













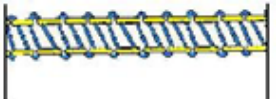





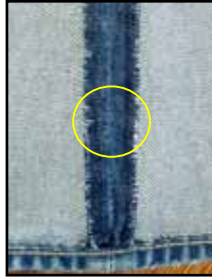
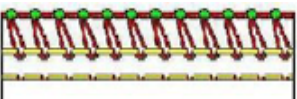

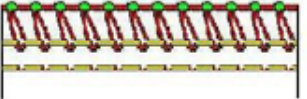



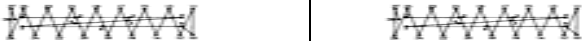

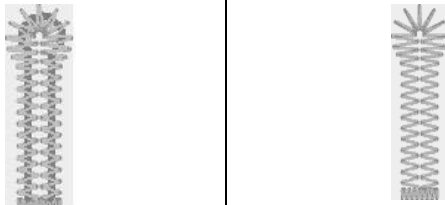


Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
Single Needle Lockstitch 	Bobbin Thread on Bottom 	301	<ul style="list-style-type: none"> - Set Pocket Facing - Set Left Fly - Topstitch Left Fly - Set Back Pockets - Topstitch Side Seams - Finish Band Ends - Hem Bottom 	- Typical SPI = 8	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 = 2	<ul style="list-style-type: none"> - Zipper Set - Set Watch Pocket - Set Front Pockets - Deco Back Pockets - Set Back Pockets - Topstitch Side Seams 	<ul style="list-style-type: none"> - Typical SPI = 8 - Needle Spacing = 1/4" 	Two rows of Stitch formed by two needle threads passing through the material and interlocking with two bobbin threads with the threads meeting in the center of the seam. Stitch looks the same top & bottom. Two independent rows of Lockstitch are formed.
					
Chainstitch 	Looper Thread on Bottom 	401	<ul style="list-style-type: none"> - Side or Inseam with busted seam construction. - Topstitch Inseam (Fake Felled Seam) 	- 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.
Double Needle Chainstitch 		401 = 2	<ul style="list-style-type: none"> - Zipper Set - Hem Watch Pkt & Back Pkts. - Riser & Seat Seam - Fell Inseam - Double Needle Topstitch - Attach Waistband 	<ul style="list-style-type: none"> - Typical SPI = 8 - Needle Spacing = 1/4" or 9/16" 	Stitch formed by 2 needle threads passing through the material and interlooping with 2 looper threads and pulled up to the underside of the seam forming 2 independent rows of stitch.
Triple Needle Chainstitch 		401 = 3	<ul style="list-style-type: none"> - Riser Seam - Seat Seam - Fell Inseam - Triple Needle Topstitch 	<ul style="list-style-type: none"> - Typical SPI = 8 - Needle Spacing = 1/8" or 9/32" 	Stitch formed by 3 needle threads passing through the material and interlooping with 3 looper threads and pulled up to the underside of the seam forming 3 independent rows of stitch.
					

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description	
Top View As Sewn	Bottom View As Sewn					
2 Needle Bottom Coverstitch 	Looper Thread on Bottom 	406	- Make Belt Loops	- 1/4" Needle Spacing - Use fusible tape on inside of loop	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.	
						
2 Needle Chainstitch with Cover Thread 	Looper Thread on Bottom 	408	- Attaching Pocket Facings	- 1/4" Needle Spacing	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.	
2 Needle 4 Thread Coverstitch 		602	- Attaching Pocket Facings	- 1/4" Needle Spacing	Stitch formed with 2 needle threads, a top cover thread and a bottom looper thread.	
						

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View	Bottom View				
<p>2 Thread Overedge</p> 		<p>503</p>	<ul style="list-style-type: none"> - Serge Panel if busted seam construction is used. 	<ul style="list-style-type: none"> - Specify - Width Bite (Ex. 3/16", 1/4") - SPI. 	<p>Stitch formed by 1 needle thread and 1 looper thread with the purl on edge of seam FOR SERGING ONLY. Consumes less thread than a 504 stitch.</p>
<p>3 Thread Overedge</p> 		<p>504</p>	<ul style="list-style-type: none"> - Serge left fly - Serge on right fly - Serge Pocket facings 	<ul style="list-style-type: none"> - Specify - Width Bite (Ex. 3/16", 1/4") - SPI. 	<p>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.</p>
					
<p>4 Thread Safetystitch</p> 		<p>515 (401+503)</p>	<ul style="list-style-type: none"> - Bag Front Pockets - Sideseam - Inseam 	<p>Specify:</p> <ul style="list-style-type: none"> - Needle spacing & bite - Ex.: - 3/16" - 1/4" - SPI = 8 spi 	<p>Combination stitch consisting of a single-needle chainstitch (401) and a 2 thread Overedge stitch (503) that are formed simultaneously.</p> <p>* Uses less thread than a 516 stitch; however, many manufacturers prefer a 516 stitch.</p>
<p>5 Thread Safetystitch</p> 		<p>516 (401+504)</p>	<ul style="list-style-type: none"> - Bag Front Pockets - Sideseam - Inseam 	<p>Specify:</p> <ul style="list-style-type: none"> - Needle spacing & bite - Ex.: - 3/16" - 1/4" - SPI = 8 spi 	<p>Combination stitch consisting of a single-needle chainstitch (401) and a 3 thread Overedge stitch (504) that are formed simultaneously.</p> <p>* Usually preferred over 515 stitch.</p>
					

Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
<p>Bartack</p> 		304	<ul style="list-style-type: none"> - Tack Hip Pockets - Tack Fly - Attach Belt Loops 	<ul style="list-style-type: none"> - Length of Tack 1/4" to 3/4" - Width of Tack 1/8" to 5/32" - Common stitches per cycle - 28 	Most bartacks are formed with Running stitches that are then covered with cross-over stitches made on cycle machines. At the end of the cycle, several tying stitches are formed to prevent the thread from pulling out of the stitch.
					
<p>Buttonhole</p> 		304	<ul style="list-style-type: none"> - Buttonhole Waistband - BH Pocket Flap 	<ul style="list-style-type: none"> - Length of BH - Buttonhole Gimp 	Lockstitch Buttonhole formed with cross-over stitch formed in a zig-zag pattern.
