

GLOSSARY OF DEFECT TERMINOLOGY USED IN THE GARMENT INDUSTRY

This glossary has been compiled as a reference to establish a common language of defect terminology understandable to the garment manufacturer and to his supplier. The breakdown of the categories is as follows:

- I. Cutting Room Defects
- II. Sewing Room Defects
- III. Finishing Room Defects
- IV. Closure Defects
- V. Thread Defects
- VI. Interlining Defects
- VII. Machinery Defects

Inasmuch as so many defects can be the result of error in more than one category, repetition of terms is unavoidable. Still again, as the interpretation of the defect cause may vary with the individual, for a complete understanding, it is suggested that all sections possibly related be studied. It is recognized that many defect terms listed in the glossary cannot readily be detected by all manufacturers; yet, their exclusion would make the glossary incomplete.

A number of photographs have been included to illustrate some of the most obvious defects.

I.

Glossary of Cutting Room Defects

Pattern Grading Defects

1. Grade Not Conforming to Specification (measurements):
Finished product not measuring to specified dimensions and component parts not fitting in relationship to notches, openings and seams such as armholes, sleeve heads, neck bands, neck openings, side seams, inseams, waist measurements and etc.
2. Distorted Grading:
Unbalanced patterns which would cause twisted seams, puckering, pleating and a general uneconomical yardage waste.

Marking Defects

1. Shaded Parts:
All component parts not included in same section.
2. Pieces not Symmetrical:
Will not sew together without puckering or pleating.
3. Not Marked by Directional Lines:
Bias will not fit together, causing twisting, puckering, pleating and a general mismatching of component parts.
4. Skimpy Marking:
Marker did not use outside perimeter of pattern. Pattern moved after partially marked to fit into space.
5. Notches and Punch Marks:
Left out, not clearly marked or misplaced.
6. Marker Too Wide:
Parts will not catch in lay, causing skimpy garments or requiring recuts.
7. Marker Too Narrow:
Results in wasted material.
8. Mismatched Plaids:
Marker did not block component parts to match.
9. Misdirected Napping:
Patterns not marked in same direction on napped fabrics.

Spreading Defects

1. Uneven Spreading:
Front edge of lay is not even, resulting in front or back edge of marker not catching all plys.
2. Narrow Material:
Bolts or rolls of material too narrow to cover marker width.
3. Missed Sectional Breaks:
Sectional marker breaks too long or too short. Parts in lay will be short or material wasted.
4. Improper Tension:
Cloth spread too tight or too loose, causing parts not to fit in sewing or distorting dimensions of garments.
5. Mismatching Plaids:
Material spread too loose or too tight, causing plaid lines to run diagonally or bow.
6. Misdirected Napping:
Air pockets not removed. Napped material reversed in spreading.
7. Improper Matching of Face of Material:
Not spread face down, face up or face to face as required.

Cutting Defects

1. Marker or Perforator:
Not stapled or stencilled on lay to catch both edges, causing parts to miss in cutting. Too tight or too loose, distorting dimensions of garment. Perforated stencil not powdered, or inked, sufficiently to show distinct lines, notches and punch marks.
2. Misplaced Piece Rate Tickets or Bundle Members:
Attached to, or marked on, wrong bundles, causing mixed sizes or/and shades.
3. Drill Marks:
Drill marks misplaced, not perpendicular, omitted or wrong side drill used.
4. Opening Slits:
Cut under, above, to the side or at incorrect angle. Not cut through entire bundle or omitted.
5. Improper Cutting:
Not following marker lines, resulting in distorted parts. Letting knife lean, causing top and bottom plys to be of different sizes.
6. Notches:
Misplaced, too deep, too shallow or omitted.
7. Oil Spots:
Equipment improperly oiled or cleaned.
8. Improper Knife Sharpening:
Causing ragged, frayed or fused edges on bundles.
9. Knife or Scissors Cut:
Piece damaged by over run in cutting previous piece.

Shade Marking Defects

1. Pencil or Machine Marking:
Too dark, too light, bleeding through, not legible or marked on wrong side.
2. Stains:
Ink stains from stamping or pin ticket machines.
3. Thermoply or Pin Ticket Marking:
Improperly placed or marked.

4. Mixed Plys:
Results in mixed shades.

Take Off and Bundling Defects

1. Not Stacked in Numerical Order:
Bundle numbers not in order on rack, skid or box.
2. Matching Linings:
Wrong size or wrong material.

II.

Glossary of Sewing Room Defects

1. Scissors or Knife Cut:
Self-explanatory.
2. Tear:
Usually the result of excessive strain or snagging on manufacturing machinery.
3. Needle Chew:
Caused by use of wrong or blunt needle or machine feeding difficulty.
4. Incorrect Material Shading:
Where components do not match exactly as to shade.
5. Spots or Stains:
Normally the result of a defective machine or a dirty work area.
6. Loose Threads:
Can be caused either by malformed stitching or poor trimming techniques.
7. Puckered Seams:
An irregular seam surface usually caused by a) inherent fabric characteristic, b) needle puncture, c) machine feed slippage or d) incorrect machine application.
8. Pleated Seams:
Caused by incorrect machine attachments, machine sewing parts too large or small for fabric or seam desired, irregularly cut patterns or fabric irregularities and operator feeding fabric faster than normal feeding action of the machine.
9. Thread Breaks:
Wrong thread application, sewing machine malfunction, defective thread.
10. Insecure Backstitching:
Original stitch row not covered with second seam.
11. Wrong Shade of Thread:
Either caused by basic purchasing error, manufacturing defect by thread supplier or operator selecting wrong color from thread bin.
12. Irregular Gauge of Stitching:
Not using correct sewing machine or using single needle machine where a multiple needle machine is required.
13. Open Seams:
Incorrect folder or poor operator technique. Sometimes results from poor selection of type of seam for fabric used or purpose of seam in garment.
14. Run Offs:
Operator not following marking or not using mechanical aids such as edge guides to assure uniform stitching.
15. Wrong Seam or Stitch Type:
Management error in selection—or operating personnel failing to follow specifications.
16. Loose Thread Tension:
Tensions not adjusted correctly by operator.
17. Tight Thread Tension:
Same as above.
18. Wrong Stitches Per Inch:
Normally caused by operators who lengthen stitch to increase machine speed.
19. Skipped Stitches:
Caused by machine malfunction or excessive needle heat due to friction.
20. Broken Stitches:
Often times the fault of wrong type of stitch for specific seam construction. Could be caused by excessive tightness in machine tensions.
21. Closures Omitted:
Normally an oversight by operators or failure by inspectors.
22. Closures Misplaced:
Inattention or inexperience by operating personnel, or improper alignment with gauges.
23. Finished Components Not Measuring to Tolerances:
Could be caused by faulty pattern, cutting, previous operations in stitching or by indifferent operator attention to the specified tolerance.
24. Dimensions out of Tolerance:
Same as above.
25. Notches Exposed:
Poor operator technique and execution, in not covering notch with seam.
26. Omission of Any Part of Garment:
Poor work flow, inattentive operator, wrong work tickets or poor inspection.
27. Twisted Seam:
Caused by improper alignment of fabric pieces, uneven tension or pull on plies being stitched.
28. Pieces Not Aligned:
Pieces sewn together not matched to each other.
29. Reversed Pieces:
Where piece is sewn with face side opposite from specification; where part cut for one side of garment sewn in other.
30. Excessive Fullness:
Caused where piece surface not smoothed prior to stitching.
31. Uneven Edge:
Where stitching not straight or improperly formed in creasing machine.
32. Ragged Edges:
Usually occurs where knives on automatic buttonhole machines do not clip smoothly.
33. Uncut Buttonhole:
Where knife failed to cut buttonhole.
34. United Stitches:
Where tying stitches on automatic machines fail to secure.
35. Hole:
Damage caused by faulty machine or related equipment.
36. Faulty Gauging:
Where operator has not sewn seam to specified margin.
37. Misaligned Closure:
Closure components do not line up.
38. Misplaced Component:
Where part not positioned according to specifications.
39. Misaligned Seam:
Where seams do not line up or cross specified point.
40. Mislocated Reinforcement:
Where bartack or brad not in proper location.

41. **Uneven Stitch:**
Caused by operator speeding up machine too rapidly or by holding back or pushing fabric through machine in variance with correct machine feed.
42. **Needle Pick:**
Failure of operator to replace a dull needle.
43. **Caught Piece:**
Where a component part of a garment has been caught in an unrelated operation.

III.

Glossary of Finishing Department Defects

Trimming Defects

1. **Thread not Trimmed or Threads not Trimmed to Specified Length:**
Self-explanatory.
2. **Cuts or Nicks:**
Caused by indifferent handling of scissors, snips or mechanical trimmers.
3. **Seam Tears:**
Frequently caused by the turning equipment used to reverse garments in finishing.
4. **Soil:**
Caused by oil, grease or dirt. Often times originating from a dirty work area or machinery not properly cleaned.
5. **Streaks:**
Markings caused by some types of turn boards or defectively finished trimmings.

Pressing Defects

1. **Pressing Omitted, Burned or Scorched Garments:**
Self-explanatory.
2. **Inadequate Pressing:**
Excessive heat or pressure resulting in poor pleating, fullness or twisting of a seam or garment surface.
3. **Garments not Thoroughly Dried:**
Resulting in excessive wrinkling of garment.
4. **Improper Pressing Over Zippers or Other Closures:**
Often produces a tear or unsightly impression on the face of the garment.
5. **Pockets or Linings not Pressed Correctly:**
Causing wrinkles or ridges to appear on the surface of the garment.
6. **Pressing Producing a Shine in Fabric:**
Usually caused by excessive heat or incorrect type of pressing surface.

Folding Defects

1. **Garment not Folded to Specifications:**
Self-explanatory.
2. **Garment not Folded with Proper Materials:**
Cardboard, tissue or other specified packaging materials omitted.
3. **Pins or Folds in Garment Incorrect:**
Pins in wrong location or folds not correctly aligned for package.
4. **Garments not Buttoned, Folds not Closed, Incorrect Number of Pins:**
Self-explanatory.
5. **Label not Showing:**
Garment not positioned in package to show label on top surface.

Final Inspection Checks

1. **Proper Hang Tag and Fiber Identification not Applied:**
Omission of fabric contents violates Fiber Product Identification Act. Hang tag and label should correspond.

Packaging

1. **Use of Correct Container:**
The package itself must be suitable for the use to which it will be put, i.e. shipping, consumer display, etc.
2. **Position of Garment in Package or Box:**
Must be sufficient for shipping and possible display depending upon the tradition of merchandising of the individual type garment in question.

IV.

Glossary of Closure Defects

ZIPPERS

Slider Defects

1. **Won't Lock:**
Not apparent without testing by placing zipper slider in locked position and applying tension.
2. **Faulty Dimensions:**
Not readily apparent. May cause either a hard or a loose operating zipper. Either condition may result in zipper failure before garment is worn out.
3. **Crushed Slider:**
May be due to improper garment pressing or to padding or compensating springs in the presses not being in best condition.
4. **Tarnished:**
Does not generally interfere with operating qualities, but is a matter of appearance only. Judging this as a defect depends upon degree of tarnish.
5. **Burrs or Rough Spots:**
Not immediately apparent. Can cause snagging and early wear on the zipper tape.
6. **Lock Prong Interferes:**
Indicated by pull-tab not staying in locked position or slider not moving freely after being released from locked position.
7. **Weak Slider Bodies:**
Can best be determined with proper testing equipment. However, manifests itself by slider becoming compressed or crushed under minimum pressure or becoming distorted enough to create hard operation.

Chain or Teeth Defects

1. **Improper Dimensions:**
Not always apparent unless slider works with great difficulty or operates too easily. Zipper may give initial satisfactory operation but fail after only moderate use and especially after laundering or dry cleaning.
2. **Mismeshed and Unmeshed Teeth:**
Readily visible, particularly in large sizes. Usually results in inoperable zipper.
3. **Missing Teeth:**
Readily visible, particularly in large sizes. Will result in early failure of the zipper.
4. **Misplaced Teeth:**
This refers to a tooth being out of position, and occasionally may involve two or three teeth. Seriousness ranges from trifling to almost as serious as a missing tooth, depending upon degree of misplacement and general design of zipper. (By the latter, we refer, as an example, to a tooth that is symmetrical, being less prone to damage in this type of defect than is a non-symmetrical tooth.)

5. **Humpy Chain:**
Readily noticeable by its waviness. Causes difficulty at sewing operation and distorts finished garment's appearance.
6. **Curved or Crooked Chain:**
Same comment as with humpy chain.
7. **Discoloration:**
Varies in degree and quite noticeable in extreme condition.
8. **Exposed Cord:**
Not readily visible. Results from legs of teeth not completely covering or clamping around the cord. Except for what appears in slight degree, exposed cord tends to cause hard operation and weakness of the zipper under strain.
9. **Cord not Attached to Tape:**
Due to skipped stitches during operation of sewing cord to tape. Not readily apparent but, under strain, cord and teeth will rip away from tape and render zipper and garment unusable.
10. **Length:**
Improper zipper length for given opening.

Top or Bottom Stop Defects

1. **Missing Top or Bottom Stop:**
Readily apparent and will result in zipper failure. If facilities for attaching a top or bottom stop are not available, then the entire zipper should be replaced. In some instances, bottom stops are attached at garment plant. An improperly or poorly attached bottom stop may be result of carelessness on part of the operator or of improper functioning of the bottom stop machine.
2. **Improper Dimensions of Top or Bottom Stop:**
Not readily apparent. Results in stop pulling away from fabric and may cause zipper to jam. May not be evident until the garment is in use.

Tape and Cord Defects

1. **Color not Fast:**
Fastness must be suitable to the garment but not necessarily to the same degree as the garment material. Fastness to laundering and dry cleaning must be sufficient to not stain other parts of garment. Can be determined only by testing. Damage from lack of fastness will be apparent only after consumer use.
2. **Holes and Cuts:**
Easily discernible and seriousness depends on size and location. Holes and cuts on the inner stitch line or between the inner stitch line and the teeth are serious. Those beyond the inner stitch line are minor in importance except as they may affect the appearance of the finished garment.
3. **Uneven Edge:**
This is a minor appearance defect, except that with some tape constructions it is evidence of a possible unevenness on the opposite side to which the teeth are attached and, in this case, could cause serious physical weakness. This is especially pertinent where the cord is sewn to the tape rather than woven in at the time of manufacture.
4. **Narrow or Varying Width:**
This presents a problem only at the sewing operation and generally when a double needle sewing operation is used. Narrow tape permits outer row of stitching to run off the edge and, although not serious, it doesn't provide maximum strength and mars the appearance. If tape is too wide beyond the outside row of stitching, it may mar the appearance and, in addition, may fold over and catch in the slider when the zipper is opened or closed.
5. **Reeding:**
Yarn slippage not apparent except under test. Will reduce the life of the zipper.

6. Off-color:

This defect is quite apparent. Zipper manufacturers normally carry a complete range of tape colors. Due to similarity of different colors, one may be mistaken for another. It is also possible, because of color similarities or difference in dye lots, that the two halves of the zipper will have two different shades of tape.

NYLON SPIRAL ZIPPER

Slider Defects

1. **Won't Lock:**
Same as for metal zippers.
2. **Crushed Slider:**
Same as for metal zippers.
3. **Lock Prong Interferes:**
Indicated by slider not moving freely downward from locked position.
4. **Weak Slider Bodies:**
Same as for metal zippers.

Coil Defects

1. **Mismeshed and Unmeshed Coil:**
Unmeshed chain below the slider, except when caused by inadvertent coil damage, can be re-engaged by operation of the slider over the disengaged portion.
2. **Coil not Securely Attached to Fabric:**
Due to improper stitching or to mechanical damage to stitching. Slight irregularities of stitch pattern are not serious but, if more than one consecutive convolution is not secured, failure early in life of garment is likely.

Top or Bottom Stop Defects

1. **Missing Top or Bottom Stop:**
Readily apparent and will result in zipper failure.
2. **Improper Dimensions of Top or Bottom Stop:**
Not readily apparent. Results in stop pulling away from fabric.
3. **Improperly Located Stop:**
If top stop or bottom stop does not contain the end of the coil, it will permit coil to loosen from fabric, interfering with slider operation.

Tape and Cord Defects

Same as for metal zippers except Point 3 does not apply.

Metal Buttons

1. **Improperly Attached:**
This may be due to lack of sufficient reinforcement at point of attachment, material at point of attachment too thin or too thick, or material at point of attachment not even, i.e., several thicknesses under part of closure and less than that under other part, or improper attaching machine adjustment.
2. **Misplaced:**
This may be due to operator error or lack of proper positioning gauges.
3. **Marred or Defaced:**
This may be caused by improper finishing in button manufacturing process, by overloading of hoppers on attaching machine or by improper attaching dies.
4. **Tarnished or Off-color:**
May be caused by improper finishing in button manufacturing process or by buttons being held in stock too long. Certain fabric finishes and dyes react unfavorably on metal plating. Nickel plating is most capable of resisting chemical reaction.
5. **Damaged or Crushed:**
May be due to lack of padding or compensating

springs in presses. Springs and padding should be checked frequently to make sure that they are in proper condition.

Snap Fasteners

All defects listed under Metal Buttons also apply to Snap Fasteners. In addition, the following items should also be considered:

1. Hard Action:

In light-weight goods, this may result in stud or socket pulling through the material. The snap fastener manufacturer can be of help in recommending proper tension of stud in socket for weight of garment material.

2. Light Action:

Snap fastener does not stay closed because of lack of proper tensions. Same comment applies as for tight closure.

Rivets & Burrs

The first four points listed in reference to Metal Buttons also apply in regard to Rivets and Burrs.

Hooks & Eyes

1. Improperly Applied:

This is usually caused by a careless operator or improperly adjusted attaching equipment, and corrections are usually simple when apparent.

2. Improper Alignment:

Gauges are available for attaching equipment to assure proper alignment in positioning. This is a necessity if garment is to have a properly tailored look. If the top of the zipper is extended into the waistband of the trouser, then the hook and eye should be offset to prevent it from hitting the zipper material.

3. Poor Finish:

May be the result of improper finishing or pocking of the metal surfaces and, while this defect does not interfere with the functional operation, it may not leave the desired finished appearance of the garment. Improper plating could result in rust if exposed to dampness.

4. Tight Closure:

Attaching equipment is fitted with an adjustable feature permitting secure application of hook and eye to either light or heavy-weight goods. If closures seem too tight, then one should immediately check the attaching equipment for proper adjustment.

5. Loose Closure:

Same comment as with Tight closure.

Plastic Buttons

1. Undercure:

Not apparent without testing in laboratory. Causes lack of compressive strength and poor resistance to washing and ironing.

2. Faulty Material:

Same comment as with Undercure.

3. Extreme Variations in Thickness:

Button functionally satisfactory but will probably cause a problem if automatic button feed is used.

4. Incompletely Formed:

A rare defect and is usually caught during button manufacturing process.

5. Sharp Edges:

Vitaly important not to have sharp edges if automatic feed is used.

6. Flash Adhering to Button:

Same comment as with Sharp edges.

7. Soiled:

May be caused by dirty containers or careless handling.

8. Rough or Dull Surfaces:

This is not a serious fault except in cases of extreme roughness or poor surface appearance.

9. Thin and Weak Where Thread Bunch Occurs:

This is not common but generally causes breakage at the bridge.

10. Non-Uniform, Inaccurately Spaced, Chipped or Blocked Sew Holes:

This type of defect is sometimes not noted during the garment manufacturing operation and can slip past inspection unnoticed, but it frequently causes needle breakage or cut thread.

11. Non-Uniform Color:

This defect varies in degree and may not be serious enough to classify a garment as a second.

Pearl Buttons

1. Faulty Material:

Not apparent without laboratory testing. There are as many as five quality grades. Better and more uniform appearance is attained in the higher quality.

2. Extreme Variations in Thickness:

Button functionally satisfactory but will probably cause a problem if automatic button feed is used.

3. Incompletely Formed:

A rare defect and is usually caught during button manufacturing process.

4. Sharp Edges:

Vitaly important not to have sharp edges if automatic feed is used.

5. Rough or Dull Surfaces:

This is not a serious fault except in cases of extreme roughness or poor surface appearance.

6. Thin and Weak Where Thread Bunch Occurs:

This is not common but generally causes breakage at the bridge. Less applicable to ocean pearl than to fresh water.

7. Non-Uniform, Inaccurately Spaced, Chipped or Blocked Sew Holes:

This type of defect is sometimes not noted during the garment manufacturing operation and can slip past inspection unnoticed, but it frequently causes needle breakage or cut thread.

8. Non-Uniform Color:

This defect varies in degree and may not be serious enough to classify a garment as a second.

V.

Glossary of Thread Defects

Winding

1. Under Wound:

Thread wound over or under itself. This causes thread to pull off cones or spool unevenly resulting in breakage.

2. Wind too Open:

Tends to make thread package too large.

3. Wind too Close:

Thread will not pull off smoothly. Makes package less than uniform size.

4. Wind too Tight:

Tends to over stretch thread, which reduces elongation.

5. Slipped Spool:

Common mostly to spools rather than cones. Body of thread not secure against spool or cone.

Spinning

1. **Slack Twist:**
Insufficient twist in thread.
2. **Dropped Ply:**
One of the plies breaks in manufacturing, producing a section of thread with one less ply than specified.
3. **Corkscrew Twist:**
Uneven tension in twisting process producing a "workscrew" effect on surface of thread.
4. **Lint Accumulation:**
Extraneous matter caught in spinning.
5. **Slubs:**
A short section in the spinning where the cotton is not properly spun.
6. **Plied Knots:**
A break in all the plies rejoined by a knot.
7. **Single Knot:**
A break in the individual ply which has been rejoined.
8. **Poor Balance:**
The condition in which the twist of the individual plies does not balance correctly with the twist of the combined plies.
9. **Mixed Yarn:**
When the individual plies are of different yarn count.
10. **Insufficient Tensile:**
When thread tensile is not normal for thread of its size and finish.
11. **Uneven Spinning:**
Low spots that would reduce tensile. High spots that would tend to make the thread too large for a needle. Both would cause thread breakage.
12. **Dirty Thread:**
Grease or dirt in thread processing machinery.

Finish

1. **Lack of Finish:**
Results in poor sewability.
2. **Excessive Finish:**
Excess comes off on needle, reducing sewing ability.
3. **Unevenly Applied Finish:**
Causes erratic sewing performance.

Dyeing

1. **Color not as Specified on Original Order:**
Self-explanatory.
2. **Color not Matching Thread Previously Shipped:**
Self-explanatory.
3. **Crocking:**
Excess of dye on thread that rubs off.
4. **Bleeding:**
Insufficient color fastness.
5. **Streaked Dye:**
Not evenly applied.

Labeling

1. **Thread not as Stated on Label:**
 - (a) Thread size.
 - (b) Yardage of package.
 - (c) Color.
 - (d) Type of fastness of color.
 - (e) Kind of finish (soft, mercerized, glazed or other)

Packing

1. **Poorly Packed in Carton:**
Causing chafing or crushed comes in transit which weakens thread.

2. **Insufficient Carton Strength:**
Self-explanatory.

Storage

1. **Thread Deterioration:**
Due to improper storage such as exposure to acids, extreme heat or dryness.
2. **Too Long in Storage:**
Thread left too long in storage tends to dry out. This is partly dependent upon storage conditions.

Transit

1. **Transit Damage:**
Resulting in broken spools, crushed cones, dirt, cuts, etc.

VI.

Glossary of Interlining Defects

1. **Holes:**
Resulting from greige goods weaving, finishing, or needle cuts such as would occur in the sewing operation.
2. **Stains:**
Mill stains, oil spots, or other stains which are either in the basic fabric or which have been acquired in the sewing operation.
3. **Mill Splices:**
Butted seams or splices which have been overlooked in the converting operation.
4. **Weaving Defects:**
Fabric imperfections at the mill.
5. **Off-shades:**
Defects which occur from lot to lot or within a lot, the shading wherein the interlinings in the garment show two or three different shades of the same basic color.
6. **Too Bias:**
Cutting of the part has been cut on too bias an angle and therefore does not sew in properly.
7. **Broken Quilted Stitches:**
Occur in the quilting of the garment lining and which are not apparent until after the garment has come to the inspection department.
8. **Incorrect Weight:**
A lighter or heavier weight interlining has been used than what is properly standard for the garment.
9. **Improper Finishes:**
Finishes which are weak, brittle, have long selvages, hard to cut or hard to sew.
10. **Uneven Width of Waistband:**
A variation in the overall width of the waistband and or the fold on the waistband which does not permit an even set in your sewing operation.
11. **Mismatched Band Ends:**
Usually caused by the use of two different sizes or shades of bands.

VII.

Glossary of Machinery Defects

A. Sewing Machines and Attachments

1. **Needle Picking:**
Threads broken or material weave distorted by sewing machine needle having burred point.
2. **Needle Cuts:**
Threads broken or material damaged by needles, caused by incorrect size, point or design of needle.

3. **Incorrect Needle:**
Results in cuts, burns, picking and poor sewability.
4. **Needle Burns:**
Scorched or fused thread or fabric caused by excessive friction.
5. **Feed Chews:**
Caused by excessive machine speeds, improper selection and/or adjustment of fittings.
6. **Feed Cuts:**
Caused by use of wrong type or size feed dogs for the fabric used, excessive feed pressure, improper alignment of pressure foot with feed surface, worn or damaged throat plate.
7. **Feed Marks:**
Improper feed selection for material sewn, improper alignment of foot and feed.
8. **Attachments:**
Incorrect selection and/or adjustment for specific job intended.
9. **Pucker:**
The gathering of material resulting from improper tension adjustment, fittings selection and adjustment, needle selection.
10. **Twisted Seam:**
Uneven feeding caused by improper selection and adjustment of fittings.
11. **Pleated:**
Incorrect selection and adjustment of attachment, or by a damaged feed tooth.
12. **Slipped Seam:**
Caused by stitches too long, insufficient seam margin.
13. **Seam Grin:**
Improper adjustment of tensions.
14. **Raw Edges:**
An exposed edge of fabric due to poor folder adjustment.
15. **Staggered Stitch:**
Usually caused by faulty feed motion or use of wrong type needle and/or fittings.
16. **Skipped Stitch:**
Caused by faulty looper, needle, hook, incorrect tensions or machine timing.
17. **Broken Stitch:**
Caused by tight tension, excessive machine speed, sharp feeds or too much pressure.
18. **Stitch Formation:**
Improper adjustment of tension, fittings or machine timing.
19. **Ravelled Stitch:**
Caused by feed dog cuts on thread, skipped stitches and unbalanced tensions.
20. **Uneven Stitch:**
Caused by excessive machine speed, improper fittings, worn machine parts.
21. **Soiling:**
Results from incorrect oiling, improper cleaning of machine, improper belt guard or defective machine.

B. Part Forming Machines

1. **Spots or Stains:**
Caused by wet steam, rust or oil.

2. **Tear:**
Results from machine malfunction or improper handling by operator.
3. **Ripped Seam:**
Same as 2.
4. **Scorch:**
Machine temperature too high for fabric, or operator failure to remove piece at proper time.
5. **Malformed Piece:**
Results from machine fault and/or adjustment or failure of operator to position piece properly.
6. **Shading:**
Where temperature of machine changes color of fabric.

C. Pressing Equipment

1. **Scorch:**
Equipment temperature too high for fabric; garment subjected to pressing beyond specified limits, or not conditioned properly prior to pressing.
2. **Water Spots:**
Caused by leaks in pressing unit or improper steam.
3. **Closure Damage:**
Closed pressure of press too great, insufficient press padding.
4. **Damp Finish:**
Vacuum system in need of draining, steam too moist.
5. **Shine or Glass Finish:**
Incorrect combination of heat, pressure and press covering.
6. **Flattened Nap:**
Pressing on incorrect equipment.
7. **Grid Plate Mark:**
Incorrect selection of grid plate and/or padding.

D. Trimming Equipment

Defect terminology for this category is effectively described in the finishing department section.

E. Work Handling Equipment

- Snags:**
Usually caused by careless handling or faulty equipment.
- Raveled Stitches:**
Can result from partial severance of thread.
- Tears:**
Results from rough edges, corners protruding nails, screws, bolts, etc. and/or careless handling.
- Soiled Garments:**
Usually the result of excess oiling, poor housekeeping, improper handling or carelessness, sub-standard equipment.
- Ripped Seams:**
Faulty adjustment of stackers or work moving equipment.
- Holes or Marks:**
Caused by drag on garment while being transported.