SOFT WOVEN CONSTRUCTION STANDARDS

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**BINDINGS:**

1. Straight seams - cut binding on straight grain unless the Technician advises otherwise.
2. Curved seams – cut binding on bias unless the Technician advises otherwise.

**BONING:**

* CASING: 1/2” WIDE, CLEAN FINISHED AND EDGESTITCHED
* CASING MAY BE SET TO THE INSIDE WHEN THERE IS A NECK FACING
* PLACE BACK BONING AT SIDE SEAM WHEN THERE IS CB SMOCKING

**OPTION B:** INSTEAD OF SEPARATE CASING,
MAKE A PLEAT TO CREATE CASING, EDGSTITCH DOWN FOLDED EDGE
**DART - SHAPING:**

**SHAPING THE BODY**
THINK OF THE BODY AS ROUND, NO STRAIGHT LINES.

EXAMPLE: BODICE

CLOSING DARTS THAT TAPER DOWN
MAKES CONVEX CURVE AT WAIST

CLOSING DARTS THAT EXPAND WIDE
MAKES CONCAVE SHAPE AT WAIST

EXAMPLE: SKIRT
DARTS – COMMON BODICE CORRECTIONS:

**BODICE DART CORRECTIONS**

IF YOU NEED TO INCREASE FULLNESS AT APEX BUT NOT CHANGE AT X- CHEST

ADDED +1/2” AT APEX, SHIRRING HAS INCREASED

NEED TO PINCH OUT OF NECKLINE SLASH & CLOSE, PIVOT AT APEX OPEN IN CENTER OF SHIRRING SO SHIRRING WILL INCREASE

NEED TO PICK UP BODICE AT SIDES CLOSE OUT DART TO APEX, PIVOT OPEN AT SEAM SHIRRING FULLNESS INCREASES
**EASE:**
1. Skirts always need to be ½” to ¾” bigger total, depending on the fabric at the waistband for ease. This helps with the curve shape on the high hip, so it is not so flat.
2. Bodice always needs 1/2” to 1” total ease into seam or waistband. This helps with the bust fullness. Bodice seam allowance should be pressed up unless clean finished with waistband.

**EDGE FINISHES:**

E001: CUT FAGGOTING

![Cut Faggoting](image)

E002: 3/8” CLEAN FINISHED HEM WITH TRIM SET ON TOP AT EDGE (STANDARD FOR ANTHROPOLOGIE LINED GARMENTS WITH TRIM)

![Clean Finished Hem with Trim](image)

**FACE SIDE**

**INSIDE**
**ELASTIC:**

1. Sandwich elastic with merrow where applicable instead of tunneling (ex: waist seams & bottom of smocking).

   **EL001: Elastic Tunneled Inside Seam**

   **EL002: Elastic Set On Top Of Seam**

   **EL003: Elastic Merrowed Into Seam**

   **ELASTIC WITH CASING ON INSIDE OF GARMENT**

   ![Outside View](Image)

   ![Inside View](Image)
Silicone Gripper Elastic Tape

* set to inside ply or facing with ends folded in edgestitch all sides
* 1/8" minimum placement from top edge minimum

**FABRIC:**
***ALL FABRIC MUST BE TESTED FOR SEAM SLIPPAGE AT SAMPLING STAGE AND UPON RECEIPT OF BULK FABRIC. IF SEAM SLIPPAGE IS FOUND, ALL SEAMS MUST BE FUSED WITH DTM TRICOT FUSIBLE.*
**HANGER LOOPS:**

Any hanger loop that is set into seam with a zipper must be stitched 1/4" from seam to keep from catching into zipper. Therefore cut 1/4" longer folded.

Blouses & Dresses: Tech will advise due to necklines and armhole changes.

Skirts standard: 4 1/2" folded set in waistband side seams 1" below top edge.

On the zipper setting side fold ribbon back and stitch 1/4" from setting to keep from getting caught in the zipper.

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**HANGER LOOPS ON STRAPLESS DRESSES AND TOPS:**
LINING

SET CASING ON FACE SIDE OF LINING INSERT HANGER LOOP

5/8" THREAD CHAINSTITCH 3/4" BELOW NECK EDGE

side back side front

* WHEN THERE IS A NECK FACING THE RIBBON MAY BE INSERTED IN THE JOINING SEAM OF THE FACING & LINING TO THE OUTSIDE EDGE OF BONING.

CASING TO THE INSIDE

2 1/2" 3 1/2"

HANGER LOOPS: 5 1/2" FOLDED
**STRAPLESS GARMENTS: HANGER LOOPS WITH DETACHABLE STRAPS**

HEMS
BABY HEM:
1/16” FOR LIGHT WEIGHT FABRICS
1/8” FOR HEAVY WEIGHT FABRIC.
***BABY HEM SHOULD NEVER BE MORE THAN 1/8”

LININGS:
1. Add CB seam to all linings on skirts & skirt part of dresses. If the fabric is sheer make a French seam and seam is toward body. Self skirts that have shirring or multiple pleats: lining should have minimal fullness.
   - Shirring 1 ¼:1 ratio
   - Pleats should be reduced to 1 or 2 on each side of CF & CB
   - Lining sweeps should be NO MORE than 34” flat on sample size.

PICOT & PICKSTITCH :
1. Should be made by machine unless the Technician advises otherwise.

RUFFLES:
1. Cut on straight grain, no bias unless the Technician advises otherwise.
**SEAMS & TOPSTITCH:**

ISO#103: SINGLE THREAD BLINDSTITCH
- 3.5-4 SPI

ISO#301: SINGLE NEEDLE LOCKSTITCH
- 10-12 SPI

ISO#304: ZIGZAG
- *8 CYCLES PER INCH

ISO#304: BUTTONSEW (4 hole)
- 16 per button

ISO#304: BUTTONHOLE (1/2’’)
- 85-90 total per buttonhole

ISO#304: BARTACK (1/4’’)
- 24-28 PER TACK

ISO#401: CHAINSTITCH
- 10-12 SPI

ISO#502: PURL MERROW
- 30-34 SPI

ISO#504: COMMON OVEREDGE
- 12-14 SPI

ISO#516: 5 THREAD SAFETY STITCH
- *STANDARD APPLICATION FOR ALL SAFETY SEAMS
- 12-14 SPI

***ALL SPI ARE STANDARD REQUIREMENT, UNLESS OTHERWISE REQUESTED IN TECH PACK

**SEAMS:**

1/2’’ MERROW PRESS OPEN

3/8’’ SAFETY SEAM

1/4’’ FRENCH SEAM
1/4” PIN HEM

1/2” PRESS OPEN WITH 3/16” BINDING

3/8” FLAT FELLED WITH 1/4” DN TS
**FUSED SEAM**

**RAW CUT LAPPED SEAM**

**SEAM JOINING:**
JOINING SEAMS
ALWAYS PUT JOINING SEAMS TOGETHER AFTER EACH PATTERN ADJUSTMENT TO ENSURE AN EVEN AND SMOOTH SEWING LINE. SHAVE OFF TO MAKE SMOOTH LINES

**SMOCKING:**

***ALL SMOCKED BACK OF GARMENTS MUST HAVE WOVEN ELASTIC SET IN TOP EDGE OF FOLD, OR IF THERE IS A RUFFLE AT THE TOP, BETWEEN TOP 2 ROWS OF SMOKING.***

***SMOCKING THAT IS ATTACHED TO A SEAM THAT SHOULD STRETCH WITH SMOKING, SHOULD HAVE ELASTIC SET IN SEAM***

**S001:**
ELASTIC SMOKING WITH CHAINSTITCH BACK
S002:
ELASTIC SMOCKING STITCH
*MULTINEEDLE (TAJMAI, TAIS, KANSAI)

STRAPS:

1. Cut on straight grain unless the Technician advises otherwise.

ANTHROPOLOGIE DETATCHABLE STRAPS:

1. Always set at princess seams.
   a. Set ½” from top edge and tack.
2. If there are no princess seams, set:
   a. Front strap distance 9 ½”. Grade distance ¼” per size.
   b. Back strap distance 7 ½” (If no smocking) & 6 ½” (If there is smocking at back). Grade distance ¼” per size.
• Fold of loop tacked down.
• Fold of loop 3/8” from top finished edge.
• Hardware should not extend past edge.

**WAISTBAND CLOSURES:**

**SKIRT WAISTBAND CLOSURE WITH HOOK & FLEX**

**SKIRT WAISTBAND CLOSURE WITH BUTTONS & BUTTONHOLES**

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**WAISTBAND INSERTS ON TOPS AND DRESSES:**
MUST BE SEWN CLOSED AT TOP AND BOTTOM
INSIDE PLY WAISTBAND FUSED

2-PLY WB CLEAN FINISHED AT TOP & BOTTOM CLOSED WITH CRACKSTICH OR EDGSTITCHED AS PER TECH
WAISTBAND PATTERN SHAPE:

WAIST BANDS ABOVE NATURAL WAIST

WAIST BANDS BELOW NATURAL WAIST

CF

BODICE WAISTBAND

TOP = 15 1/4"
BOTTOM = 14 3/4"

OKAY TO TAPER UP TO 1/8" AT SIDE SEAMS IF NEEDED

SKIRT WAISTBAND

CORRECT

THIS IS WRONG. WHEN SIDE SEAMS ARE JOINED IT MAKES A POINT

F B

JOINED SS IS CONTINUOUS LINE
**ZIPPERS – APPLICATION FOR BIAS GARMENTS:**

TAKE NOTICE TO THE CB ZIPPER OPENING IS SHORTER THAN THE ZIPPER NOTCHED LENGTH

THIS IS BECAUSE THE BODY IS BIAS AND SO WILL GROW DEPENDING ON FABRIC, EVERY FABRIC WILL DRAPE DIFFERENTLY.

THIS CAN ONLY BE DETERMINED BY DRAPING THE BACK ON THE MANNEQUIN TO SEE THE GROWTH.

EX: YOU MAY MARK THE NOTCH AT 17” FROM CB NECK PIN ON THE MANNEQUIN AND IT WANTS TO BE 17 1/2 OR 18”. THAT IS THEN WHAT IT MUST BE, YOU CAN THEN ADJUST TO DESIRED ZIPPER LENGTH

IF YOUR BACK NOTCH IS THE SAME AS YOUR ZIPPER NOTCH YOU WILL MOST LIKELY HAVE BUBBLING AT THE ZIPPER

**ZIPPERS - INVISIBLE:**

MUST BE CLEAN FINISHED WITH BINDING AT TOP AND BOTTOM EDGE OF ZIPPER
TO TOP EDGE: MUST HAVE HAND SEWN HOOK AND EYE AT TOP EDGE

STOPS 1” FROM TOP EDGE: BUT BE TACKED AT TOP OF ZIPPER
**FUSE:**

*WE HAVE SELECTED FUSE OPTIONS FOR SOFT WOVENS: LIGHT WEIGHT, MEDIUM WEIGHT AND HEAVY WEIGHT. THE PCC INFORMATION SHEET FOR EACH WEIGHT IS ATTACHED. ALL SPECIFICATIONS MUST BE FOLLOWED.

*WHITE FUSE SHOULD ONLY BE USED ON WHITE FABRICS. NATURAL AND BLACK SHOULD BE USED TO CLOSEST MATCHING COLOR.

*DTM FUSE SHOULD BE USED ALL ANY TRANSPARENT FABRICS AND FUSED SEAMS

**SOFT WOVEN’S STANDARD INTERFACING OPTIONS:**

*(refer to the Tech Pack for specification)*

- Light Weight Fusible Tricot Knit = PCC style # KF121
- Mid Weight Fusible Tricot Knit = PCC style # KF789
- Heavy Weight Fusible Tricot Knit = PCC style # KF501
- Lightweight Fusible Stretch Woven Option = PCC style # PX313
  * comes in colors
  * good choice for fusible strips when having seam slippage
- Light Weight Fusible Non-Woven = PCC style # KF100
- Mid Weight Fusible Non-Woven = PCC style # KF230
- Heavy Weight Fusible Non-Woven = PCC style# KF240
# Specification Sheet

## GARMENT APPLICATIONS

- Blouses
- Dresses
- Shirts
- Light Jacket
- Heavy Jacket
- Coats
- Raincoat
- Plackets
- Waistbands
- Embroidery
- Special Applications:

## TECHNICAL INFORMATION

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Width</td>
<td>60 inches (152 cm)</td>
</tr>
<tr>
<td>Put-up</td>
<td>200 yards (182.88 m)</td>
</tr>
<tr>
<td>Colors</td>
<td>White, Black</td>
</tr>
<tr>
<td>Total Weight</td>
<td>1.60 oz (54 gsm)</td>
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### Base Fabric
- Construction: Circular Knit
- Fiber content: Polyester

### Adhesive Coating
- Resin type: Polyamide
- Mesh: 22 mesh

### Fusing Conditions
- Fusing method: Electric Press
- Temperature (Fuseline): 240-290°F (116-143°C)
- Time: 12-14 seconds
- Pressure: 3-4 bar

## CARE INSTRUCTIONS

The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.

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# Specification Sheet

## GARMENT APPLICATIONS
- Blouses
- Dresses
- Shirts
- Light Jacket
- Heavy Jacket
- Coats
- Raincoat
- Plackets
- Waistbands
- Embroidery
- Stone wash
- Garment dye
- Special Applications:

## TECHNICAL INFORMATION

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<tr>
<th>Parameter</th>
<th>Value</th>
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<tbody>
<tr>
<td>Width</td>
<td>60 inches (152 m)</td>
</tr>
<tr>
<td>Put-up</td>
<td>200 yards (182.88 m)</td>
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<td>Colors</td>
<td>White, Black, Natural</td>
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<tr>
<td>Total Weight</td>
<td>2.00 oz (58 gsm)</td>
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### Base Fabric
- **Construction:** Circular Knit
- **Fiber content:** Polyester

### Adhesive Coating
- **Resin type:** Polyamide
- **Mesh:** 17 mesh

### Fusing Conditions
- **Temperature (Fuseline):** 240-280°F (116-143°C)
- **Time:** 12-14 seconds
- **Pressure:** 4-6 bar

## CARE INSTRUCTIONS

[Instructions icon]

The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.

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Email: pco@pccousa.com

Date: 3/1/2001  Rev. 1
## Specification Sheet

### GARMENT APPLICATIONS

- [ ] Blouses
- [ ] Dresses
- [ ] Shirts
- [ ] Light Jacket
- [ ] Heavy Jacket
- [ ] Coats
- [ ] Raincoat
- [ ] Plackets
- [ ] Waistbands
- [ ] Embroidery
- [ ] Special Applications
- [ ] Stone wash
- [ ] Garment dye

### TECHNICAL INFORMATION

- **Width:** 60 inches (152 cm)
- **Put-up:** 200 yards (182.88 m)
- **Colors:** White, Black
- **Total Weight:** 1.80 oz/yd² (61 gsm)

### Base Fabric

- **Construction:** Circular Knit
- **Fiber content:** Polyester

### Adhesive Coating

- **Resin type:** Polyamide
- **Mesh:** 17 mesh

### Fusing Conditions

- **Temperature (Fuseline):** 240-280°F (116-143°C)
- **Time:** 12-14 seconds
- **Pressure:** 4-6 bar

### CARE INSTRUCTIONS

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Date: 3/1/2001  Rev. 208
# Specification Sheet

## GARMENT APPLICATIONS

- Blouses
- Dresses
- Shirts
- Light Jacket
- Heavy Jacket
- Coats
- Raincoat
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- Special Applications:

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<td>Put-up</td>
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<td>Colors</td>
<td>White, Grey, Black</td>
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<tr>
<td>Total Weight</td>
<td>1.06 oz (36 gsm)</td>
</tr>
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## Base Fabric

- **Construction:** Thermal-bonded nonwoven
- **Fiber content:** Nylon/Polyester

## Adhesive Coating

- **Resin type:** Polyamide
- **Mesh:** 25 mesh

## Fusing Conditions

- **Electric Press**
  - **Temperature (Fuseline):** 240-290°F (116-143°C)
  - **Time:** 12-14 seconds
  - **Pressure:** 4-6 bar

## CARE INSTRUCTIONS

[Instructions diagram]

*The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.*

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Date: 3/1/2001 Rev. 1
# Specification Sheet

## GARMENT APPLICATIONS

- Blouses
- Dresses
- Shirts
- Light Jacket
- Heavy Jacket
- Coats
- Raincoat
- Plackets
- Waistbands
- Embroidery
- Special Applications:
- Stone wash
- Garment dye

## TECHNICAL INFORMATION

- **Width:** 60 inches (152 cm)
- **Put-up:** 200 yards (182.88 m)
- **Colors:** White, Charcoal
- **Total Weight:** 1.10 oz (37gsm)

### Base Fabric

- **Construction:** Thermal-bonded nonwoven
- **Fiber content:** Polyester

### Adhesive Coating

- **Resin type:** Polysamide
- **Mesh:** 17 mesh

### Fusing Conditions

- **Electric Press**
- **Temperature (Fuseline):** 240-280°F (116-143°C)
- **Time:** 12-14 seconds
- **Pressure:** 4-6 bar

## CARE INSTRUCTIONS

![Care Symbols]

The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.

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### Specification Sheet

#### GARMENT APPLICATIONS

- Blouses
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- Special Applications:

#### TECHNICAL INFORMATION

- **Width:** 60 inches (152 cm)
- **Put-up:** 100 yards (91.44 m)
- **Colors:** White, Charcoal
- **Total Weight:** 140 oyn (47 gsm)

#### Base Fabric

- **Construction:** Thermal-bonded nonwoven
- **Fiber content:** Polyester

#### Adhesive Coating

- **Resin type:** Polymide
- **Mesh:** 17 mesh

#### Fusing Conditions

- **Electric Press**
  - **Temperature (Fuseline):** 240-280°F (116-143°C)
  - **Time:** 12-14 seconds
  - **Pressure:** 4-6 bar

#### CARE INSTRUCTIONS

The above instructions are to be used as a guideline. Because of variables in fabrics and garment manufacturing, we recommend that all fused samples and garments be tested for performance prior to garment production.

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Seam slippage construction:

**ADD PINTUCK STITCH CONSTRUCTION FOR JOINING SEAMS TO PREVENT SEAM SLIPPAGE**

1. Stitch side seams together with 3/8" safety finish (ISO #516)

2. Fold seam allowance and stitch 1/16" tuck through seam allowances only; no stitch should be visible on exterior garment.
Seam slippage construction for collar and yoke seams

Baby hem for seam slippage - must be applied to back neckline

Baby hem
body inside collar

Body

Baby hem for seam slippage

Baby hem
body inside yoke

Body

YOKE CONSTRUCTION FOR SEAM SLIPPAGE ISSUES

UNDER Ply IS WIDER THAN Top Ply

SELF
SEAM SLIPPAGE CONSTRUCTION FOR PLACKET

PLACKET, NECKBAND OR CUFF CONSTRUCTION FOR SEAM SLIPPAGE ISSUES