

Stitches and seams —

Part 2: Classification and terminology of seam types

Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Textiles and Clothing Standards Policy Committee (TCM/-) to Technical Committee TCM/40, upon which the following bodies were represented:

- British Association of Clothing Machinery Manufacturers
- British Clothing Industry Association
- Clothing and Footwear Institute
- Hollings College for the Food and Fashion Industries
- Knitting Industries' Federation Ltd.
- Linen Sewing Thread Manufacturers' Association
- Ministry of Defence
- SATRA Footwear Technology Centre

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National foreword

This British Standard has been prepared under the direction of the Textiles and Clothing Standards Policy Committee. It is identical with ISO 4916:1991 “*Textiles — Seam types — Classification and terminology*”, published by the International Organization for Standardization (ISO), which was prepared, with the active participation of the United Kingdom, by Technical Committee ISO/TC38.

This third edition supersedes BS 3870-2:1983, of which it forms a minor technical revision and which is withdrawn.

For ease of production the French text has been retained.

Cross-reference

International standard	Corresponding British Standard
ISO 4915:1991	BS 3870 <i>Stitches and seams</i> Part 1: <i>Classification and terminology of stitch types</i> (Identical)

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

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

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 64, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 4916 was prepared by Technical Committee ISO/TC 38, *Textiles*.

This second edition cancels and replaces the first edition (ISO 4916 : 1982), of which it constitutes a minor technical revision.

Annex A forms an integral part of this International Standard.

Avant-propos

L'ISO (Organisation internationale de normalisation) est une fédération mondiale d'organismes nationaux de normalisation (comités membres de l'ISO). L'élaboration des Normes internationales est en général confiée aux comités techniques de l'ISO. Chaque comité membre intéressé par une étude a le droit de faire partie du comité technique créé à cet effet. Les organisations internationales, gouvernementales et non gouvernementales, en liaison avec l'ISO participent également aux travaux. L'ISO collabore étroitement avec la Commission électrotechnique internationale (CEI) en ce qui concerne la normalisation électrotechnique.

Les projets de Normes internationales adoptés par les comités techniques sont soumis aux comités membres pour vote. Leur publication comme Normes internationales requiert l'approbation de 75 % au moins des comités membres votants.

La Norme internationale ISO 4916 a été élaborée par le comité technique ISO/TC 38, *Textiles*.

Cette deuxième édition annule et remplace la première édition (ISO 4916 : 1982), dont elle constitue une révision technique mineure.

L'annexe A fait partie intégrante de la présente Norme internationale.

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 annex A.

NOTE 1 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.

Introduction

La présente classification des coutures a pour objet de fournir des renseignements utiles aux services d'achats, aux confectionneurs, aux fabricants de machines, aux étudiants, etc. Le document fournit principalement un guide descriptif destiné à identifier les coutures et à rendre leur désignation plus aisée.

Suivant le but de la présente Norme internationale, les coutures consistent en une suite de types de points tels qu'ils sont définis dans l'ISO 4915, le nombre de composants et leur configuration étant représentés dans présente Norme internationale.

Afin que la désignation d'une couture soit la plus complète possible, la désignation du type de point doit être ajoutée après la désignation de la couture. Si l'on utilise deux ou plusieurs types de points, ils doivent être lus de gauche à droite.

Les désignations ISO ainsi que les désignations nationales antérieures sont données à l'annexe A.

NOTE 1 Pour les types de coutures qui pourraient être créés ultérieurement, en informer le secrétariat de ISO/TC 38 afin qu'une classification correcte leur soit attribuée, après consultation des membres de l'ISO/TC 38.

Textiles — Seam types — Classification and terminology

1 Scope

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 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 4915 : 1991, *Textiles — Stitch types — Classification and terminology*.

3 Definition

For the purposes of this International Standard, the following definition applies.

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

Textiles — Types de coutures — Classification et terminologie

1 Domaine d'application

La présente Norme internationale classe, illustre et désigne les divers types de coutures. Elle n'est pas exhaustive mais illustre les types de coutures les plus utilisées. Elle s'applique aux coutures utilisées plus particulièrement dans l'industrie de l'habillement. Toutes les illustrations montrent seulement la coupe de la configuration du matériau.

Il y a lieu de lire la présente Norme internationale conjointement avec l'ISO 4915.

2 Référence normative

La norme suivante contient des dispositions qui, par suite de la référence qui en est faite, constituent des dispositions valables pour la présente Norme internationale. Au moment de la publication, l'édition indiquée était en vigueur. Toute norme est sujette à révision et les parties prenantes des accords fondés sur la présente Norme internationale sont invitées à rechercher la possibilité d'appliquer l'édition la plus récente de la norme indiquée ci-après. Les membres de la CEI et de l'ISO possèdent le registre des Normes internationales en vigueur à un moment donné.

ISO 4915 : 1991, *Textiles — Types de points — Classification et terminologie*.

3 Définition

Pour les besoins de la présente Norme internationale, la définition suivante s'applique.

couture: Application d'une suite de points ou types de points à une ou plusieurs épaisseurs de matériau.

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 table 1 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.

4 Classification

Les coutures sont réparties en huit classes selon les types et le nombre minimal de composants de la couture. Les composants sont dits «limités» ou «illimités» en largeur (voir 6.3). Les caractéristiques de chaque classe sont indiquées dans le tableau 1 et sont décrites ci-dessous.

4.1 Classe 1

Dans cette classe, les coutures sont réalisées avec, au minimum, deux composants limités du même côté. Chacun des autres composants est soit semblable à l'un des deux, soit limité des deux côtés.

4.2 Classe 2

Dans cette classe, les coutures sont réalisées avec, au minimum, deux composants dont l'un est limité d'un côté et le deuxième de l'autre côté. Ces deux composants sont opposés à des niveaux différents et se chevauchent. Chacun des autres composants est soit semblable à l'un des deux, soit limité des deux côtés.

4.3 Classe 3

Dans cette classe, les coutures sont réalisées avec, au minimum, deux composants dont l'un est limité d'un côté, le second, limité des deux côtés, étant rapporté sur le bord du premier (à cheval). Chacun des autres composants doit être semblable à l'un des deux.

4.4 Classe 4

Dans cette classe, les coutures sont réalisées avec, au minimum, deux composants dont l'un est limité d'un côté et le second de l'autre côté. Ces deux composants sont opposés et au même niveau. Chacun des autres composants est soit semblable à l'un des deux, soit limité des deux côtés.

4.5 Classe 5

Dans cette classe, les coutures sont réalisées avec, au minimum, un composant illimité des deux côtés. Chacun des autres composants peut être soit limité d'un côté, soit limité des deux côtés.

4.6 Classe 6

Dans cette classe, les coutures sont réalisées avec un seul composant limité d'un côté (soit à droite, soit à gauche).

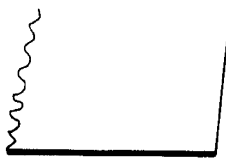
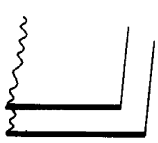
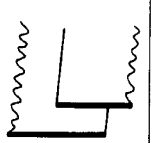
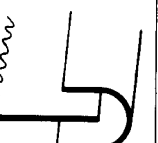
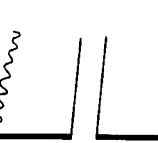
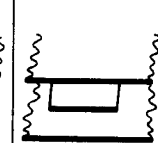
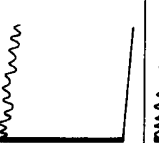
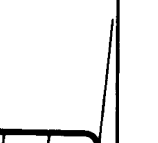
4.7 Classe 7

Dans cette classe, les coutures sont réalisées avec, au minimum, deux composants dont l'un est limité d'un côté (à droite ou à gauche) et tous les autres sont limités des deux côtés.

4.8 Classe 8

Dans cette classe, les coutures sont réalisées avec, au minimum, un composant limité des deux côtés. Chacun des composants est aussi limité des deux côtés.

Table 1 – Classification of stitched seams
Tableau 1 – Classification des coutures

Components Composants	Class Classe							
	1	2	3	4	5	6	7	8
	2 or more ou plus	1 or more ou plus	1 or more ou plus	1 or more ou plus + 1 or more ou plus	0 or more ou plus	1	1	—
	—	1 or more ou plus	—	in the same horizontal plane dans le même plan horizontal				—
	—	—	—	—	1 or more ou plus	—	—	—
	0 or more ou plus	0 or more ou plus	1 or more ou plus	0 or more ou plus	0 or more ou plus	—	1 or more ou plus	1 or more ou plus
Minimum total components Nombre minimal de composants	2 or more ou plus	2 or more ou plus	2 or more ou plus	2 or more ou plus	1 or more ou plus	1	2 or more ou plus	1 or more ou plus
Basic material configuration Configuration de base du matériau								

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)

5 Désignation

Chaque couture est identifiée au moyen d'une désignation numérique constituée de cinq chiffres. Ceux-ci correspondent aux notions suivantes:

Premier chiffre: Classes de 1 à 8

Deuxième et troisième chiffres: Nombres allant de 01 à 99 pour indiquer des différences de configuration du matériau

Quatrième et cinquième chiffres: Nombres allant de 01 à 99 pour indiquer des différences d'emplacements de points de pénétration ou de passage de l'aiguille et/ou la représentation symétrique de la configuration du matériau (comme par les deuxième et troisième chiffres)

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 Conventions appliquées dans les illustrations

6.1 Les illustrations indiquent normalement le nombre minimal de composants nécessaires pour réaliser la couture.

6.2 Chaque épaisseur de matériau est représentée par un trait fort:

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



6.3 Un bord de matériau illimité est représenté par un trait ondulé:

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

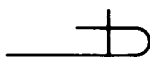


6.4 Un bord de matériau limité est représenté par un trait droit:

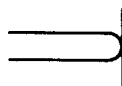
6.5 The penetration(s) or passage(s) of the needle(s) is denoted by a straight line, e.g.



or/ou



or/ou

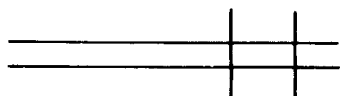


6.5 Le(s) point(s) de pénétration ou de passage de l'aiguille (ou des aiguilles) est (sont) représenté(s) par un trait droit, par exemple:

There are two possibilities of passage.

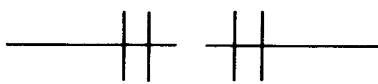
Il existe deux possibilités de passage.

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

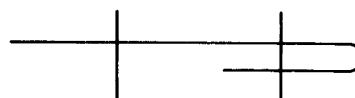


e.g. sewn by stitch type 602 or 401.401
Par exemple, cousu par le type de point 602 ou 401.401

6.5.1 L'aiguille traverse le matériau, auquel cas le trait est représenté dépassant de chaque côté du matériau:



e.g. sewn by stitch type 606 or 607
Par exemple, cousu par le type de point 606 ou 607



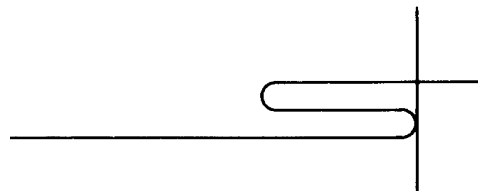
e.g. sewn by stitch type 302
Par exemple, cousu par le type de point 302

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
Par exemple, cousu par le type de point 103

6.5.2 L'aiguille ne traverse pas le matériau, auquel cas la ligne s'arrête sur le matériau ou lui est tangente:



e.g. sewn by stitch type 503 or 505
Par exemple, cousu par le type de point 503 ou 505

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

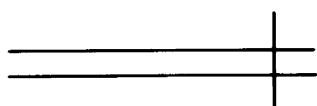
6.6 La section d'un cordonnet de garniture est représentée par un gros point: ●

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.

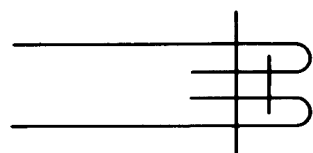
6.7 Toutes les coutures sont représentées telles qu'elles sont effectuées sur une machine. Dans le cas d'opérations multiples, elles sont représentées telles qu'elles apparaissent après la dernière opération.

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

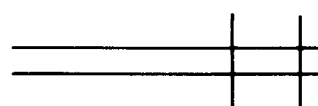
6.8 Quelques exemples de désignations numériques des types de coutures sont donnés ci-dessous:



1.01.01/301
or/ou
1.01.01/401
or/ou
1.01.01/504



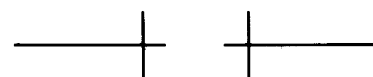
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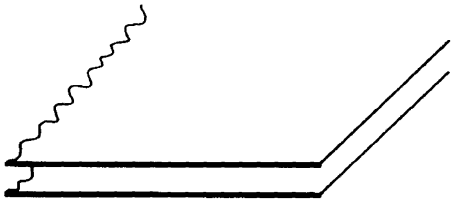
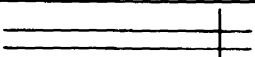
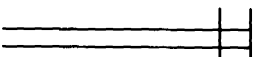
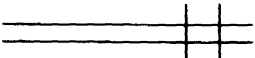
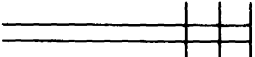
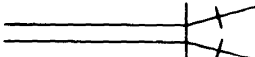
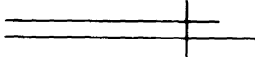
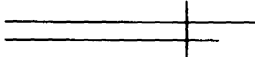
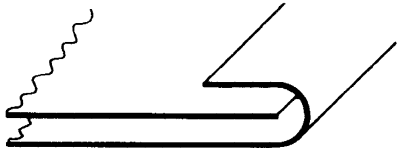
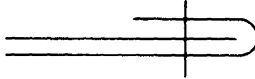
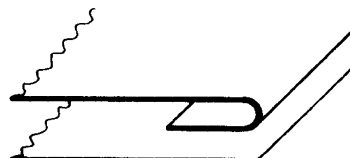
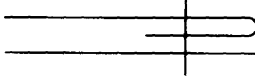
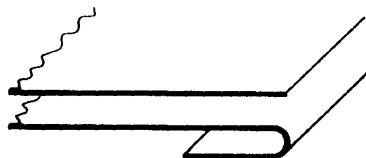
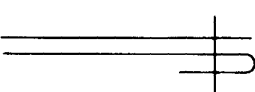
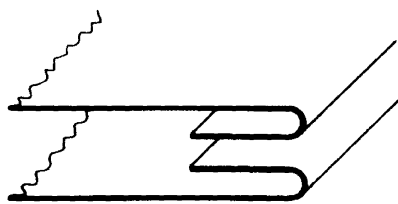
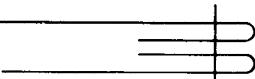
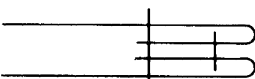
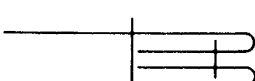
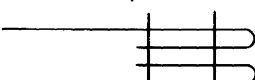


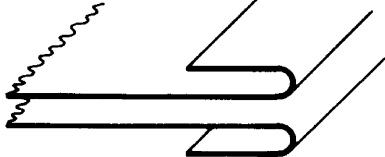
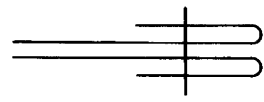
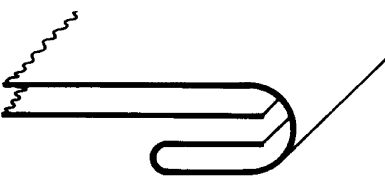
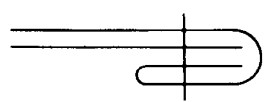
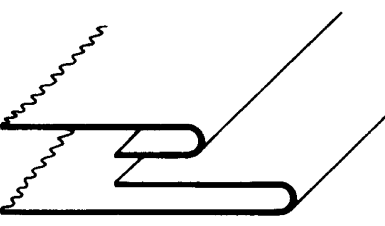
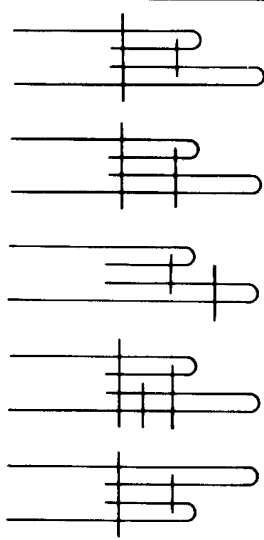
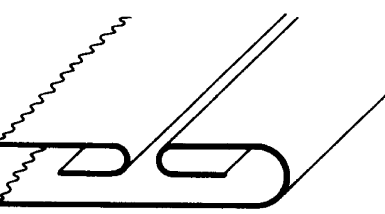
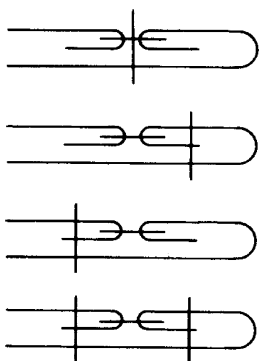
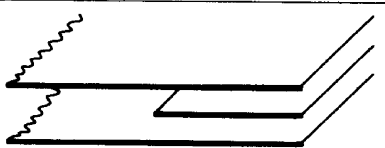
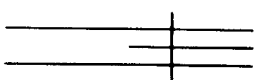
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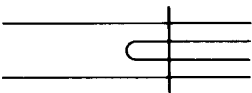
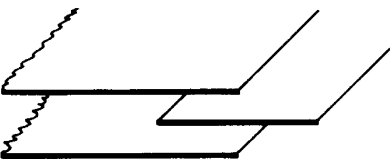
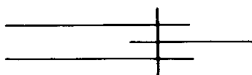
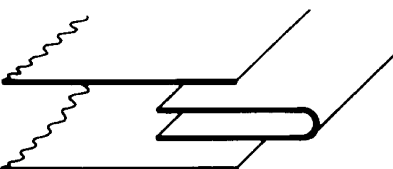
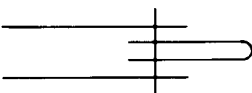
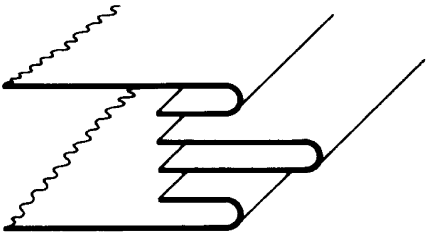
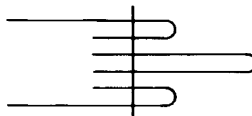
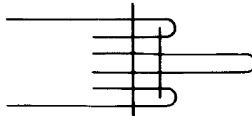
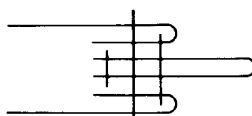
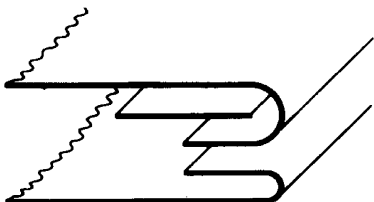
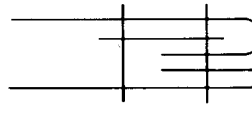
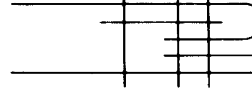
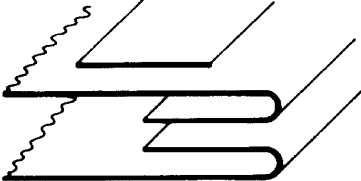
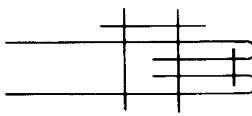


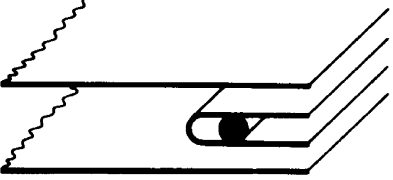
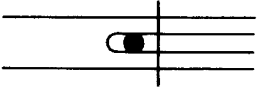
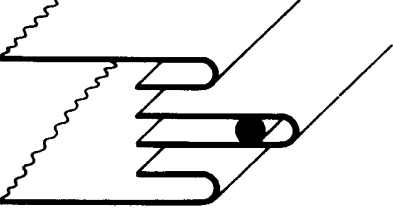
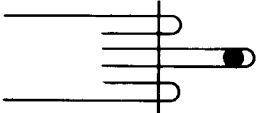
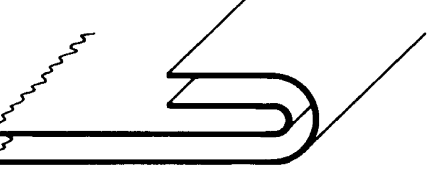
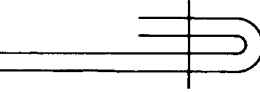
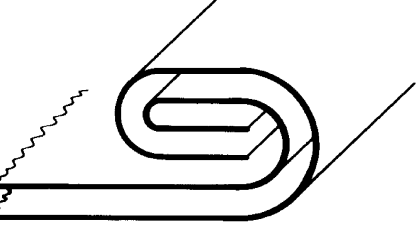
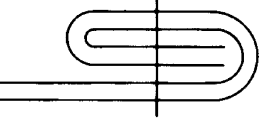
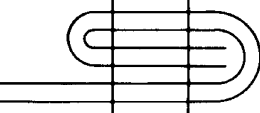
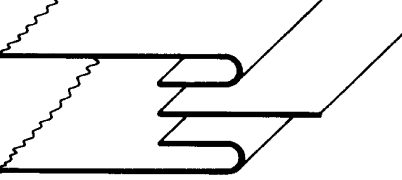
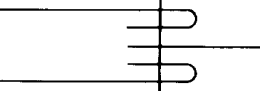
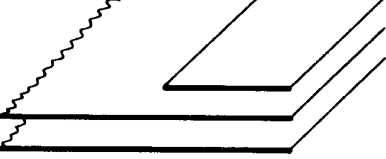
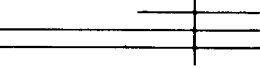
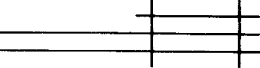
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or/ou
4.01.01/404

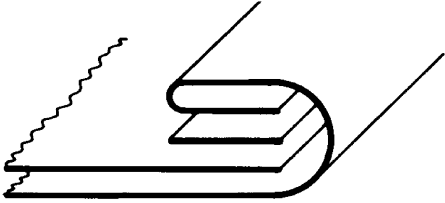
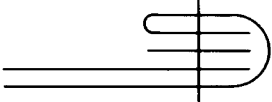
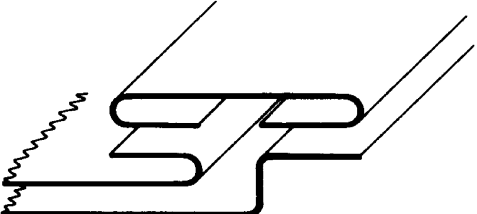
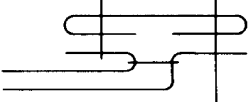
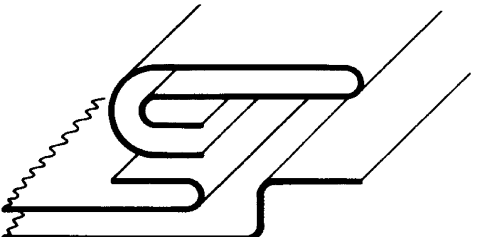
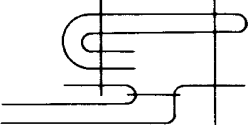
7 Illustrations/Illustrations

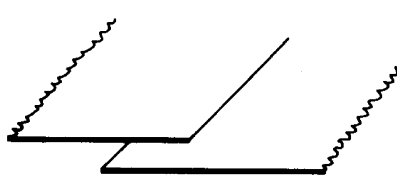
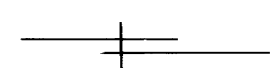
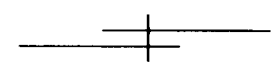
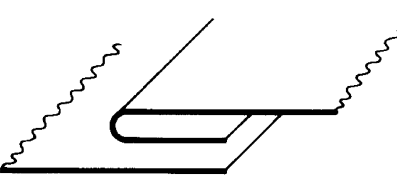
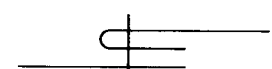
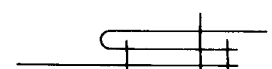
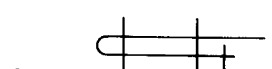
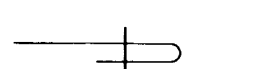
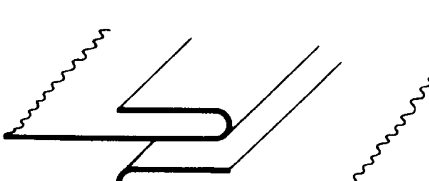
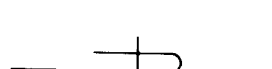
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
1.01 		1.01.01
		1.01.02
		1.01.03
		1.01.04
		1.01.05
1.02 		1.02.01
		1.02.02
1.03 		1.03.01
1.04 		1.04.01
		1.04.02
1.05 		1.05.01
1.06 		1.06.01
		1.06.02
		1.06.03
		1.06.04

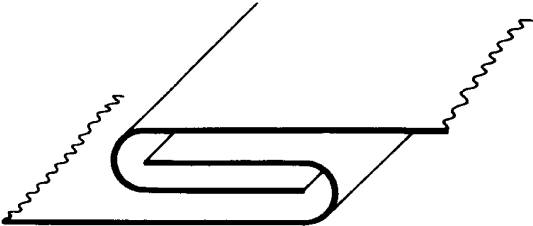
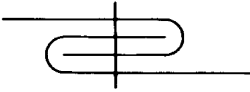
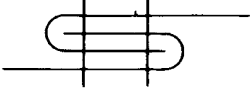
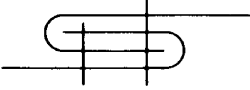
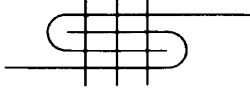
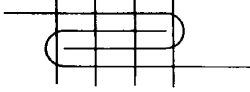
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
1.07 		1.07.01
1.08 		1.08.01
1.09 		1.09.01 1.09.02 1.09.03 1.09.04 1.09.05
1.10 		1.10.01 1.10.02 1.10.03 1.10.04
1.11 		1.11.01

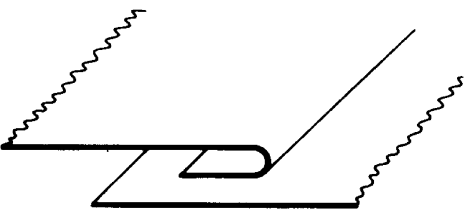
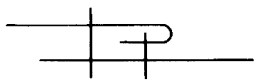
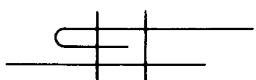
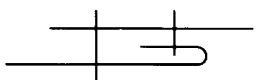
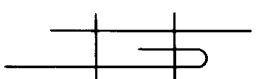
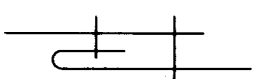
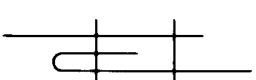
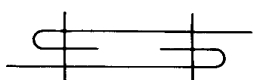
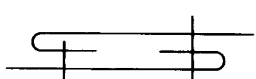
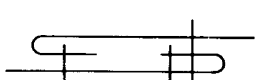
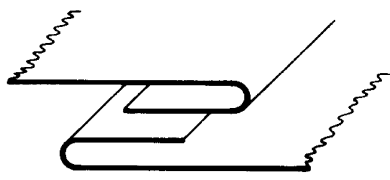
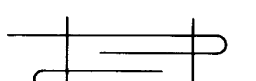
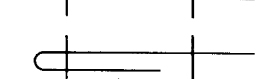
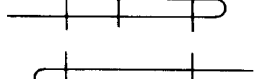
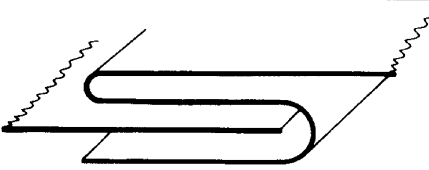
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
1.12 		1.12.01
1.13 		1.13.01
1.14 		1.14.01
1.15 		1.15.01
		1.15.02
		1.15.03
1.16 		1.16.01
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1.17 		1.17.01

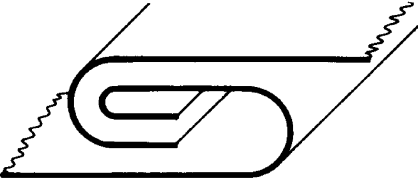
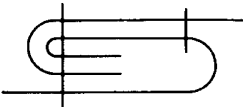
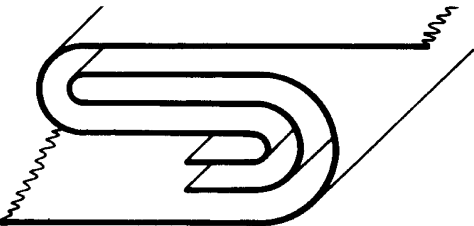
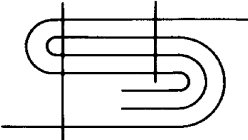
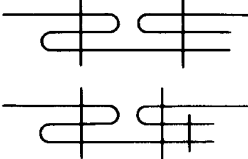
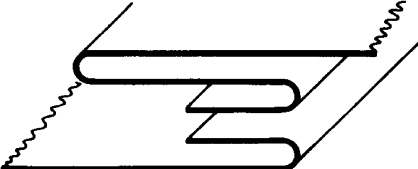
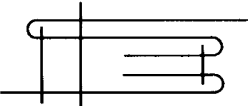
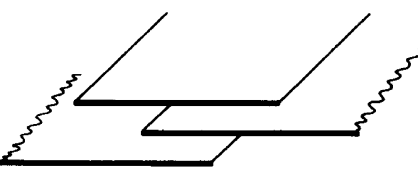
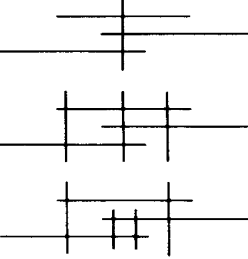
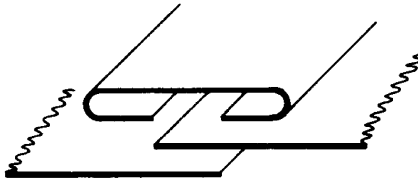
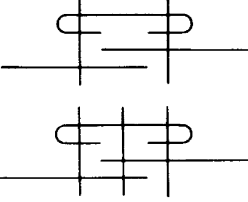
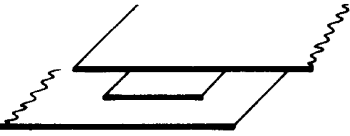
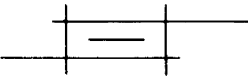
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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1.19 		1.19.01
1.20 		1.20.01
1.21 		1.21.01
		1.21.02
1.22 		1.22.01
1.23 		1.23.01
		1.23.02
		1.23.03

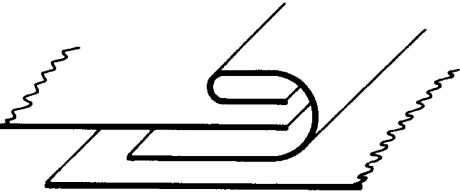
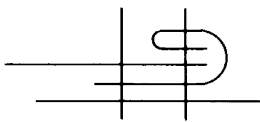
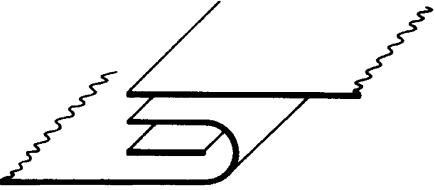
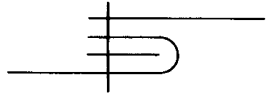
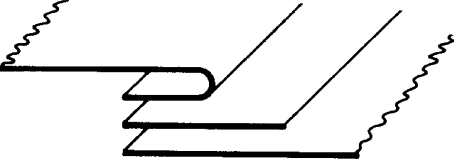
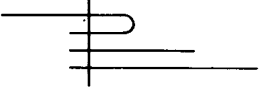
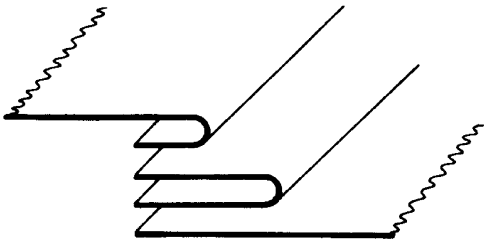
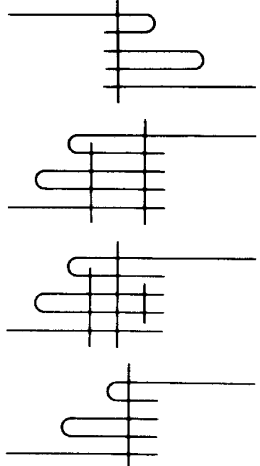
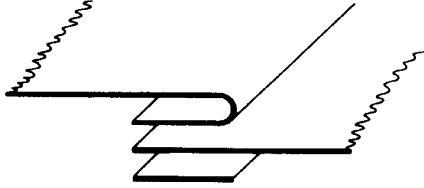
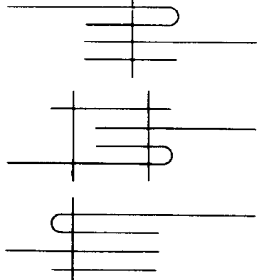
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
1.24 		1.24.01
		1.24.02
1.25 		1.25.01
1.26 		1.26.01

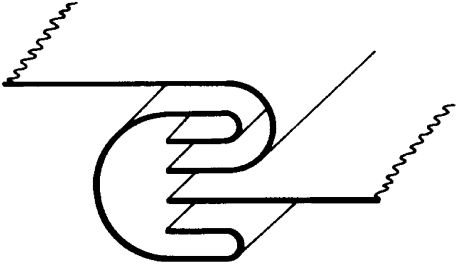
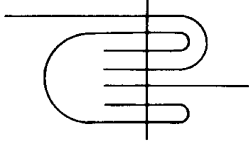
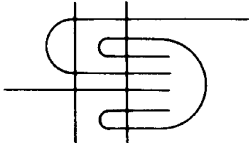
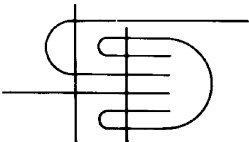
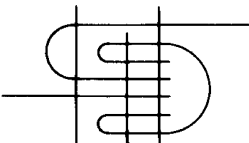
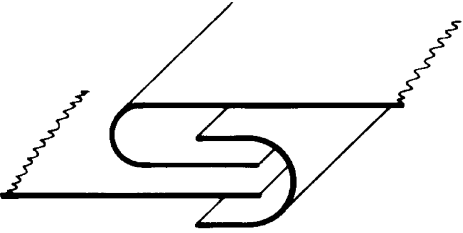
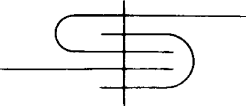
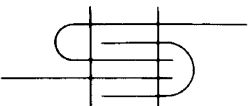
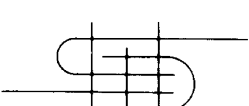
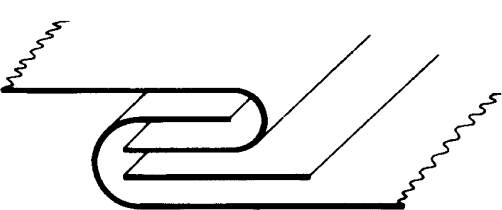
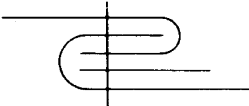
Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
2.01 		2.01.01
		2.01.02
2.02 		2.02.01
		2.02.02
		2.02.03
		2.02.04
		2.02.05
		2.02.06
		2.02.07
2.03 		2.03.01
		2.03.02

Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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
		2.04.09

Material configuration Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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 Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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 Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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 Configuration des matériaux	Location of needle penetration or passage Emplacement des points de pénétration de l'aiguille	Numerical designation Désignation numérique
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