

# The Apparel Mentor

## ISO Stitch Guide













Thank you for downloading The Apparel Mentor's ISO Stitch Guide!

This guide shows most industrial stitches used to create your garment! This is great for those that have a good foundation and knowledge of measure apparel in general. This guide uses the International Standards Organization (ISO) labels for different types of stitches.















Please remember to indicate Stitches Per Inch and bite width if applicable.

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Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
<b>Single Thread Chainstitch</b> 		<b>101</b>	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>	<b>101 or 304</b>	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>	<b>103</b>	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> 	<b>301</b>	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> 		<b>304</b>	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> 	<b>401</b>	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> 	<b>404</b>	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.

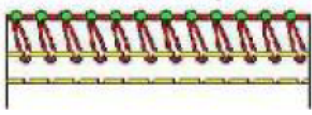

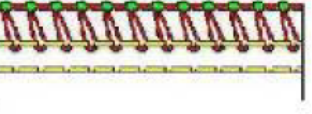

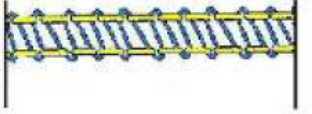

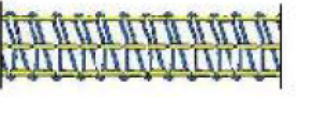

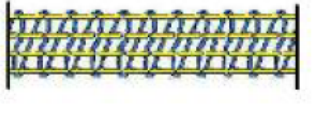

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Stitch Drawing		ISO 4915 Number	Common Application	Requirements	Stitch Description
Top View As Sewn	Bottom View As Sewn				
<b>2 Needle Bottom Coverstitch</b> 	<b>Looper Thread on Bottom</b> 	<b>406</b>	Hemming, Attaching, Elastic, Binding, Coverseaming, 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> 	<b>407</b>	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> 	<b>408</b>	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> 	<b>503</b>	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> 	<b>504</b>	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> 	<b>505</b>	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> 	<b>512</b>	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

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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.

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