BEISSEL

MAKES FASHION FASHIONABLE

# CASUAL PANT SEWING

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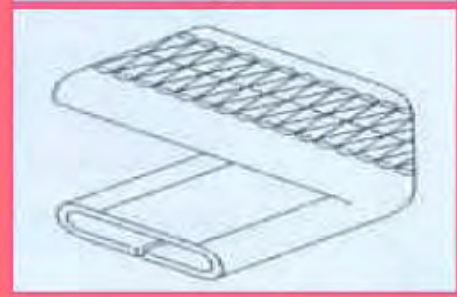
- Belt loop making = ⟶
- Needle system = UY 128 gas
- Needle size = 11 or 12
- Point style = "R"
- Machine type = ⟶

  2 needle flatbed chain stitch machine
- Stitch picture = ⟶



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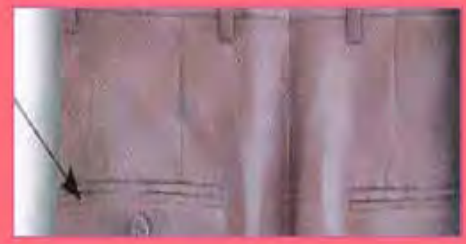
- Pocket welting = →
- Needle system = DPx5
- Needle size = 14/90
- Point style = "R"
- Machine type = →

2 needle lock stitch machine

- Stitch picture = →

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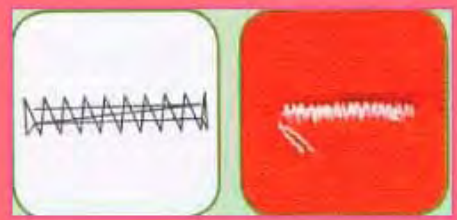
- Bar tacking = →
- Needle system = DPx5
- Needle size = 14to90
- Point style = "R"
- Machine type = →

2 needle lock stitch machine

- Stitch picture = →



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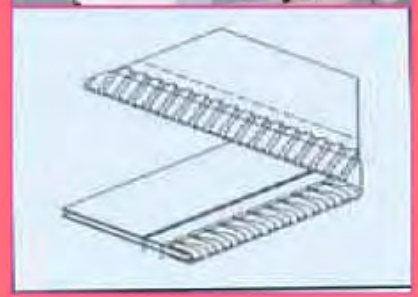
- Pocket inner over lock = ⟶
- Needle system = DCX1
- Needle size = 14to90
- Point style = "R"
- Machine type = ⟶

2 needle lock stitch machine

- Stitch picture = ⟶



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- Front zip close sew =
- Needle system = DPX5
- Needle size = 14
- Point style = "R"
- Machine type =

2 needle lock stitch machine

- Stitch picture =

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- Sew inside = →
- Needle system = TVX7
- Needle size = 14
- Point style = "R"
- Machine type = →

1 or 2 needle chain stitch

- Stitch picture = →

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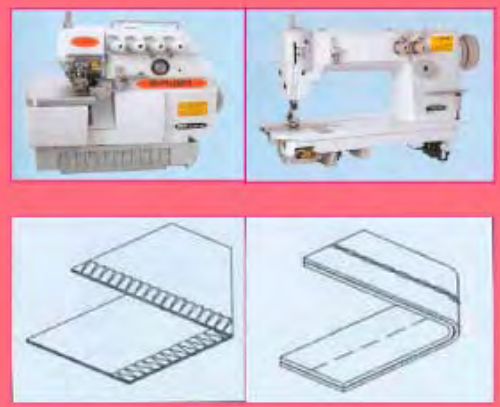
- Inside safety sewing = ⟶
- Needle system = DCX1 or TVX7
- Needle size = 12 or 14
- Point style = "R"
- Machine type = ⟶

Safety stitch or chain stitch machine

- Stitch picture = ⟶



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- Button hole sewing = →
- Needle system = TQX1
- Needle size = 12 or 14
- Point style = "R STU"
- Machine type = →

Button stitching machine

- Stitch picture = →

BEISSEL

- Button hole sewing = →
- Needle system = DPX5
- Needle size = 12 or 14
- Point style = "R"
- Machine type = →

Button stitching machine

- Stitch picture = →

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# SEWING PROBLEMS

DESCRIPTION: Where the seam does not lay flat and smooth along the stitch line. Caused by one of the following:

1) Feed Puckering - where the plies of fabric in the seam are not being aligned properly during sewing.

2) Tension Puckering - where the thread has been stretched and sewn into the seam. The thread then causes the seam to draw back and pucker.

3) Yarn Displacement or structural jamming - caused by sewing seams with too large of thread that causes the yarns in the seam to be displaced, giving a puckered appearance.

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# SEWING PROBLEMS

## MINIMIZING EXCESSIVE SEAM PUCKERING:

1) Use the correct thread type and size for the fabric. In many cases, a smaller, higher tenacity thread is required to minimize seam puckering but maintain seam strength (See Beissel Thread Selection Guide or Minimizing Seam Puckering)

2) Sew with minimum sewing tension to get a balanced stitch.

3) Make sure machines are set up properly for the fabric being sewn.

4) Check for proper operator handling techniques.

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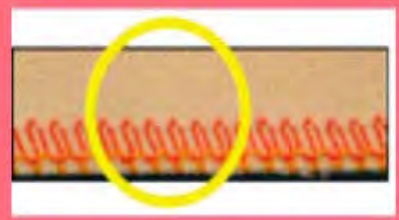
## IMPROPER STITCH BALANCE:

Where the needle loop is not pulled up to the underside of the seam and the "purl" is not on the edge of the seam.



Solution:

1) Use a quality thread with consistent frictional characteristics.

2) Properly balance the stitch so that when the looper thread is unraveled, the needle loop lays over half way to the next needle loop on the underside of the seam.

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UNEVEN STITCH:

Where the loops on the bottom-side of the seam are inconsistent and do not appear uniform.

Solution:

1) Use a quality thread with consistent frictional characteristics.

2) Properly balance the stitch so that when the looper thread is unraveled, the needle loop lays over half way to the next needle loop on the underside of the seam.

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## OPEN SEAM FAILURE:

Where the stitch line is still intact but the yarns in the fabric have ruptured.

## Minimizing seam failure:

1) Reinforce stress points with Bar tacks. Make sure the bar tacks are the proper length and width for the application

2) Check to make sure the patterns have been designed for proper fit

3) Make sure the ideal seam construction is being used

4) Contact your fabric supplier

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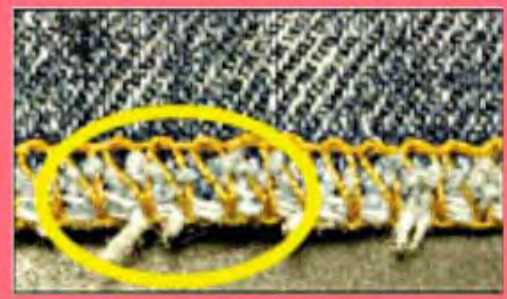
## RAGGED/INCONSISTENT EDGE - OVER-EDGE OR SAFETY STITCH SEAMS:

Where the edge of the seam is either extremely "ragged" or "rolls" inside the stitch.



Solution:

1) Make sure the sewing machine knives are sharpened and changed often.

2) The knives should be adjusted properly in relationship to the "stitch tongue" on the needle plate to obtain the proper seam width or width bite. In the photo, the trimming knives have been set wider than the "stitch tongue" on the needle plate causing the "ropy" appearance.

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Please refer BEISSEL

Fashion Bible

for detailed sewing solutions