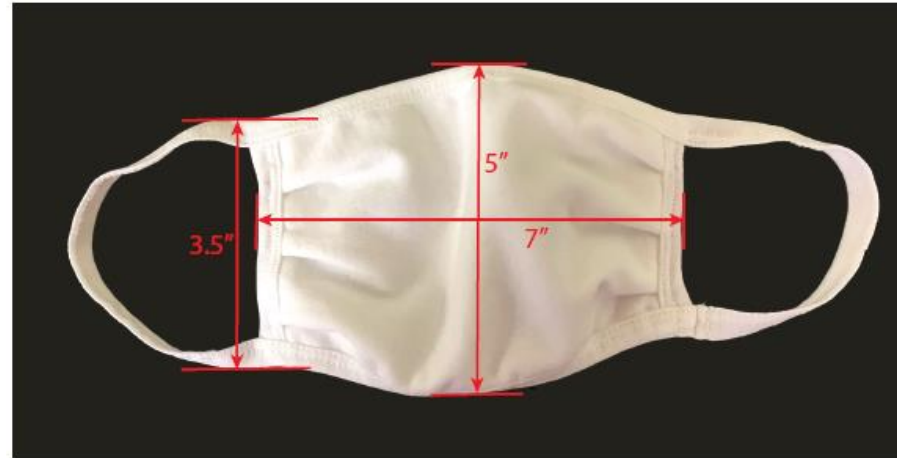
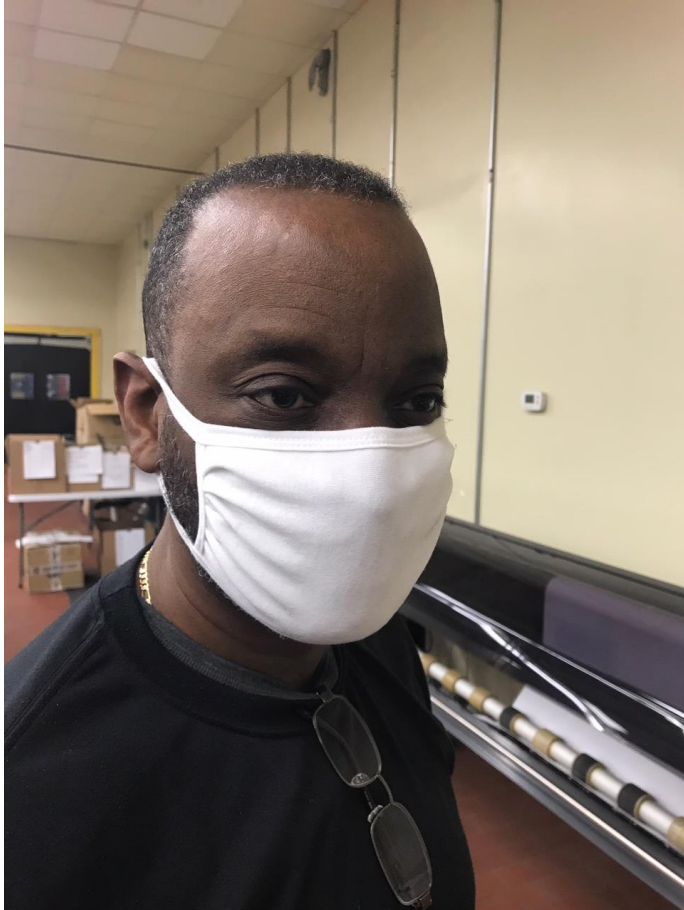
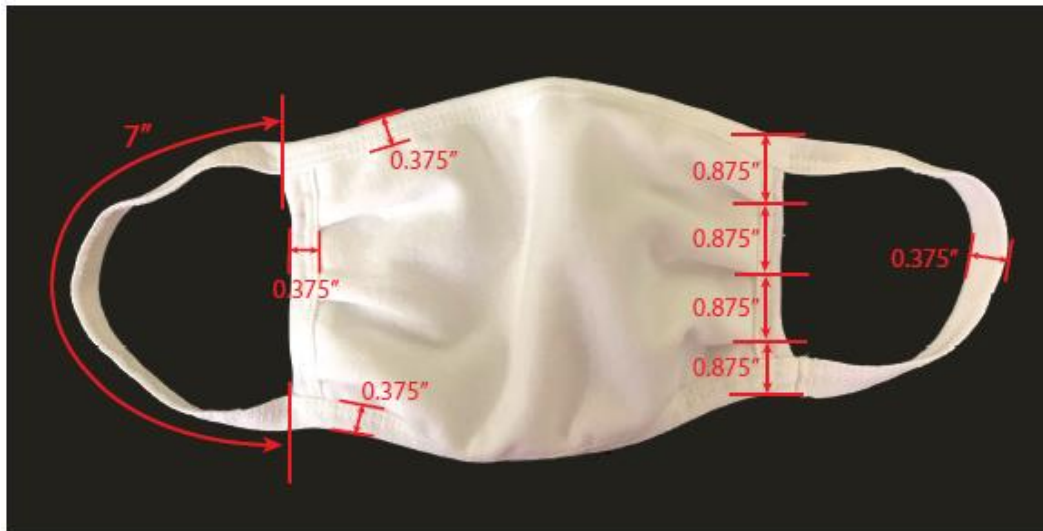
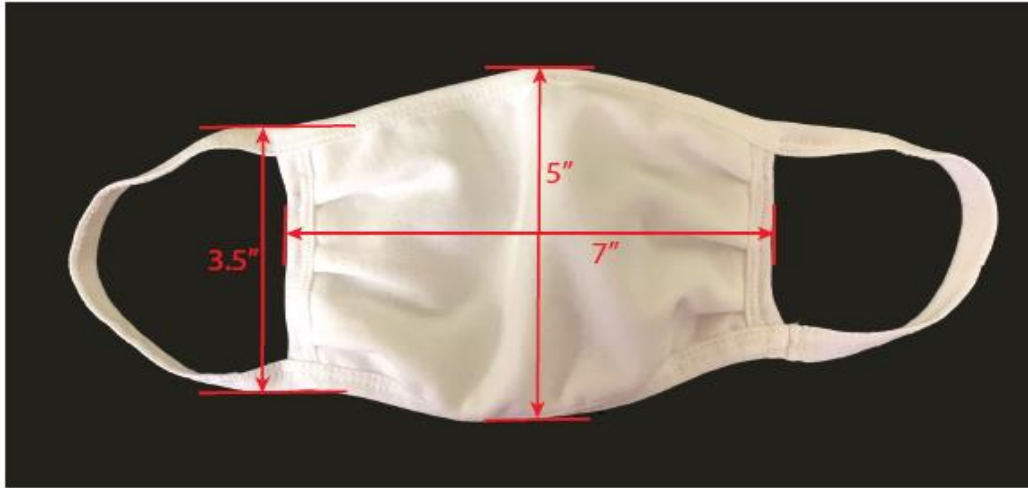


Hanes Mask – 3 Ply 100% Cotton with Antimicrobial Finish



Mask Finished Measurements –

100% Cotton 4oz sq/yd Jersey Fabric with rubber inside cotton binding for stretch; mask is 3 ply over face
- pleats or fabric gathers on sides are acceptable if equipment restrictions exist



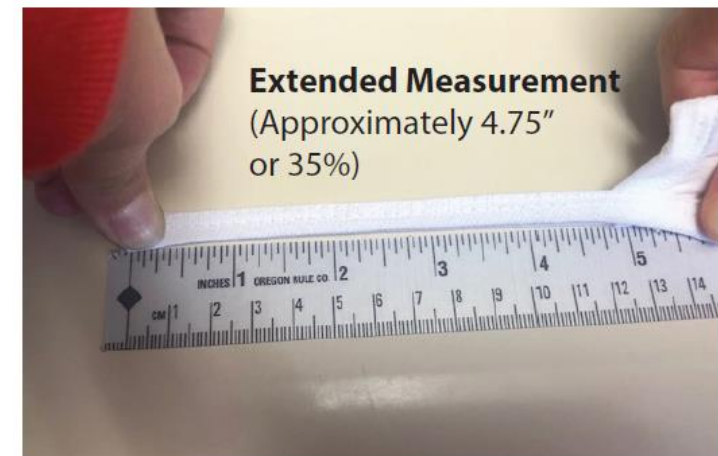
Garment has three pleats on right and left side (pleats are evenly spaced between top and bottom edge)
Right and Left side of garment should be symmetrical
All binding width is 0.375" (finished width)

Pleat overlap is approximately 0.375"

Ear Loop/Band (half) should stretch a minimum of 35%



Relaxed Measurement
(Approximately 3.5")



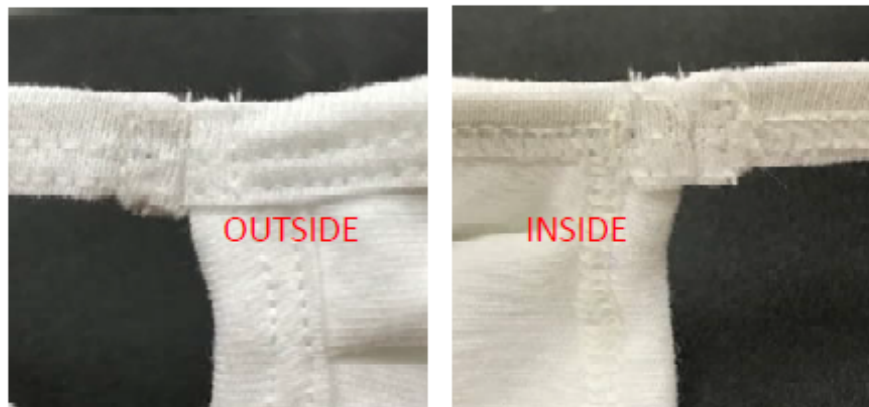
Extended Measurement
(Approximately 4.75"
or 35%)

Sew Sequence – note may change based on machine type availability

Face Mask Sew Sequence

Opt. #	Operation	Stitch Type/Description	Gauge Width	Seam/Trimoff Allowance	SPI	Thread Type
1	Fold pleats and single needle staystitch down (see measurement page for specific pleat placement and measurements)	301 Lockstitch	N/A	N/A	14	T24 Poly Core
2	Bind right and left sides, making sure pleats face down on both sides	406 2N Bottom Coverstitch (both needles on binding)	8gg / 3.2mm	folder- 1T- 3/8" finish binding	12	T18 Tex Poly
3	Bind top and bottom edges with rubber, forming ear loops in the process (see measurement page for specific loop measurements)	406 2N Bottom Coverstitch (both needles on binding)	8gg / 3.2mm	folder- 1T- 3/8" finish binding	12	T18 Tex Poly
4	Seam binding together to close.	301 Lockstitch	N/A	N/A	14	T24 Poly Core
5	Turn binding and tack down flat (see pictures below) (2). Trim excess binding so that binding turnback is approximately 1/4" on either side	301 Lockstitch	N/A	N/A	14	T24 Poly Core

Operation #5 Details



BINDING SHOULD BE BIAS-CUT

Sewing Labor and Materials with Usage

Sew Labor:

Apply Binding to Entire Mask			0.4251	SAM/Piece
Bartack Final Start-Stop		+	0.1816	SAM/Piece
Total Mins. Per Garment			0.6067	
1 Dozen		x	12	
Total Minutes per Dozen			7.2804	
		/	60	
SAH/Doz			0.1213	

Material Usage:

Fabric: 100% Cotton 4oz/sq yd Jersey

Yarn: 28/1 100 Cotton KPOE or KPRS; Knit Stitch 12.4"/100N; 45cpi; 31.5 wpi

-.0307 lb of 4oz sq/yd 100% Cotton Jersey per full 3 ply mask

.0233 lb for face cover per 3 ply mask

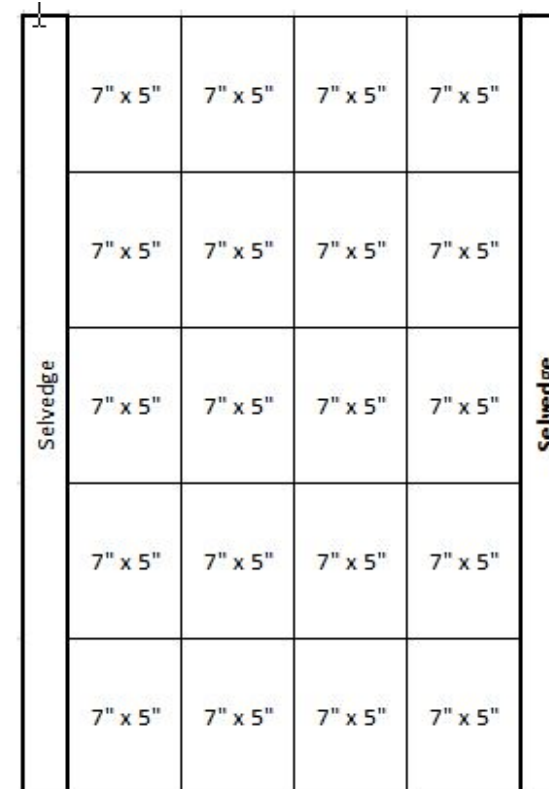
.0074 lb for binding per mask (1" wide bias cut)

-36" of AK0649 1/4" x .075 rubber per mask (inside strap)

Fabric Finish:

1.5% OWG Agion AMB-10 Antimicrobial

**Cut Marker: 90% efficiency; 22" Tubular
7" runs length of fabric parallel to fold**



Casing, Packaging, Labeling of Bags

Casing: 504 masks per Carton; 7 or 14 masks to a bag

-50% of cases packed 7 masks per bag; 50% packed 14 masks per bag

-Polybag for 7 or 14 masks is std 7" wide x 8" long (quart size) with masks stacked and folded

-Sticker (ASE255) to be applied to outside of each 7 or 14 mask Polybag and to Carton

-Sticker to be printed in-plant

STICKER TO BE APPLIED TO OUTSIDE OF POLYBAG
AND SHIPPING CARTON
FOR FACE MASKS

Carton:

Part #	Type	ECT	FLUTE	L	W	H	Inner Cube (ft ³)
PC-809	RSC	32	C Flute	18.5000	10.5000	12.0000	1.349

