

Stitch Guide

Most Common Stitch Types in ASTM D-6193 and ISO 4915:1991 Standards

This quick reference guide is to help communication between designers, production managers and sewing contractors. The guide is freely distributed.

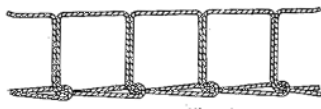
Images courtesy of www.garmento.org, www.wikipedia.org, www.merrow.com

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ASTM D-6193

ISO

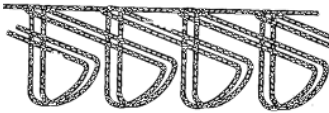
101



ISO# 101 Chainstitch

Stitch formed by a needle thread passing through the material and interlooping with itself on the underside of the seam.

103



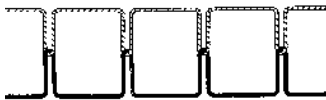
ISO# 103 Blindstitch

Stitch is formed with one needle thread which interloops with itself on the top surface of the material. The thread passes through the top ply and horizontally through portions of the bottom ply.

104 Blindstitch

One thread Blindstitch for hemming, See page 4

301



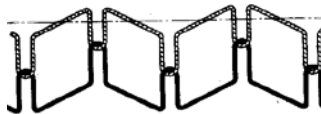
ISO# 301 Lockstitch

Stitch formed by a needle thread passing through the material and interlocking with a bobbin thread. Threads are meeting in the center of the seam. Stitch appear the same on the top as well as the bottom.

ISO# 301 Twin Needle Lockstitch

Same as 301 except that two rows of stitch are formed. Common needle spacing is 1/4" (6mm) however, the machines are available from 3/16" up to 1" (6-25mm)

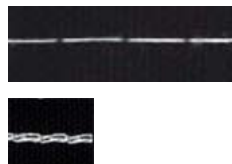
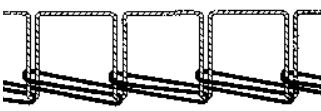
304



ISO# 304 Zig Zag

Lockstitch is formed with a needle and bobbin thread forming a symmetrical zig zag pattern. This stitch is also used in bartacking and lockstitch buttonsewing and buttonholing.

401



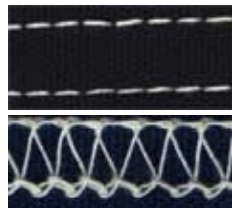
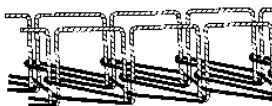
ISO# 401 -Chainstitch

Stitch formed by 1 needle thread and being interlooped with 1 looper thread that is set on the underside of the seam.

ISO# 401 Twin Needle Chainstitch

Stitch formed by 2 needle threads being interlooped with 2 looper threads, forming 2 independent rows of stitch set.

406



ISO# 406 Bottom Coverstitch

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.

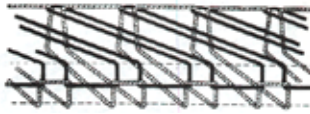
407

ISO# 407 Bottom Coverstitch

Stitch formed by 3 needle threads passing through the material and interlacing 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.

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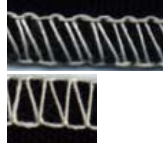
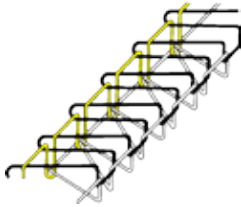
503



ISO# 503 Overedge

Formed by 1 needle thread and 1 looper thread producing a purl on the edge of the seam. Use: serging or blindhemming.

504



ISO# 504 Overedge

Formed by 1 needle thread and 2 looper threads producing a purl on the edge of the seam. Use: overedge seaming and serging.

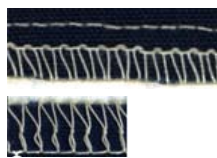
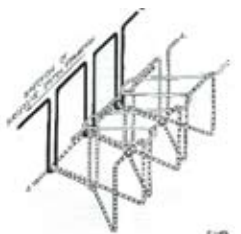
505



ISO# 505 Overedge

Formed by 1 needle thread and 2 looper threads forming a double purl on the edge of the seam. Use: serging

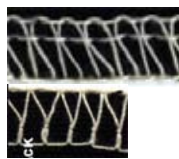
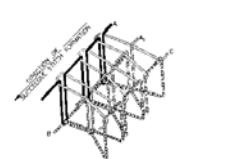
512



ISO# 512 Overedge

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.

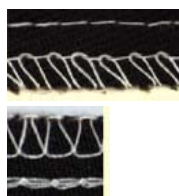
514



ISO# 514 Overedge

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.

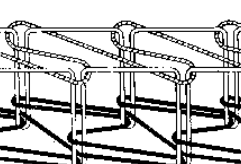
516



ISO# 516 Safety Stitch

5-thread safety stitch. Combining a single-needle chainstitch (401) and a 3-thread overedge stitch (504) that are formed simultaneously.

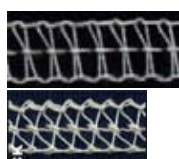
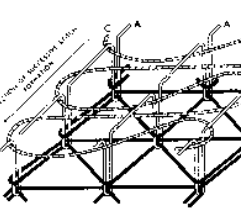
602



ISO# 602 Coverstitch

Formed with 2-needle threads, a top cover thread and a bottom looper thread.

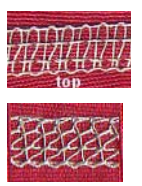
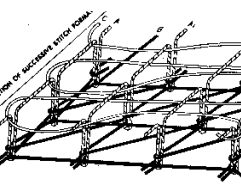
605



ISO# 605 Coverstitch

Formed with 3-needle threads, using a top cover thread and a bottom looper thread.

607



ISO# 607 Coverstitch

Formed with 4-needle threads, a top cover thread and a bottom looper thread.

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104 Blindstitch

One thread Blindstitch for hemming,



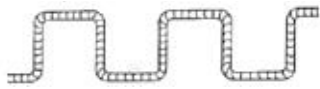
202 Handstitch

Chainstitch provides stretchability for knits



205 Handstitch

One Thread True Handstitch for Topstitching



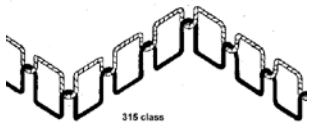
306 Blindstitch

Two Thread blindstitch



315 Three Step Zig-Zag

Lockstitch zig-zag with more stretch



316 Lockstitch

One Thread lockstitch using autoloading bobbin



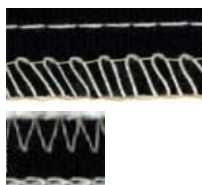
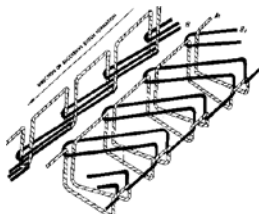
502 Overedgestitch

One needle overedge stitch used for serging



515 True Safetystitch

Chainstitch provides stretchability for knits



ASTM D-6193 Stitches Not shown in This guide

Stitch Class & Thread Count

- 102 One Thread
- 105 One Thread
- 201 Two Thread
- 203 One Thread
- 204 One Thread
- 302 Three Thread
- 303 Four Thread
- 305 Three Thread
- 307 Five Thread
- 308 Two Thread
- 309 Three Thread
- 310 Three Thread
- 311 Three Thread
- 312 Three Thread
- 313 Two Thread
- 314 Two Thread
- 402 Three Thread
- 403 Four Thread
- 404 Two Thread
- 405 Three Thread
- 407 Four Thread
- 501 One Thread
- 505 Three Thread
- 506 Four Thread
- 507 Four Thread
- 508 Three Thread
- 509 Three Thread
- 510 Two Thread
- 511 Two Thread
- 517 Five Thread
- 518 Four Thread
- 519 Six Thread
- 520 Eight Thread
- 521 Three Thread
- 522 Four Thread
- 601 Three Thread
- 603 Five Thread
- 604 Six Thread
- 606 Nine Thread

Buttonholes

Photos: Juki



Single
Stitched



Double
Stitched



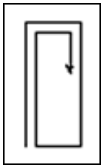
Purl
Stitching



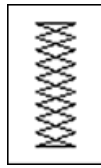
Whip
Stitching



Keyhole
Buttonhole



Basting
Stitch



Joining
Stitch

Button Stitches



Cross
Stitch



Four Hole
Stitch



Two Hole
Stitch



Button -Flat

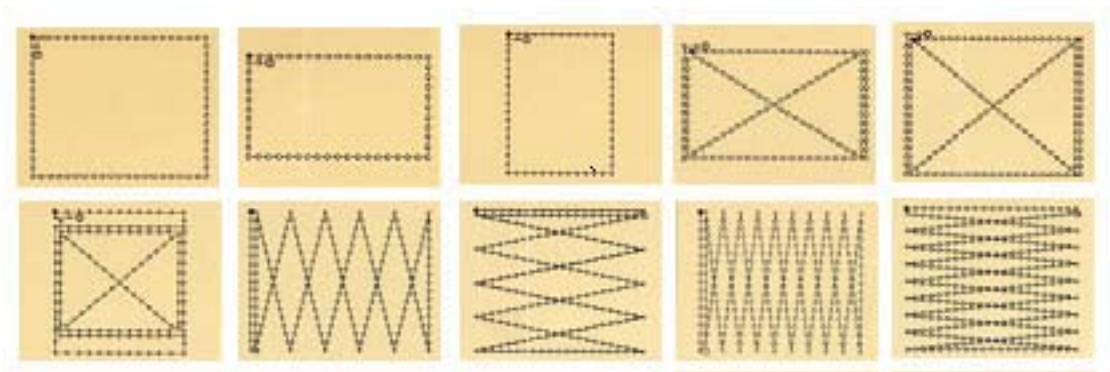


Button -Shank



Button
Wrapped

Label Tacking, Webbing Attachment



Types of Overlock Stitches

Overlock stitches are classified in a number of ways. The most basic classification is by the number of threads used in the stitch. Industrial overlock machines are generally made in 1, 2, 3, 4, or 5 thread formations. Each of these formations has unique uses and benefits: 1-thread formations are used for end-to-end seaming, or 'butt-seaming'. Two- and three-thread formations, also known as 'merrowing', are the most common, used for edging and seaming, especially on knits and wovens. Four-thread formations are called mock safety stitches and create extra strength while retaining flexibility. 5-thread formations, which utilize 2 needles, are called safety stitches, creating a very strong seam used for apparel manufacturing.

Overlocking is also referred to as "overedging", "merrowing" or "serging". Though "serging" technically refers to overlocking with cutters, in practice the four terms are used



Merrow rolled blanket stitch



2-thread, 1/8" wide, 20 stitches per inch, with differential feed: Photo: Merrow



Purl Stich, Photo: Merrow Sewing Machine Company



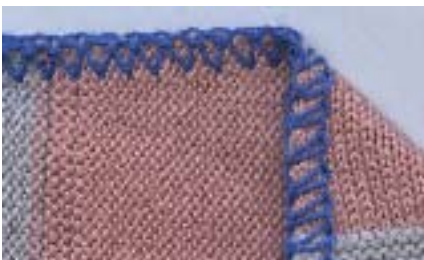
Narrow blanket Stitch



4-thread, 5/32" wide, 17 stitches per inch
Photo: Merrow Sewing Machine Company



Merrow blanket Stitch



3-thread, 1/4" wide, 7 stitches per inch



Traditional Blanket Stitch



4-thread, 5/32" wide, 17 stitches per inch, Photo: Merrow

Crochet Shell Stitches



22-FJ Large Shell



22-FJ



27-FJ



27FJ



35-FJ Small Shell



35-FJ



Crochet Stitches

15-CA-1



17-F



18-A



18-E



18-G



18-S



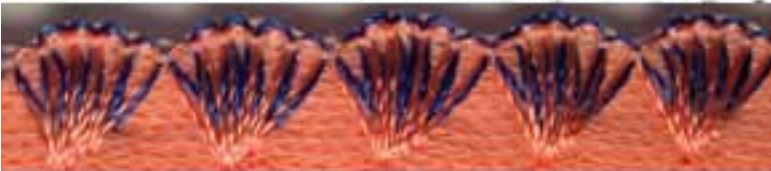
MG-2DNR-1



MG-3DR



MG-4Q-67



MG-3U



70-Y3B-2 / 72-Y3B



72-D3BR



70-D3B-2 / 72-D3B & THE NEW M-D3B-2



70-1D-7 / M-1D-7



70-1D-2 / M-1D-2

