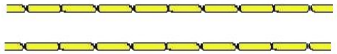
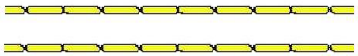
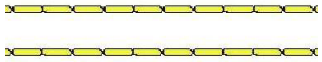
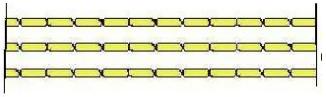
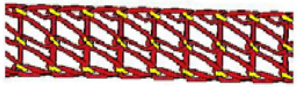
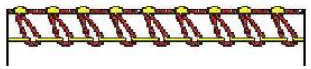
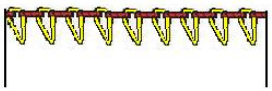
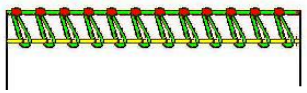
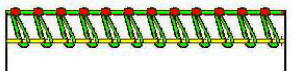
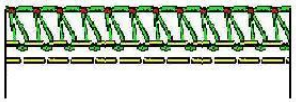
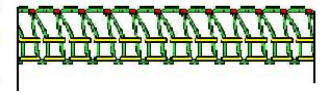
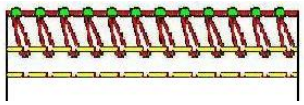
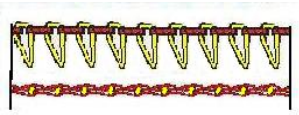
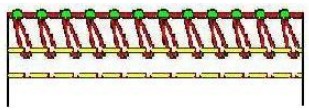
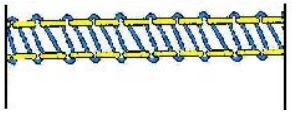
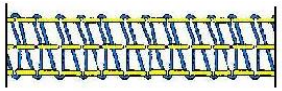
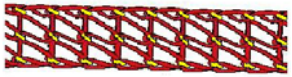
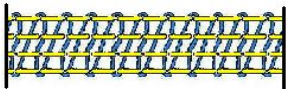
Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	**Bottom View As Sewn**				
Single Thread Blindstitch 	**Stitch is not visible on the Outside of Sewn Product**	103 Blindstitch	Blindstitch Hemming, Felling, Making Belt Loops	Specify 1) SPI 3 - 5 SPI 2) Non-skip or 2 to 1 skipped stitch	Stitch is formed with one needle thread that is interlooped with itself on the top side. The thread passes through the top ply and horizontally through portions of the bottom ply without completely penetrating its full depth.
Lockstitch - Most Common of All Stitches	**Bobbin Thread on Bottom**	301 Lockstitch	Single Needle, Straight Stitching, Topstitching	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.
Double Needle Lockstitch 	**Bobbin Thread on Bottom** 	301 – 2 Lockstitch	Double Ndl. Topstitching	Specify SPI.	Stitch formed by 301 lockstitch machine with two needles and two bobbins make two independent rows of 301 lockstitch simultaneously.
Zig Zag Lockstitch 		304 Zig Zag	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.
Chainstitch	**Looper Thread on Bottom** 	401 Chainstitch	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.
2 Ndl.Chainstitch 	**Looper Thread on Bottom** 	401 – 2 Chainstitch	Double Needle Seaming	Specify SPI.	Stitch formed by 401 chainstitch machine with two needles and two loopers make two independent rows of 401 chainstitch simultaneously.
2 Needle Bottom Coverstitch 	**Looper Thread on Bottom** 	406 Bottom Coverstitch	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.
3 Needle Bottom Coverstitch 	**Looper Thread on Bottom** 	407 Bottom Coverstitch	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.

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
2 Thread Overedge 	**Single "purl" on Edge** 	503 1 Ndl.	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.
3 Thread Overedge 	**Common Overedge Stitch** 	504 1 Ndl.	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.
3 Thread Overedge 	**Double "purl" on Edge** 	505 1 Ndl. Dbl. Purl	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.
Mock Safety Stitch 	**2 Needle Overedge** 	512 2 Ndl.	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 2 Ndl.	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.
4 Thread Safetystitch 		515 **(401+503)** Safetystitch	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.
5 Thread Safetystitch 		516 **(401+504)** Safetystitch	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.

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
2 Needle 4 Thread Coverstitch 		602 Coverstitch	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.
3 Needle 5 Thread Coverstitch 		605 Coverstitch	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.
4 Needle 6 Thread Coverstitch 	**Flatseamer/Flatlock** 	607 Flatseam Coverstitch	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.

BUTTONSEW, BUTTONHOLE, BARTACK

Stitch Appearance		ISO 4915 Number	Common Application	Requirements	Stitch Description
Lockstitch Buttonsew, Buttonhole or Bartack 	*** 304 Lockstitch is preferred when stitch security is a Must.**	304 Lockstitch	Buttonsew Buttonhole Bartack	1) Buttonsew - specify stitches per cycle (Ex. 8,16, 32) 2) BH - specify length & width (1/2", 3/4", 1") 3) Bartack – specify the length & width of the tack	Buttonsewing can be done with either a single thread buttonsewer or a lockstitch buttonsewer. Because single thread sewn buttons can unravel if the stitch is not locked properly, lockstitch sewn buttons is often preferred. 2 hole buttons are usually sewn with 6 or 8 stitches. 4 hole buttons are normally sewn with 12 or 16 stitches. Knit Shirts - Buttonhole length generally is 1/2 inch, is placed horizontally, with approximately 85-90 stitches. Most common bartack machines sew tacks with 28 stitches. Usually this includes running stitches that are then overlayed with cross-over stitches.
Single Thread Chainstitch Buttonsew	**101 chainstitch Buttonsew with single thread**	101 Chainstitch			