

BOMBER JACKET VARIANT

MASTER CONSTRUCTION & PRODUCTION GUIDE

GOLDEN RULE FOR PREMIUM BOMBER CONSTRUCTION: Leather keeps permanent needle holes. You cannot unpick a mistake. Every tailor must test thread tension and stitch settings on scrap pieces of the exact same black premium natural-grain hide before assembly. Because this silhouette uses thick elasticated ribbing at the neck, cuffs, and hem, machine tension must be balanced carefully to avoid pulling, stretching, or warping the leather frames.

1. WORKSHOP PREPARATION & SETUP

- **For the Main Black Leather Body:** Set up the machine with a heavy-duty thread and a **Size 16 or 18 Leather Needle (Wedge Point)**. A standard round needle will catch, drag, punch irregular holes, and tear the hide.
- **For the Interior Silk/Cupro Lining:** Wipe down the feed dogs and walking foot to remove any oil residue. Swap to a fresh, sharp **Size 10 or 12 Needle** and lighter thread to protect the smooth interior fabric.

2. FRONT PANELS & MINIMALIST FRAMING

The front profile delivers "luxury calmness"—a totally clean, minimal surface broken only by the central golden zipper and subtle, flawless seam lines.

EXPOSED CENTER FRONT GOLDEN ZIPPER

- **Stitch Settings:** Straight topstitch, set slightly longer (about 6 to 7 stitches per inch) for a clean luxury finish.
- **How to sew:** Stabilize the front edges by gluing a lightweight fusible stay-tape internally before sewing. Stitch perfectly straight, 2mm to 3mm from the edge. The zipper tape must sit entirely flat; any puckering or waving will compromise the front panel profile.

RAGLAN SLEEVE FRONT SEAMS

- **How to sew:** Unlike standard shoulders, these sleeves curve up gracefully into the collar. Join the seams from the inside, clip the allowances along the curve so they rest smoothly, apply high-quality leather glue, and hammer them entirely flat. No topstitching should show on the outside.

DOUBLE-WELT MINIMALIST FRONT POCKETS

- **How to sew:** Slit and box the pocket windows with extreme precision. The leather welts must align parallel without overlapping. Double-stitch internal pocket bags securely to the inner structural facings to prevent sagging over time.

3. BACK PANELS & THE STRUCTURAL SPINE

RAISED CENTER BACK SPINE SEAM

- **Stitch Settings:** Regular straight stitch, medium-small size.
- **How to sew:** Stitch the center back spine carefully. Open the internal seam allowances, apply leather contact cement, and hammer them flat. Lay an internal cotton stay-tape directly over the seam line on the inside to reinforce the spine and eliminate leather distortion or stretching across the shoulder blades.

SIDE-BACK CURVED PANELING

- **How to sew:** Sew slowly along the structural arching panel seams without pulling or feeding the hide unevenly. These panels shape the bomber's anatomical curves, dropping seamlessly toward the lower ribbing frame.

LOWER LATERAL VENTS (HIDDEN KIKOY REVEAL)

- **Fabric Preparation:** Pre-wash and steam-iron the handwoven Kikoy inserts to eliminate any risk of future internal shrinkage.
- **Pleat Apex Reinforcement:** The top point of each vent takes heavy movement tension. Lock this area down internally with a 2 to 3-pass hidden bar-tack.
- **Stitching the Vents:** Join the Kikoy inserts to the inner pleat walls with a loose machine thread tension. This guarantees the handwoven fabric won't pull, pucker, or dimple the outer black leather frame. The vibrant pattern must remain completely hidden, revealing its color only through active movement.

4. RIBBED OPENINGS & CLOSURES

COLLAR, CUFF, & HEM RIBBING ATTACHMENT

- **How to sew:** Stretch the heavy elasticated knit ribbing uniformly as you stitch it to the flat leather panels. Use a durable lockstitch from the inside. Fold the leather frame over cleanly so that all raw edges are bound safely out of sight inside the lining.

5. LINING & INTERIOR FINISHING

- **Full Lining Construction:** Assemble the premium lining using tight straight stitches (10 to 12 stitches per inch) to prevent fraying along the seams.
- **Center Back Ease Fold:** Leave a loose, unstitched ½-inch vertical fold along the spine of the lining fabric. Never stitch this flat; it ensures the wearer can reach forward naturally without stress or tear risks to the interior fabric.



QUALITY CONTROL CHECKLIST FOR THE BOMBER

1. **Symmetry Check:** Ensure the raglan seam lines and lateral back vents mirror each other identically across both sides.
2. **Ribbing Tension:** Check that the waist and cuff ribbing sit flush without causing the adjoining leather frame to buckle or bunch uncomfortably.
3. **Spine & Seams:** Run hands across the raised center back spine and panel joins—ensure all interior allowances are glued and hammered perfectly flat.
4. **Zero Residue:** Inspect both the outer premium leather and inside lining for stray glue marks or machine oil.