



BS 3870 : Part 2 : 1983
ISO 4916-1982

UDC [677.027.84:746.412] :006.74

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British Standard

Stitches and seams

Part 2. Classification and terminology of seam types

[ISO title: Textiles – Seam types – Classification and terminology]

Points et coutures

Partie 1. Classification et terminologie des types de coutures

Stiche und Nähte

Teil 1. Einteilung und Begriffe für Nahttypen

British Standards Institution

BS 3870 : Part 2 : 1983

Contents

	Page		Page
National foreword	Inside front cover	5. Designation	3
Cooperating organizations	Back cover	6. Conventions used in the illustrations	3
		7. Illustrations	4
Classification		Annex	
0. Introduction	1	Previous national and ISO designations	60
1. Scope and field of application	1	Table	
2. Reference	1	Classification of stitched seams	2
3. Definition	1		
4. Classification	1		

National foreword

This Part of this British Standard was prepared under the direction of the Clothing Standards Committee and is identical with ISO 4916 'Textiles — Seam types — Classification and terminology' published by the International Organization for Standardization (ISO).

This Part of this standard, together with Part 1, supersedes BS 3870 : 1965 which is withdrawn. Part 1 of this standard is identical with ISO 4915 'Textiles — Stitch types — Classification and terminology'.

Terminology and conventions. The text of the international standard has been approved as suitable for publication as a British Standard without deviation. Some terminology and

certain conventions are not identical with those used in British Standards; attention is drawn especially to the following.

Wherever the words 'International Standard' appear referring to this standard, they should be read as 'British Standard'.

Cross-reference

International standard	Corresponding British Standard
ISO 4915 : 1982	BS 3870 Stitches and seams Part 1 : 1982 Classification and terminology of stitch types (Identical)

Compliance with a British Standard does not of itself confer immunity from legal obligations.

British Standard

Stitches and seams

Part 2. Classification and terminology of seam types

0 Introduction

This classification of stitched seams should provide valuable information for purchasing officers, garment manufacturers, machine manufacturers, students and others. The document primarily provides a descriptive guide for purposes of identification and ease of reference.

Stitched seams, for the purpose of this International Standard, consist of a sequence of stitch types as defined in ISO 4915, together with a number of components and their configuration, which appear in this International Standard.

In order for a seam specification to be meaningful, the designation of the stitch type has to be added after the designation of the stitched seam. If two or more stitch types are used, they should be stated from left to right.

The ISO designations, together with previous national designations, are listed in the annex.

NOTE — Further seam types which may be developed in the future should be notified to the secretariat of ISO/TC 38 in order to obtain, after consultation with ISO/TC 38, the correct classification.

1 Scope and field of application

This International Standard classifies, illustrates and designates the various kinds of stitched seams. It is not intended to be fully comprehensive but to illustrate a number of the most used seam types. It is applicable to seams used most particularly in the clothing industry. All illustrations show the cross-section of the material configuration only.

This International Standard should be read in conjunction with ISO 4915.

2 Reference

ISO 4915, *Textiles — Stitch types — Classification and terminology*.

3 Definition

seam : The application of a series of stitches or stitch types to one or several thicknesses of material.

4 Classification

Stitched seams are divided into eight classes according to the types and minimum number of components within the seam. The components are termed as being of "limited" or "unlimited" width (see 6.3). The characteristics of each class are shown in the table, and indicated below.

4.1 Class 1

In this class, seams are produced with a minimum of two components, both limited on the same side. Any other component is either similar to one of these two or limited on two sides.

4.2 Class 2

In this class, seams are produced with a minimum of two components of which one is limited on one side and the second on the other side. These two components are opposite and at different levels and overlap each other. Any other component is either similar to one of these two or limited on two sides.

4.3 Class 3

In this class, seams are produced with a minimum of two components, one of which is limited on one side with the second, limited on both sides, straddling the edge of the former. Any other component is similar to one of these two.

4.4 Class 4

In this class, seams are produced with a minimum of two components of which one is limited on one side and the second on the other. These two components are opposite and on the same level. Any other component is either similar to one of these or limited on two sides.

4.5 Class 5

In this class, seams are produced with a minimum of one component unlimited on two sides. Any other component may be either limited on one side, or limited on two sides.

4.6 Class 6

In this class, seams are produced with only one component limited on one side (either on the right or the left).

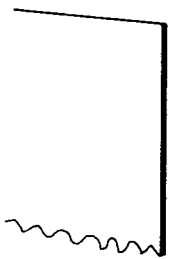
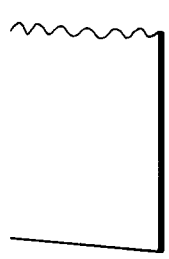
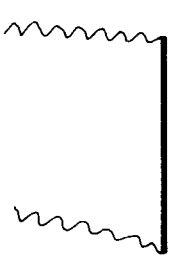
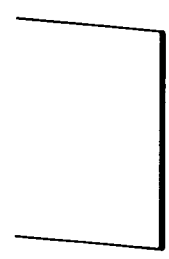
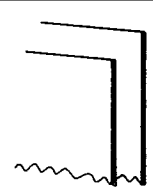
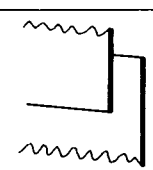
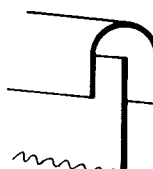
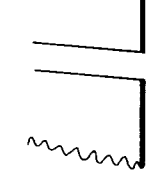
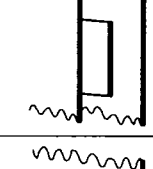
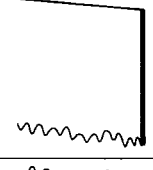
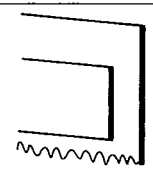
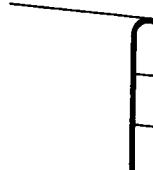
4.7 Class 7

In this class, seams are produced with a minimum of two components of which one is limited on one side (on the right or left) and all others are limited on two sides.

4.8 Class 8

In this class, seams are produced with a minimum of one component limited on two sides. Any other component is also limited on two sides.

Table — Classification of stitched seams

Components	Class							
	1	2	3	4	5	6	7	8
	2 or more	1 or more	1 or more	1 or more + or more	0 or more	1	1	—
	—	1 or more	—	in the same horizontal plane	—	—	—	—
	—	—	—	—	1 or more	—	—	—
	0 or more	0 or more	1 or more	0 or more	0 or more	—	1 or more	1 or more
Minimum total components	2 or more	2 or more	2 or more	2 or more	1 or more	1	2 or more	1 or more
Basic material configuration								

5 Designation

Each stitched seam is identified by a numerical designation composed of five digits. These are as follows :

First digit : Classes 1 to 8

Second and third digits : Counting numbers 01 . . . 99 to indicate differences in material configuration

Fourth and fifth digits : Further counting numbers 01 . . . 99 to indicate differences in location of needle penetrations or passages and/or mirror images of the material configuration (as indicated by the second and third digits)

6 Conventions used in the illustrations

6.1 The illustrations normally indicate only the minimum number of components needed to construct the seam.

6.2 Material layers are denoted by a heavy line :



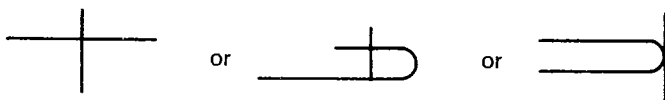
6.3 An unlimited material edge is denoted by a wavy line :



6.4 A limited material edge is denoted by a straight line :

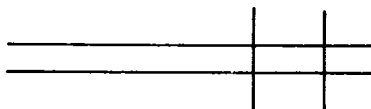


6.5 The penetration(s) or passage(s) of the needle(s) is denoted by a straight line, eg.

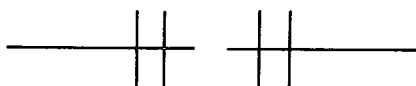


There are two possibilities of passage.

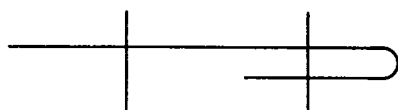
6.5.1 The needle passes through the material, in which case the line is shown passing through each side of the material.



e.g. sewn by stitch type(s) 602 or 401.401

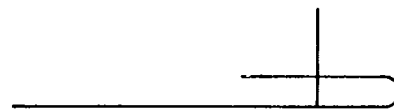


e.g. sewn by stitch type(s) 606 or 607

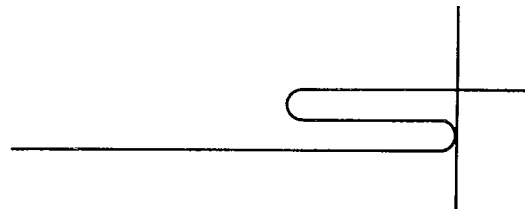


e.g. sewn by stitch type(s) 302

6.5.2 The needle does not pass through, in which case the line is shown stopping on the material, or at a tangent to it.



e.g. sewn by stitch type 103

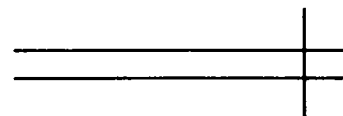


e.g. sewn by stitch type(s) 503 or 505

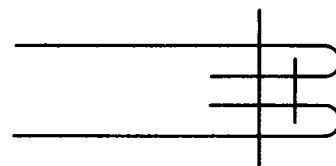
6.6 Piping cross-section is denoted by a large dot: ●

6.7 All seams are shown as sewn on a machine. In the case of multiple operations, they are shown as sewn after the final operation.

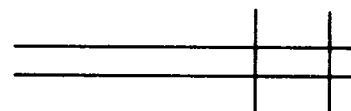
6.8 Some examples of numerical designations of seam types are as follows :



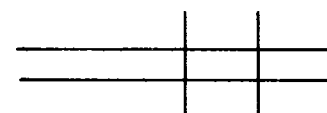
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or
1.01.01/401
or
1.01.01/504



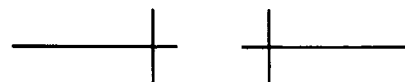
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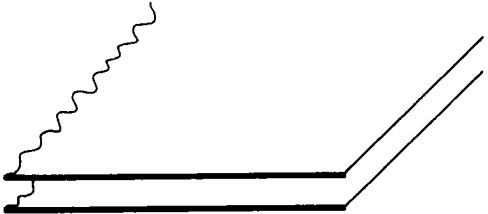
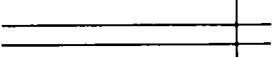
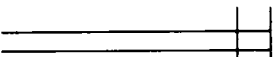
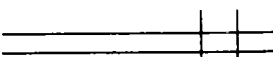
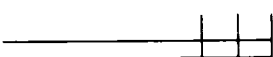
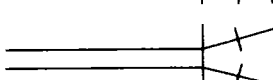
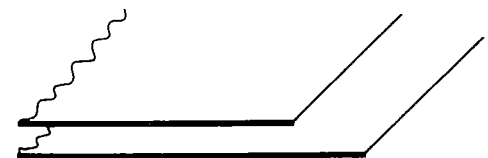
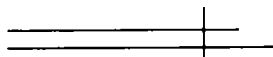
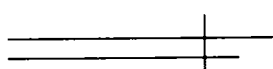
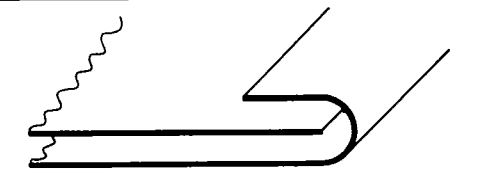
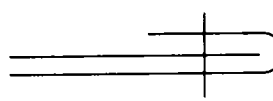
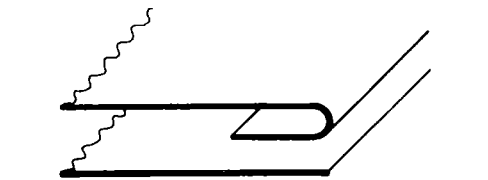
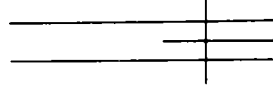
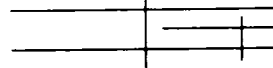
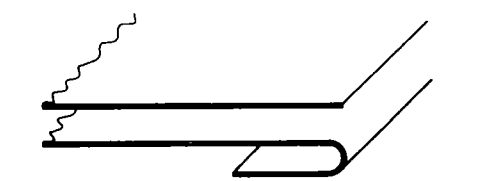
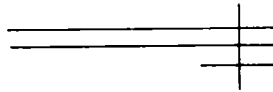
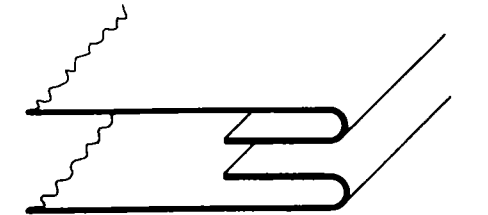
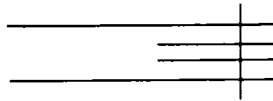
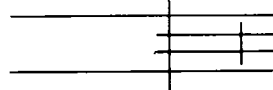
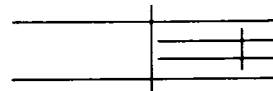
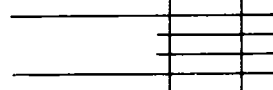


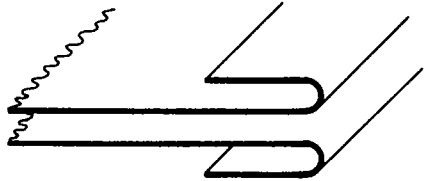
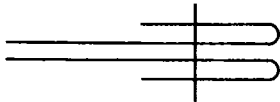
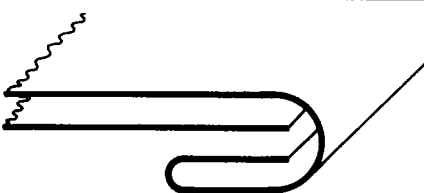
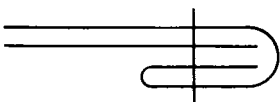
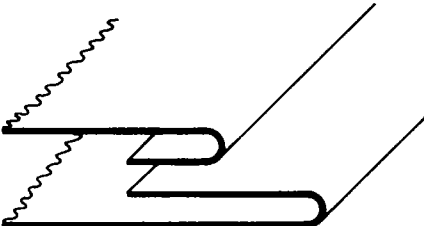
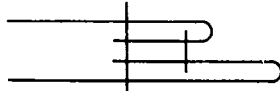
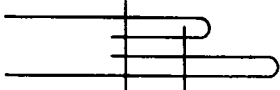
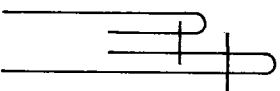
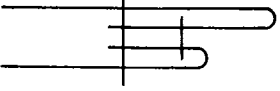
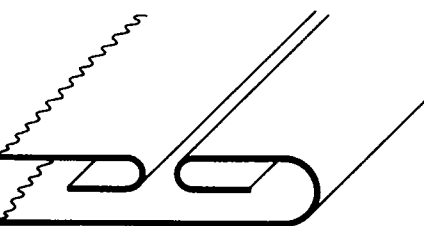
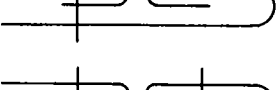
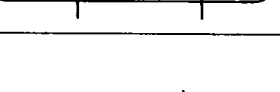
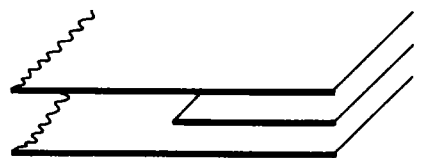
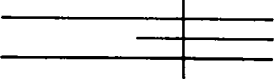
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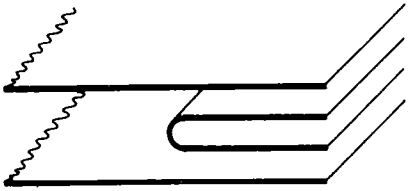
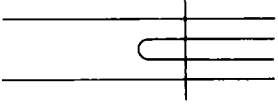
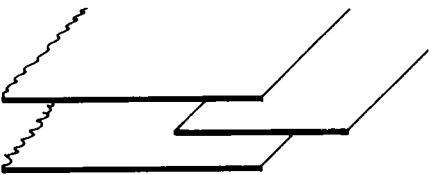
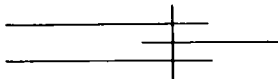
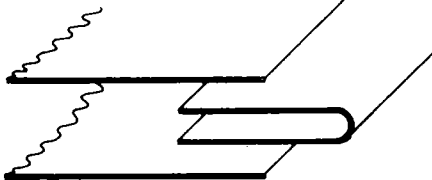
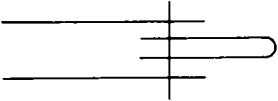
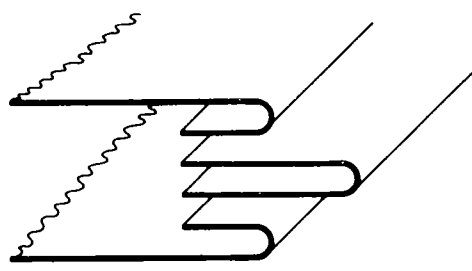
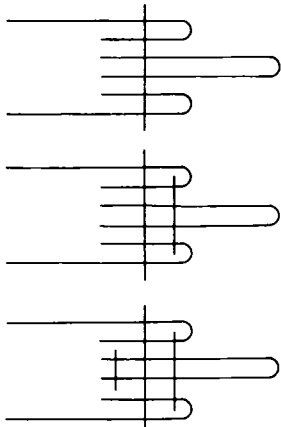
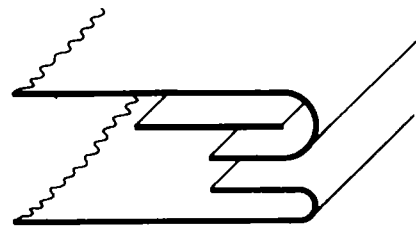
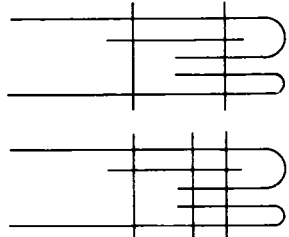
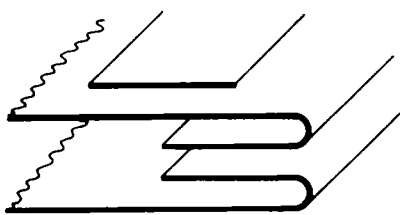
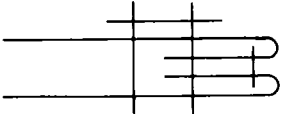


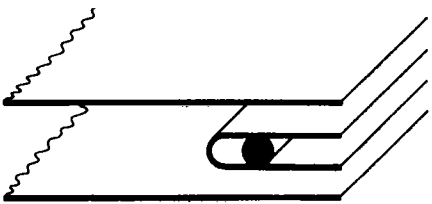
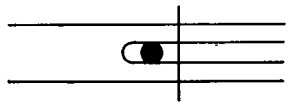
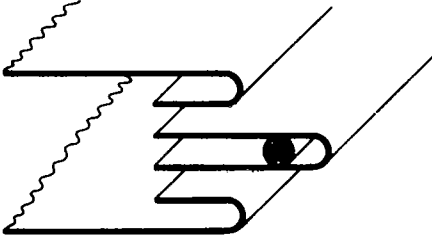
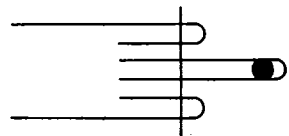
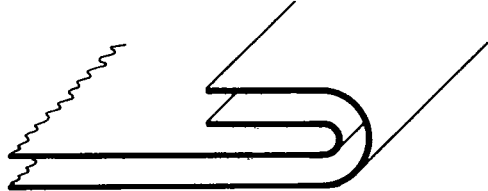
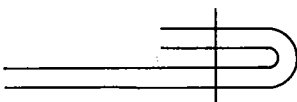
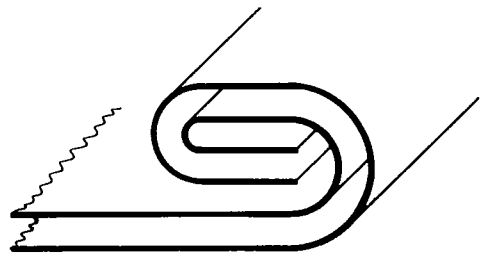
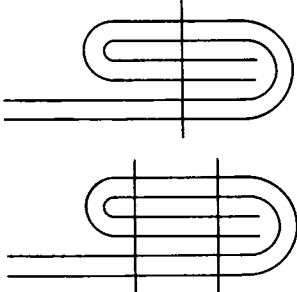
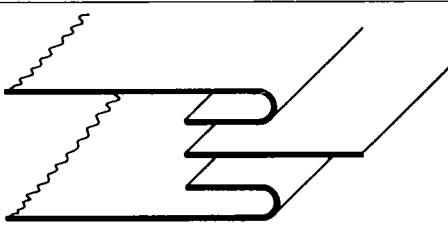
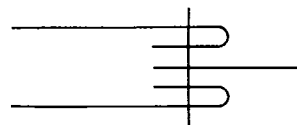
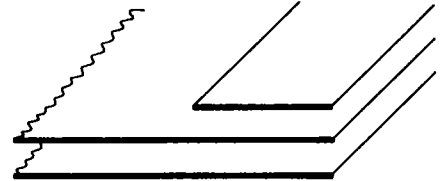
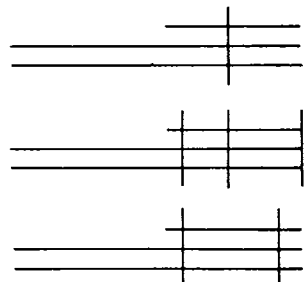
4.01.01/602
or
4.01.01/404

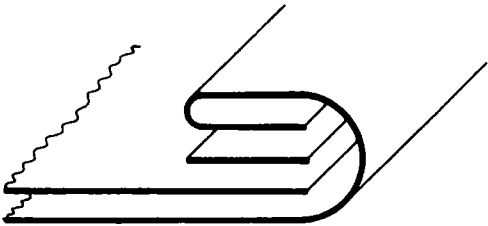
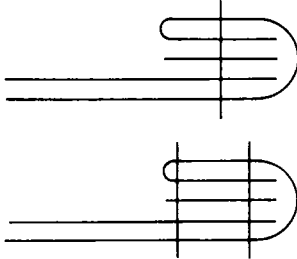
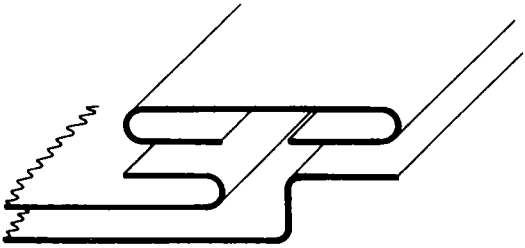
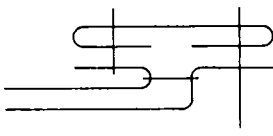
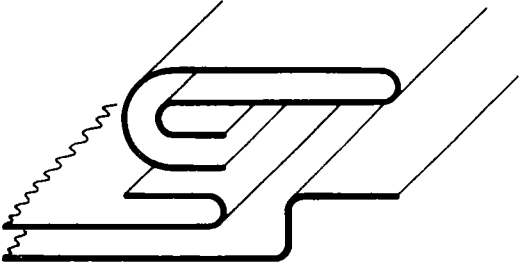
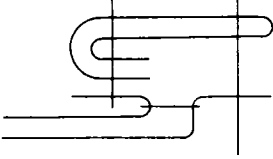
7 Illustrations

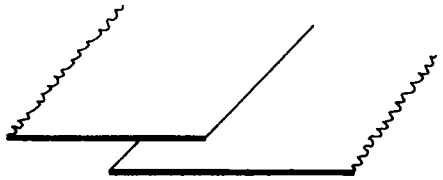
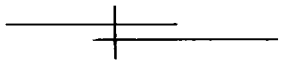
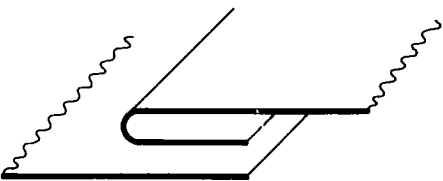
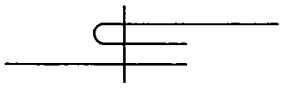
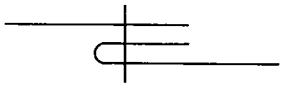
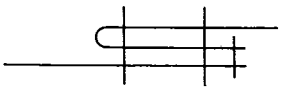
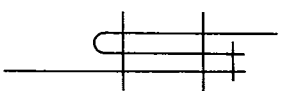
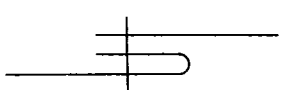
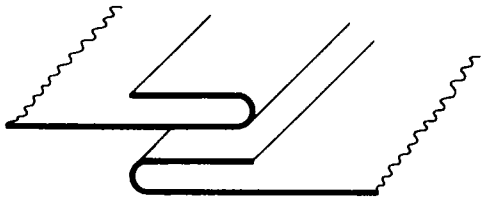
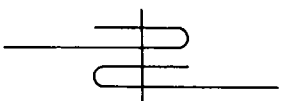
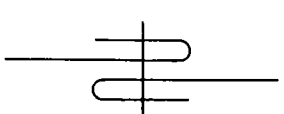
Material configuration	Location of needle penetration or passage	Numerical designation
1.01 		1.01.01
		1.01.02
		1.01.03
		1.01.04
		1.01.05
1.02 		1.02.01
		1.02.02
1.03 		1.03.01
1.04 		1.04.01
		1.04.02
1.05 		1.05.01
1.06 		1.06.01
		1.06.02
		1.06.03
		1.06.04

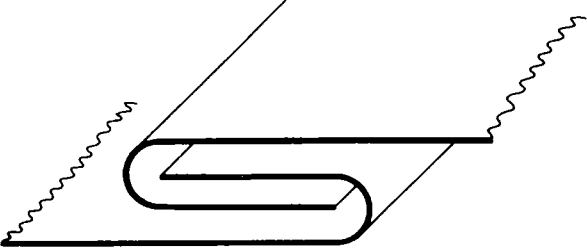
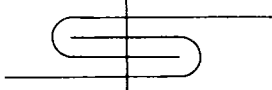
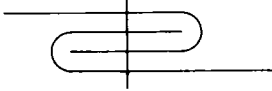
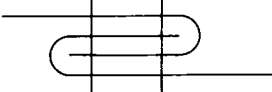
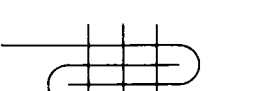
Material configuration	Location of needle penetration or passage	Numerical designation
1.07 		1.07.01
1.08 		1.08.01
1.09 	    	1.09.01 1.09.02 1.09.03 1.09.04 1.09.05
1.10 	   	1.10.01 1.10.02 1.10.03 1.10.04
1.11 		1.11.01

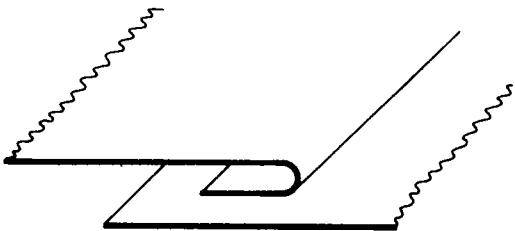
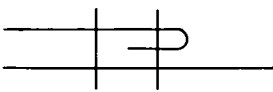
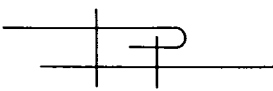
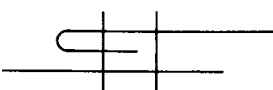
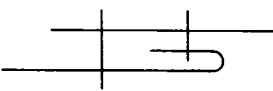
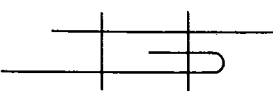
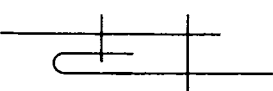
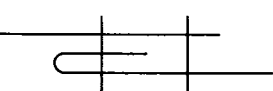
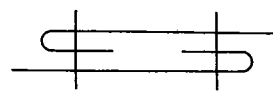
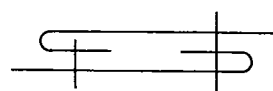
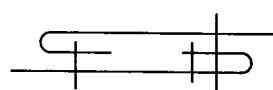
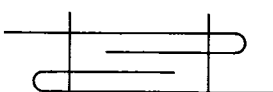
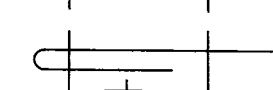
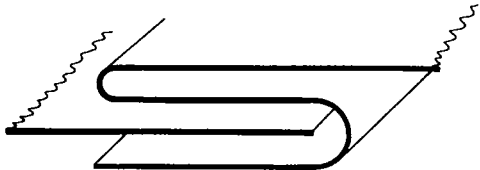
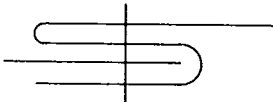
Material configuration	Location of needle penetration or passage	Numerical designation
1.12 		1.12.01
1.13 		1.13.01
1.14 		1.14.01
1.15 		1.15.01 1.15.02 1.15.03
1.16 		1.16.01 1.16.02
1.17 		1.17.01

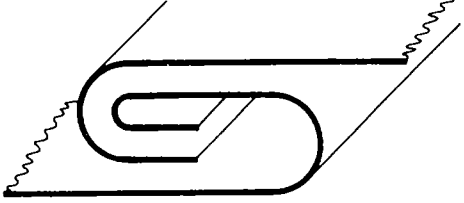
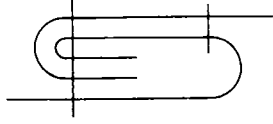
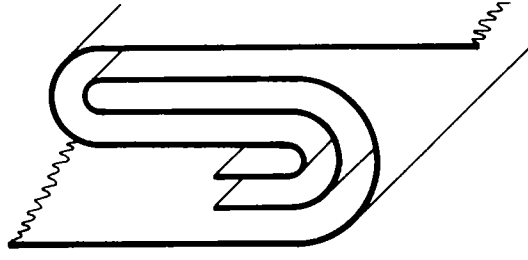
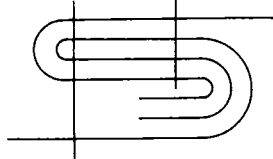
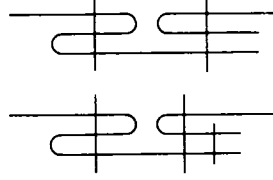
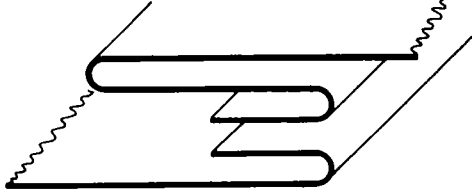
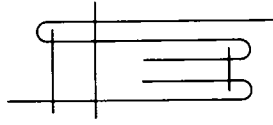
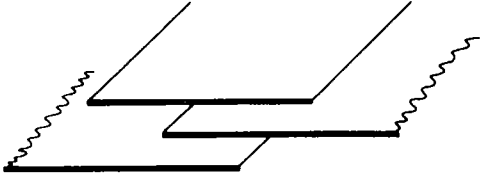
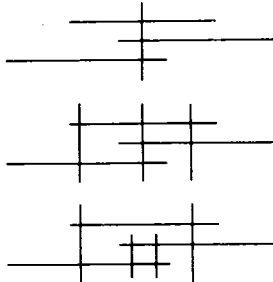
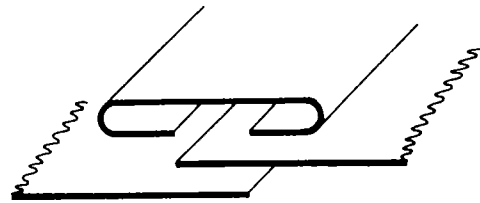
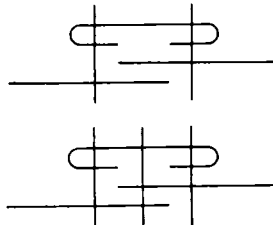
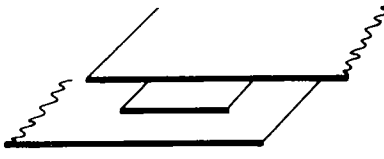
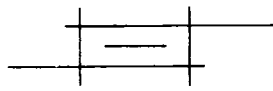
Material configuration	Location of needle penetration or passage	Numerical designation
1.18 		1.18.01
1.19 		1.19.01
1.20 		1.20.01
1.21 		1.21.01 1.21.02
1.22 		1.22.01
1.23 		1.23.01 1.23.02 1.23.03

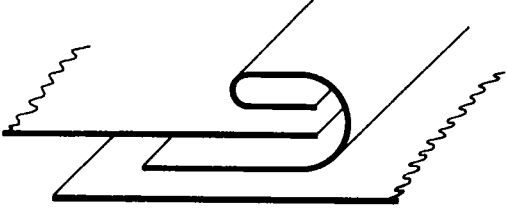
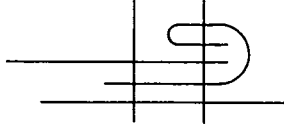
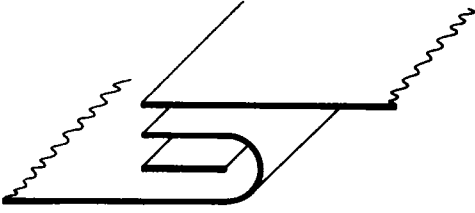
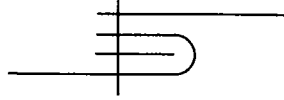
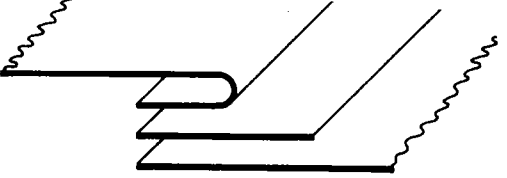
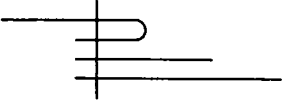
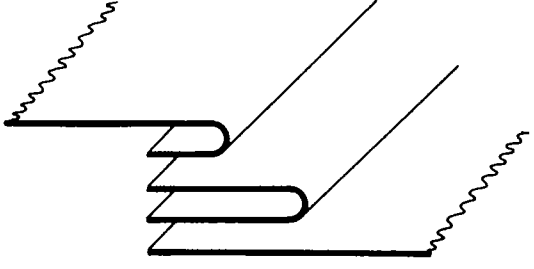
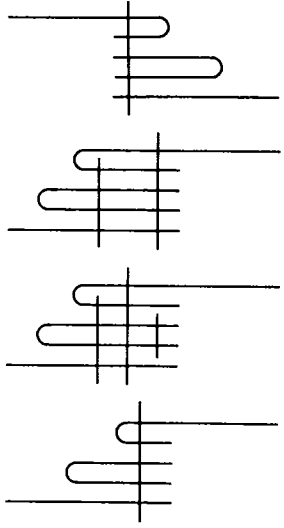
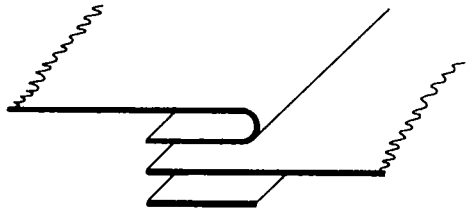
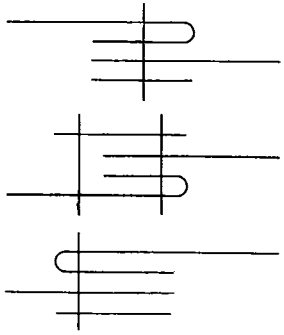
Material configuration	Location of needle penetration or passage	Numerical designation
1.24 		1.24.01 1.24.02
1.25 		1.25.01
1.26 		1.26.01

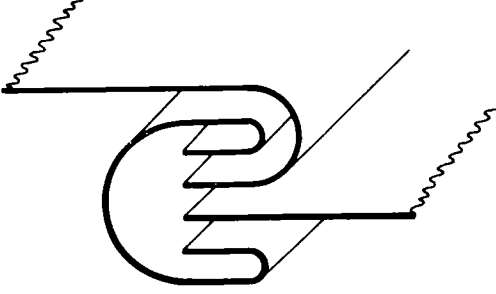
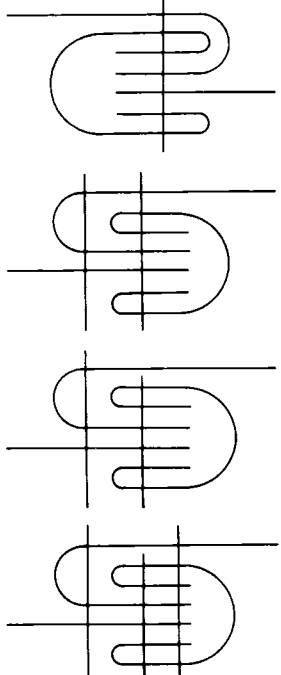
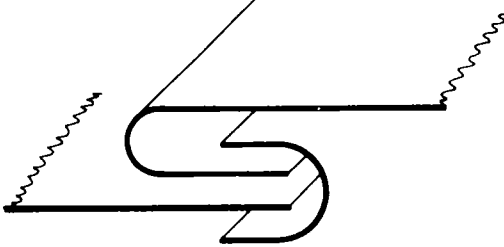
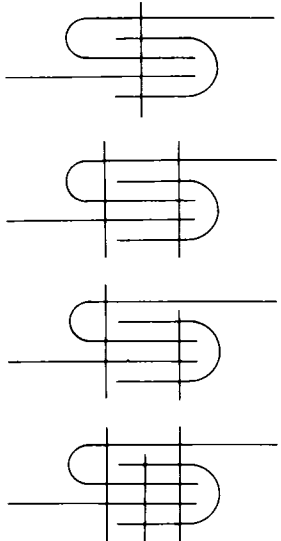
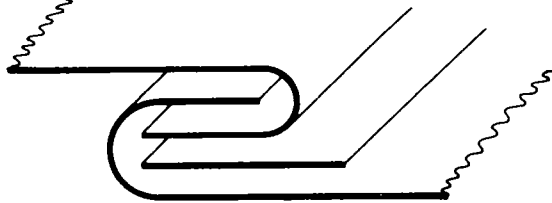
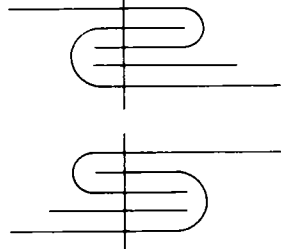
Material configuration	Location of needle penetration or passage	Numerical designation
2.01 		2.01.01
		2.01.02
2.02 		2.02.01
		2.02.02
		2.02.03
		2.02.04
		2.02.05
		2.02.06
		2.02.07
2.03 		2.03.01
		2.03.02

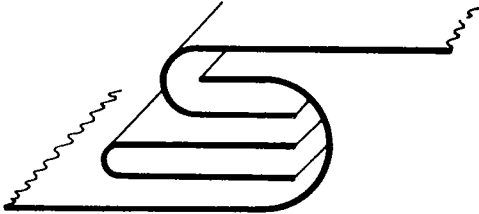
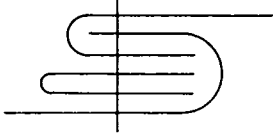
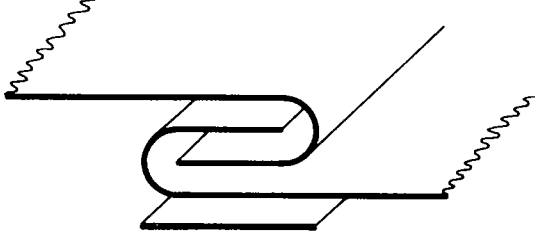
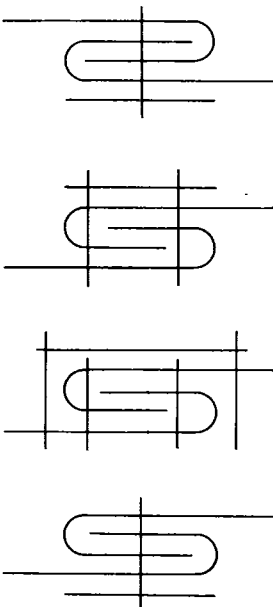
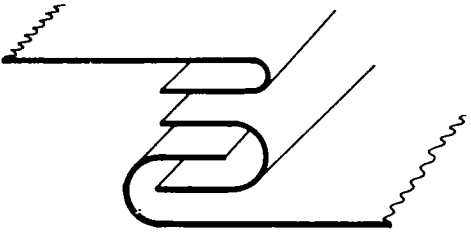
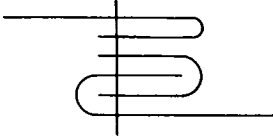
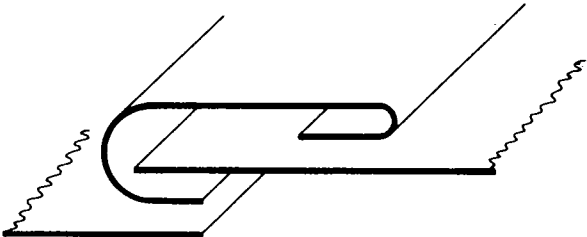
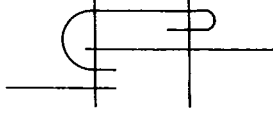
Material configuration	Location of needle penetration or passage	Numerical designation
2.04 		2.04.01
		2.04.02
		2.04.03
		2.04.04
		2.04.05
		2.04.06
		2.04.07
		2.04.08

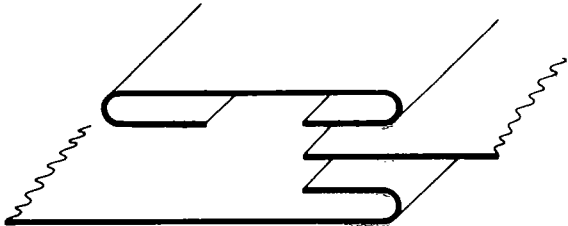
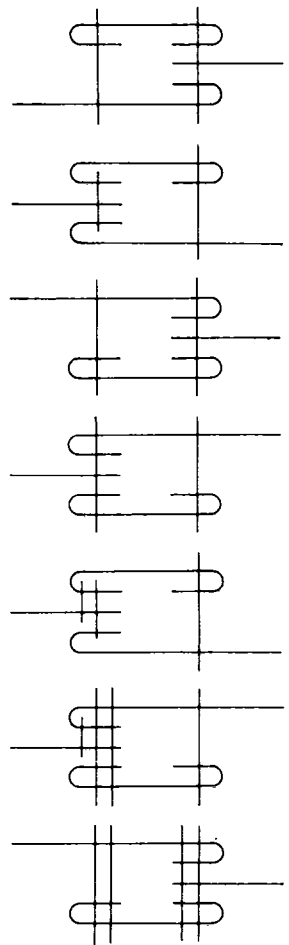
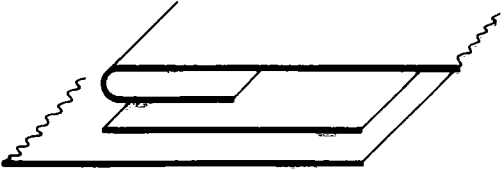
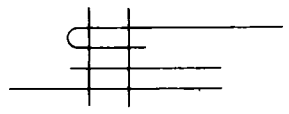
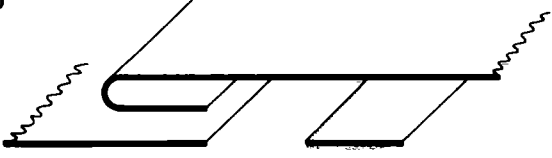
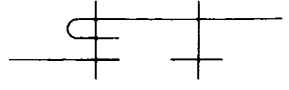
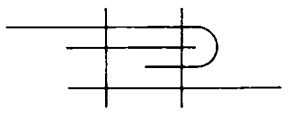
Material configuration	Location of needle penetration or passage	Numerical designation
2.05 		2.05.01
		2.05.02
		2.05.03
		2.05.04
		2.05.05
		2.05.06
		2.05.07
2.06 		2.06.01
		2.06.02
		2.06.03
2.07 		2.07.01
		2.07.02
		2.07.03
2.08 		2.08.01

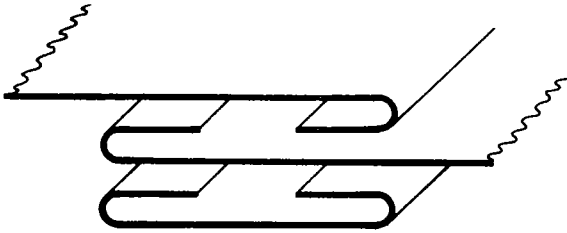
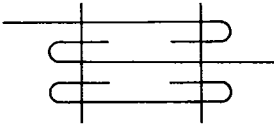
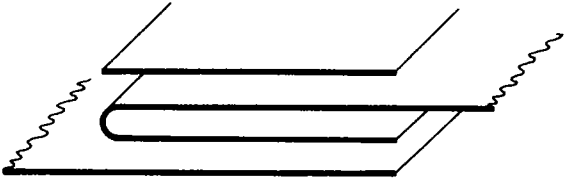
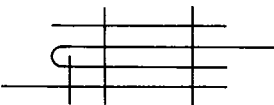
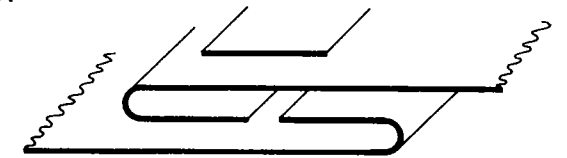
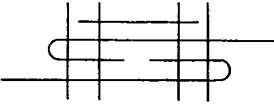
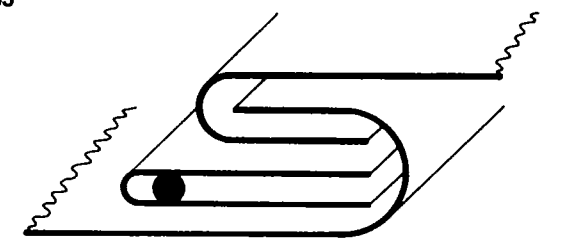
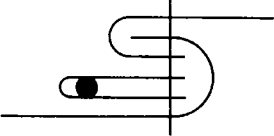
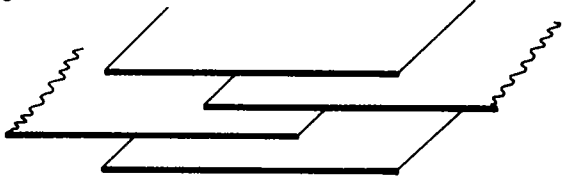
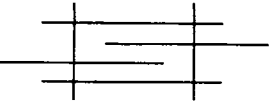
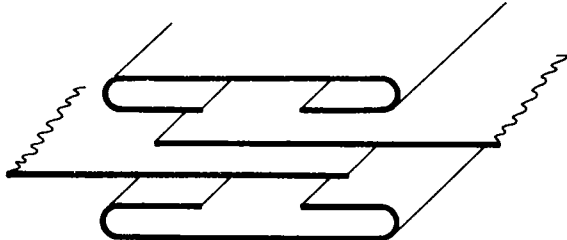
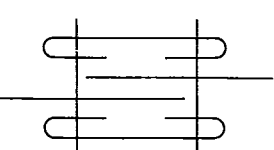
Material configuration	Location of needle penetration or passage	Numerical designation
2.09 		2.09.01
2.10 		2.10.01
2.11 		2.11.01 2.11.02
2.12 		2.12.01
2.13 		2.13.01 2.13.02 2.13.03
2.14 		2.14.01 2.14.02
2.15 		2.15.01

Material configuration	Location of needle penetration or passage	Numerical designation
2.16 		2.16.01
2.17 		2.17.01
2.18 		2.18.01
2.19 		2.19.01 2.19.02 2.19.03 2.19.04
2.20 		2.20.01 2.20.02 2.20.03

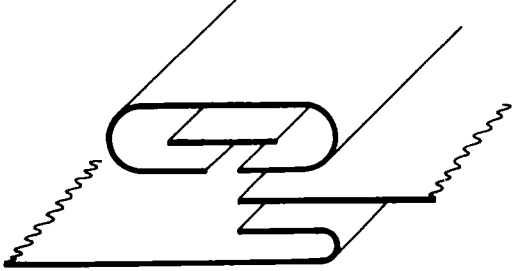
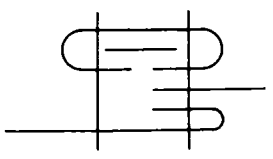
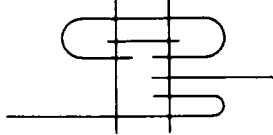
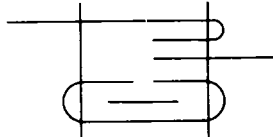
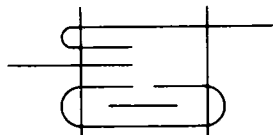
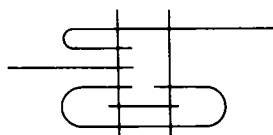
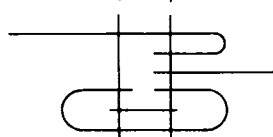
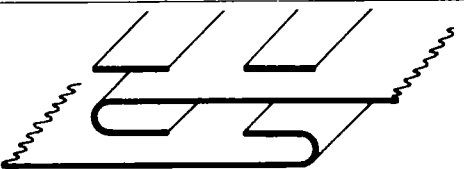
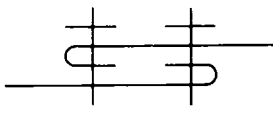
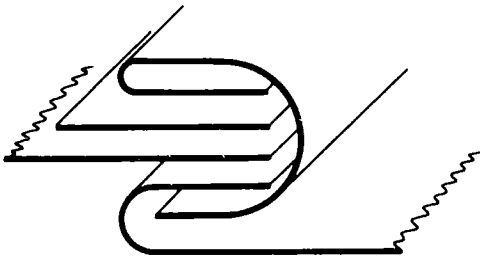
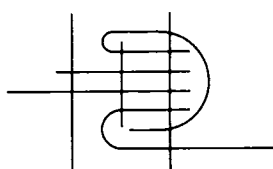
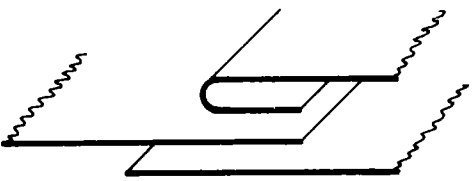
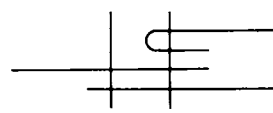
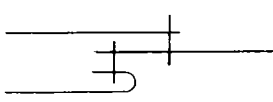
Material configuration	Location of needle penetration or passage	Numerical designation
2.21 	 2.21.01 2.21.02 2.21.03 2.21.04	
2.22 	 2.22.01 2.22.02 2.22.03 2.22.04	
2.23 	 2.23.01 2.23.02	

Material configuration	Location of needle penetration or passage	Numerical designation
2.24 		2.24.01
2.25 		2.25.01 2.25.02 2.25.03 2.25.04
2.26 		2.26.01
2.27 		2.27.01

Material configuration	Location of needle penetration or passage	Numerical designation
2.28 		2.28.01 2.28.02 2.28.03 2.28.04 2.28.05 2.28.06 2.28.07
2.29 		2.29.01
2.30 		2.30.01
2.31 		2.31.01

Material configuration	Location of needle penetration or passage	Numerical designation
2.32 		2.32.01
2.33 		2.33.01
2.34 		2.34.01
2.35 		2.35.01
2.36 		2.36.01
2.37 		2.37.01

BS 3870 : Part 2 : 1983

Material configuration	Location of needle penetration or passage	Numerical designation
2.38 		2.38.01
		2.38.02
		2.38.03
		2.38.04
		2.38.05
		2.38.06
2.39 		2.39.01
2.40 		2.40.01
2.41 		2.41.01
		2.41.02