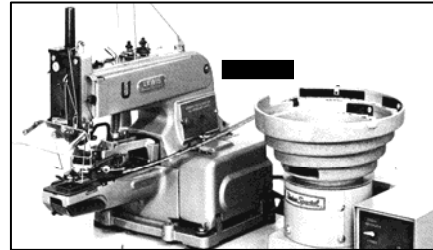


Eliminating Buttonsew Failures

One of the most common reasons for consumer complaints and returns in apparel is because of buttons unraveling and falling off. A tail of thread usually is seen on the top of the button and when this thread is pulled, the stitch unravels and the button falls off. On certain products like baby and infants clothing, this is NOT acceptable.



Buttonsew failure



Single-thread buttonsewer

101 Single Thread Chainstitch Buttonsew

Use of a 101 single-thread chainstitch buttonsewer is very common and used by many manufacturers. This stitch attaches the button to the fabric by repeatedly looping a single thread through the button and the fabric. If the machine is properly maintained and a quality thread is used to minimize skipped stitches during the sewing cycle, then the stitch is secure and the buttonsew will not unravel. However, this method of attaching buttons always has the potential of unraveling if there is a sewing problem or if the sewing operator begins to remove the button from the clamp before the sewing cycle is completed.

Solutions

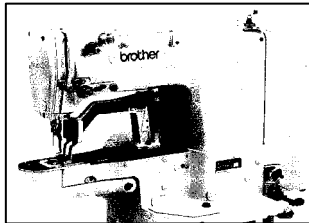
- Use A&E's ***NEW Perma Core® Reactive*** sewing thread. When used as a buttonsewing thread, and activated, ***Perma Core® Reactive*** will form a durable bond between the stitches. This prevents the button-sew stitch from unraveling.

Activating the thread is done by ironing from the underside which fuses the buttonsew threads together. Another benefit of ***Perma Core® Reactive*** is that the activated thread is not melted so it still has a soft-hand.

- Specify and verify the use of a 304 Lockstitch buttonsew versus a 101 single-thread chainstitch buttonsew.

Use a 304 Lockstitch Buttonsewing Machine

Many retailers have found that the best way of eliminating the possibility of buttons falling off due to unraveled stitches is to specify a 304 Lockstitch buttonsew attachment instead of the single-thread buttonsew. This stitch attaches the button to the fabric by interlocking the needle thread with a bobbin thread. This method secures the button and insures that the stitch will not unravel.



Lockstitch buttonsewer

We are often asked if you can look at a sewn button and tell if it was sewn with a chainstitch or lockstitch buttonsewing machine. The answer is that it is very difficult unless you can see two ends of thread on the under side of the button indicating a needle and bobbin thread were used. Our GRS team came up with a possible solution that will make it easier to tell what stitch was used to sew on the button. Using a different shade of thread in the bobbin to make it easier to inspect the buttons to assure that they were sewn with a lockstitch buttonsewer.

Implementation

1. You should specify on all product packages and BOM's to use either A&E's **Perma Core[®] Reactive** or a Lockstitch Buttonsew on products where buttonsew failure has been a problem.
2. Sourcing should confirm with vendors that they have lockstitch buttonsewers in their factories and they will be used on your production.
3. Quality Assurance auditors should report any and all button unraveling problems which is a clear indication that a lockstitch buttonsew was not used.

If you need assistance in determining what would be an adequate stitch level for your sewn products, please contact A&E's technical service team for assistance. We look forward to serving you.