

VENTILE STITCHING SPECIFICATION

1. Use double lapped felled seams.
Do not use plain or raised seams.
2. Use core-spun polyester thread – polyfill 120 / coats 180's poly poly
3. Use as fine a needle diameter as possible, i.e 70's or 80's a round point needle with a triangular (sehmetz SD1 is recommended)



Plain Seam



Single lapped or raised seam



Double lapped felled seam

Guides to overcome 'seam pucker' in Ventile Fabric.

There are 3 potential causes of seam plucker.

1. **Inherent or Structural Jamming.**
Follow the above recommendations for stitching. For top stitching / decorative stitching or raised seams, a stitch density of 8 – 9 stitches per 2.5cm is recommended.
2. **Differential Feeding Pucker**
The types of seams used in the manufacture of protective outerwear are more prone to this type of pucker, irrespective of the fabric constructive used.

Recommendations

This type of pucker can be greatly reduced by the use of a compensation foot to accommodate the differing thickness of the seam either side of the needle. To gain maximum benefit an independent type of compensation foot should be used. This allows even pressure to be applied. **It is important that the separate parts of the slipper conform to the stitching margin of the raised seam.**

3. **Thread Tension Pucker**

This type of pucker can occur on any type of fabric, but if the machine is serviced and adjusted correctly and the following procedure is adopted should present few problems.

Recommendations

Tensions applied to the sewing threads must be kept to a maximum and the threads must have minimum shrinkage at the pressing stage.

Procedure

1. The spool or bobbin winder should be set to the minimum tension that will wind an even spool.
2. Reduce tension of the spoolcase so that it will just support the weight of a full spool and case when suspended by the free end of the thread. (Note extra allowance must be made if devices to avoid spool spin are being used.)
3. The needle thread tension should then be adjusted to the minimum which will give a well balanced stitch. (Note – ensure the check or take up spring is functioning correctly.)
4. Ensure that all parts of the machine which come into contact with the sewing threads are smooth, highly polished and free from burrs.
5. Ensure that the rotary hook mechanism is synchronised correctly.