, etc.	<u>505 Overedge Stitch</u> Formation with 14 to 18 Stitches Per Inch. Seam width - 1/8 to 3/16" or 3 to 4.5mm.
 <p>LETTUCE EDGE SERGING</p>	Same as seaming thread.	Serging Edges of womens, childrens, infants clothing	<u>504 or 505 Stitch Formation</u> with reverse differential feeding action to uniformly stretch the fabric as it is being sewn.
 <p>BLANKET STITCH</p>	T-180 to T-350 Spun Polyester	Serging Edges of Blankets, Sweaters, Polar Fleece, etc.	<u>503 Stitch</u> Formation with 4 stitches per inch. Seam width usually 1/2" or 12.7mm
 <p>ZIG ZAG CHAINSTITCH</p>	T-24 PW Core or T-27, T-30 Spun Poly	Zig Zag Chainstitch operations on Childrenswear	<u>ISO 404 Stitch</u> Formation - Zig Zag Chainstitch



SPECIAL STITCH PHOTO & COMMON NAME	THREAD RECOMMEND.	COMMON APPLICATION	STITCH DESCRIPTION
 <p>PICOETTA STITCH</p>	T-24 PW Core or T-27, T-30 Spun Poly	Pico edging of womens, childrens, infants clothing	<u>ISO 411 Stitch</u> Formation - Two thread Multi-Step Chainstitch generally formed just off the edge of the seam.
 <p>2 NDL. FAGOTING</p>	T-24 PW Core or T-27, T-30 Spun Poly	Duplex fagoting of womens, childrens, infants clothing	Fagoting is the uniting the finished edges of two pieces of fabric with a space between the edges using decorative chainstitch. In this case a Duplex (double needle) ISO 411 stitch is being used.
 <p>PICOETTA STITCH</p>	T-24 PW Core or T-27, T-30 Spun Poly	Picoetta decorative stitching of womens, childrens, infants clothing	<u>ISO 411 Stitch</u> - Two thread Multi-Step Chainstitch used to topstitch a seam.
 <p>PIN, PICK OR SADDLE STITCH</p>	T-24 to T-60 PW Core or Spun Poly	Decorative Topstitching of Coats, Jackets, Dresses, etc.	<u>ISO 108 Single Thread Chainstitch</u> . 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. 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.
 <p>PIN, PICK OR SADDLE STITCH</p>	T-24 to T-60 PW Core or Spun Poly	Decorative Topstitching of Coats, Jackets, Dresses, etc.	<u>ISO 201 Single Hand Stitch</u> . Formed when a double pointed needle with the eye in the center carries an end of thread through the fabric. Seam is limited to 90 cm long.

SPECIAL STITCH PHOTO & COMMON NAME	THREAD RECOMMEND.	COMMON APPLICATION	STITCH DESCRIPTION
 BLIND STITCH	T-24 Core or T-27 Spun Poly	Decorative Topstitching of Knit Tops, Dresses, etc.	Currently there isn't an ISO stitch number for this stitch. It is referred to by some sewing machine companies as a Blind Stitch Deco stitch. Formed by make three or four straight stitches and then a zig zag stitch over to the edge or the fabric. Then the pattern repeats with straight stitches and then a zig zag. Normally you will specify the SPI and the width of throw for the zig zag. On domestic sewing machines, this is the stitch used for blind hemming. However this stitch is also commonly used for decorative stitching on the edge of woven or knit garments.
 MULTI-STEP ZIG ZAG	T-24 Core or T-27 Spun Poly	Attaching Elastic, Seaming Intimate Apparel	<u>ISO 308 Stitch</u> - is a two step Zig Zag where there is two stitches to the left and then two stitches to the right. This pattern is repeated for the length of the seam. <u>ISO 321 stitch</u> is a three step Zig Zag here there is three stitches to the left and then three stitches to the right. This pattern is repeated for the length of the seam. . <u>ISO 322 stitch</u> is a four step Zig Zag here there is four stitches to the left and then four stitches to the right. This pattern is repeated for the length of the seam. Each of these stitches us a single needle thread and single bobbin thread.
 BLINDHEM	T-21 or T-27 Spun Poly, T-18 or T-24 Textured Polyester.	Hem Tee Shirts, Knit Tops, etc.	<u>ISO 503 Stitch</u> - is used to make a blindhem where the fabric is folded in an "S" configuration and then overeged with a two thread overedge machine with a blindhemming attachment. The hemming guides position right to left determines the amount of "bite" or thread showing on the outside of the garment.