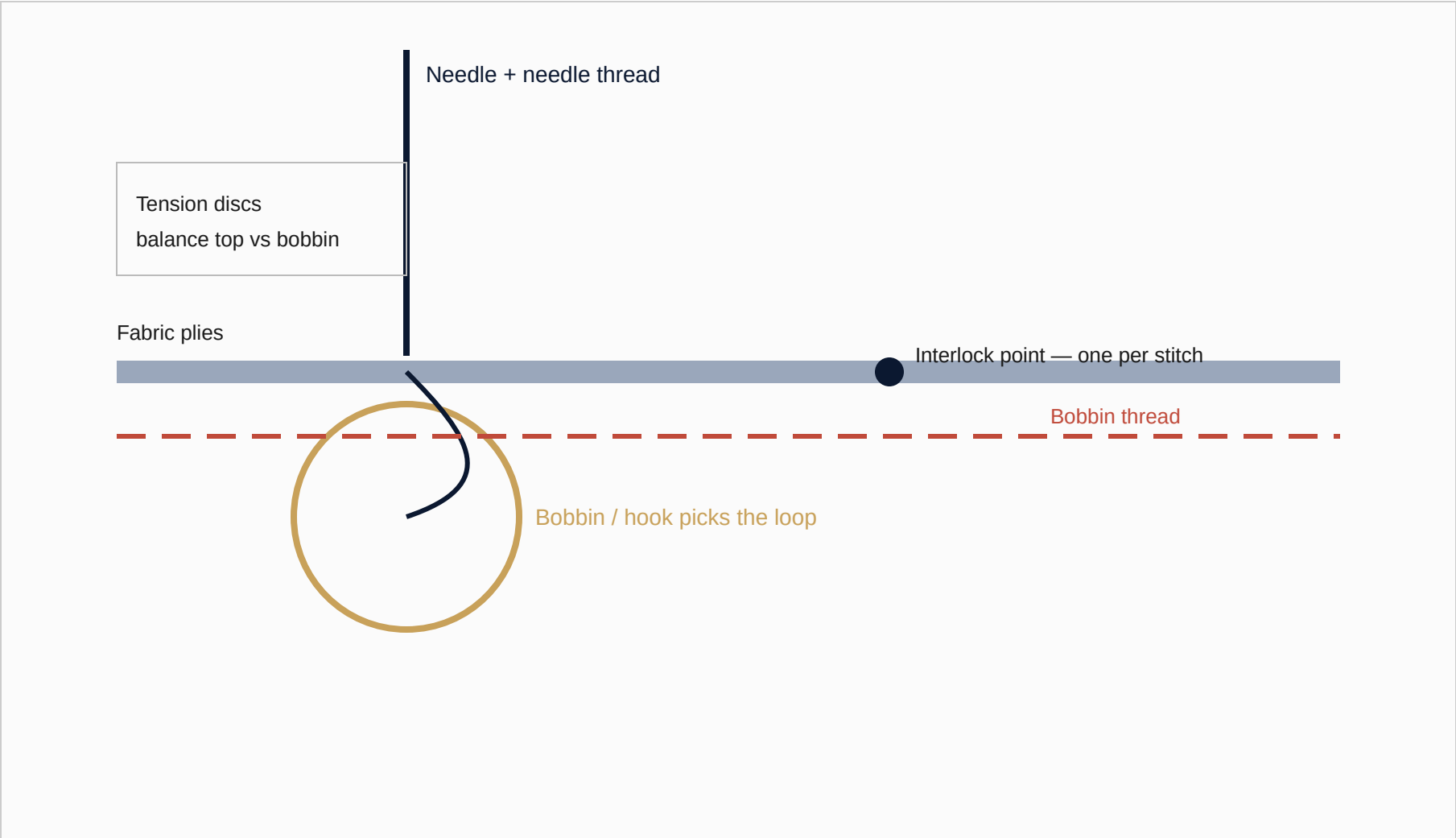


Machinery diagram — lockstitch formation

How a single-needle lockstitch (class 301) is actually formed, with baseline settings.



Stitch / cycle sequence

- 1 Needle carries the top thread down through both plies.
- 2 Needle rises slightly and a loop forms behind the eye.
- 3 The rotating hook or bobbin case picks that loop.
- 4 The loop is carried around the bobbin thread and interlocks.
- 5 Take-up lever pulls the stitch tight; feed dog advances the fabric.

Baseline settings

Stitch density, shirting	10 – 12 stitches per inch
Needle, light woven	Sharp 70/10 – 80/12
Thread balance	Interlock centred between plies
Presser foot pressure	Lightest that stops ply slip
Common defect	Skipped stitch = worn needle or wrong point