URBN STANDARDS FOR

UNDERWIRE BRAS & MOLDED CUP BRAS

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WIRES, BONING AND CASINGS

WIRE - 
NON COATED METAL 
WITH DIPPED ENDS

WIRE/BONE CASINGS - 
BRUSHED CASING WITH 
A RIBBON BACKING

OUTSIDE

INSIDE

BONING- 
3/16” FLEXIBLE 
PLASTIC BONE 
WITH ROUNDED 
EDGES
STANDARD WIDTH ELASTICS

BOTTOM OPENINGS - 3/8” SOFT KNIT ELASTIC WITH BRUSHED SIDE AGAINST SKIN

3/8” STRAP ELASTIC WITH BRUSHED SIDE AGAINST SKIN
Bra Findings

**J-Hook**
Hook faces out. This allows wearer to hook strap rings together to switch to racerback styling.

**V-Wire / U-Wire**
Padding must be added to construction for comfort.
**Graduated Cup**

Molded cup with no bump. Padding is slightly thicker @ apex and tapers along the edges.

1.5 MM foam @ neckline and armhole edge
Bump Pad (Cookie or Bra Pad)

Removable or non-removable bottom cup padding usually made of fiber-fill, lightweight silicone or thermoplastic polyurethane (TPU) and filled with air, water or oil.
Bras with removable bump pads must have a hidden internal pocket at the bottom of the cup. The pocket opening can be at the armhole side or center of the cup.
Bump Cup

Molded cup with non-removable bump pad shaped into inside of cup.
Rouleau or Spaghetti Strap

Thin tubes made of fabric, ribbon or elastic, generally 1/8” in diameter. The cylindrical shape differentiates a rouleau from a 1/8” wide ribbon or flat elastic strap.

Strap elastic must be trimmed 1/16” from bartack
BRA LININGS:

*POWER MESH - NYLON/SPAN BLEND WITH STRETCH, USED TO LINE SHEER FABRICS ALL OVER FOR SUPPORT AND OPACITY. FABRIC WEIGHT CAN VARY FROM LIGHT TO MAX SUPPORT

*15 DENIER STRETCH TRICOT (TRICOT MESH) - 100% NYLON WITH MECHANICAL STRETCH, USED TO LINE SHEER FABRICS FOR SUPPORT AND OPACITY. MOSTLY USED ON UNDERWIRE CUPS. ALSO USED FOR SIDE SLINGS ON LARGER CUP SIZES

*15 DENIER STABILIZED TRICOT (RIGID MESH) - 100% NYLON, NO STRETCH. USED AT FRONT AND SIDE CRADLE TO STABALIZE WIRE. CAN BE FUSED TO SELF FABRIC TO ELIMINATE PUCKERING/STRETCHING
Cup Placement at Frame

Cups can be set to the Interior of the frame or the exterior of the frame. Both will always have the felt channeling at interior for the underwire. Bras with no under bust frame will always be set to the exterior.
Construction Options

3 step zig zag stitch OR Merrow & 1 step zig-zag stitch (a.k.a. baby zig-zag stitch): To join body to wider bottom band. Zig-zag stitch is visible at face.
**3 step zig zag stitch** – For armhole, wing top edge & bottom edge elastic. Excellent for joining elastic to a body fabric that has a lace edge. All stitching is visible at face.

**1 step zig-zag stitch, turn & topstitch with 1 step zig-zag stitch** – For armhole, cup top edge & wing top edge & bottom edge elastic. Stitching is less obvious/ visible, only topstitch zig-zag is visible at face.
1 step zig-zag stitch, turn & topstitch with 1/8” gg 2N bottom coverstitch #406 – For bottom edge elastic. Sporty look with 2N stitch only visible at face.

1/4” - 5/16” elastic in turnback, 3/16” gg 2N Bottom Coverstitch #406 – For bottom edge. Sporty/clean look. Good option for when elastic cannot be DTM.
1/8”gg Top & Bottom coverstitch straddling binding edge #602 – For armhole, neckline edge and back top edge. Smooth clean finish, blurs binding edge for clean look. Top & Bottom coverstitch is visible at face.

Clean finish to cup – For contoured cup top edge. Must be joined to a molded cup top edge, cannot be used on non-foam cups. Clean look, no visible stitches.
**SN Topstitch at Binding** – For cup top edge. Limited stretch at top edge, not ideal for fabric cups with a lot of stretch. All stitching is visible.

**2N Bottom coverstitch at Binding #406** – For cup top edge & armhole. Better stretch than single needle version, but more sporty look. 2N stitch is visible.
Clear mobilon or 1/8” tape elastic with 1 step zig-zag stitch – For cup top edge & lace edges that are turning/rolling. Use on a cup that is using the fabric’s lace edge at top edge. Excellent for correcting stretch lace that is turning or rolling – apply elastic tape 1/16” from lace edge. Zig-zag stitch is visible at face but depending on the lace pattern & placement, the stitches are usually hidden.
**Tack fabric to cup in 4-5 places along edge**— For cup top edge. Use on a cup that is using the fabric’s lace edge at top edge. If sewing tension is correct, the stitches are not visible.

**SN Topstitch along edge**— For cup top edge. Use on a cup that is using the fabric’s lace edge or decorative trim at top edge. Stitches can be hidden in trim or in lace pattern.
**Tricot Tape along inside top edge**—For cup top edge. Use on a cup where stretch along top edge is not desired. Can be used on a molded cup with clean finish edge to correct a stretched edge. The visibility of stitches depends on construction.

**Silicone Elastic for Strapless Bras**—Set along top or both Top/bottom edges of strapless styles to keep bra in place. Standard width is 3/8” with 1/8” row of silicone in center. Set on with baby zig zag @ top and bottom edges of elastic through to self.