

## Section 4: Precautions on Zipper Sewing <<<<<<<

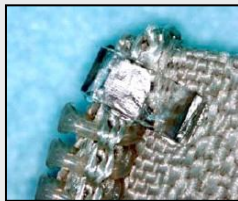
### 4-1 Proper Sewing of Coil Zippers

During the spacing process of the coil zipper production, elements are cut and removed from the zipper tape. Occasionally a half element (remained after cutting) may be left behind next to the top stops of the zipper and such cut element may be juttred if the top extension of the zipper tape is bent closely to the top stops during the garment sewing processes. The sharp cut end of the juttred element may hurt a user / consumer.

#### Suggestions

- The top extension(s) of the zipper tape should be bent at least 5mm apart from the first element (at the top stop position). This would prevent the jutting of the cut elements.
- The selection of the P-TOP (plastic top stops) products can prevent the exposure of sharp cut element, and is highly recommended for infants / kids' garments.

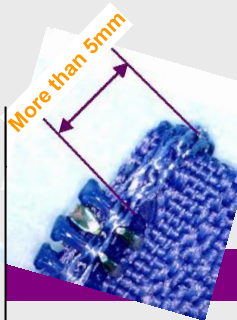
**P-TOP  
(Plastic Top Stop)**



**Metal Top Stop**



**Keep at Least  
5 mm of Space**



## >>>>>>> Section 4: Precautions on Zipper Sewing

### Proper Use / Sewing of 3CF Open-End Zippers 4-2

3CF open-end & two-way open zippers are designed for thin and light fabric. To ensure light weight, open parts of this product are made of plastic. Therefore, their strength is relatively low (about half of 5CN, which is generally used in the front opening of general garments).

Therefore, please avoid using this product in heavy knit garments, with thick fabric, or where a strong force may be applied during garment use. Strong pulling or twisting could result in the breakage of the parts.



**DO NOT twist the open parts.**

Also please note the following precautions for proper handling in order to avoid unnecessary damage or breakage.

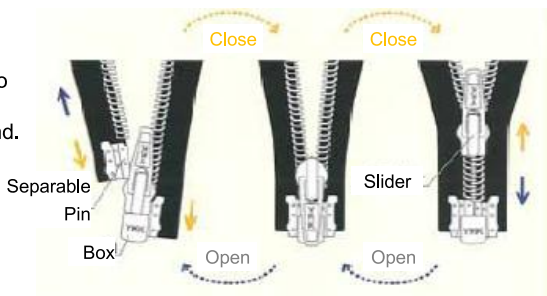
#### Zipper Operation:

##### When Closing:

1. Make sure the slider is positioned next to the box.
2. Completely insert the pin into the box end.
3. Pull up the slider.

##### When Opening:

1. Pull the slider closely to the open parts.
2. Draw the separable pin out.



#### Ironing:

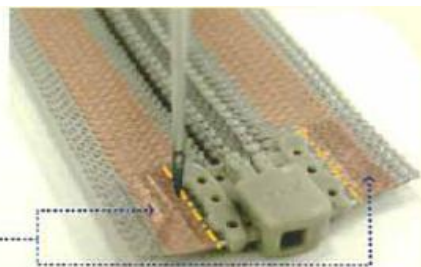
1. Please completely close the zipper and cover with a piece of cloth.
2. Ironing temperature should be lower than **130 ℃**.
3. Please be careful not to accidentally iron the plastic parts.

#### Sewing:

Please sew outside the yellow line.

**DO NOT** sew on the plastic part.

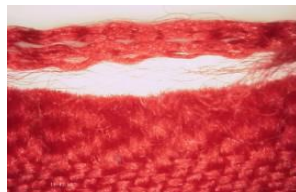
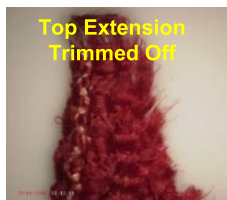
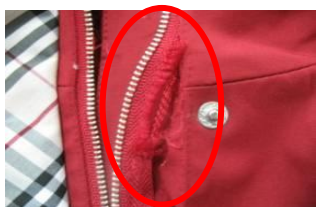
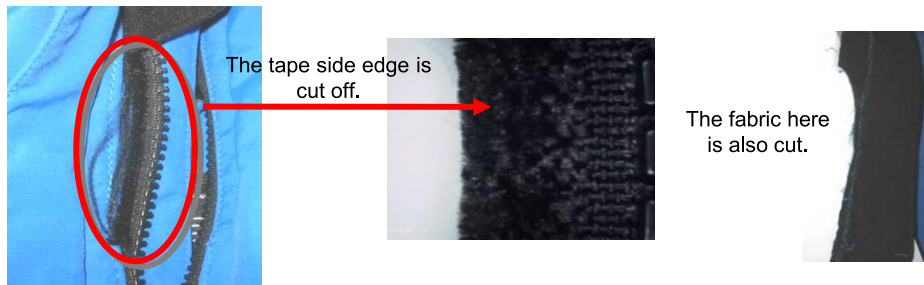
**Sew outside Yellow Line**



## Section 4: Precautions on Zipper Sewing <<<<<<<<

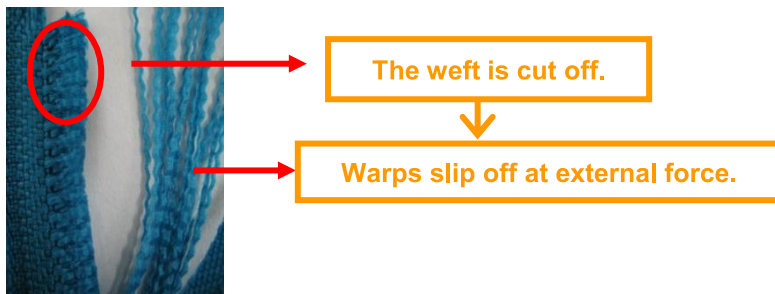
### 4-3 Zipper Tape Breakage by Trimming

Some tape tear problems reported have been found to have been caused by trimming of the tape end/edge when the zippers are sewn onto the garment.



#### Precaution on Sewing:

Zipper tape is woven in a certain pattern to secure the construction of the entire tape. When the weft of the tape is cut off, the warp can slip from the structure and result in wide tearing when the tape receives some external force.



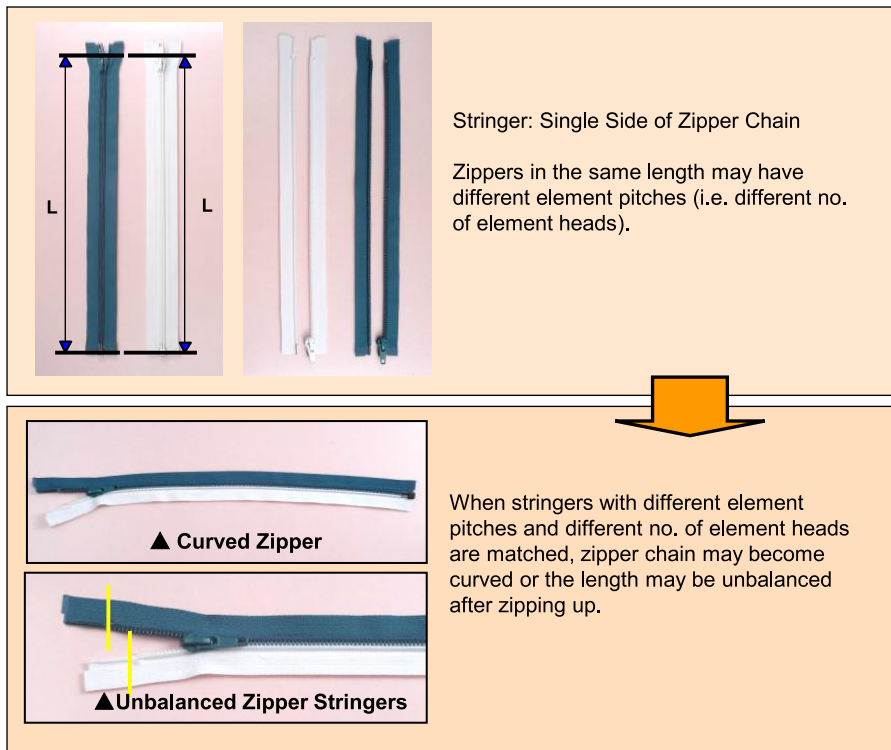
Please **DO NOT** trim off any part of the zipper tape so as to prevent any unnecessary tape breakage.

## >>>>>>> Section 4: Precautions on Zipper Sewing

### Problem of Pairing up Different Stringers 4-4

Garment manufacturers may separate an open-end zipper in order to have an easier garment sewing process. Therefore many zippers are being separated at the same time and paired up again without matching the original set of zipper chain during sewing, which may cause the unbalanced zipper length between the left and right stringers when the zipper is closed.

Risk of having such problem is high for coil zippers because their chains are generally more elastic/ stretchy in nature, the original length of the chain may be stretched out when tensions is applied on it. Different tensions applied on the zipper chains may cause deviations in the element pitches (i.e. having different number of element heads) and the matching stringers with different element pitches would lead to the unbalance zipper chain - either having a curved zipper chain or unbalanced stringer length.



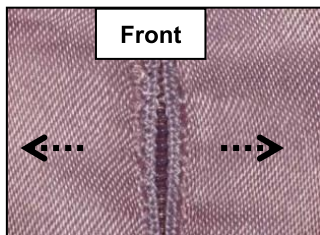
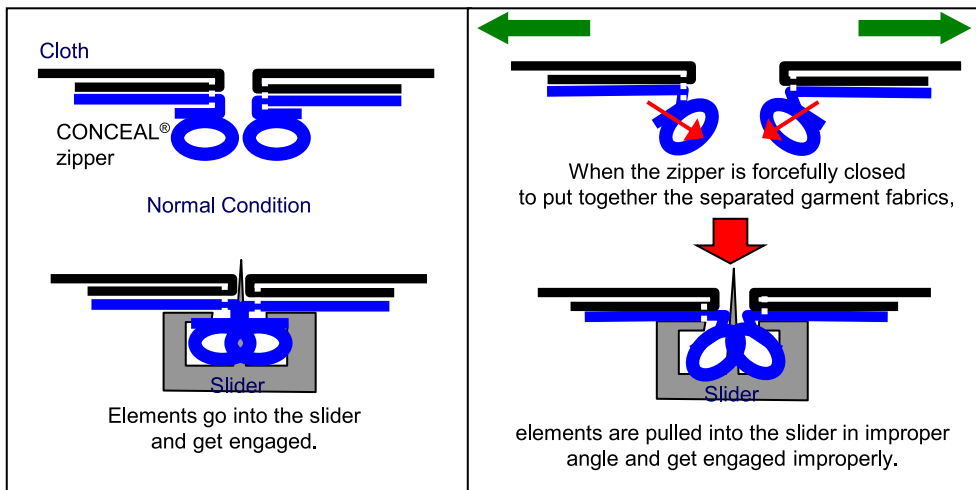
## Section 4: Precautions on Zipper Sewing <<<<<<<

### 4-5-1 Proper Use / Sewing of 2CH CONCEAL® Zipper

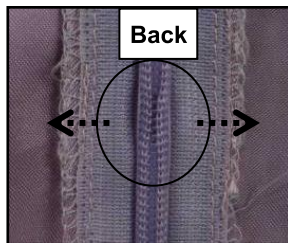
The CONCEAL® zipper may be used for tight-fitting clothes such as a dress.

Zippers are usually closed with both stringers pulled closely, elements going into the slider and engaging with the other counterpart. For tight-fitting clothes, especially at such tighter part as waist, pulling both stringers closely to close the zipper may be hard and sometimes slider is passed forcefully although the stringers aren't pulled in position.

In this situation, elements may go into the slider in an improper angle, and consequently get engaged with less area. This improperly engaged chain could easily burst at little force.



The elements received crosswise force and burst.



The elements are deformed.

#### Suggestions

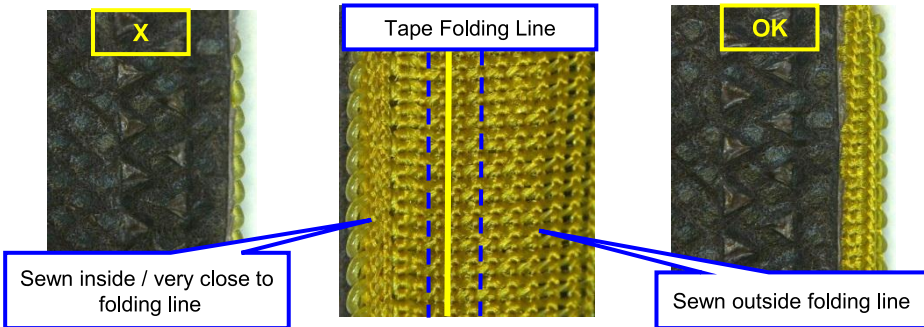
- Please make sure to pull closely together both side garments before zipping up the garment.
- Attaching hook & eye fastener at the top stops could reduce load against closed zipper chain.

## >>>>>>> Section 4: Precautions on Zipper Sewing

### Proper Use / Sewing of 2CH CONCEAL® Zipper 4-5-2

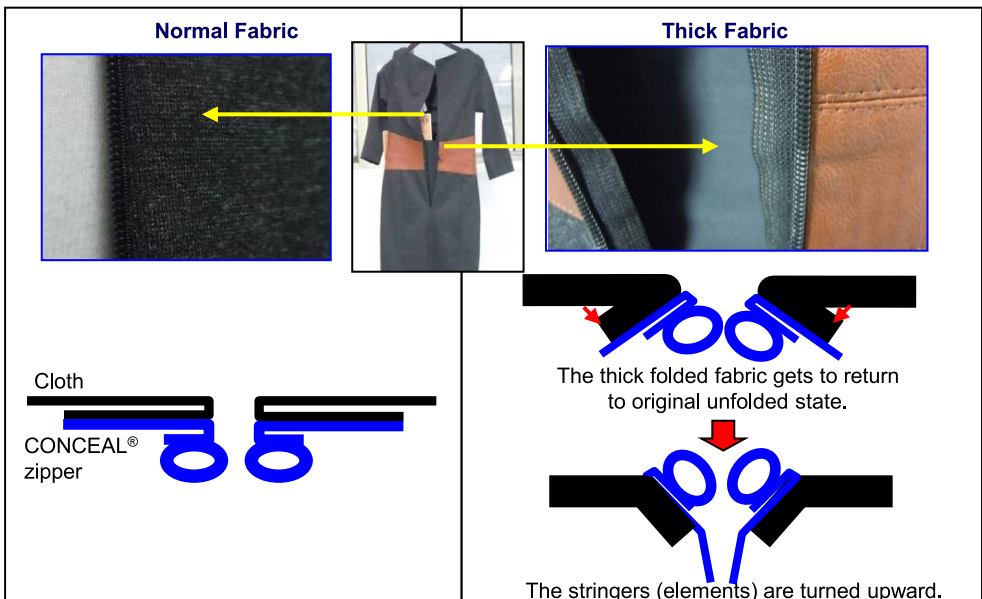
CONCEAL® zipper is often sewn to the garment fabric at the line very close to, or even inside the folding line of the zipper tape, in order to better hide the zipper.

This sewing style could easily cause chain burst problem at garment use.



In addition, when it is sewn on thick fabric or at fabric joint part, zipper stringer / elements could get turned up due to the nature of thick / folded fabric as shown in below diagram.

In this situation, it is harder to make sure the elements are aligned properly before entering the slider, therefore, slider movement could become harder. Forced pulling of the slider in this condition could easily cause mis-engagement of the elements and result in the chain bursting.

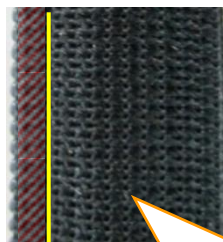


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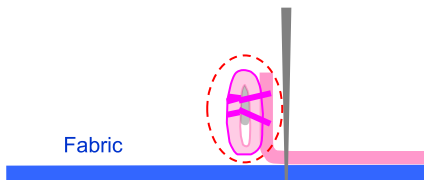
### 4-5-3 Proper Use / Sewing of 2CH CONCEAL® Zipper

#### Suggestions

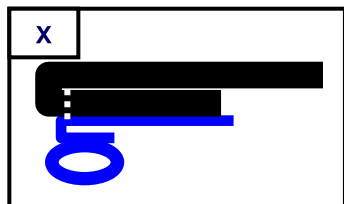
When sewing CONCEAL® zipper onto fabric, please sew outside the tape folding line keeping the element vertical, in order to give enough flexibility to zipper tape.



Sew outside the folding line.

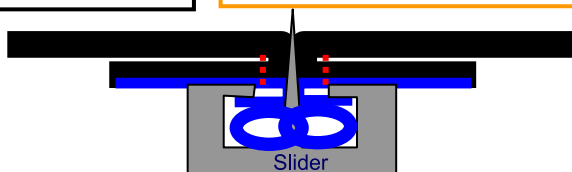


Keep the element vertical.



OK

Free Tape  
= Flexibility



Using YKK's special presser foot for CONCEAL® zipper is strongly recommended as it can easily guide the needle to the proper sewing position.

#### YKK Presser Foot for CONCEAL® Zipper





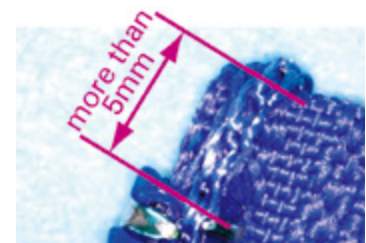
### Precautions for sewing Coil Zippers

- During the spacing process of the coil zipper production, elements are cut and removed from the zipper tape. Occasionally, a half element (remaining after cutting) may be left behind next to the top stops of the zipper, and such cut element may be protruding if the top extension of the zipper tape is bent closely to the top stops during the garment sewing processes.
- The sharp cut end of the protruding element may scratch a user/consumer.

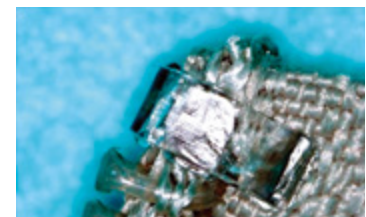


#### Solutions

- The top extension(s) of the zipper tape should be bent at least 5mm away from the first element (at the top stop position). This would prevent the elements from protruding.



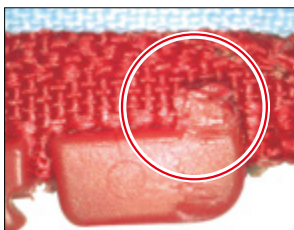
- Selecting the P-TOP (plastic top stops) products can prevent the exposure of sharp cut element, and is highly recommended for infants' / kids' garments.



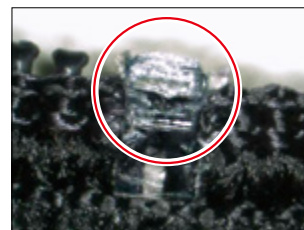
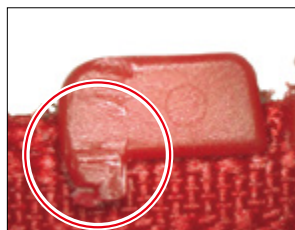
### Warnings and Requests When Sewing the P-TOP

- When stitching the zipper, if the sewing machine attachment or feed dog comes in contact with the top stop and damages it, it could create a jagged edge which can lead to injury.

Example of such damages:



VISLON® (NEWKOB4) damage example



Coil zipper (P-TOP) damage example



#### Solutions

- Please be mindful that the sewing machine attachments or feed dogs do not come in contact with the top stop when sewing near the top stop or the top extension.

