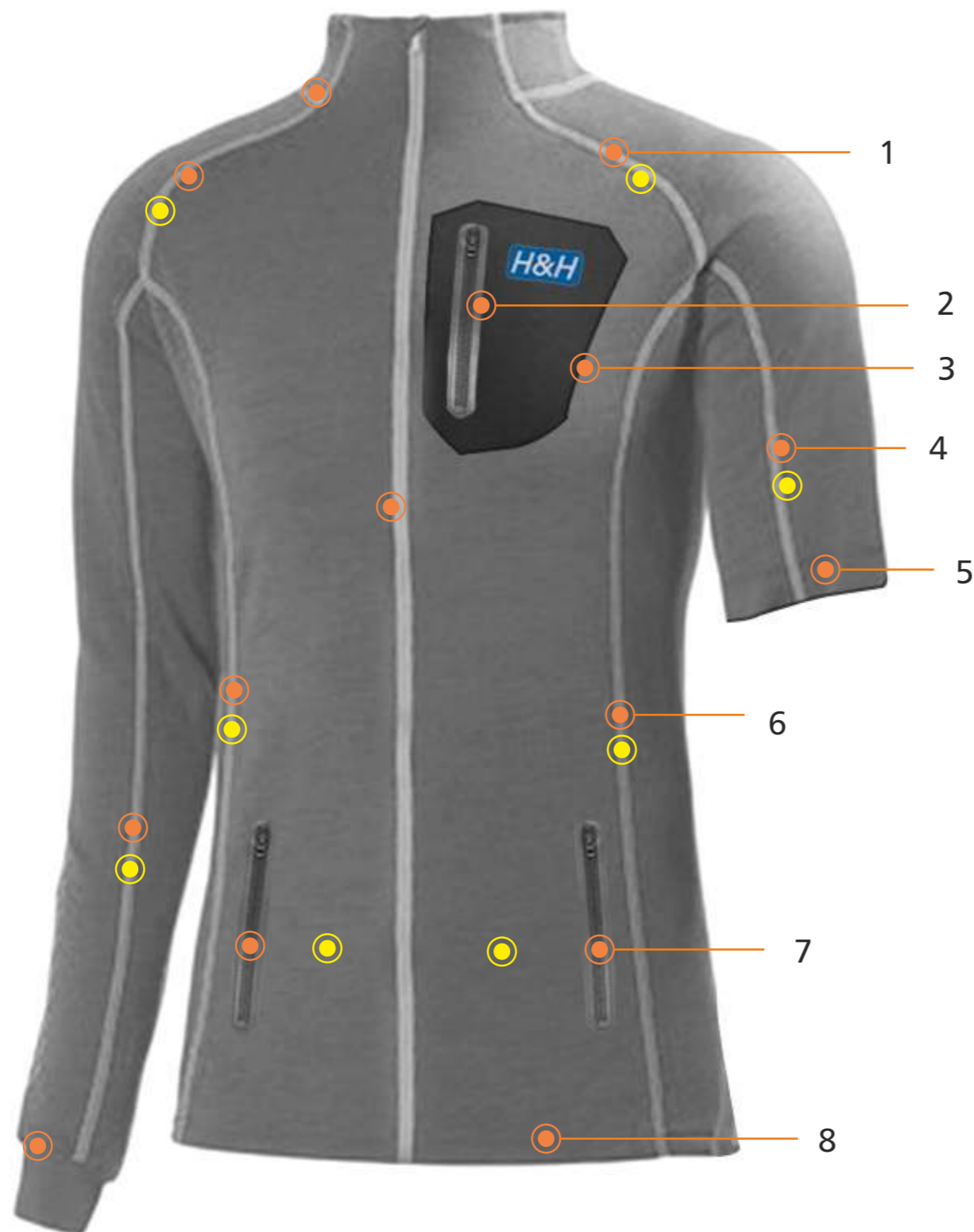


T-SHIRT BONDING LINE MACHINE RECOMMENDATION



1. Seam Construction - Overlap Seam

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

1. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

2. Zipper Bonding (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

3. Pocket Bag (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-686 spec A-F2A1-030030

4. Seam Construction - Overlap Seam

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

4. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

5. Sleeve Hemming

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Hem with Correct width by spotting - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Smart Bonding Press after final inspection - CS-651 spec A-A2R2-120073R050 (Mens and Boys Dia of sleeve reconfirm from customer)

6. Seam Construction - Overlap Seam

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD-100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Smart Bonding Press after final inspection - CS-659 spec V-A1A1-090007

6. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

7. Zipper Bonding (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

7. Inside Pocket Bag (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-686 spec A-F2A1-030030

8. Bottom Hemming

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Hem with Correct width by spotting - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Smart Bonding Press after final inspection - CS-667 spec V-A1A1-300095R191 (Slit Bottom Hem - CS-659 spec V-A1A1-0900 CS-660 spec V-A1M2-090007, Round Bottom Hem - CS-665 spec V-A1A1-060012)

Cont. next page

T-SHIRT BONDING LINE MACHINE RECOMMENDATION

9. Rib attach by stitching - Choice of customer Overlock or Overlock + Cover Stitch

10. Zipper Bonding (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

10. Inside Pocket Bag (Laser Cut machine is recommended)

- Spotting of Double sided Glue and Overlay Tape step by step - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam with Special Mould and by Hot and Cool Smart Bonding Press after final inspection - CS-686 spec A-F2A1-030030

11. Seam Construction - Overlap Seam

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Smart Bonding Press after final inspection - CS-659 spec V-A1A1-090007

11. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

12. Seam Construction - Overlap Seam

- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Smart Bonding Press after final inspection - CS-659 spec V-A1A1-090007

12. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

13. Front Zipper Attach

- Stitch the Zipper with Panel left and Right
- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Fold the Zipper by spotting - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam Hot and Cool Smart Bonding Press after final inspection - CS-681 spec V-F2A1-100010

14. Seam Construction - Overlap Seam

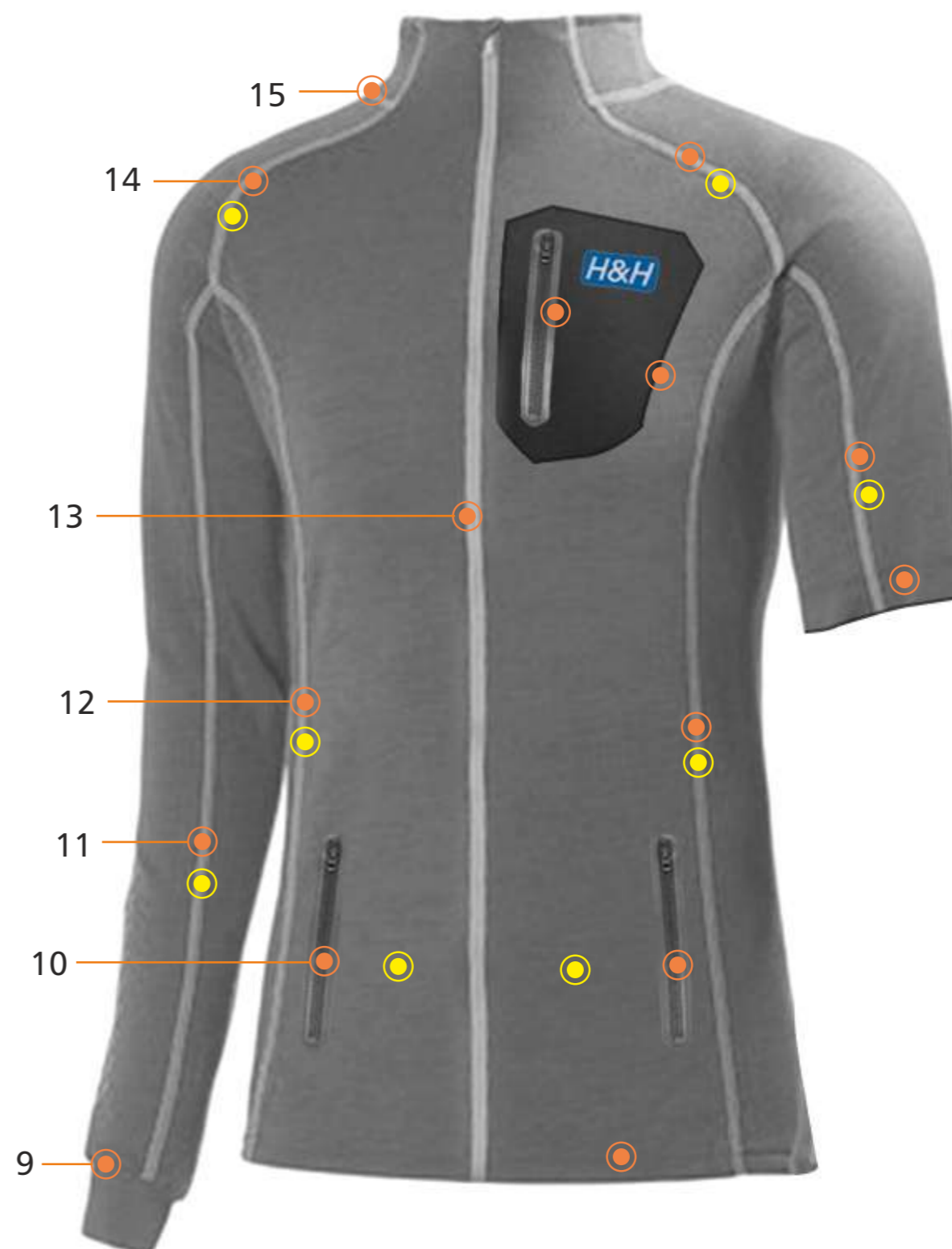
- Laydown the double side glue tape on one fabric panel together with fabric edge trimming - SF-816.
- Place the another fabric panel correctly by spotting - TD 100 (Portable bonding press station) normal vacuum table which is available in factory
- Press the seam by Hot and Cool Smart Bonding Press after final inspection - CS-661 spec A-F2A1-030010 + CL-50

14. Seam Construction - Butt Seam

- Joint the two fabric panel by Ultrasonic Machine - US-501
- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

15. Neck Hemming or Joining - Rib attach by stitching - Choice of customer Overlock or Overlock + Cover Stitch

- Apply SRT (Seam Reinforcement Tape) by Hot Air Machine - AI-001 spec A-NNN

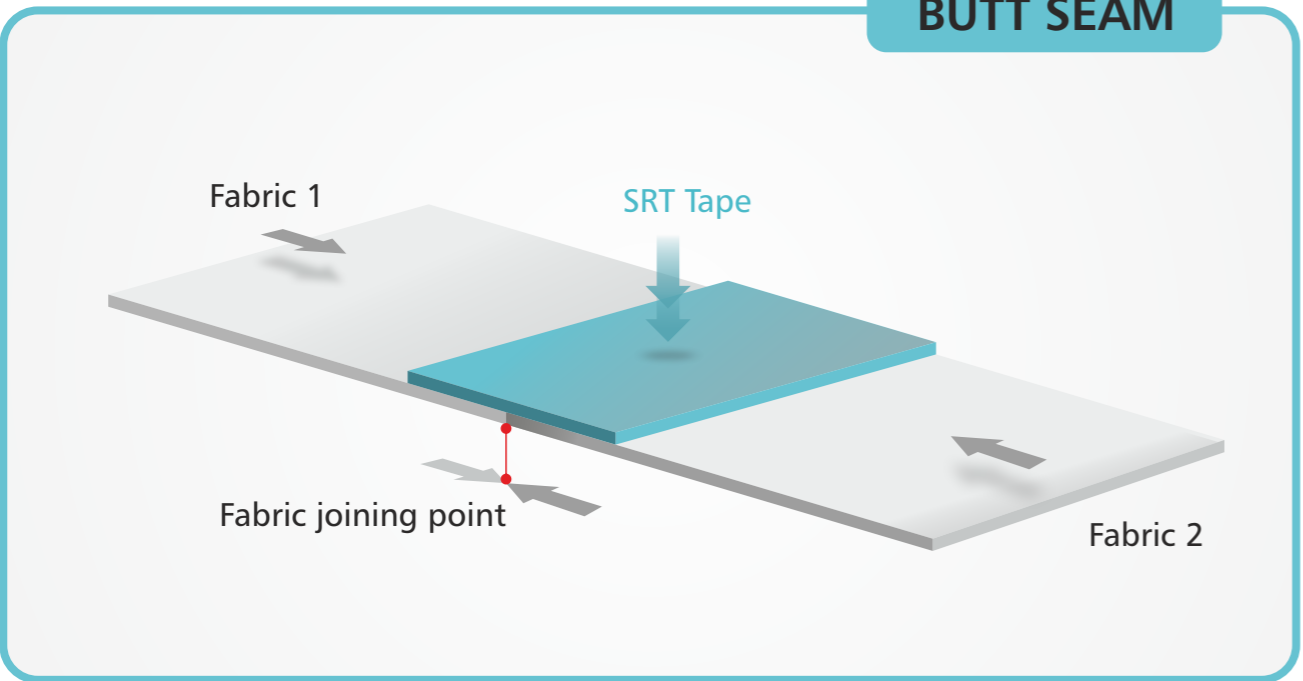


Special notes -

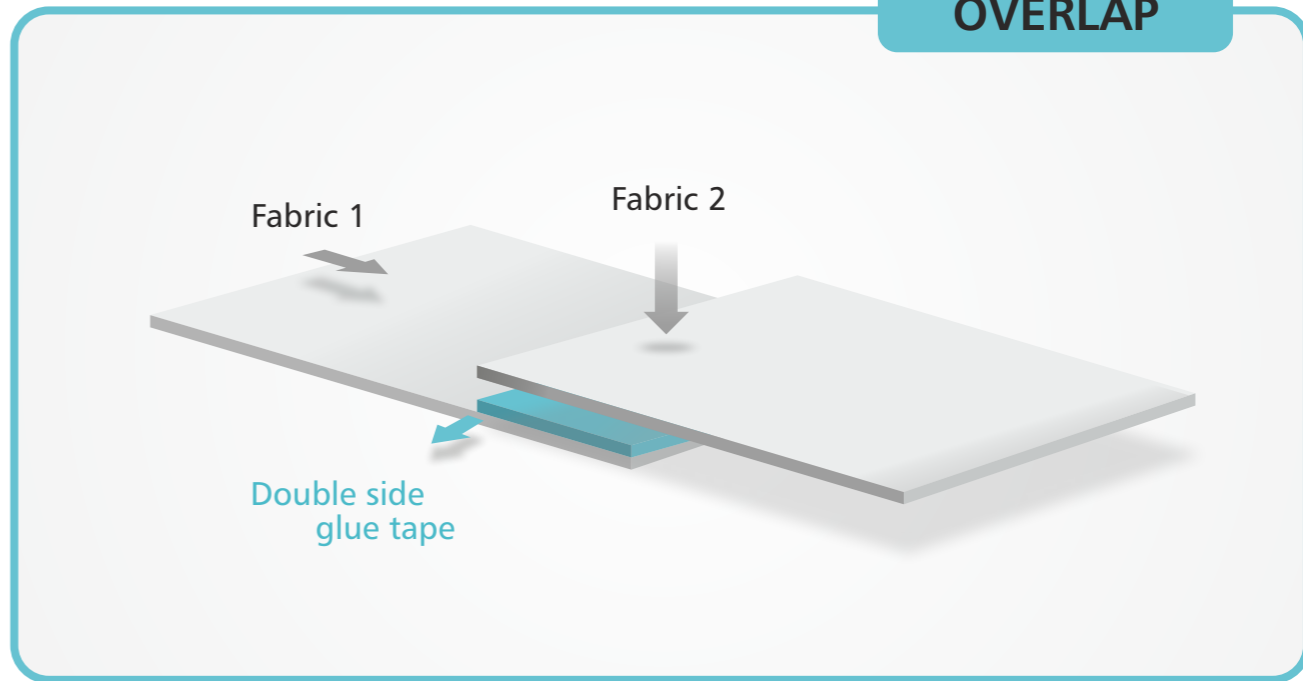
- Machines are recommended as a guide line to this picture
- All machines are recommended as per top model configuration
- For Best result We recommend for all curve and zipper the Hot and Cool Smart Bonding Press Machines
- Presses sizes finally need to rechecked while measuring the seam length and as per production requirement
- Multi Purpose Press Large Area - in case the panel colour change then we need full panel top press one time - MEPP 150XTP (size need to be checked with customer)

SEAM CONSTRUCTION

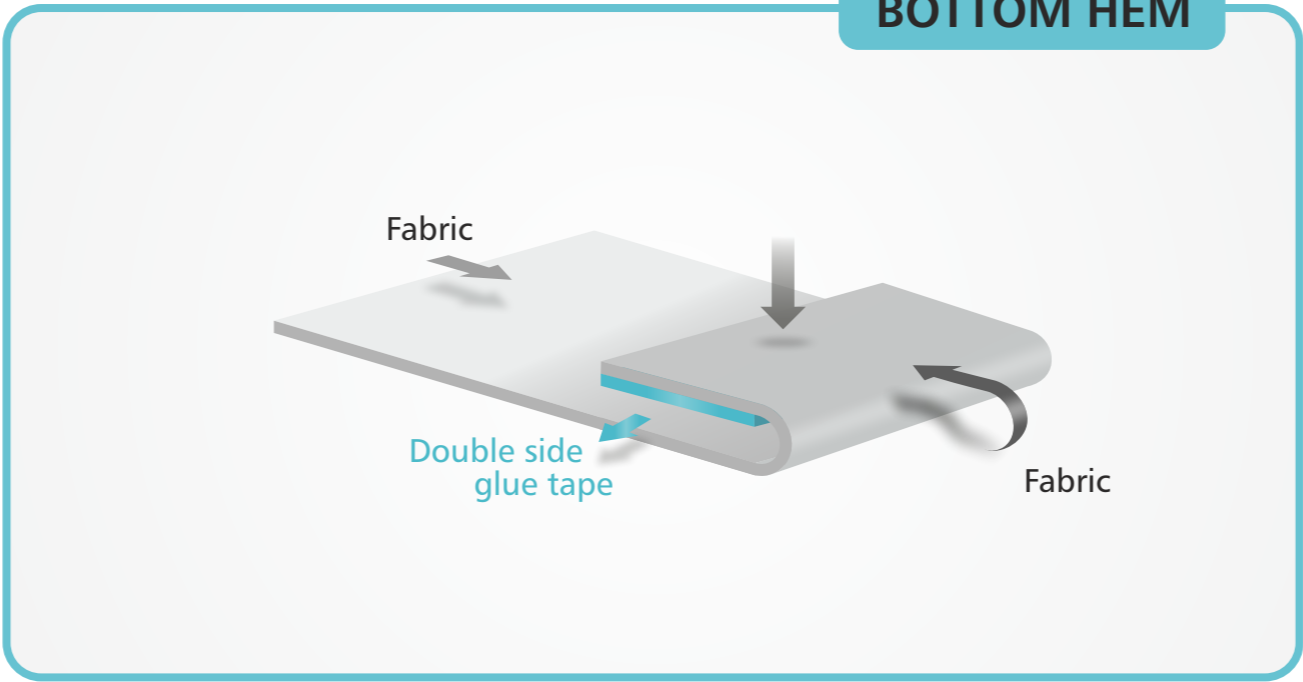
BUTT SEAM



OVERLAP



BOTTOM HEM



RECOMMENDED MACHINES



TD-100
PORTABLE BONDING
PRESS STATION



AI-001
AI-001 spec A-NNN
HOT AIR SEALING MACHINE



SF-816
SEWFREE TAPE LAYDOWN + TRIMMER



US-501
SEWFREE ULTRASONIC MULTI-PURPOSE WELDER



CS-651
CS-651 spec A-A2R2-120073R050
AUTOMATIC CUFF PRESS MACHINE



CS-659
CS-659 spec V-A1A1-090007
PNEUMATIC FLAT PRESS MACHINE



CS-660
CS-660 spec V-A1M2-090007
PNEUMATIC FLAT PRESS MACHINE



CS-661
PNEUMATIC FLAT COOL + HEAT PRESS MACHINE
PNEUMATIC FLAT COOL + HEAT PRESS MACHINE



CS-665
CS-665 spec A-A1A1-060012
PNEUMATIC FLAT PRESS MACHINE



CS-667
CS-667 spec V-A1A1-300095R191
PNEUMATIC CURVE PRESS MACHINE



CS-686
CS-686 spec A-F2A1-030030
PNEUMATIC FLAT COOL + HEAT PRESS MACHINE