



Invisible Opti Zips



Woven tape



Knitted tape



Drop

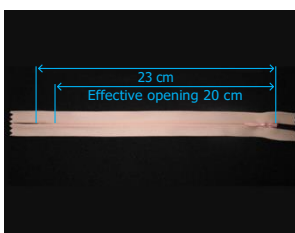


Doughnut



Triangle

Invisible zips insertion techniques



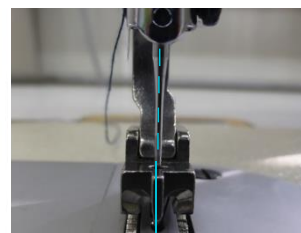
1) A concealed zip gives an effective opening approximately 2.5 cm less than its length. Thus for a 20 cm opening a 23 cm zip is required.



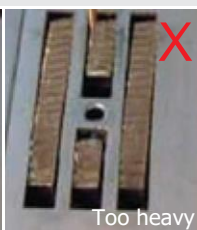
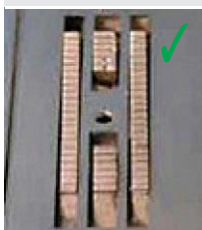
2) Do not iron. Heat or pressure can damage the teeth of the zip.



3) The correct grooved foot for invisible zips must be selected. The nose and the channels are there to help keep the teeth vertical while stitching.



4) The sewing foot should be centered properly by aligning the needle to the centre fin.



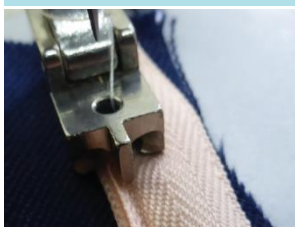
5) A balanced feed dog should be selected to obtain optimum appearance of the seam. This feed type will allow uniform pressure to be applied to the fabric and the zip, regardless of which side of the zip is sewn.



6) Turn the zip with puller to the fabric and fully open it. Align the edge of the zip tape to the selvedge of the garment panel.



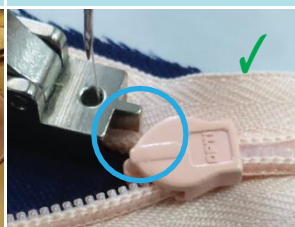
7) Unfold the spiral teeth to be at right angles to the tape and lower the channel of sewing foot over the spiral as shown, with the nose of the foot above the top stop.



8) Once the grooved foot is positioned, commence sewing, back tack for approximately 5 mm to secure the end of the zip.



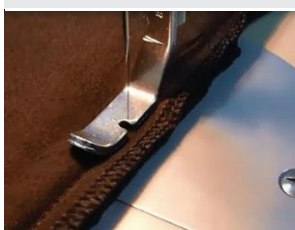
9) Sew along the length of the zip, repeating on both sides. Back tack for approximately 5 mm.



10) The correct stop position is 2 mm before hitting slider.



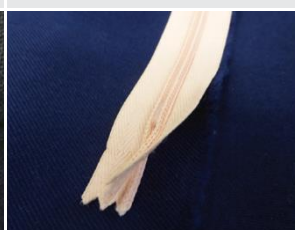
11) The incorrect stop position is when the sewing foot is hitting the slider.



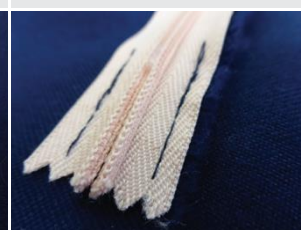
12) Use a half foot to close the seam below the zip.



13) Stitch as near as possible to the zip insertion seam, overlapping by 5 mm, back tack to secure.



14) Note that approximately 4 cm of the bottom of the zip will be unattached at this stage. The bottom tape extensions of the zip should be secured to the fabric on both sides. Otherwise seam failures are possible.

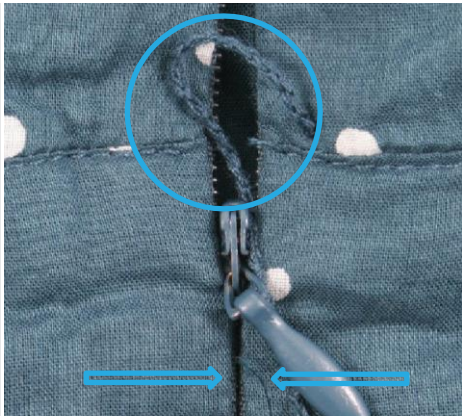
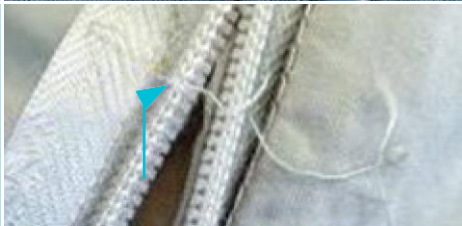
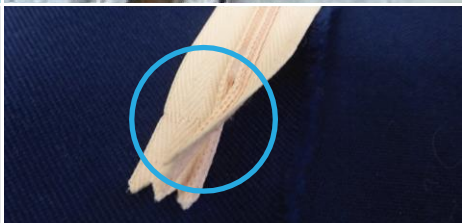


How to avoid frequently made mistakes in sewing Invisible zips

We strongly recommend to use dedicated feet for invisible zips which always deliver the correct result

Stitching problem	 Fabric Stitched to zip teeth	Using half sewing foot can lead to incorrect stitching and the fabric getting caught in the path of the slider, thus dislodging it.
Stitching problem		Care should be taken to not stitch through the zip's teeth, to avoid slider jamming and damaging the tape.
Needle damage		Not using proper grooved foot may lead to teeth damage by the needle.

Care should be taken at design stage when invisible zips cross side seams or go through the waistband

Materials in the path of the slider		Stitching should allow room for slider to run with ease, especially where cross seams and panel seams are forming multilayer fabric construction. No loop cords or labels which may jam the slider.
Loose threads		Care should be taken to cut away all loose threads to prevent the slider from jam and failure.
Loose tape ends		Do not leave the zip tape ends loose. Fix them to the seam allowance.

Products				
	S43 (#2)	S44 (#2)	S54 (#4)	S64 (#5)
Chain width	4 mm	4 mm	5 mm	6 mm
Tape type	Polyester knitted tape	Polyester woven tape	Polyester woven tape	Polyester woven tape
Main uses	<ul style="list-style-type: none"> • Lightweight skirts • Lightweight dresses • Lightweight ladies trousers • Lightweight sportswear 		<ul style="list-style-type: none"> • Skirts • Dresses • Slacks/Ladies trousers • Sportswear • Pockets and sleeves of down/wadding jackets • Bedding 	
Suitable fabric weight	<100 gr/m2, light fabrics, knitted or woven, without lycra	<140 gr/m2, light fabrics, knitted or woven, without lycra	140 - 220 gr/m2, knitted or woven fabrics, with or without lycra	>220 gr/m2, knitted or woven fabrics, with or without lycra
Standards	Certified to Öko-Tex Standard 100, Class 1.			
	Standard, Class A Ultra light (BSI3084) or Class ½ (ASTM)	Standard, Class B Light weight (BSI) or Class ½ (ASTM)	Standard, Class B Light weight (BSI) and Class 3 (ASTM)	
Sewing grooved foot	Article C4PAM	Article C4PAM	Article S5PAM	Article FOOT270
Care Information	Invisible zips are not recommended for use in heavy washed denim and leather garments.			
	<ul style="list-style-type: none"> • Not suitable for the tensions that occur in the waist and hips side openings of the garments • Care should be taken to allow room for slider running where cross seams and panel seams are forming multilayer fabric construction: <ul style="list-style-type: none"> - through the waistband style in trousers or skirts - in dresses with side seams/ruffles/layers or pleats joining at the seam position of the zip - where the pocket seam joins midway along the zip seam 		<ul style="list-style-type: none"> • Suitable for use in the side openings of waist and hip areas • Can be used in waistband and panel seam areas with multilayer fabric construction 	
			Can be used in garments made of fabrics with lycra	<ul style="list-style-type: none"> • To be preferred in garments made of fabrics with lycra • Can be used in bedding, avoiding sharp turns and corners
Floating bottom stop	<p>The additional floating bottom stop can be moved along the zip length and positioned as necessary, depending on the required effective opening length. When adjusted to just above the seam bartack it prevents:</p> <ul style="list-style-type: none"> - Damage of the seam, fabric or lining - Slider jamming - Puller is easily accessible with no risk of entering under the seam - No extra unplanned labour cost for the garment manufacturer - Reduced faulty seam risk on the garment <p>This flexible solution is available for all invisible zip sizes, bringing added satisfaction to the end user.</p>			