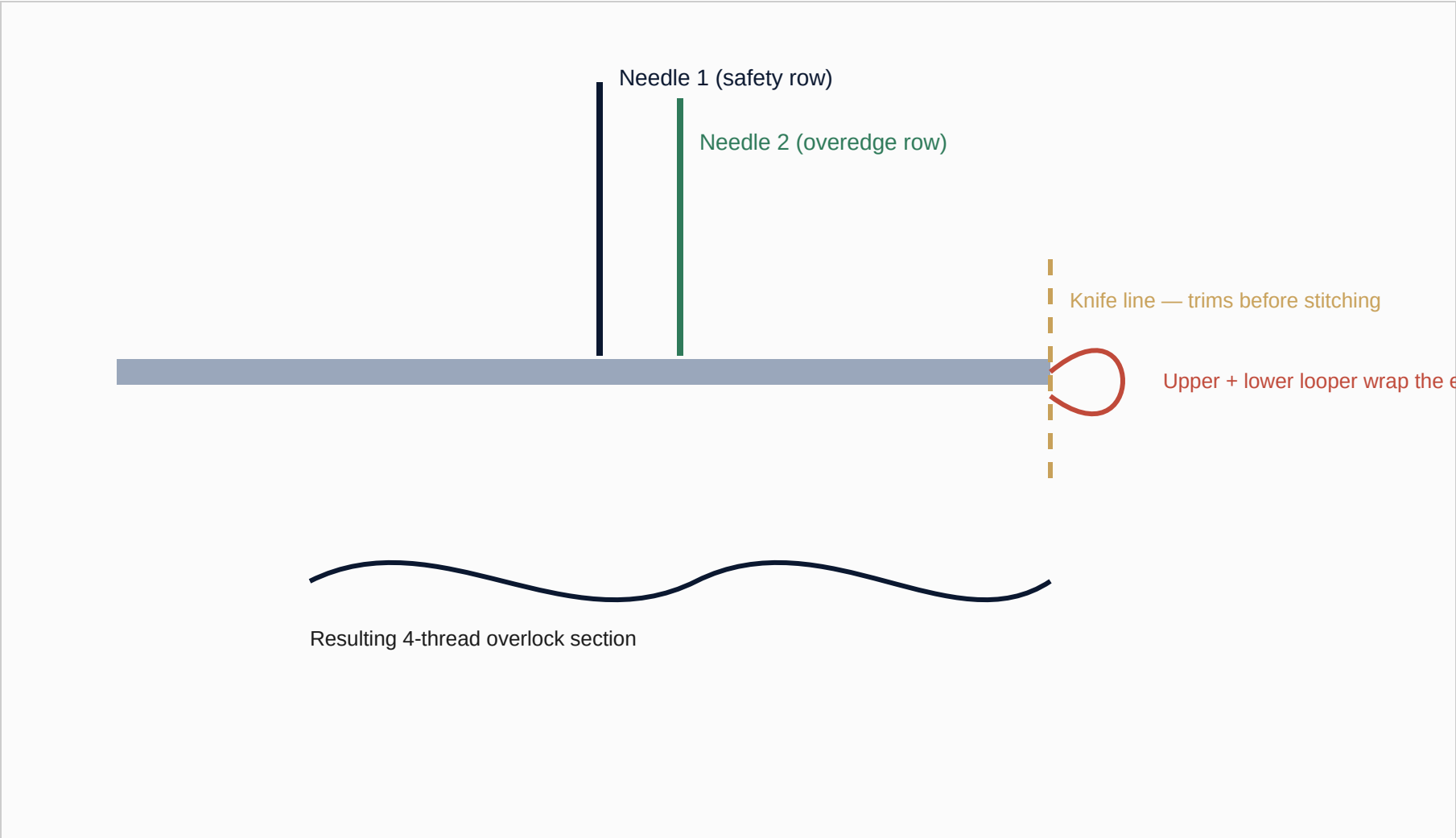


Machinery diagram — 4-thread overlock

Two needles, two loopers and a knife: how the safety-stitch seam is built.



Stitch / cycle sequence

- 1 The knife trims the edge to a constant seam allowance.
- 2 Needle 1 forms the inner safety row that carries the load.
- 3 Needle 2 forms the outer row that holds the wrap.
- 4 Upper and lower loopers wrap threads around the cut edge.
- 5 Differential feed controls stretch or pucker on knits.

Baseline settings

Seam allowance	5 – 6 mm after trimming
Stitch density, jersey	12 – 14 stitches per inch
Needle	Ball point 75/11 – 80/12
Differential feed, jersey	1.0 – 1.3 to stop wavy seams
Common defect	Rope seam = looper tension too tight