

# TECHNICAL MANUAL

## *Mens Industry—Jackets, Trousers, Small Areas*

The purpose of this Technical Manual is to give you a greater depth of knowledge, not only about Vilene and its advantages over competitive products, but of the garment industry to which you are selling.

It is hoped that you will take the time to carefully study the technical matters outlined in the Manual, and that this will give you greater confidence when discussing these problems with your customers, and in turn, we hope that this will help you to greater sales, which is our only reason for being in existence.

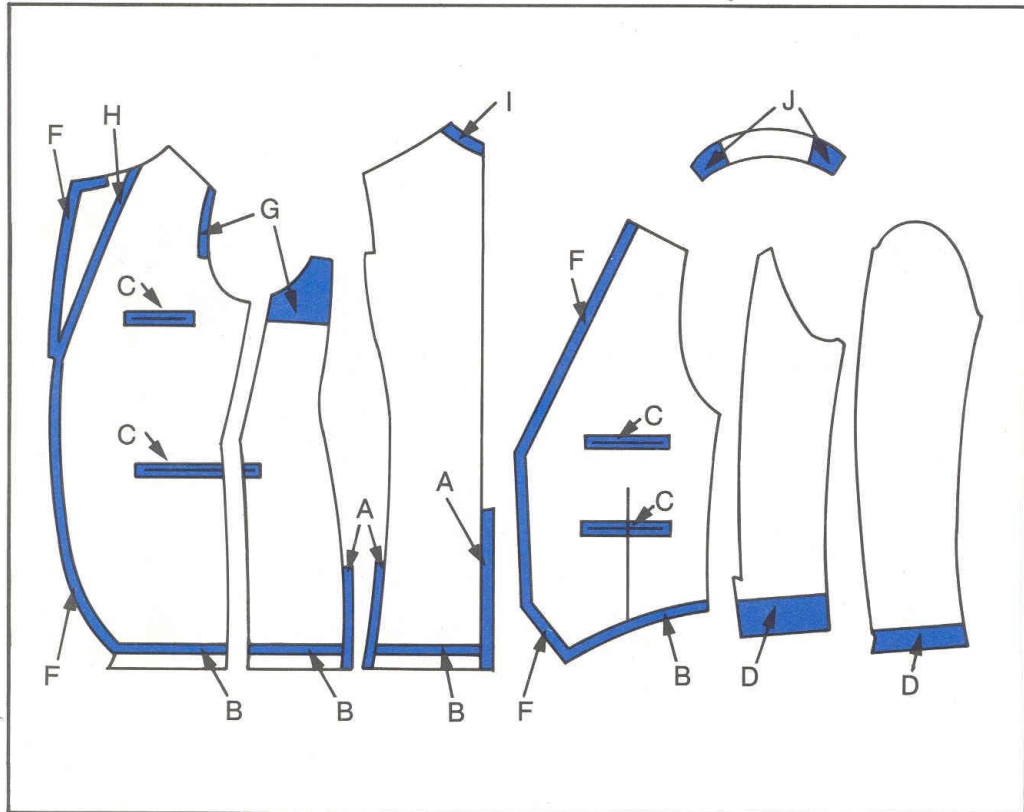
The Manual will be added to at regular intervals, and covers all aspects of our activities. If there is anything you read which you do not understand, please do not hesitate to contact one of our technicians. If there is anything you feel we have left out concerning one of the topics which we have published, we would be glad to hear from you.

In time, you should have sufficient data on every topic connected with selling Vilene that you could possibly need, and this information will be amended as changes occur.

Don't forget—read and absorb this information—it is vital to your success and to that of the Company.

## Minor applications

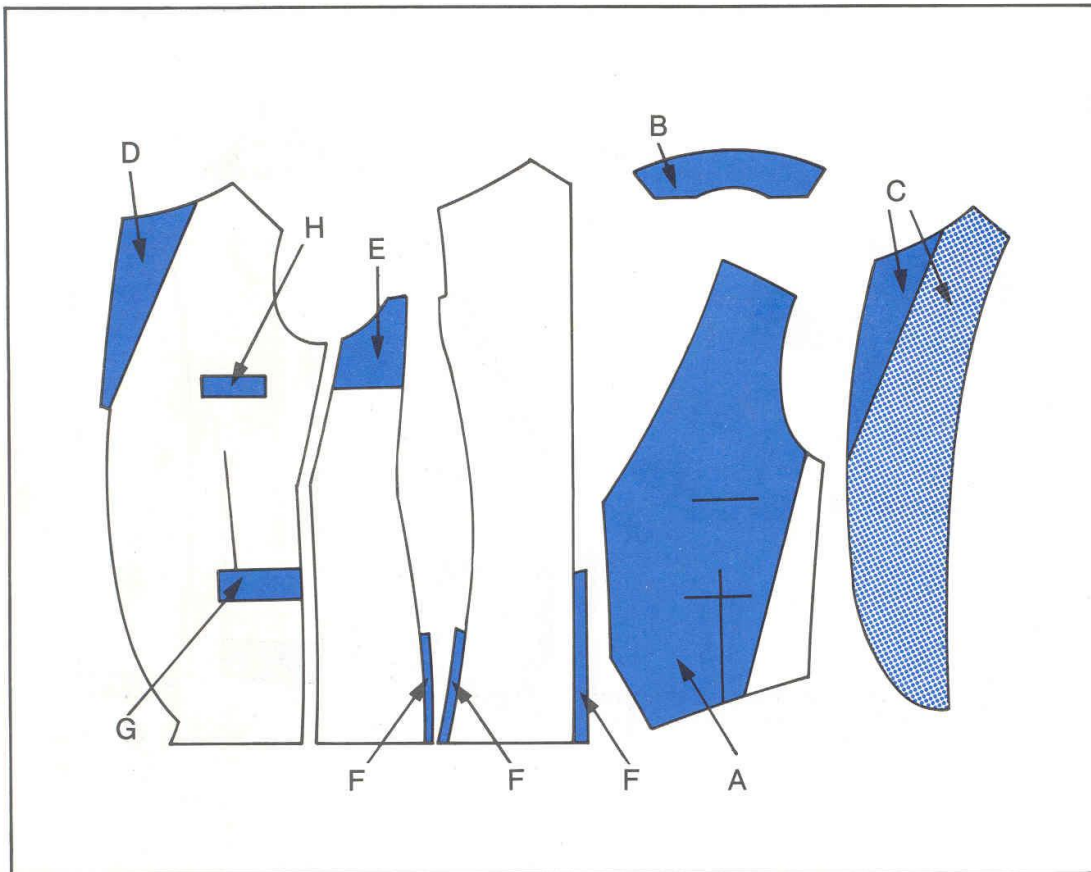
### 1. Stays and Tapes for non-fully Fused Fronts



- A. Side and centre vent stays
- B. Vest and jacket bottom stays
- C. Pocket stays
- D. Sleeve cuff stays
- F. Front edge tapes
- G. Armhole tapes
- H. Bridle stay
- I. Back neck tape
- J. Collar end stays

## Minor applications

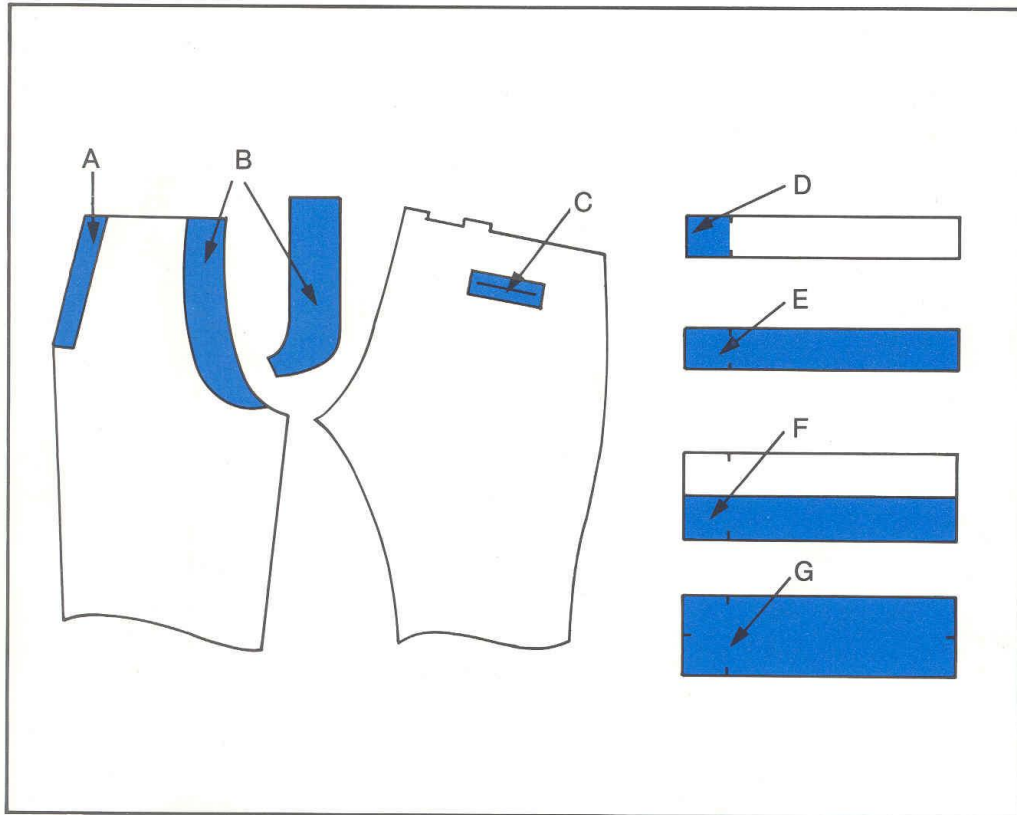
### 2. Small Area Fusing



- A. Front fusing of vests
- B. Top collars (Also undercollars particularly Crimplene self undercollars)
- C. Facing lapel or whole facing
- D. Jacket lapel
- E. Underarm on side body
- F. Side and centre vents
- G. Pocket flaps
- H. Pocket welt

## Minor applications

### 3. Trousers



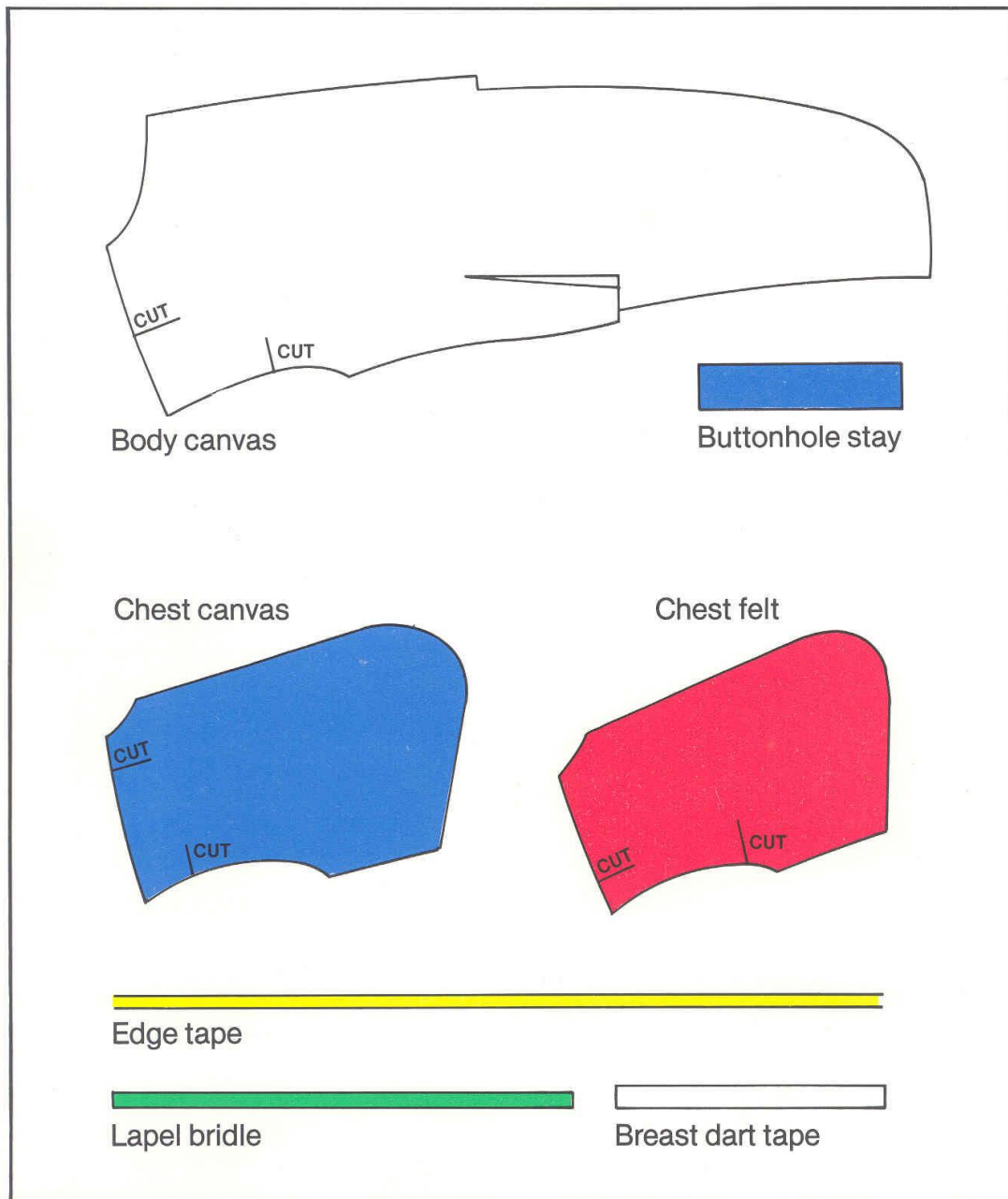
- A. Side pocket stay
- B. Fly application – fuse to trouser front or to button catch
- C. Hip pocket stay
- D. Extension end
- E. Waistband – fuse complete waistband for greater stability, i.e. Crimplene & Jersey fabrics to control stretch.
- F. & Self lined waistbands fuse stiffer vilene to 1/2 waistband width or medium
- G. stiff quality to whole width to give clean appearance to waistband and to stop rolling.



# Interlining Construction – Mens Jackets Traditional Method

## Traditional Method using Hair Canvas or sew-in Vilene

Figure 1. Component Parts



## Make up of Component Parts

Figure 2.

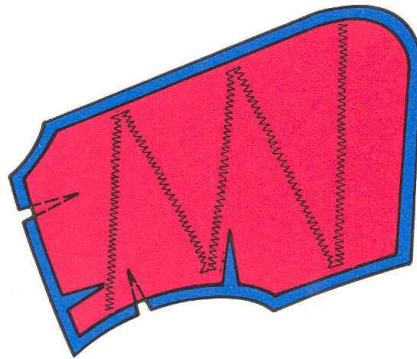
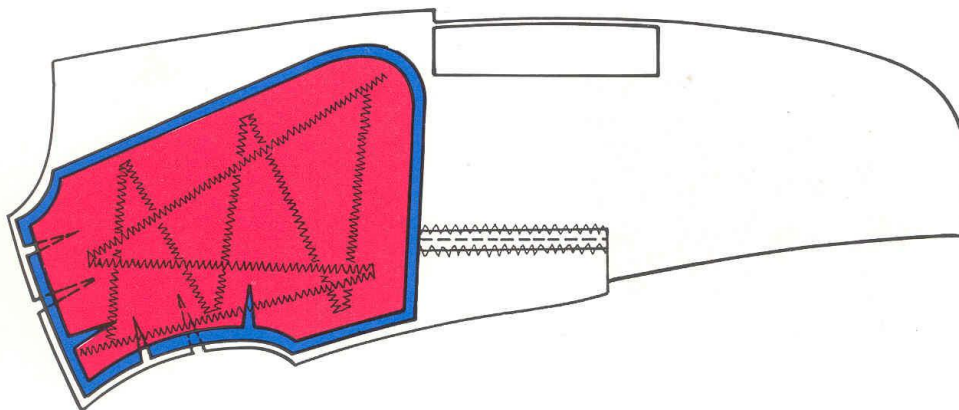


Figure 3.



## Interlining Attached to Forepart

Figure 4. View from cloth side showing basting stitches

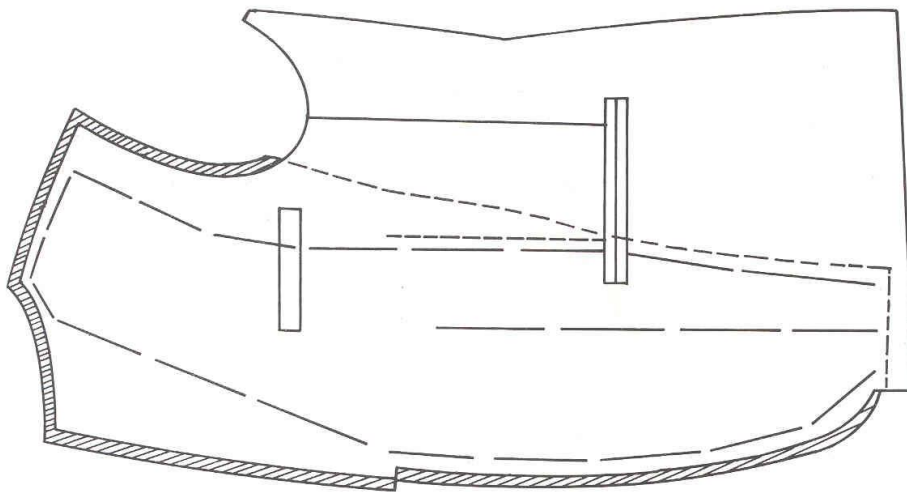
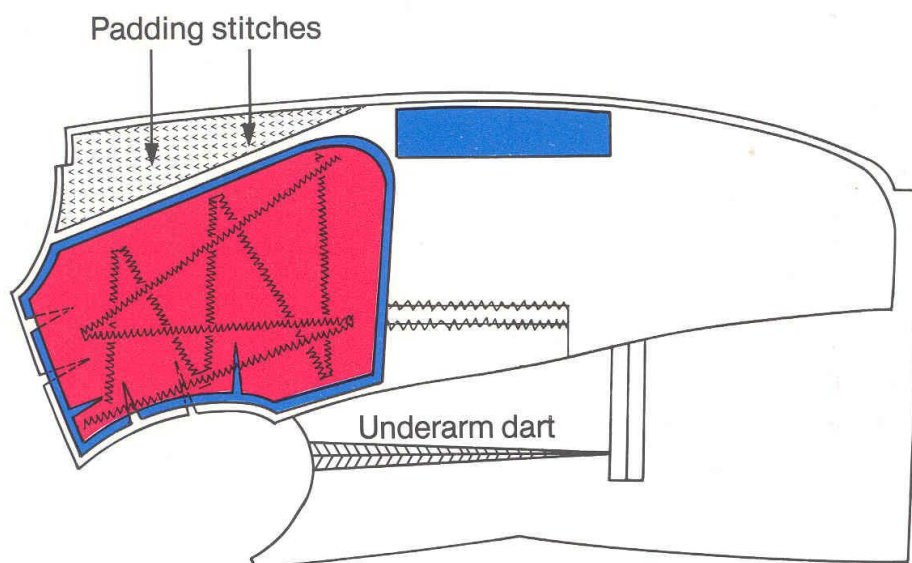
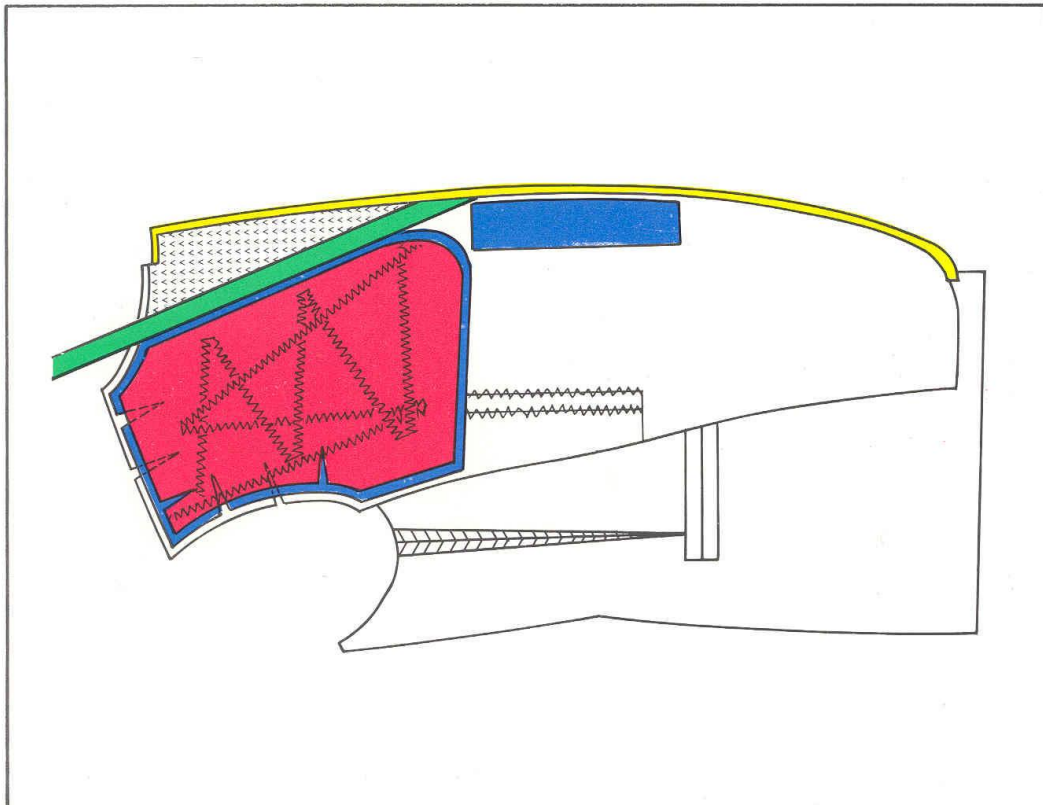


Figure 5. View from interlining side



## Jacket Completely Interlined

Figure 6. Showing edge tapes and bridle



### Method of Make

- Fig. 1. Component parts cut. Note cuts in armhole and shoulder sections of body canvas, chest canvas and felt. These are later opened during canvas making to put shape into the canvas.
- Fig. 2. First operation: Chest felt zig zag stitched to chest canvas. Note stitching goes across the canvas to help put shape into the chest area.
- Fig. 3. Breast dart closed and taped: chest piece attached to body canvas. Note stitching goes opposite way to when felt and chest canvas were stitched – this again helps to put shape into the chest area. Buttonhole stay attached to body canvas.
- Fig. 4. Completed canvas attached to Jacket front, diagram shows basting stitches. Note canvas is cut larger than cloth to allow for the easing in of the canvas during make.
- Fig. 5. Jacket canvas and forepart with lapels padded and canvas cut away from front edge of jacket and lapel, ready to be edge taped.
- Fig. 6. Jacket front completely canvassed showing the addition of edge tape and bridle.

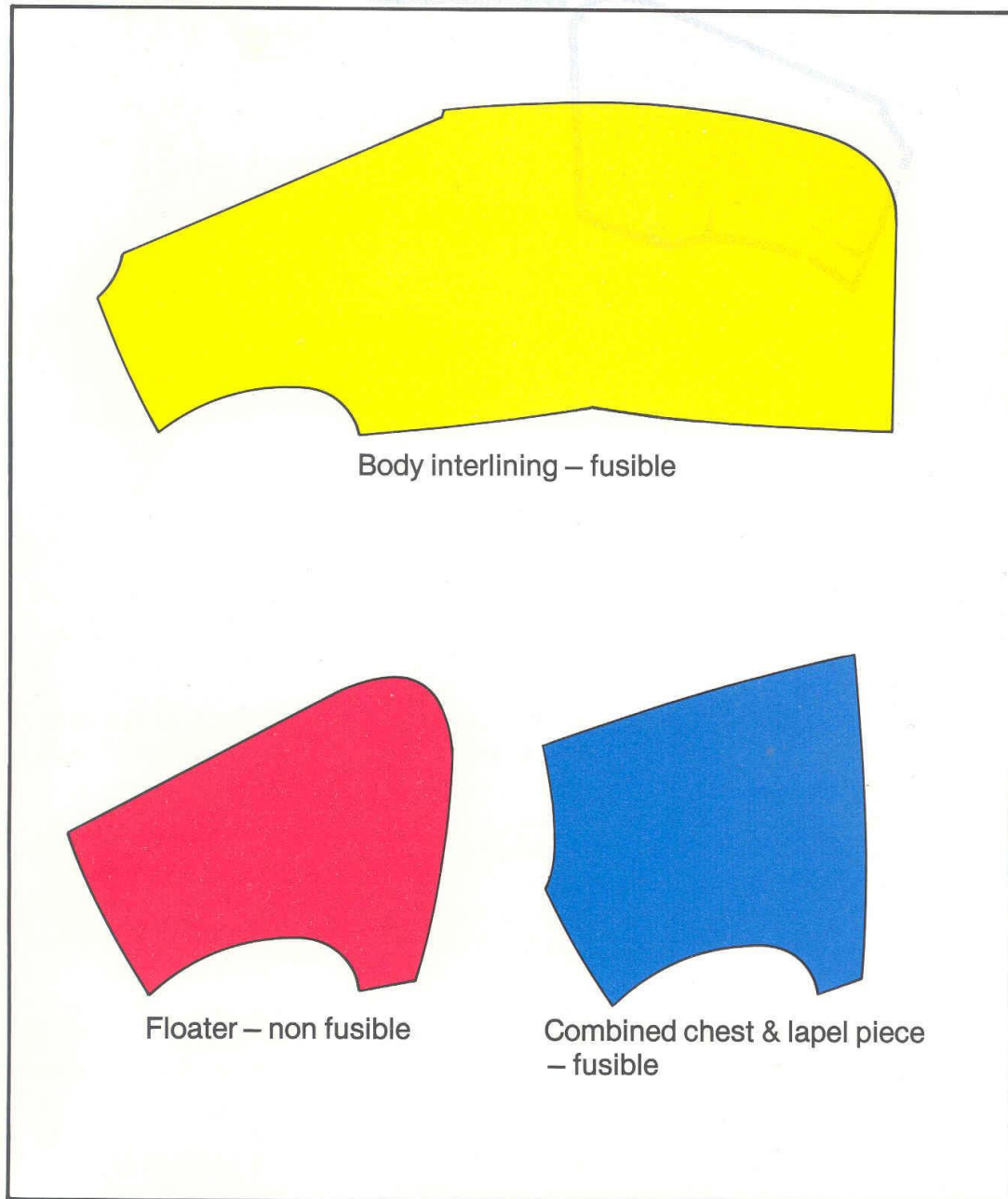
**All these operations are necessary to interline a jacket by traditional means. Now compare with the fusing method.**



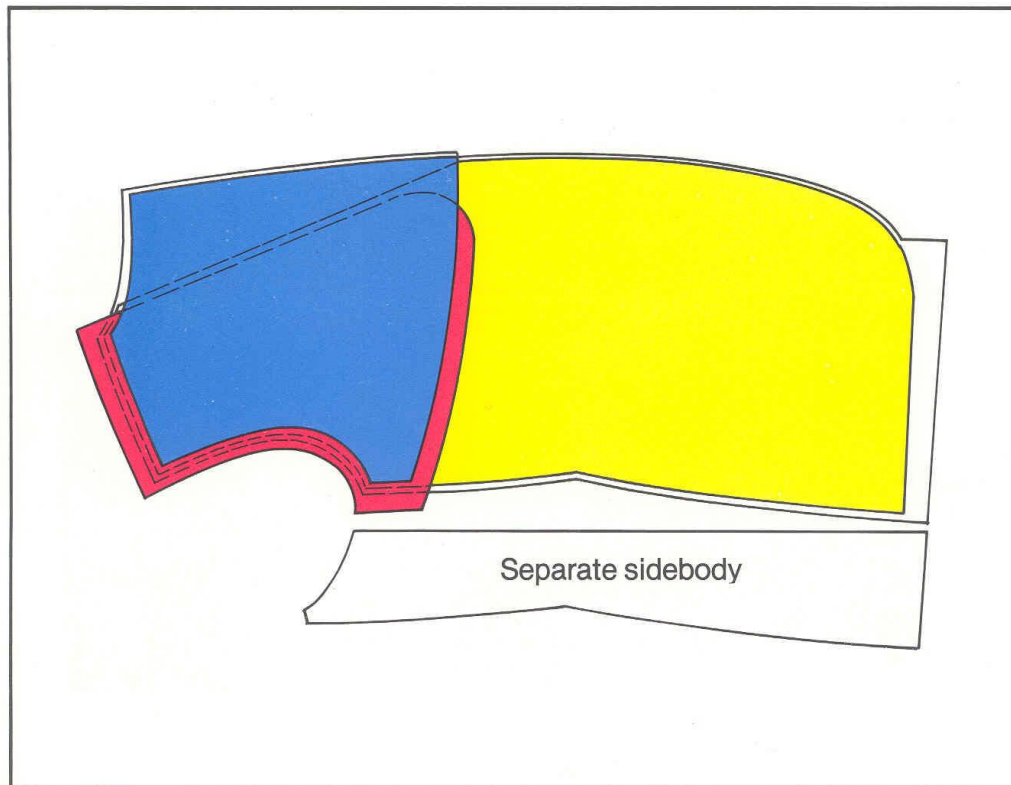
## Interlining Construction – Mens Jackets Fused Fronts – some popular variations

### 1. Hinged Floating Chest-piece – with combined Chest and Lapel Piece

Figure 1. Component Parts



**Figure 2. Fully fused forepart**



### **Method of Make**

1. Body interlining positioned and fused.
2. Floater and fusible chest piece positioned and fused.

**Thus, one, or at the most, two fusing operations of approximately 15 seconds have replaced the costly operations shown at figures 2, 3, 4, 5, and possibly 6.**

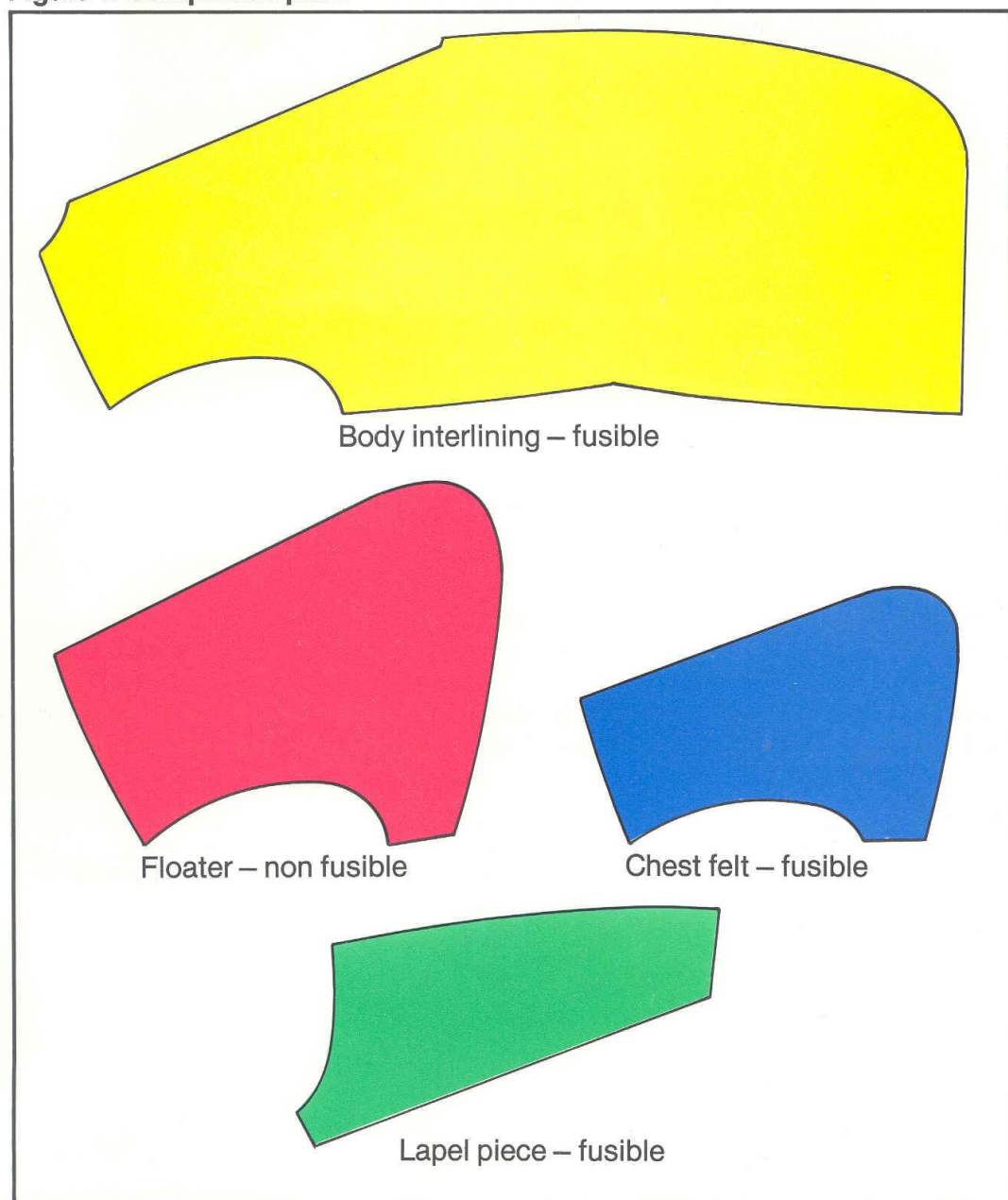
### **Note:**

Fusible interlinings should be cut  $\frac{1}{8}$  inch smaller than fabric with the exception of the side body seam where  $\frac{3}{8}$  inch is allowed. This is to avoid contamination of the fusing equipment.

## Interlining Construction – Mens Jackets Fused Fronts

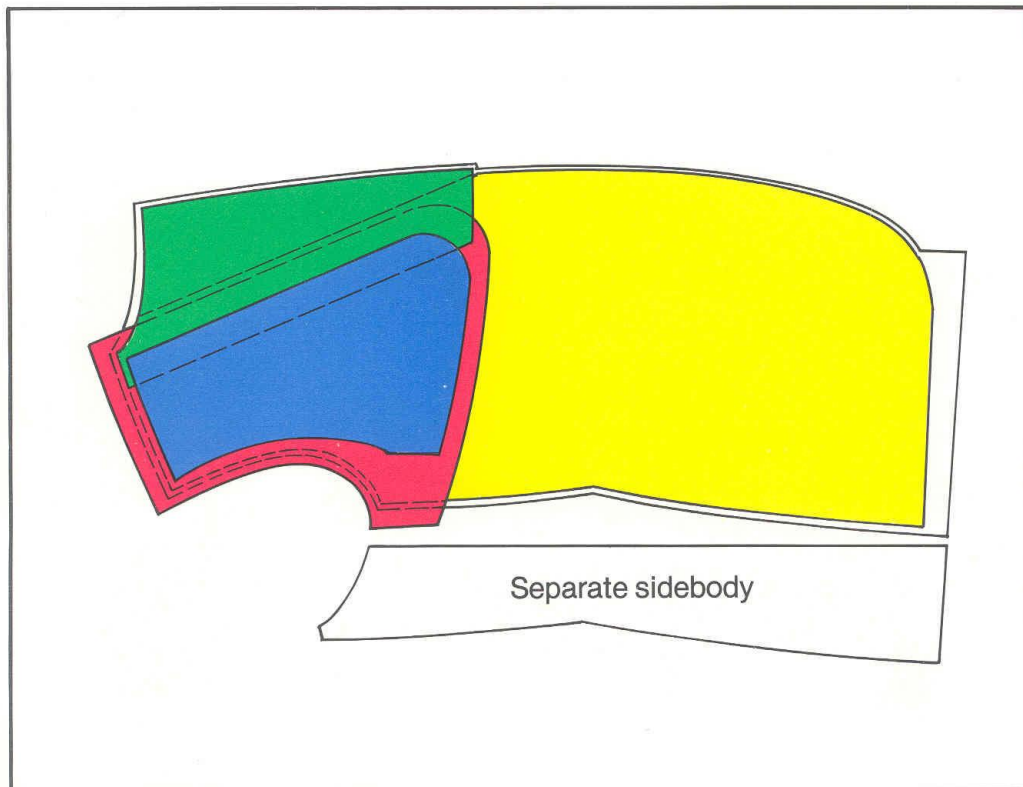
### 2. Hinged Floating Chest piece – with additional Chest Felt

Figure 1. Component parts





**Figure 2. Fully fused forepart**



### **Method of Make**

1. Body interlinings positioned and fused.
2. Floater and lapel piece positioned and fused.

**Thus, one or at the most, two fusing operations of approximately 15 seconds have replaced the costly operations shown at figures 2, 3, 4, 5 and possibly 6.**

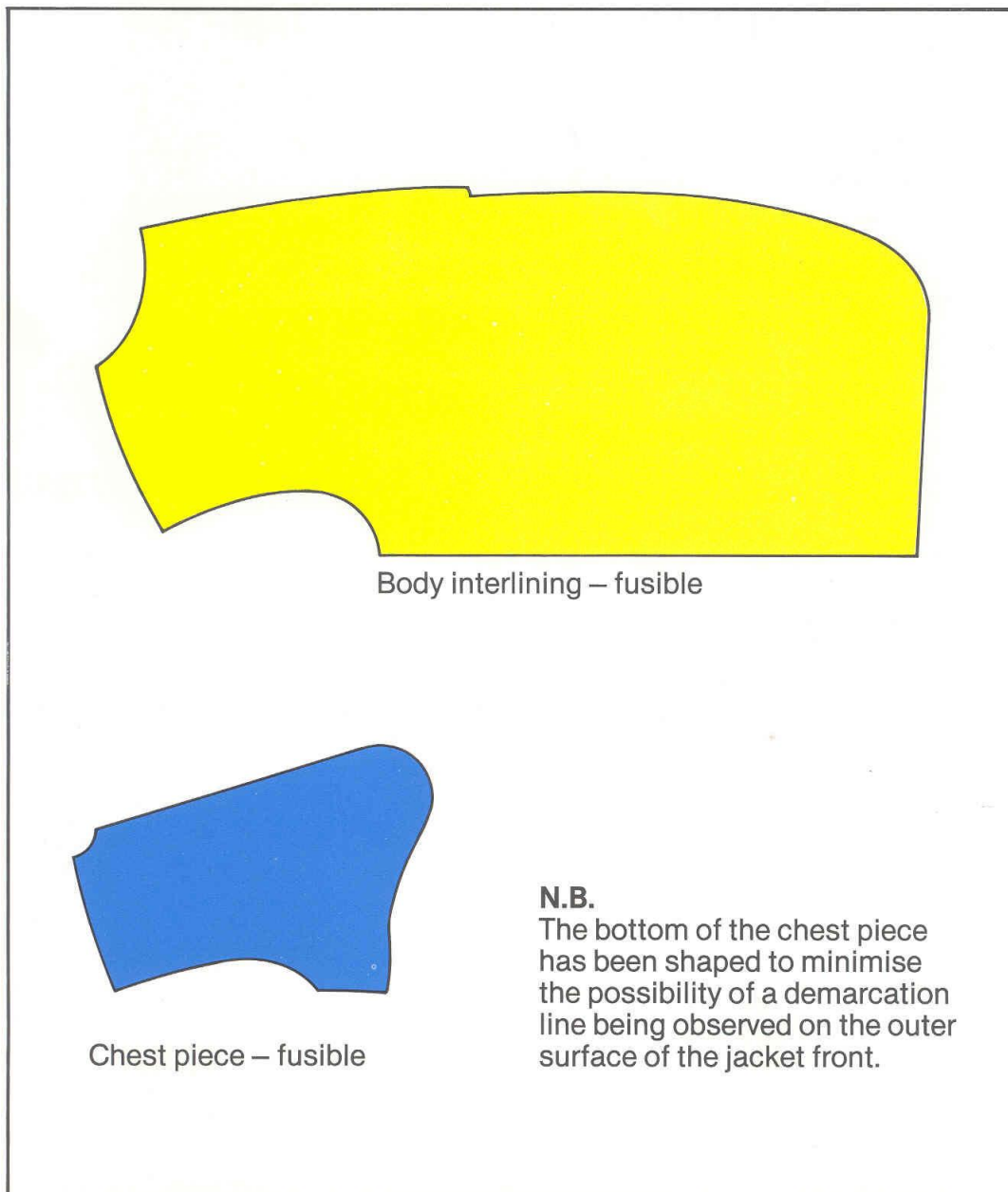
### **Note:**

There are a number of ways of building up the hinged floating chest piece, and this will depend on the manufacturers method of make. The two illustrated are, however, the most popular.

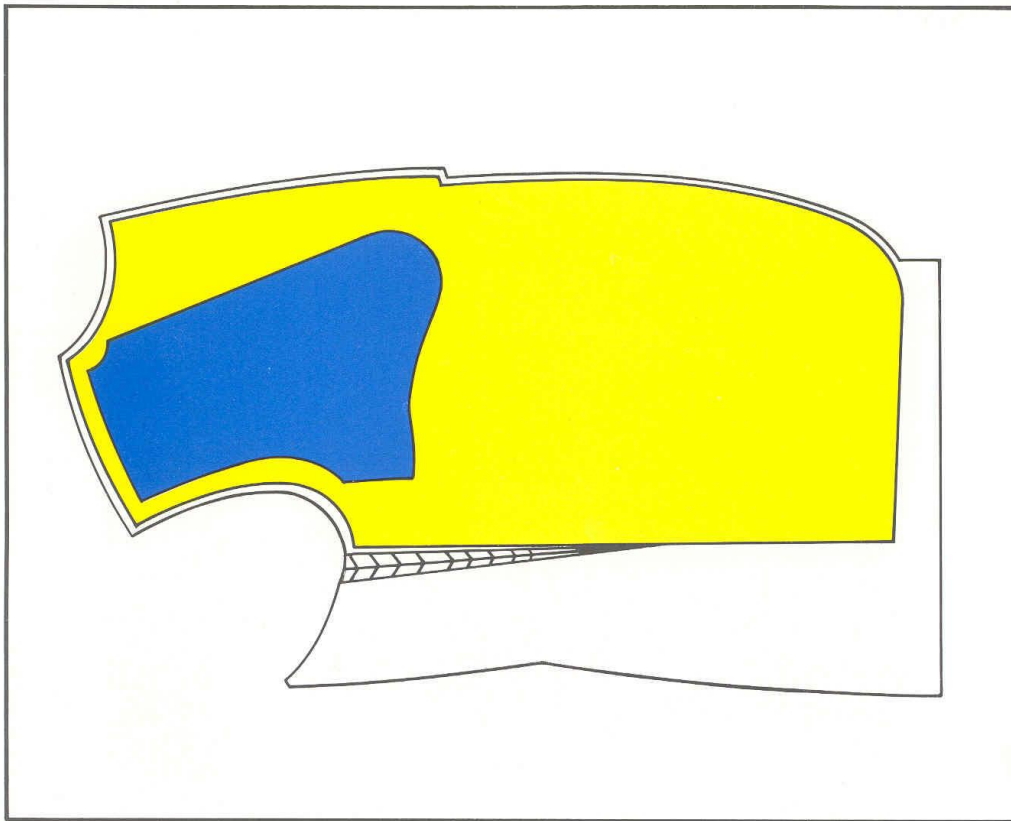
## Interlining Construction – Men's Jackets Fused Fronts

### 3. Double laminate (see notes on following page)

Figure 1. Component Parts



**Figure 2. Fully fused forepart (double laminate)**



### **Method of make**

1. Body interlining positioned and fused.
2. Chest piece positioned and fused.

### **Number of Operations – Two**

The parts can, however, be laid up and fused in one operation providing:

- A. It is fused on a continuous fusing press where the heat comes from two directions.
- B. The recommended glue line temperature is reached between the double laminate areas without adversely affecting the outer fabric.

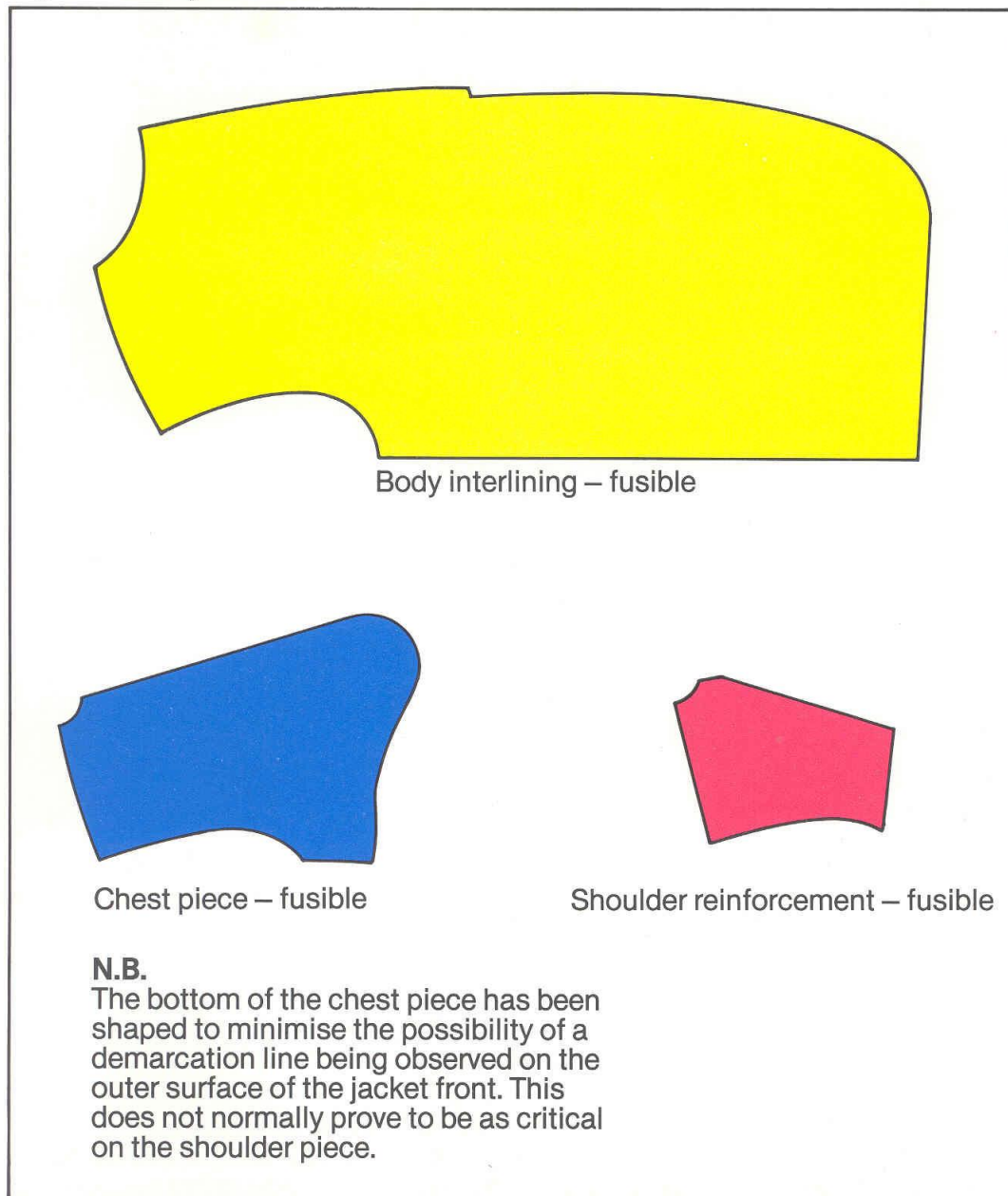
### **Note:**

1. Some difficulty can be encountered in reaching these required temperatures, especially on fusing equipment where heat is applied from one direction only.
2. In certain cases a poor bond or inferior surface appearance may be observed when double/triple laminating. The above operation is subject to full tests and/or recommendations being made by the interlining suppliers.

## Interlining Construction – Men's Jackets Fused fronts

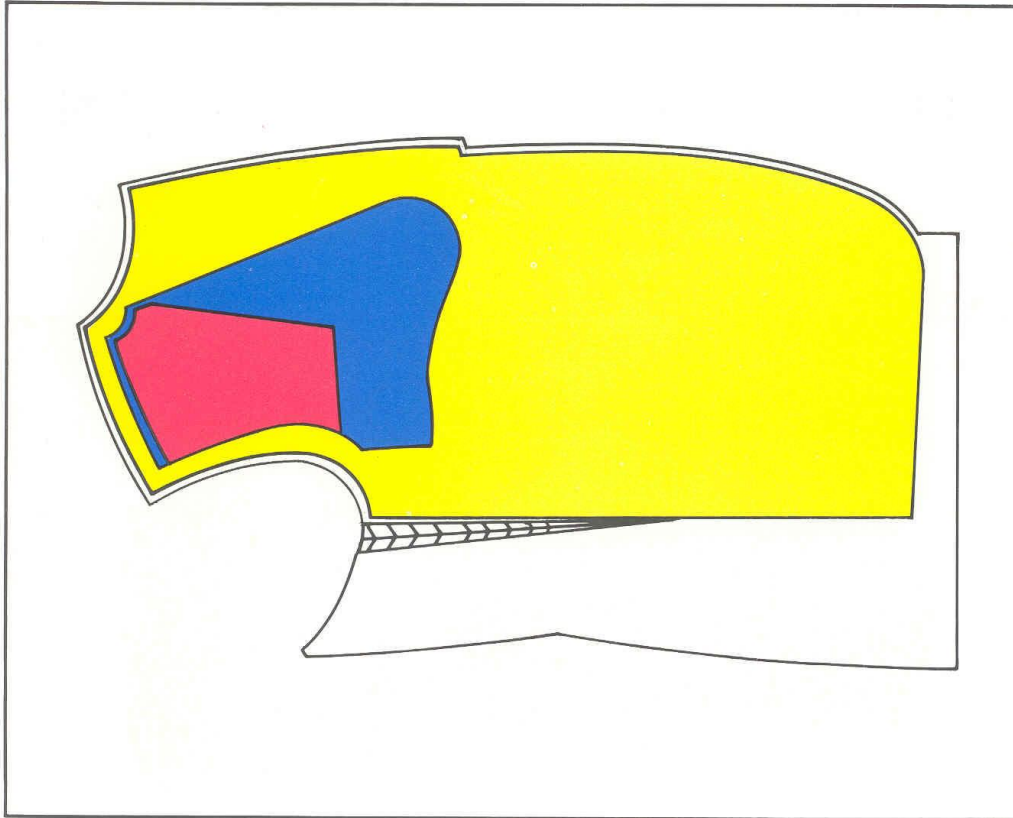
### 4. Triple laminate (see notes on following page)

Figure 1. Component Parts





**Figure 2. Fully fused forepart (triple laminate)**



### **Method of make**

1. Body interlining positioned and fused.
2. Chest piece and shoulder piece positioned and fused.

### **Number of Operations – Two**

The parts can, however, be laid up and fused in one operation providing:

- A. It is fused on a continuous fusing press where the heat comes from two directions.
- B. The recommended glue line temperature is reached between the double and triple laminated areas without adversely affecting the outer fabric.

### **Note:**

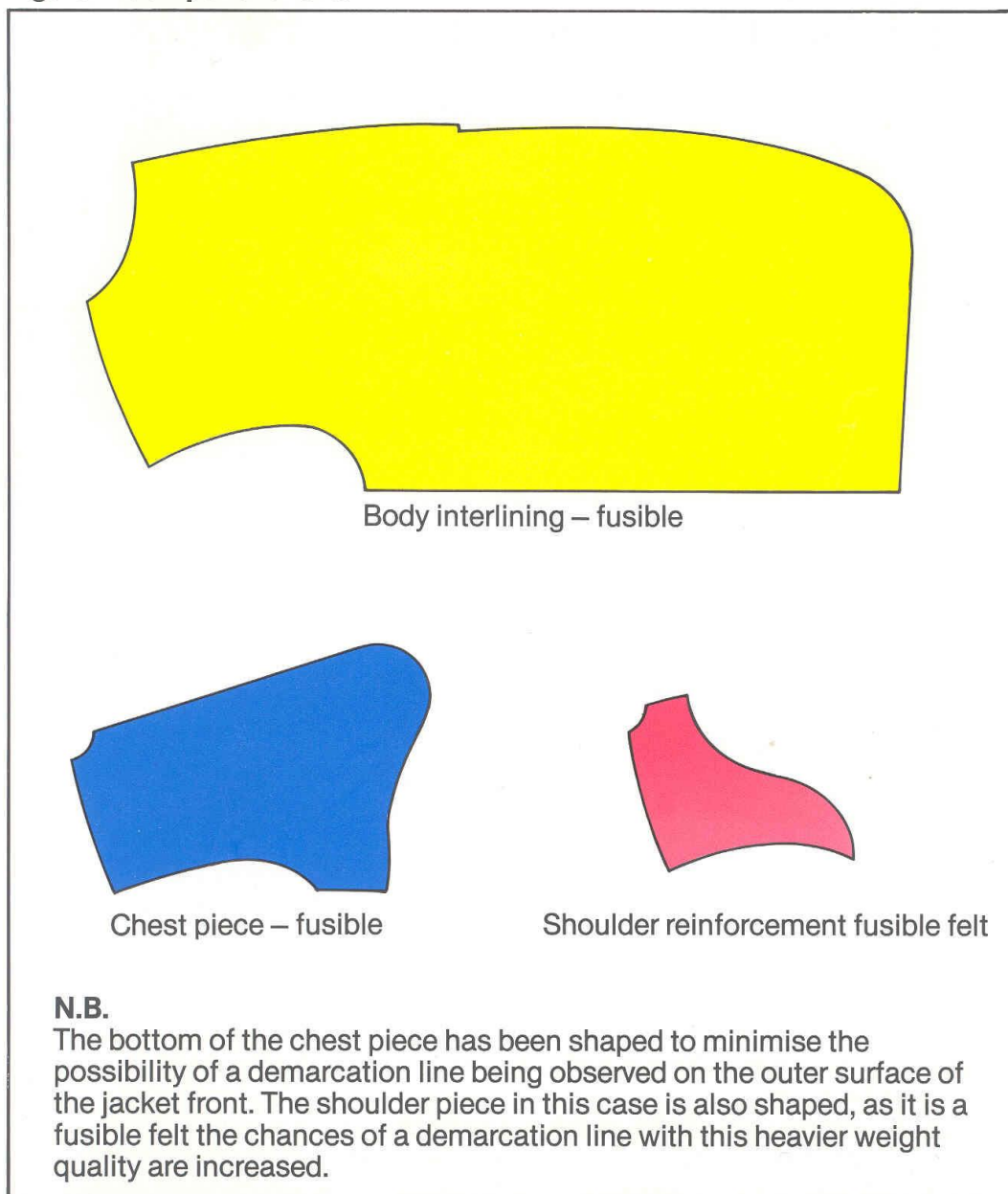
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## Interlining Construction – Mens Jackets Fused Fronts

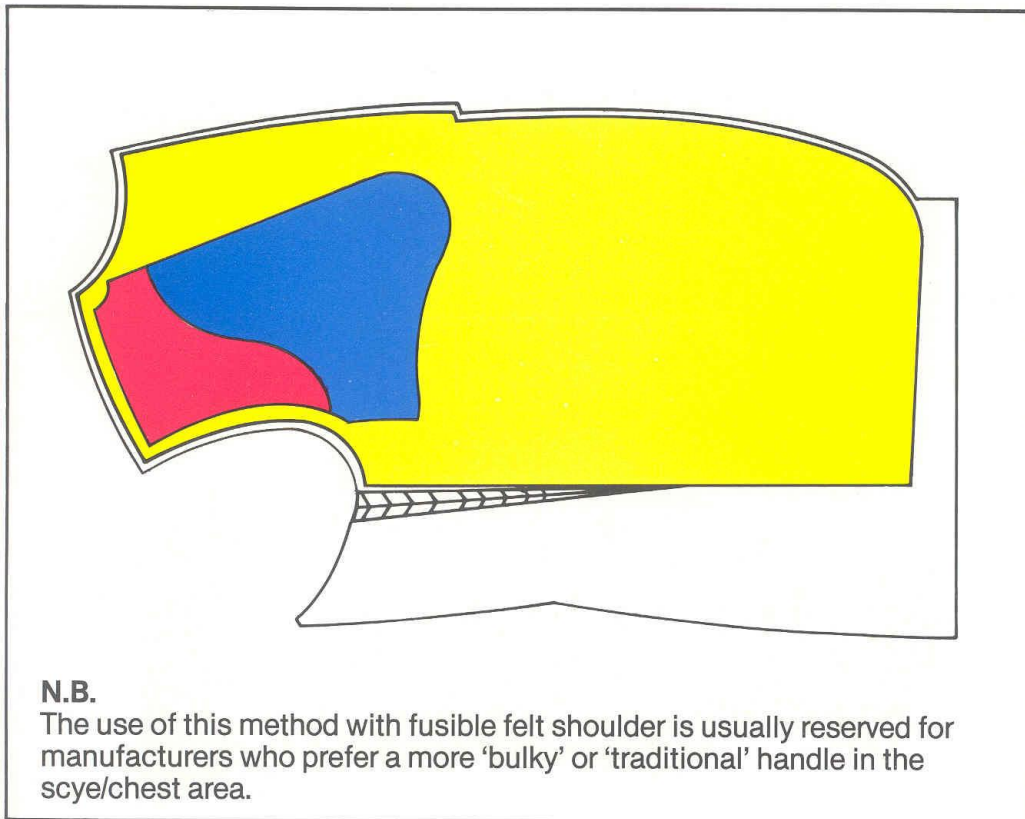
### 5. Triple Laminate (with felt fusible shoulder)

(see notes on following page)

Figure 1. Component Parts



**Figure 2. Fully fused forepart (Triple laminate with shoulder felt)**



### **Method of Make**

1. Body interlining positioned and fused
2. Chest piece and shoulder felt positioned and fused.

### **Number of Operations – Two**

The parts can, however, be laid up and fused in one operation providing:-

- A. It is fused on a continuous fusing. Press where the heat comes from two directions.
- B. The recommended glue line temperature is reached between the double and triple laminated areas without adversely affecting the outer fabric.

### **Note:**

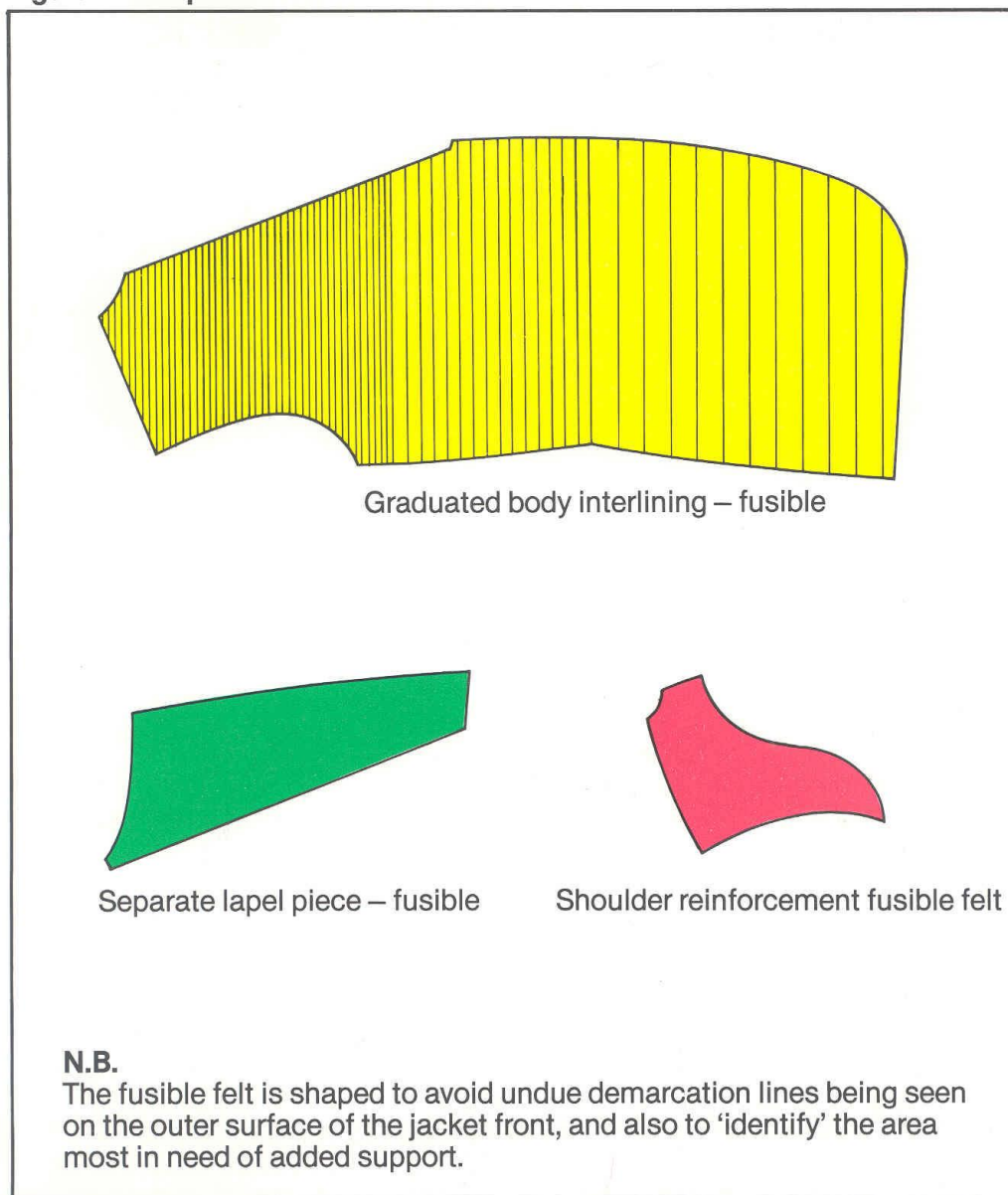
1. Some difficulty can be encountered in reaching these required temperatures, especially on fusing equipment where heat is applied from one direction only.
2. In certain cases a poor bond or inferior surface appearance may be observed when double/triple laminating. The above operation is subject to full tests and/or recommendations being made by the interlining supplier.



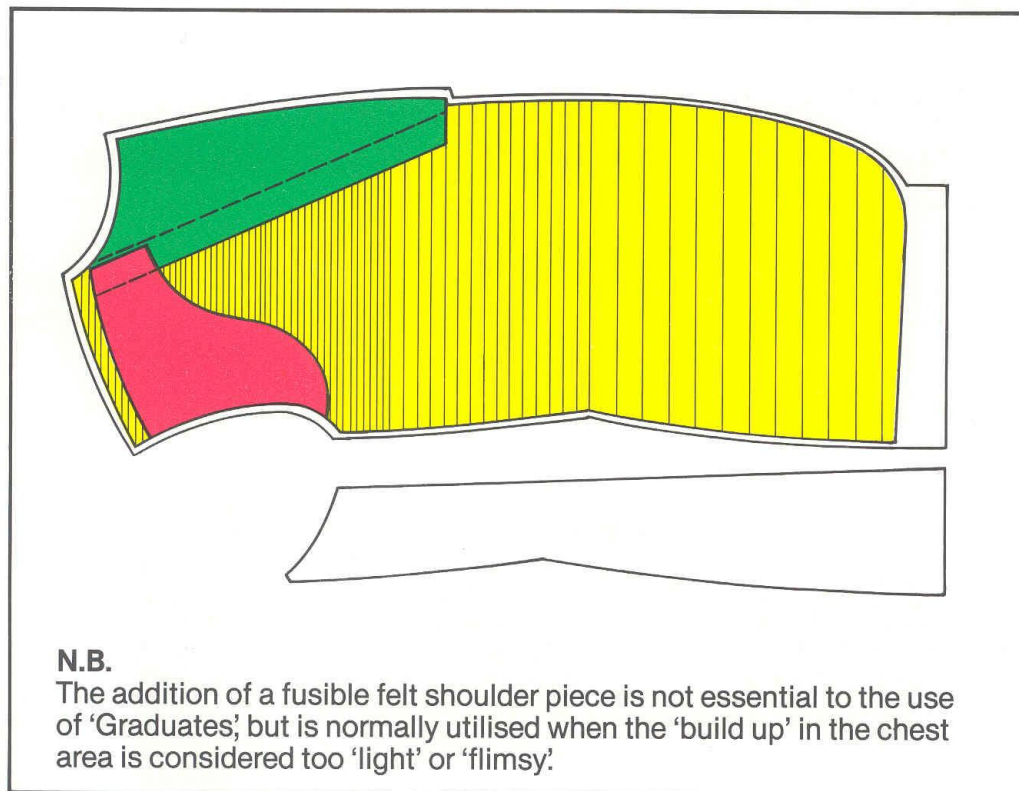
## Interlining Construction – Mens Jackets Fused Fronts

### 6. Multizonal or Tri-zonal (with extra felt fusible shoulder) – ‘Graduated’ (see notes on following page)

Figure 1. Component Parts



**Figure 2. Fully fused forepart ('Graduated' with added shoulder felt)**



### **Method of make**

1. Body interlining positioned and fused.
2. Lapel piece and shoulder felt positioned and fused.

### **Number of Operations – Two**

The parts can, however, be laid up and fused in one operation providing:-

- A. It is fused on a continuous fusing press where the heat comes from two directions.
- B. The recommended glue line temperature is reached between the double laminated areas without adversely affecting the outer fabric.

### **Note.**

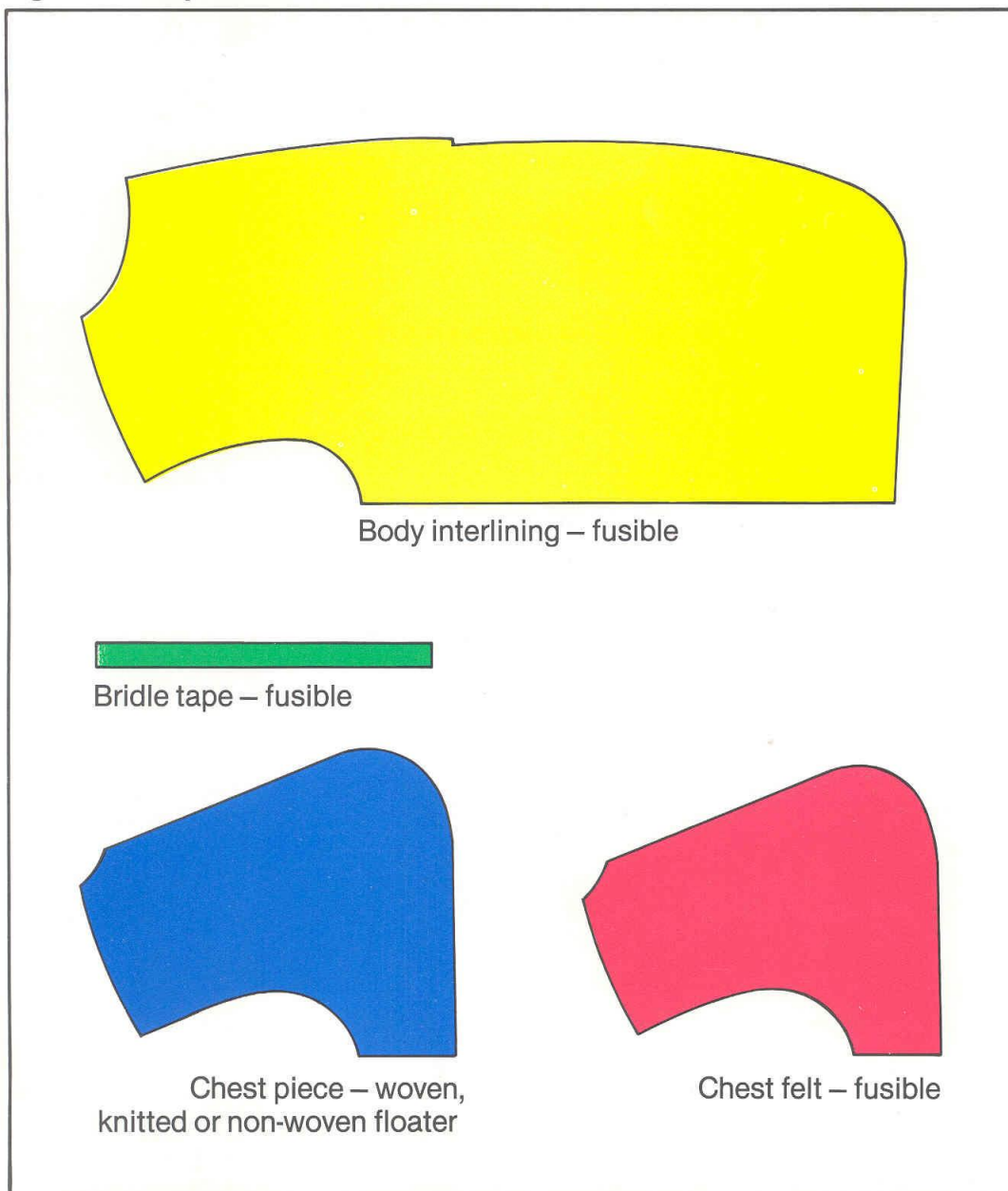
1. Some difficulty can be encountered in reaching these required temperatures, especially on fusing equipment where heat is applied from one direction only.
2. In certain cases a poor bond or inferior surface appearance may be observed when double/triple laminating. The above operation is subject to full tests and/or recommendations being made by the interlining supplier.

## Interlining Constructions – Mens Jackets Fused Fronts

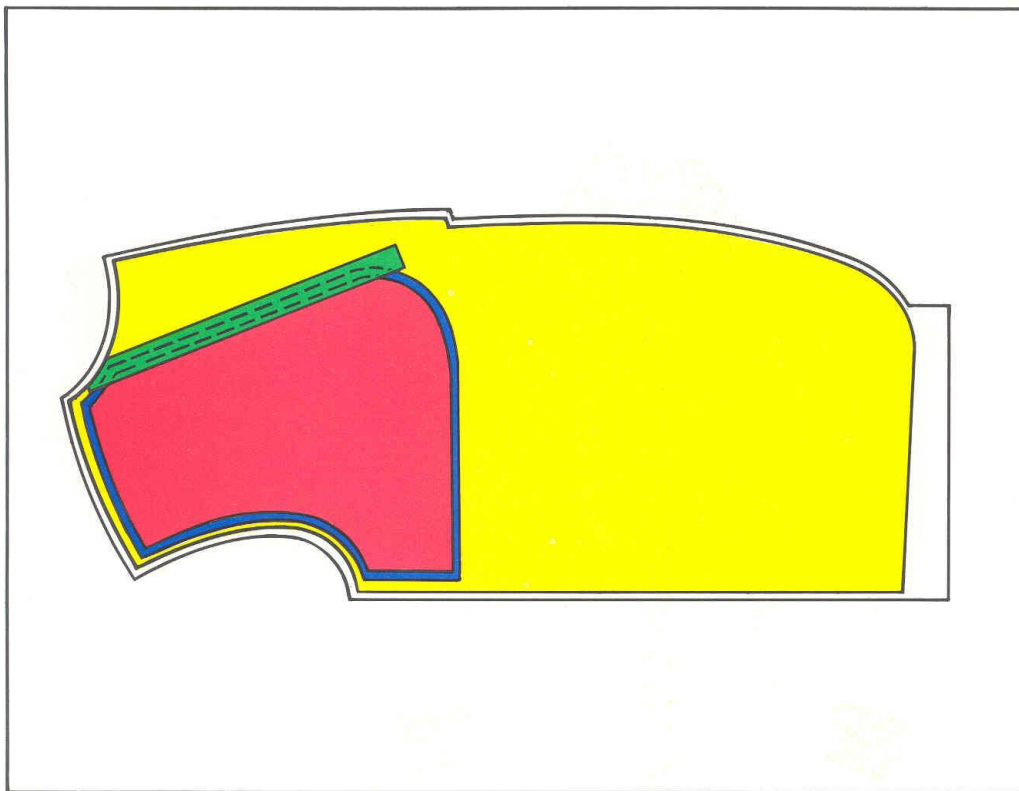
### 7. Floating Chest Piece (Woven, non-woven or knitted with fusible felt and fusible bridle)

(see notes on following page)

Figure 1. Component Parts



**Figure 2. Fully fused forepart**



**Method of make**

1. Body interlining positioned and fused.
2. Floater and fusible chest piece positioned and fused.
3. Floater and fusible chest piece attached to body by fusing bridge tape.

**Note:**

It is possible to combine operations 2 and 3 but obviously this method could cause problems, and therefore all fabric/interlinings should be checked for fusing conditions etc. prior to production commencing.

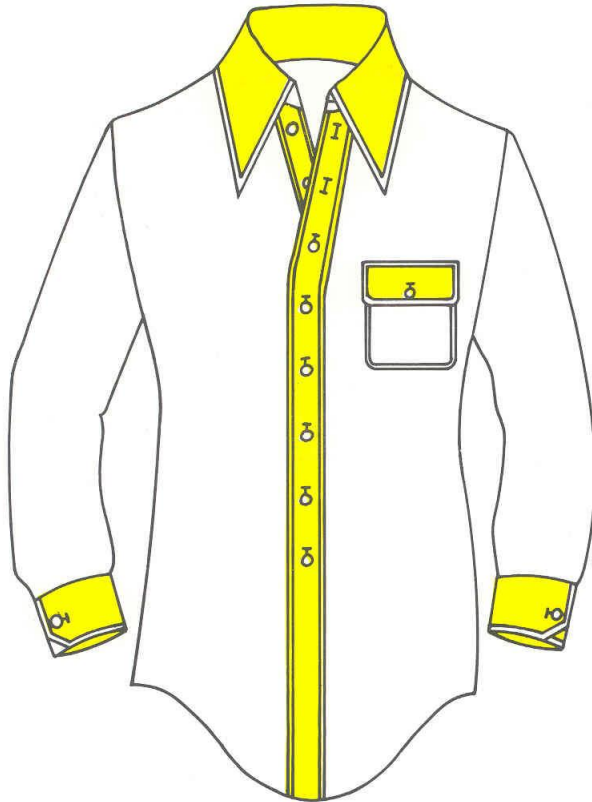
**N.B.**

Please note how the various component parts have been cut smaller to avoid excess thickness in seams etc. and also to avoid press contamination with fusible parts.



# Recommended Vilene Applications for Casual Mens and Boys Shirts

## Suggested Constructions

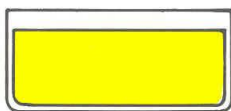


**Collar**  
Skin, Patch  
fusible

**Pocket flap**  
fusible or sew-in

**Plaquet**  
fusible or sew-in

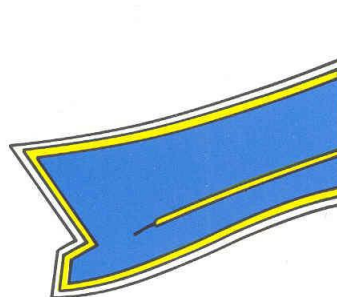
**Cuff**  
fusible or sew-in



**Flap**  
fusible or sew-in



**Cuff**  
fusible or sew-in



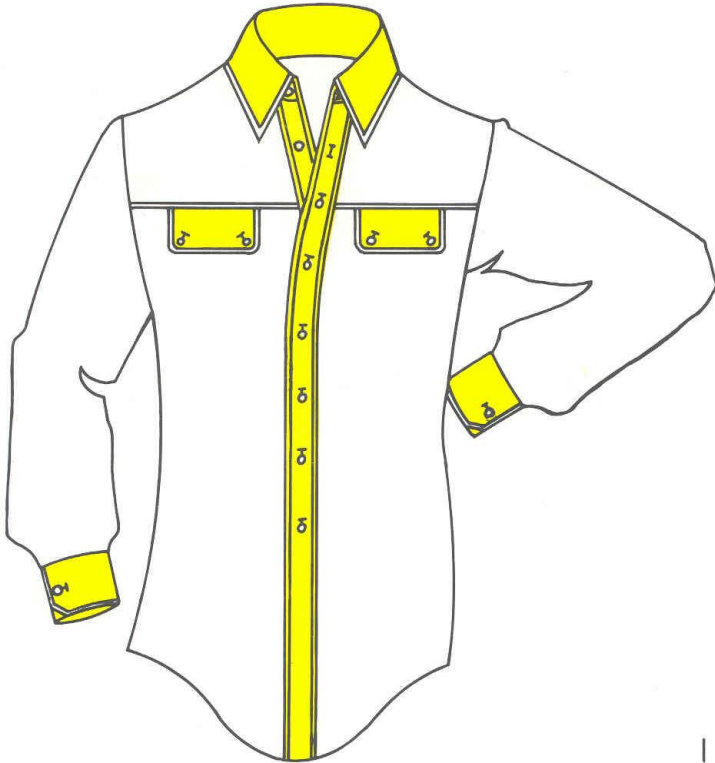
**Collar**  
1. Skin fused all over  
2. Patch with pre-cut break fused with seam allowance removed.

### N.B.

Vilene interlinings shown are cut in the same warp and weft direction as the corresponding fabric component parts.

# Recommended Vilene Applications for Casual Mens and Boys Shirts

## Suggested Constructions



The diagram shows a shirt with yellow Vilene applications on the collar, pocket flaps, cuffs, and along the front placket. Below the shirt are detailed views of these components.

**Collar**  
Skin – fusible or sew-in

**Pocket flap**  
sew-in or fusible

**Cuff**  
sew-in or fusible

**Plaquet**  
sew-in or fusible

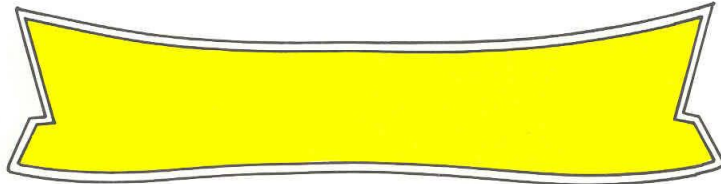
**Flap**  
sew-in or fusible

**Cuff**  
sew-in or fusible

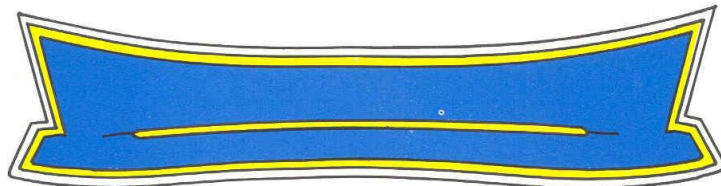
**Collar**  
1. Sew-in cut to cloth shape  
2. Skin fused all over.

**N.B.**  
Vilene interlinings shown are cut in the same warp and weft direction as the corresponding fabric component parts.

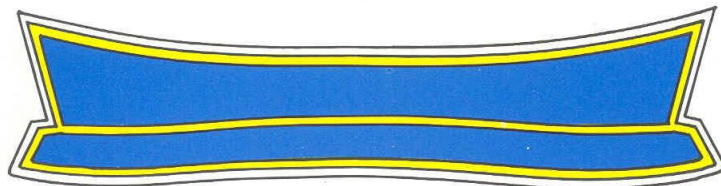
## Shirt Collar Constructions



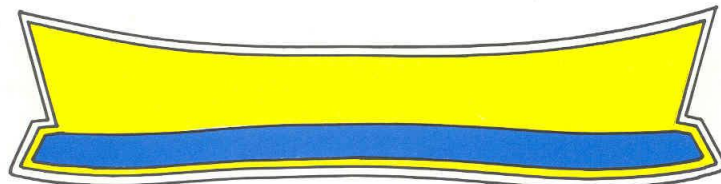
1. Single fused



2. Skin and patch – Patch in one piece with slot for break



3. Skin and Patch – Patch cut in two separate pieces leaving a gap for the break



4. Skin and band patch

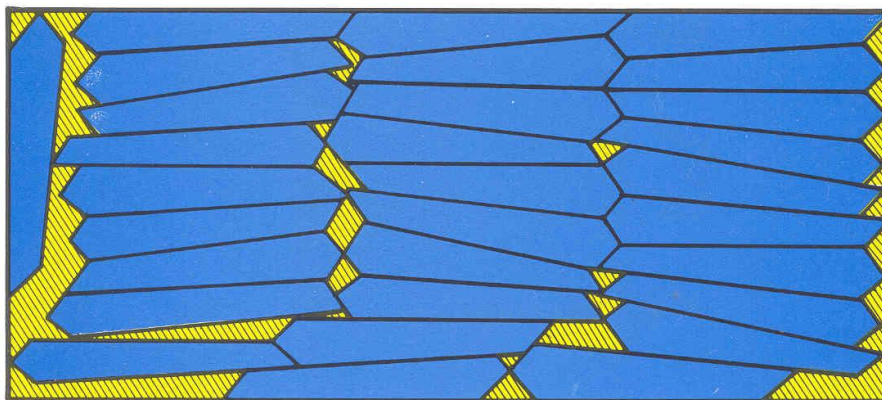
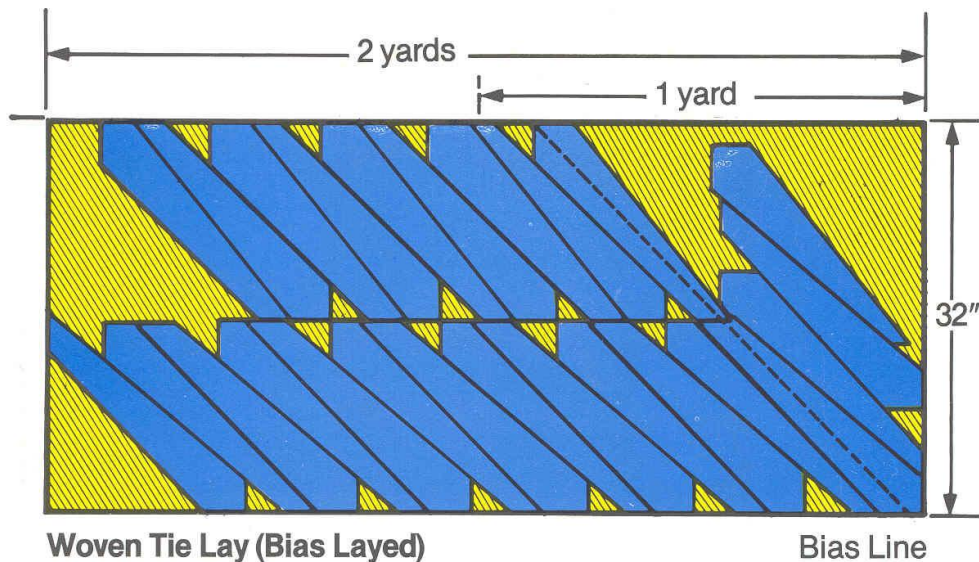
**N.B.**

Patch and skin fused in one operation.



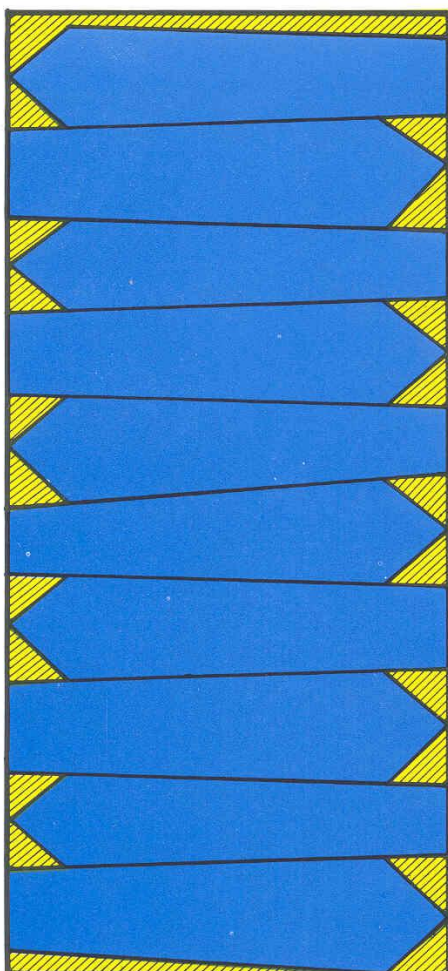
# Mens and Boys Ties

## Tie Lays

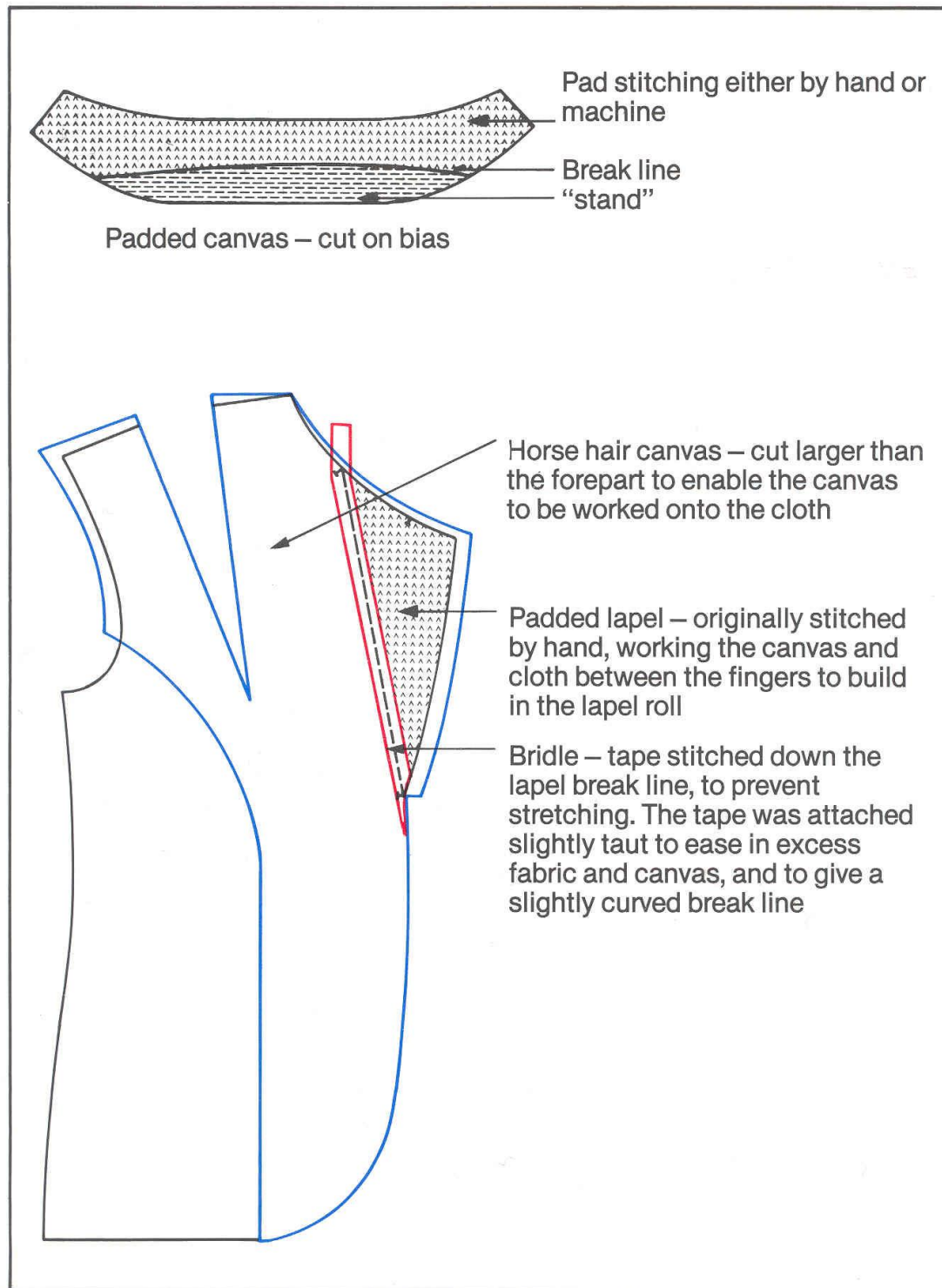


**Nonwoven Tie Lay (Multi directional lay)**

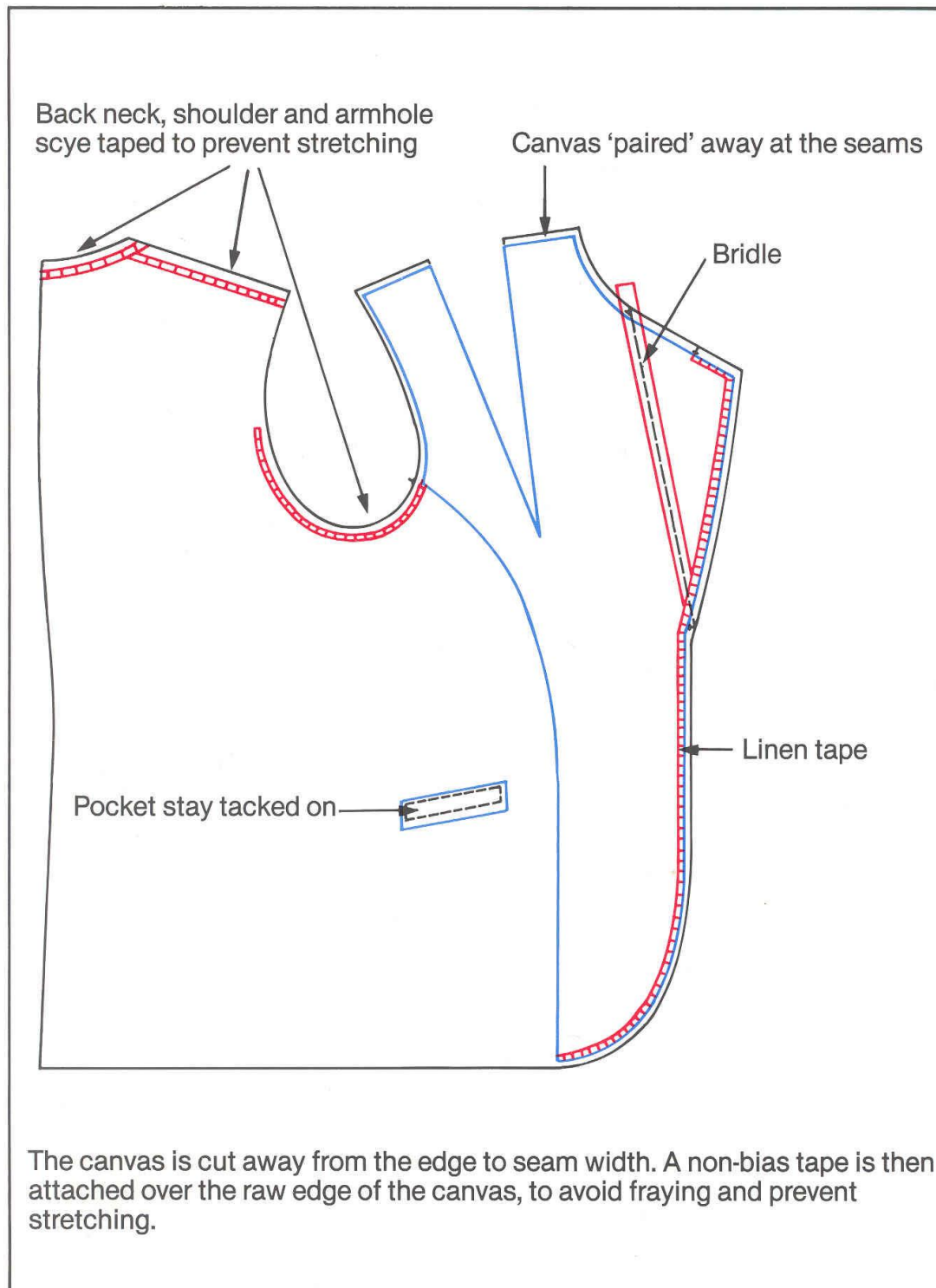
1. Shown above is the difference between a nonwoven and a woven tie lay.
2. We can obtain 8% extra fabric utilisation by using a nonwoven, as can easily be seen.
3. Ties in the non-woven lay can also be cut across the piece.



# Conventional Canvassing Methods in Ladies Tailoring

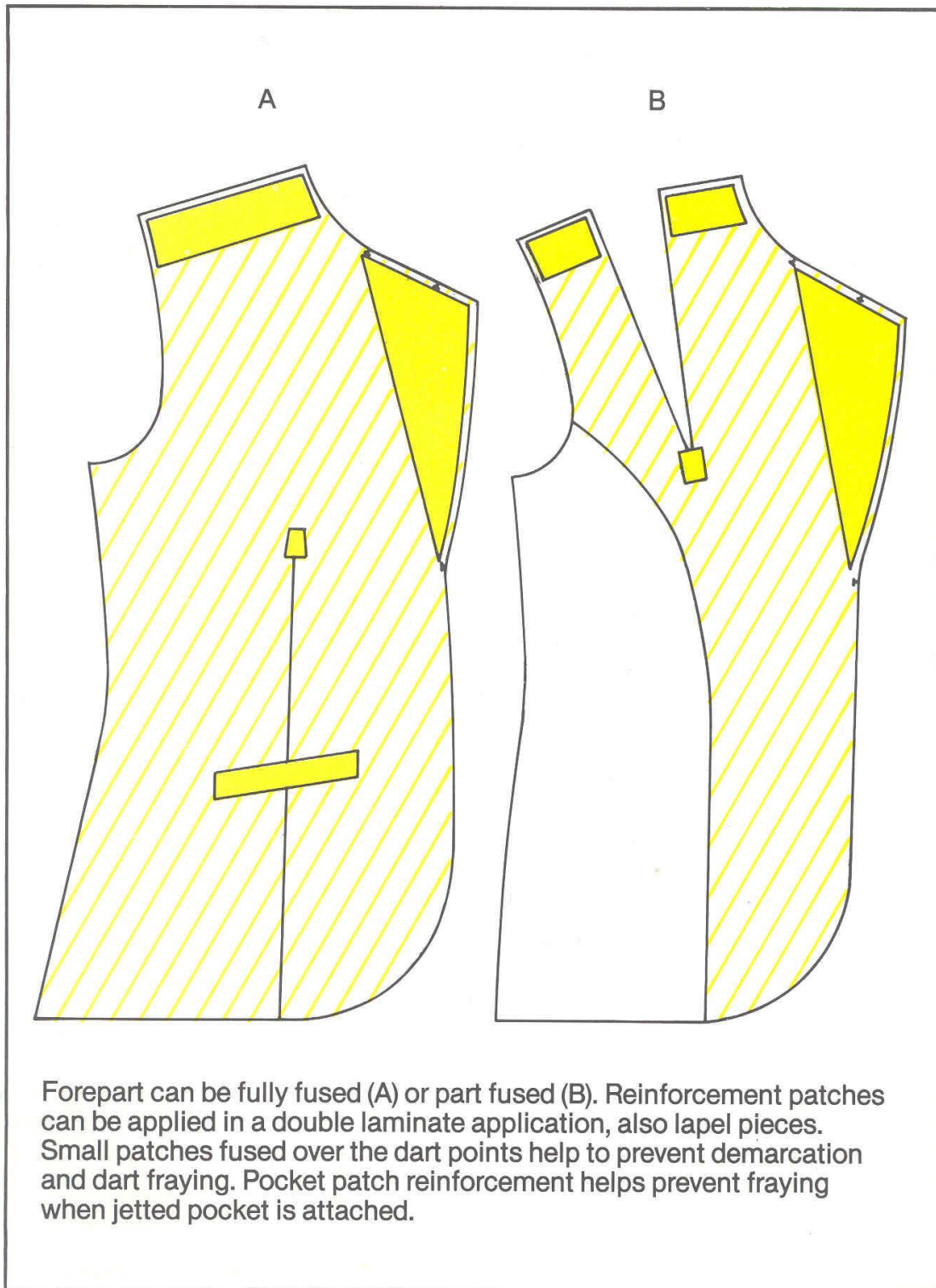


## Conventional Canvassing and Taping, Ladies Tailoring



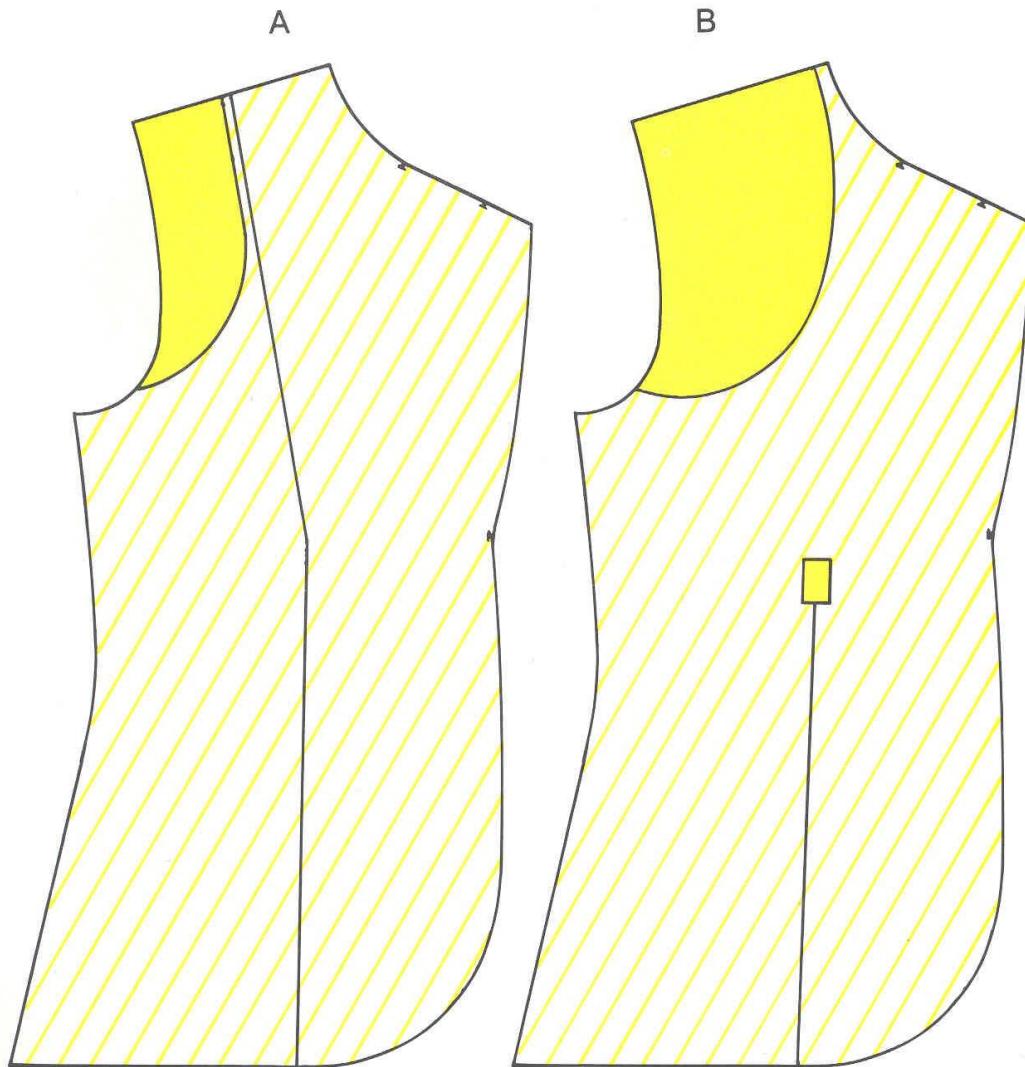


## Ladies Jacket, Lapel and Patch Applications



## Ladies Jacket – Double Laminate Applications

Always cut interlining in the same direction as the cloth to which it will be fused.

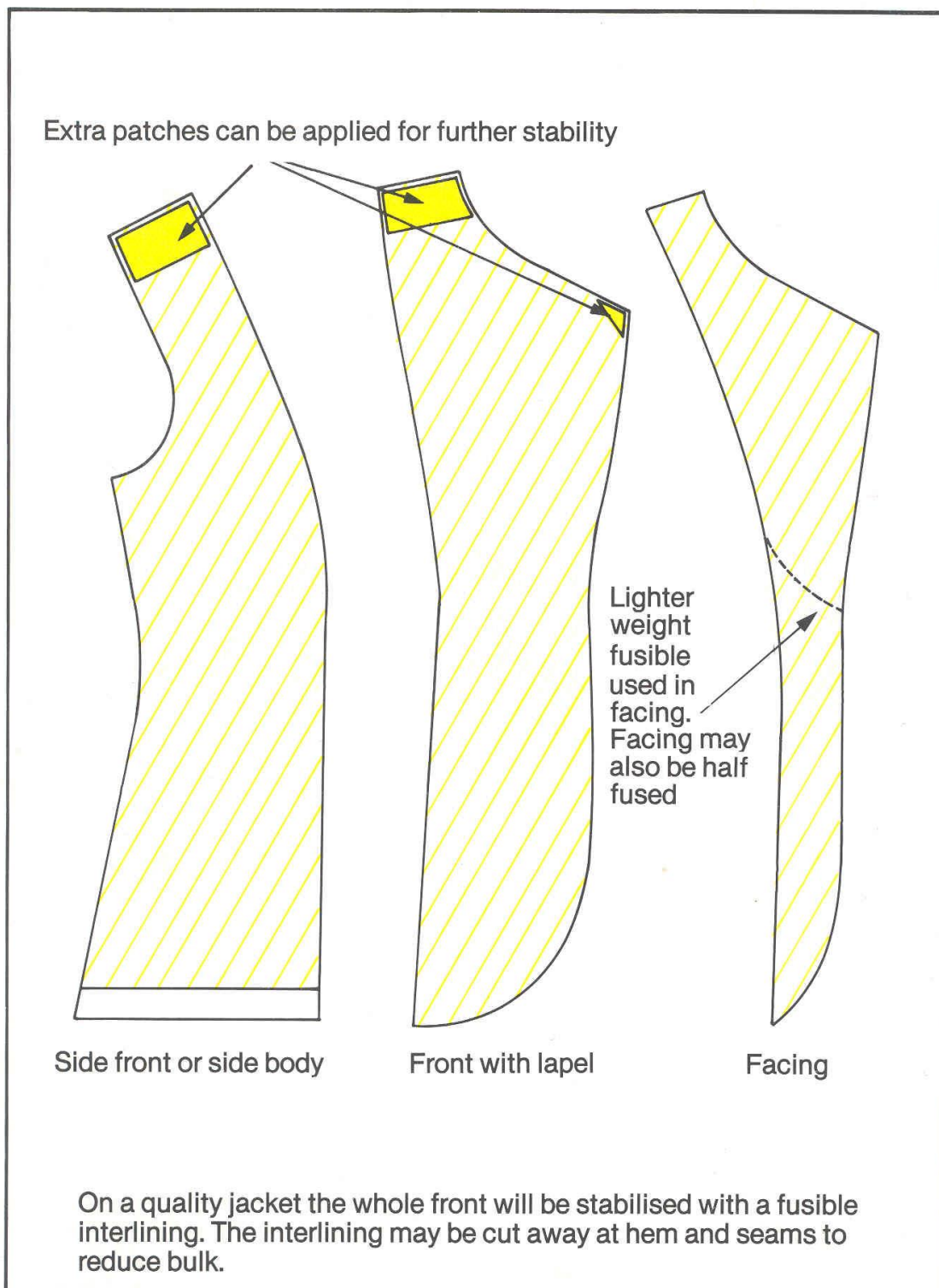


Double lamination can be used to reinforce the shoulder/scye area as in (A) or the shoulder/chest area as (B). This will depend upon the outer fabric stability and weight, and the end result required. In both A and B the forepart is fully fused.

**N.B.**

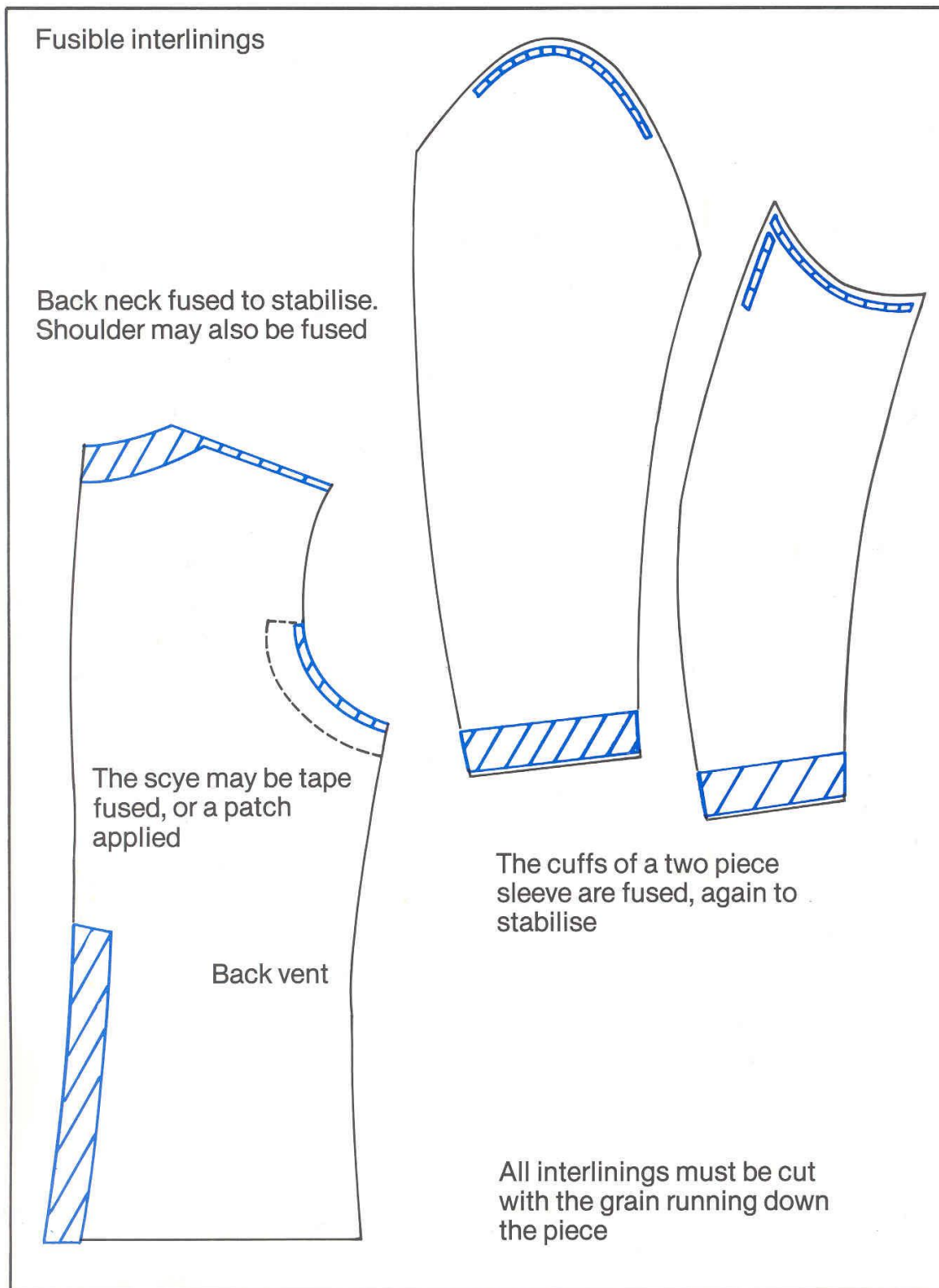
When double laminating, the recommended glue line temperature must be observed at all times.

## Fully fused Ladies Jacket with Patch Applications

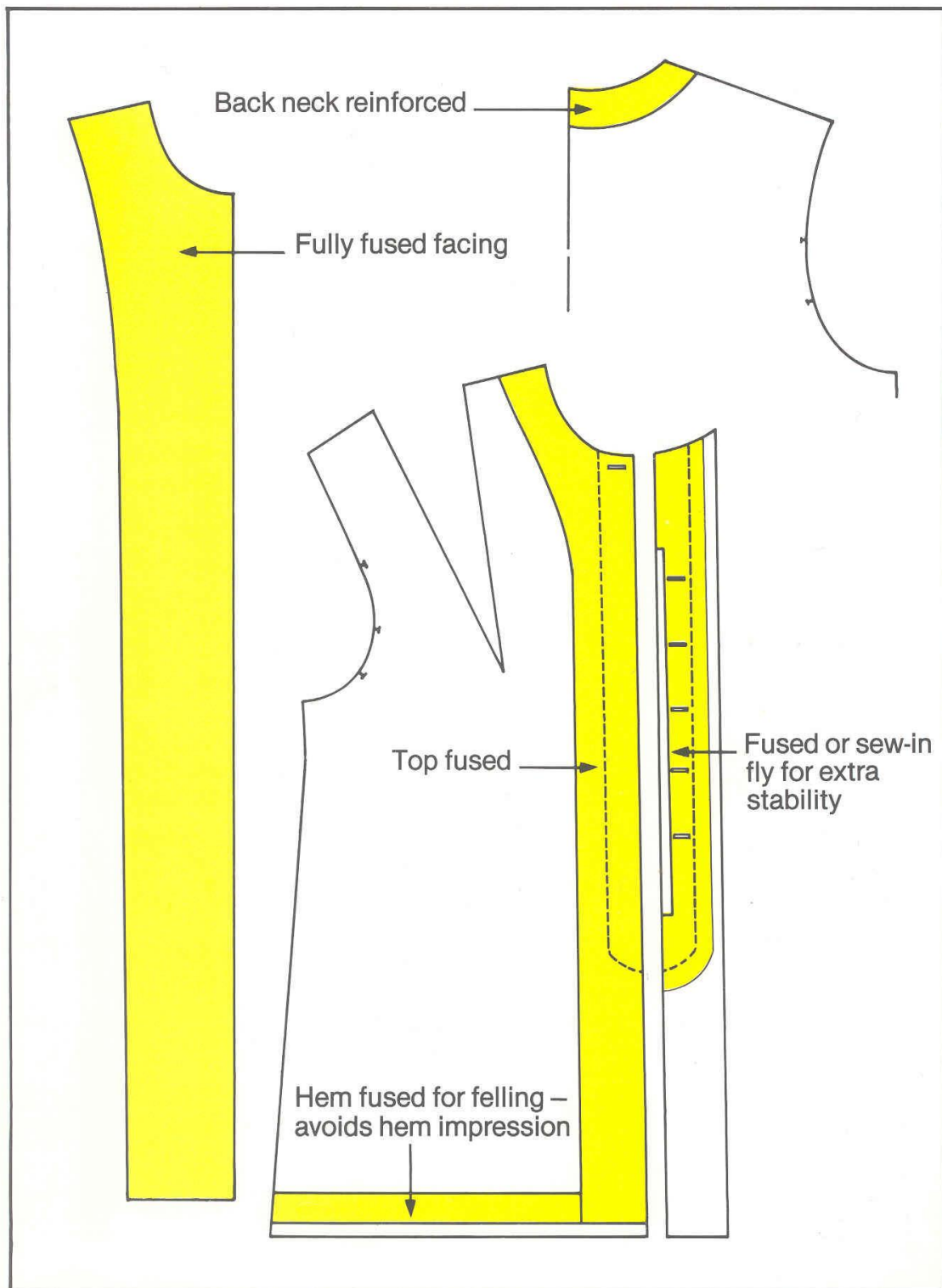




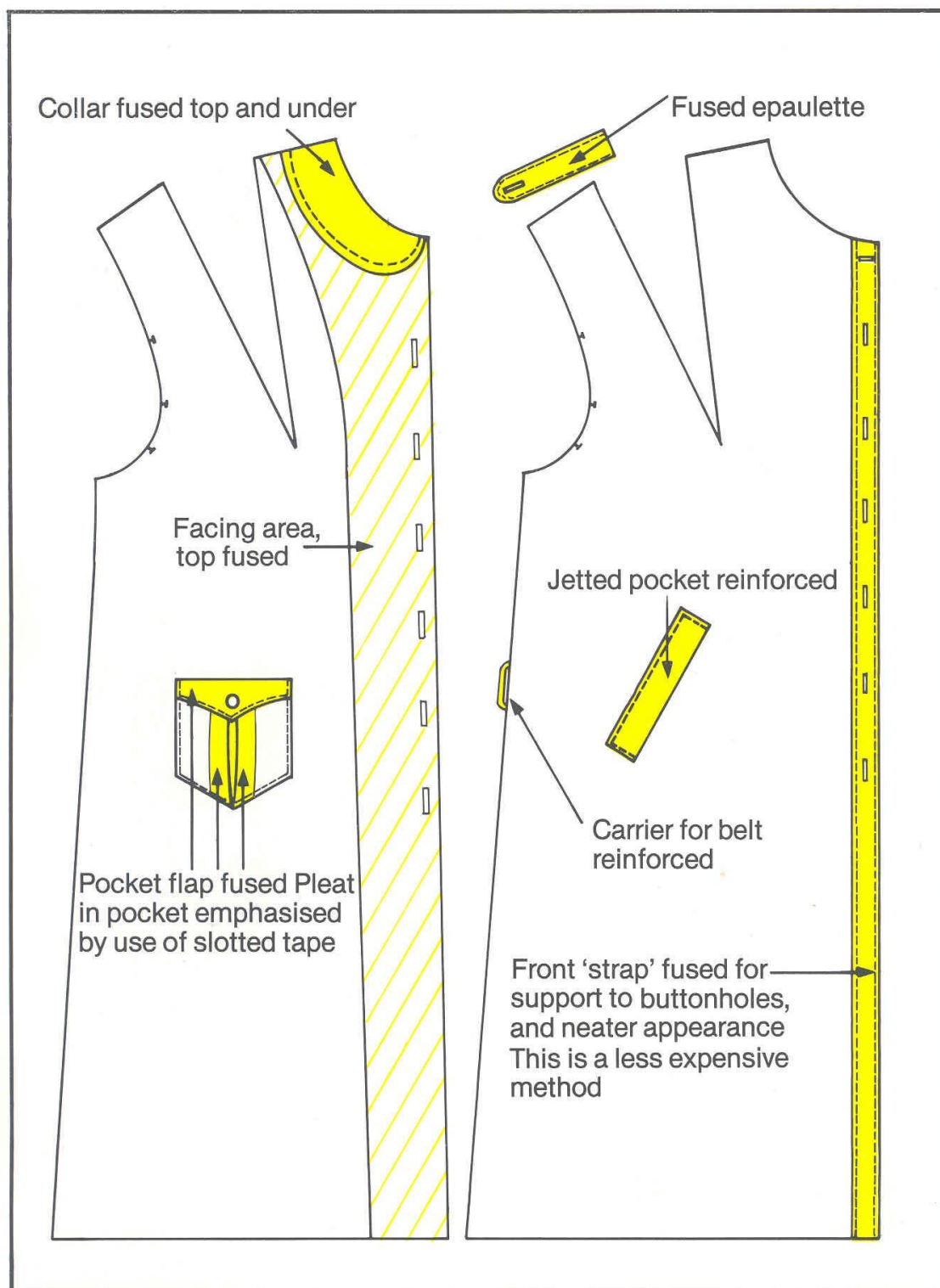
## Small Area Applications, Ladies Jacket



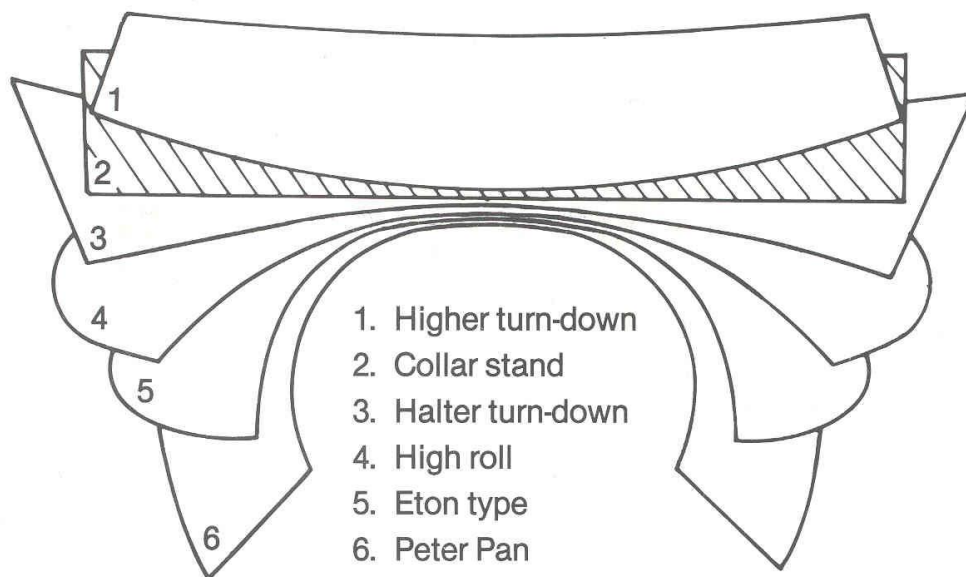
## Ladies Raincoats Facing and Concealed Fly Applications



# Ladies Raincoats, Various Applications



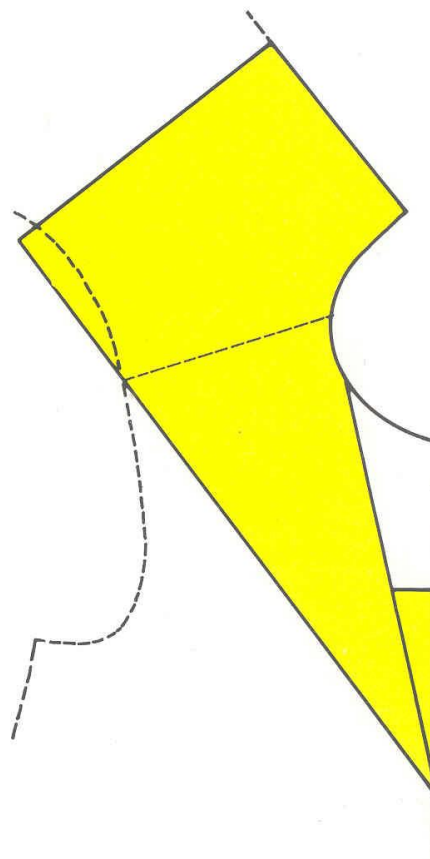
## Collars – Ladies Light Clothing



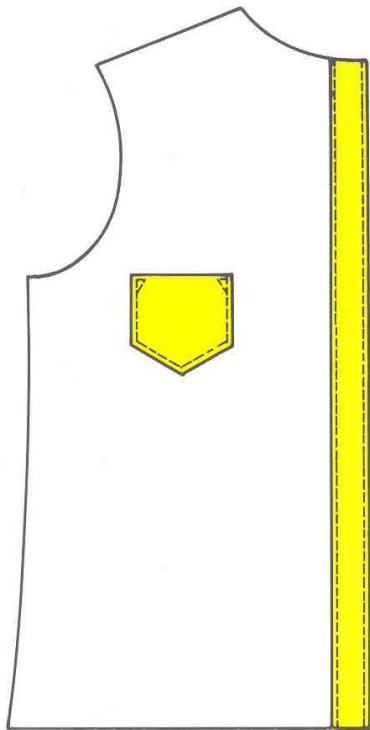
### Sailor Collar

For a smooth finish it is preferable to top fuse the interlining onto the collar. Occasionally this may be reversed due to style or fabric limitations.

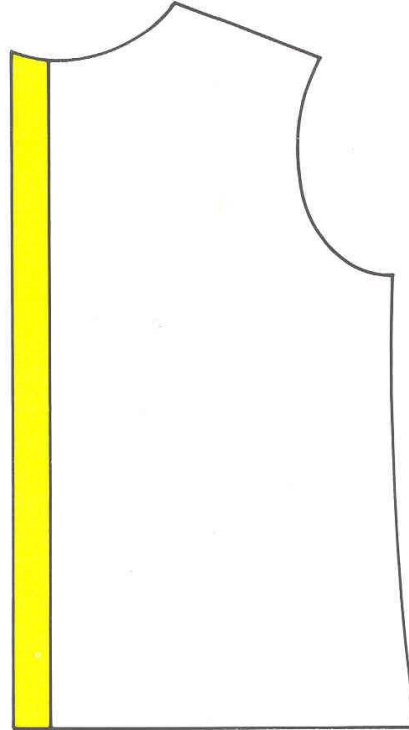
A firmer handle can be obtained by fusing both top and under collar, likewise with a collar and stand.



## Ladies Blouse – Shirt Applications



Shirt placket and pocket interlined



"Grown on" facing interlined



Shirt or blouse cuff



Two piece collar and stand

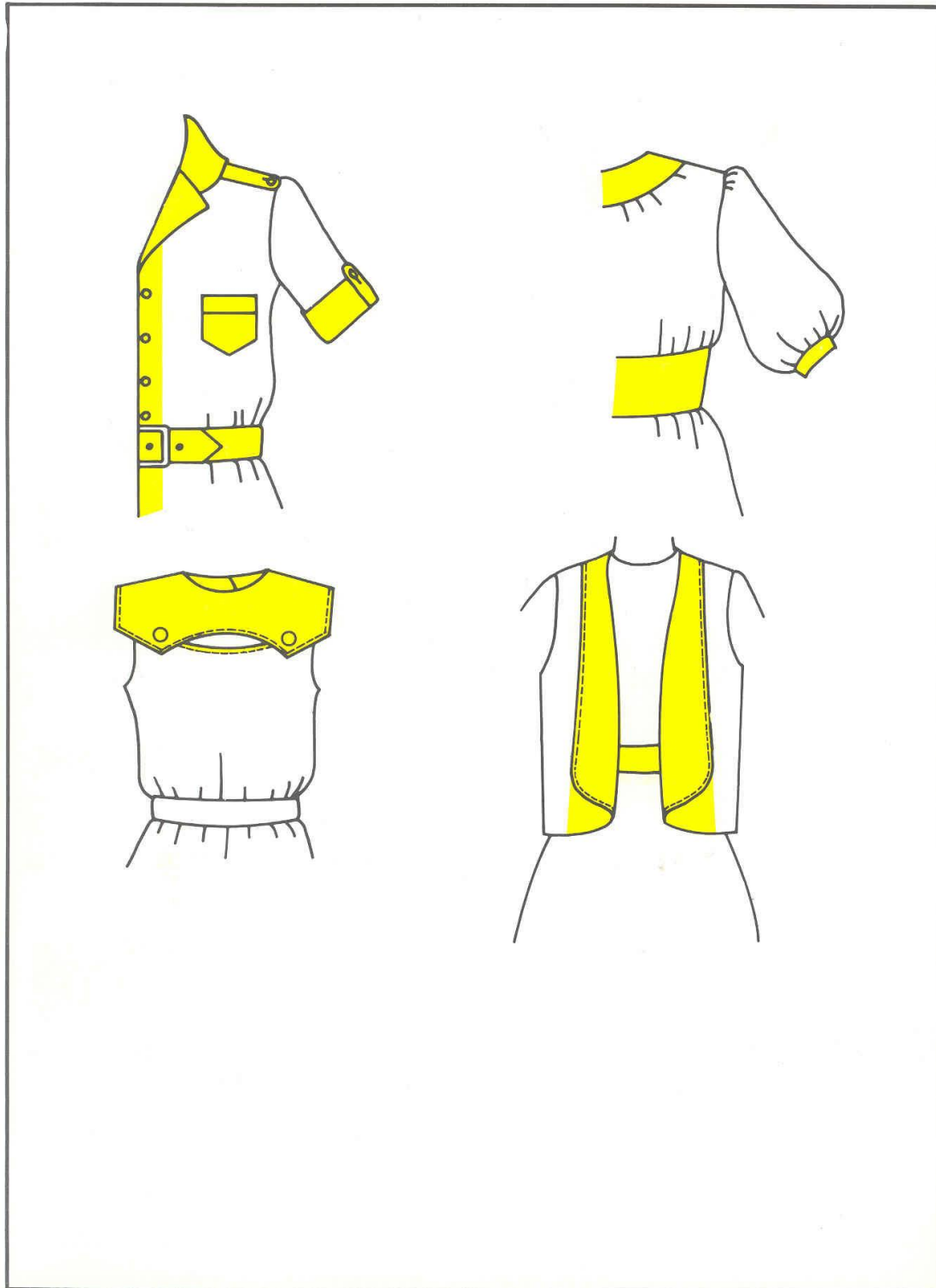
Under normal circumstances, collars and cuffs are top fused. For a firmer handle, top and underfusing may be required



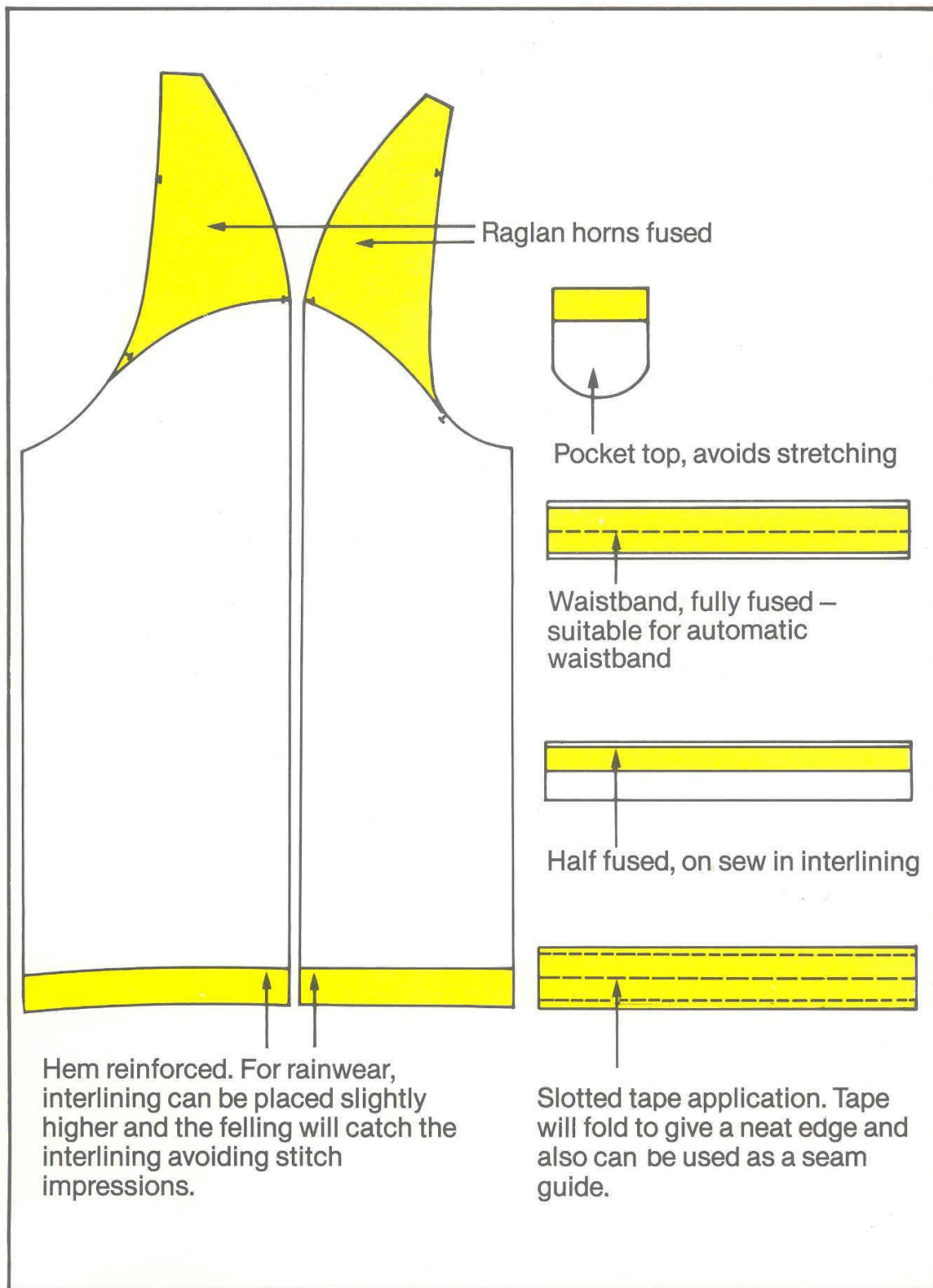
One piece collar



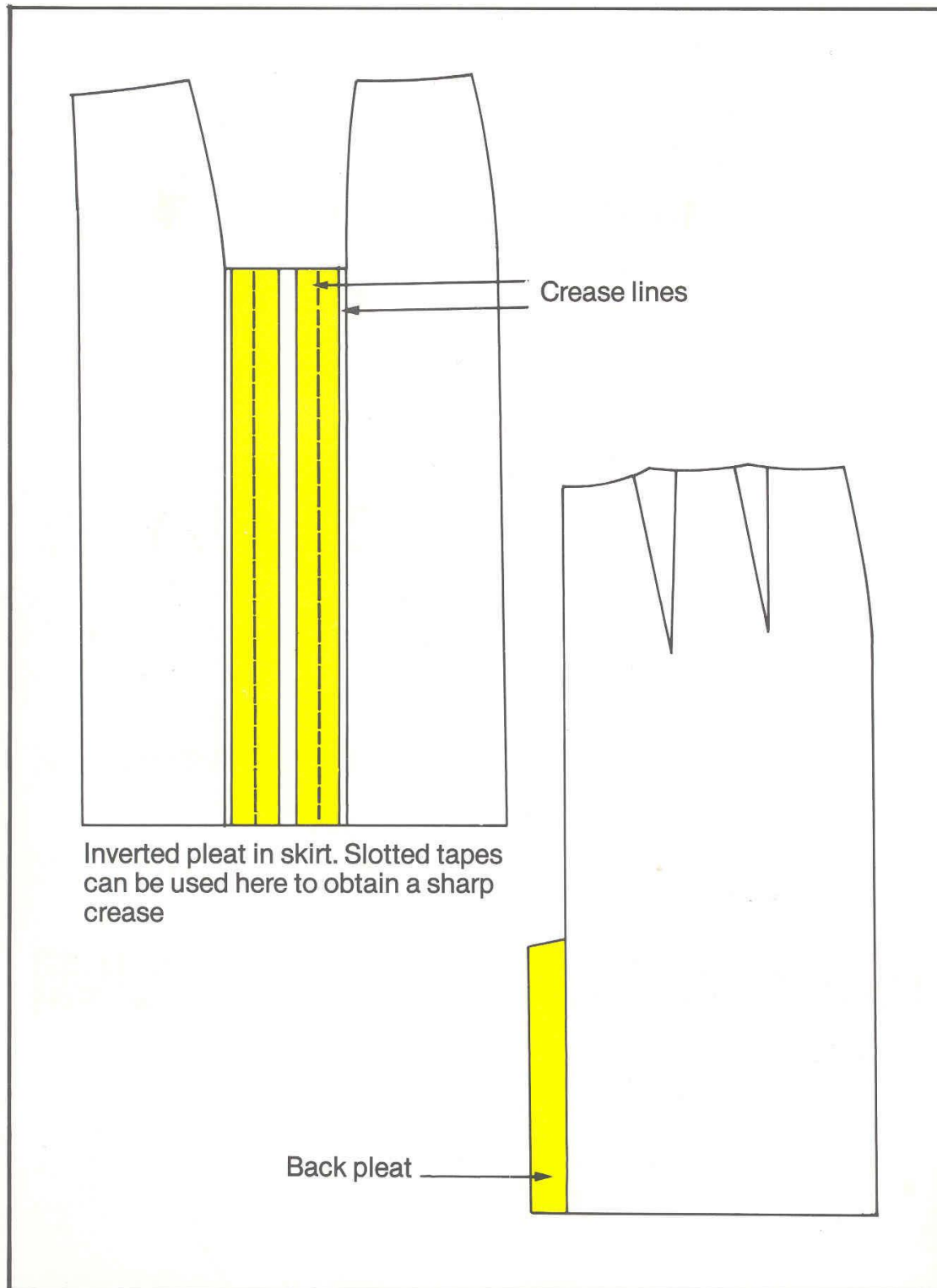
## Small Area Applications, Ladies Light Clothing



## Small Area Applications, and Waistbands



# Ladies Skirt Application



# Ladies Trouser Applications

