

FED-STD-751A
AMENDMENT-1
June 23, 1977

FEDERAL STANDARD

STITCHES, SEAMS, AND STITCHINGS

This amendment which forms part of Federal Standard 751A, dated January 25, 1965, was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

PART II. REQUIREMENTS

Under "Section 1. Stitches":

- after drawing of "Stitch type 314", add attached new drawing for "Stitch type 315".
- delete stitch types 512 and 514, and substitute attached new stitch types 512 and 514.

Add new Section 4 as follows:

"Section 4. Stitches per unit length

4.1 Stitches per unit length. Stitches per unit length requirements in Government documents shall be based on the following procedure for counting stitches.

4.1.1 Stitches per inch.

4.1.1.1 Specimen length. The specimen shall be a 3-inch representative portion of a row of stitches. If the row of stitches is less than 3 inches in length, the distance between the first and last needle perforations in the row of stitches shall be the specimen. Whenever a row of stitches follows a curve, the specimen length shall be measured along the curve without straightening or distorting the row of stitches.

4.1.1.2 Procedure. Mark off the specimen length, placing the first mark on the center of a needle perforation. Beginning at the needle perforation following the first mark, count all the needle perforations in the specimen. If any portion of the stitch float following the last perforation, falls within the specimen length, that float shall be counted as an additional perforation. To obtain the stitches per inch, divide the specimen length by the number of perforations counted.

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4.1.2 Stitches per centimeter. Stitches per centimeter shall be determined as in 4.1.1 except that the specimen length shall be 10 centimeters".

Custodians:

Army - GL
Navy - SA
Air Force - 99

Review activity:

DLA - CT

User activity:

Navy - MC

Preparing activity:

Army - GL

Civil Agency Coordinating Activities:

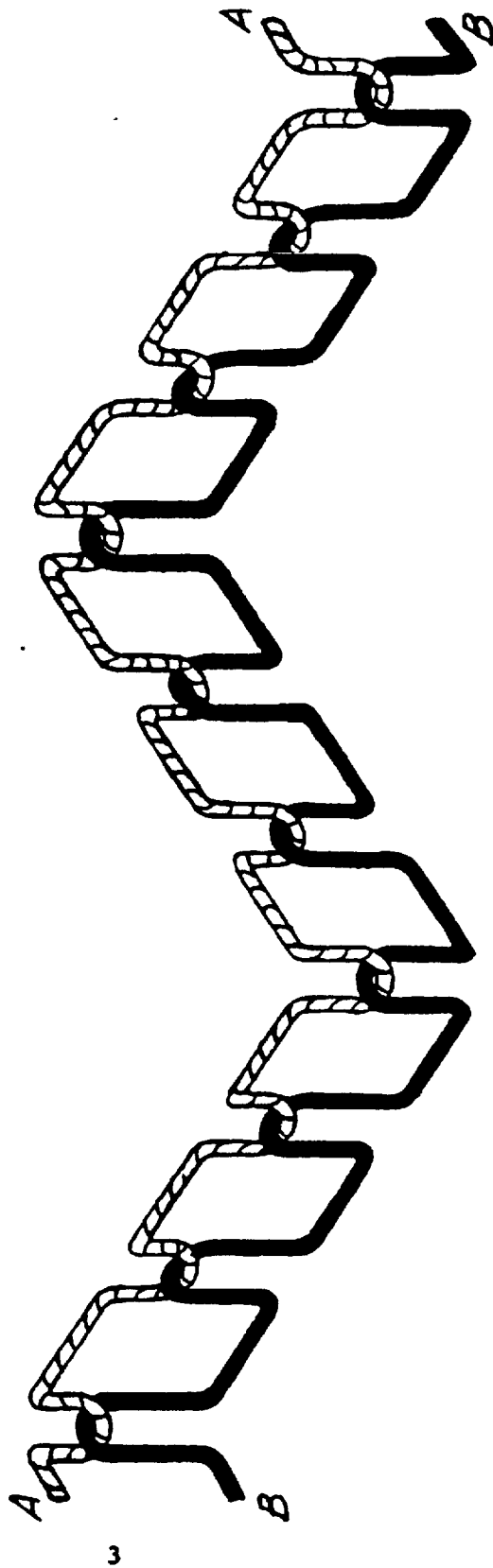
GSA - FSS
HEW - HSM

Project No. 83GP-0343

Stitch type 315

This type of stitch shall be formed with two threads: one needle thread, A, and one bobbin thread, B. This stitch type is the same as stitch type 304 except that successive groups of three stitches form a symmetrical zig-zag pattern.

DIRECTION OF SUCCESSIVE STITCH INFORMATION



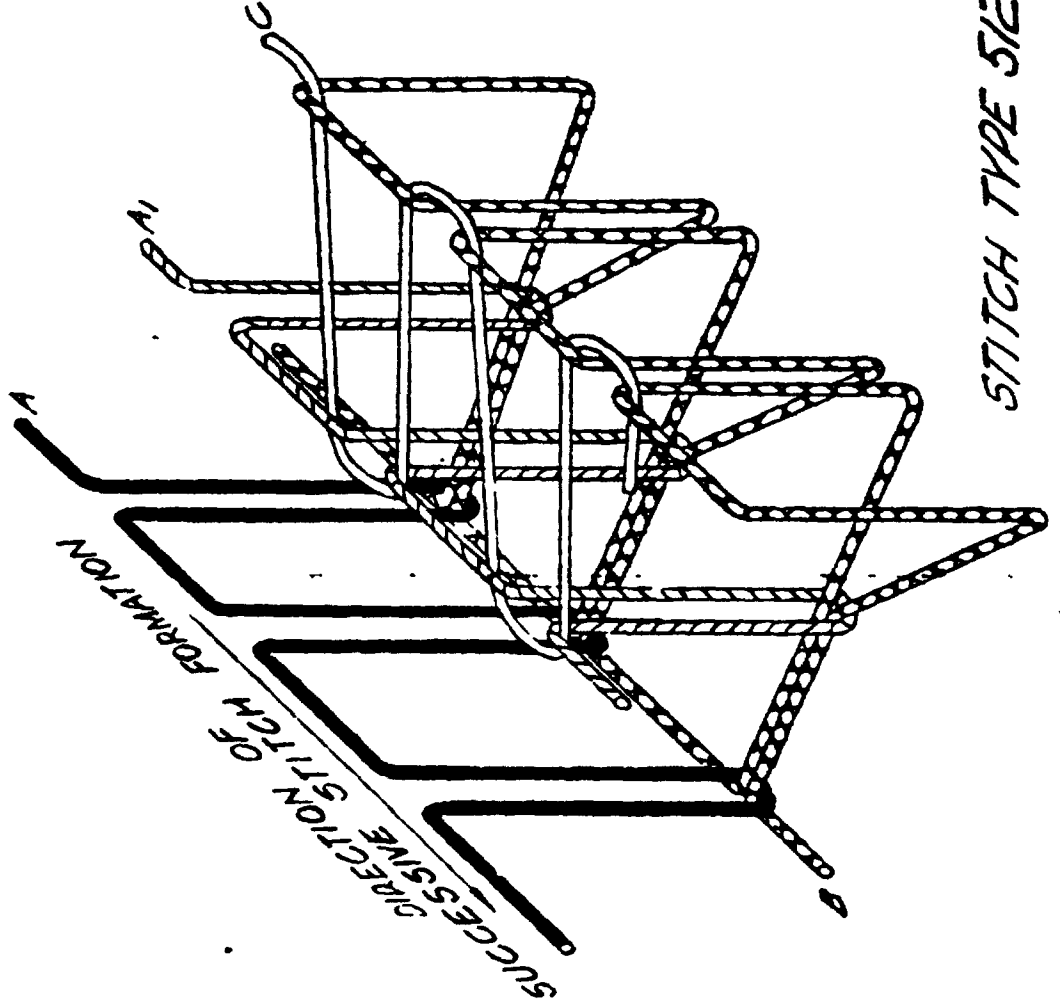
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Stitch type 512

This type of stitch shall be formed with four threads: two needle threads, A and A'; one looper thread, B; and one cover thread, C. Loops of threads A and A' shall be passed through the material where they shall be interlooped at the lower point of penetration with

thread B. The loops of thread B shall be brought around the edge and interlooped with loops of thread C. The loops of thread C shall be extended to the point of needle penetration of thread A' at the next stitch where they shall be entered by loops of that thread.

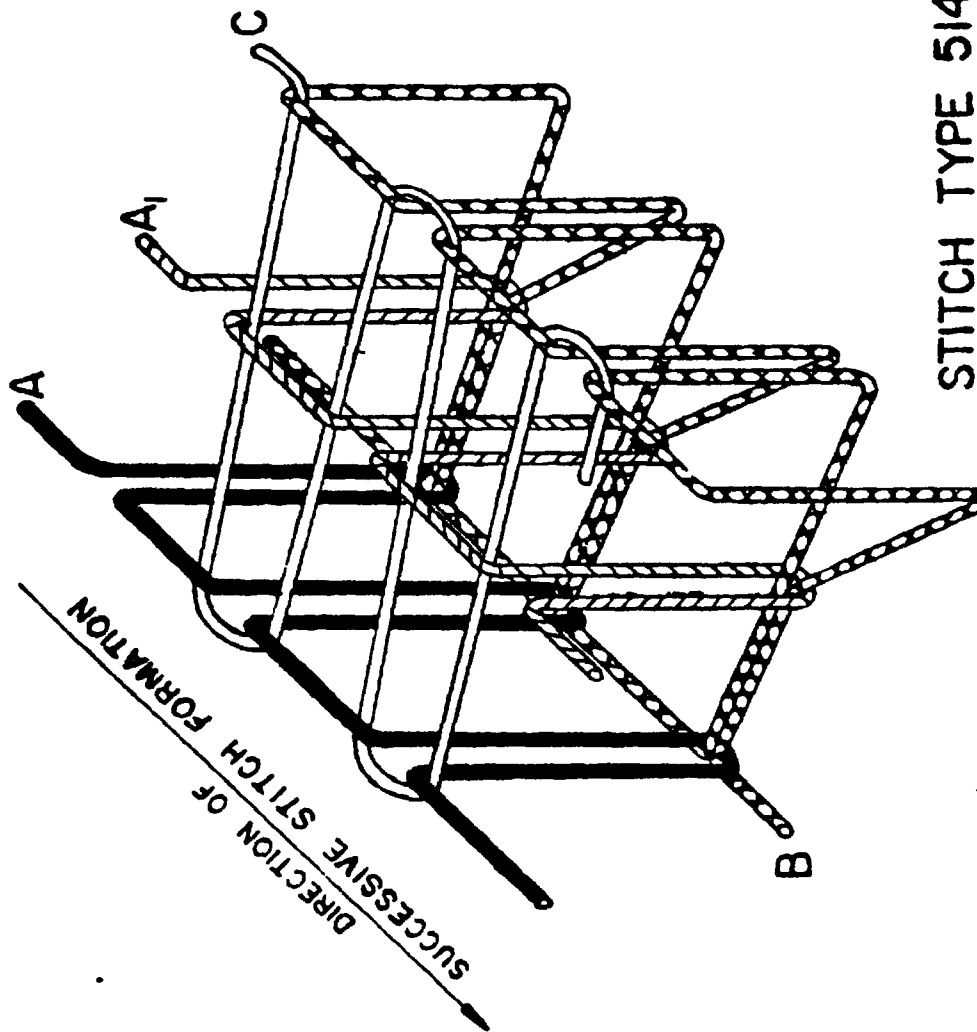


STITCH TYPE 512

Stitch type 514

This type of stitch shall be formed with four threads: two needle threads, A and A'; one looper thread, B; and one cover thread, C. Loops of threads A and A' shall be passed through the material where they shall be interlooped at the lower point of penetration with loops of thread B. The loops of thread B shall

be brought around the edge of the material and interlooped with loops of thread C. The loops of thread C shall be extended to the point of needle penetration of threads A and A' at the next stitch where they shall be entered by loops of these threads



STITCH TYPE 514