

AMANN  
GROUP



**SEWING AND  
EMBROIDERING**

**2**

**SUPPORT**

### 3.1 Important Stitch Types at a Glance

A book on sewing technology can definitely not do without an overview of the most important stitch types. The stitch type is the most significant processing element in garment production technology. The stitch type specification describes the “how to” and is the “language code” for all processes. This book too repeatedly mentions stitch type specifications. But not everybody is familiar with the numbers or designations of the different types. Not everybody has memorized the different seam types’ results. Sometimes it is good to know where to look, to make sure what a certain stitch type looks like, how it is formed, and to be able to describe it for a colleague.

Therefore, AMANN has drawn up a tabulated stitch type overview. The following pages will show the most important stitch types. Following the motto “A picture says more than a thousand words”, the individual stitch types are described with the help of pictures of the



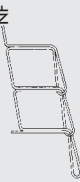











**By the way:** If you’d like to get more information about stitch types, we recommend the quality German manual “Der Weg zur richtigen Naht” (How to achieve proper seams) written by Dieter Liekweg and Sarah Dimmig. This book contains the “real” seam patterns of all the important stitch types by way of illustration. For this purpose, the individual thread systems are sewn with different contrasting colours, so that it becomes quite clear how the threads run. In addition, this book contains all the stitch type information that is important. You may order it at: [liekweg@hs-albsig.de](mailto:liekweg@hs-albsig.de)

seam construction. The images of the types of seams are especially helpful in the daily work process and facilitate the recognition and description of the stitch types. In addition, the stitch type table includes the common stitch type names and numbers according to ISO 4915 as well as listing the seam widths and stitch densities known in practice













Stitch type thread consumption is vitally important – at least for process planning and calculation. Therefore, in addition the table lists thread requirements under standard sewing conditions regarding seam width, stitch density, and material thickness. This facilitates estimates of the thread requirements for different sewing operations by just multiplying seam lengths and thread consumption. The AMANN stitch type table can be seen always on hand in many process planning departments as a quick reference tool for thread requirement calculations.



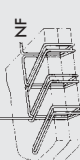








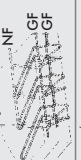








**By the way:** All the aides developed by AMANN for calculating thread requirements are based on the stitch type table. The thread requirement values were calculated “manually”, that means by sewing, separating, and measuring the lengths. In the meantime, AMANN has also worked out the thread requirements for other material and stitch densities. This produced a quite unique foundation for calculating thread requirements The AMANN Order Scheduler and the AMANN NBE software for thread requirement calculation work with these figures. Detailed information regarding sewing thread requirements has been compiled in the AMANN Service und Technik brochure as well. It may be ordered at [nf@amann.com](mailto:nf@amann.com) or downloaded from [www.amann.com/Download](http://www.amann.com/Download).

Stitch Type	ISO 4915 DIN 61400	Seam Construction	Seam Appearance	Seam Width mm	Stitches (per cm)	Thread Required per 1 m of seam	%
Single-thread chainsitch	101	 NF		-	2	NF: 3.80m	100%
Single-thread blindsitch	103	 NF		-	2	NF: 4.50m	100%
Single-thread blindsitch	105	 NF		-	2	NF: 4.50m	100%
Lockstitch (Hand stitch type)	209	 NF		-	4	NF: 1.40m	100%
Lockstitch	301	 NF · GF		-	4	NF: 1.40m GF: 1.40m 2.80m	50% 50% 100%
Lockstitch (Zigzag)	304	 NF · GF		5	4	NF: 2.70m GF: 2.70m 5.40m	50% 50% 100%

NF = Needle thread · GF = Bobbin / looper thread · LF = Cover thread Remember to allow extra thread for beginning and end of seam!













Stitch Type	ISO 4915 DIN 61400	Seam Construction	Seam Appearance	Seam Width mm	Stitches (per cm)	Thread Required per 1 m of seam	%
Lockstitch Multi-stitch Zigzag	321	 NF · GF		8	18	NF: 6.50m GF: 6.50m 13.00m	50% 50% 100%
Double chainsitch	401	 NF · GF		-	4	NF: 1.70m GF: 3.10m 4.80m	35% 65% 100%
Double chainsitch Zigzag	404	 NF · GF		3	4	NF: 2.40m GF: 4.40m 6.80m	35% 65% 100%
Two-needle double chain- stitch (with common looper)	406	 NF · NF · GF		5	4	NF: 3.40m GF: 8.40m 11.80m	29% 71% 100%
Three-needle double chain- stitch (with common looper)	407	 NF · NF · NF · GF		6	4	NF: 5.10m GF: 11.60m 16.70m	30% 70% 100%
Two-times double chain- stitch (with cover thread)	408	 1LF · NF · NF · GF		6	4	NF: 3.40m NF: 6.20m LF: 5.80m 15.40m	22% 40% 38% 100%

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Stitch Type	ISO 4915 DIN 61400	Seam Construction	Seam Appearance	Seam Width mm	Stitches (per cm)	Thread Required per 1 m of seam	%
Single-thread overedge stitch	501	 NF	 	7	4	NF: 16.40m	100%
Two-thread overedge stitch (interlaced at needle hole)	502	 NF GF	 	5	4	NF: 1.70m GF: 10.00m 11.70m	15% 85% 100%
Two-thread overedge stitch (interlaced on edge)	503	 NF GF	 	5	4	NF: 6.70m GF: 5.00m 11.70m	57% 43% 100%
Three-thread overedge stitch (interlaced at needle hole)	504	 NF GF GF	 	5	4	NF: 1.70m GF: 12.10m 13.80m	12% 88% 100%
Three-thread overedge stitch (interlaced on edge)	505	 NF GF GF	 	5	4	NF: 6.30m GF: 7.50m 13.80m	46% 54% 100%
Four-thread overedge stitch (Mock safety stitch) Interlaced at needle hole	512	 NF GF GF GF	 	6	4	NF: 3.40m GF: 12.90m 16.30m	21% 79% 100%

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Stitch Type	ISO 4915 DIN 61400	Seam Construction	Seam Appearance	Seam Width mm	Stitches (per cm)	Thread Required per 1 m of seam	%
Four-thread overedge stitch Interlaced at needle hole	514	 NF NF GF GF	 	6	4	NF: 3.40m GF: 13.70m 17.10m	20% 80% 100%
Two-needle covering chain- stitch with cover thread	602	 LF NF GF	 	6	4	NF: 3.40m NF: 8.40m LF: 5.10m 16.90m	20% 50% 30% 100%
Three-needle covering chain- stitch with cover thread	605	 LF NF NF GF	 	6	4	NF: 5.10m NF: 11.60m LF: 5.80m 22.50m	23% 52% 25% 100%
Four-needle covering chain- stitch with cover thread	607	 LF NF NF NF GF	 	6	4	NF: 6.80m NF: 14.80m LF: 5.80m 27.40m	25% 54% 21% 100%

NF = Needle thread · GF = Bobbin / looper thread · LF = Cover thread

Remember to allow extra thread for beginning and end of seam!