
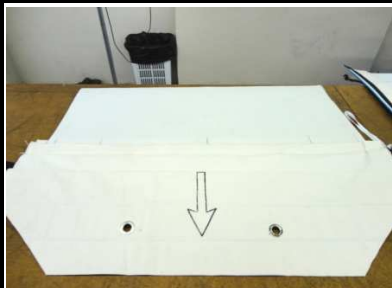
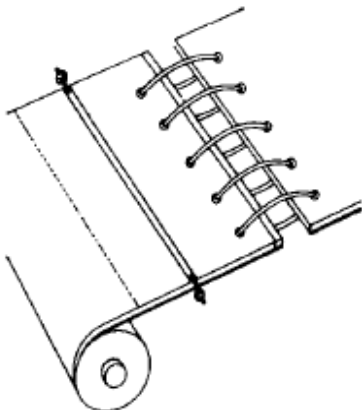


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| Doc. number: | 005/2012             |             |   |
| Department:  | Pin Seam Workstation | Review:     | 1 |
| Issued:      | December 5, 2012     | Attachment: | 0 |

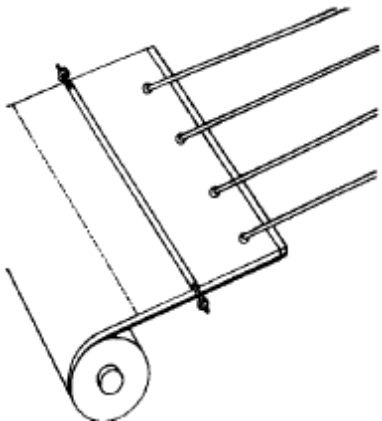

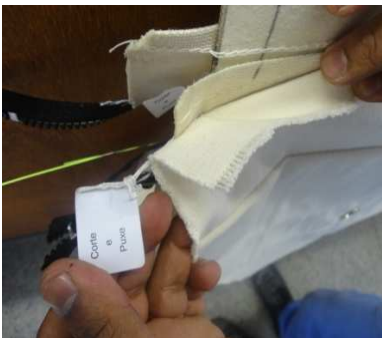



|                       |  |          |     |
|-----------------------|--|----------|-----|
| Description :         | ProSeam XT Installation                                  | Writer : | AAF |
| Part / Unit :         | Felt with double seam (ProSeam XT)                       |          |     |
| Tools and materials : | Ropes, installation pintle, needles, thread and silicone |          |     |
| Vocabulary :          |  |          |     |

| JIB'S – WORK INSTRUCTION |   |   |  |
|--------------------------|---|---|--|
| #                        | Process steps   | Action  | Reasons  |
| 1.                       |   | 1. Check the direction of the arrows on the packaging before positioning and open.  | 1. Unwinding direction of felt.                            |
| 2.                       |  | 1. Attach the felt in the running direction according to the arrow shown in the leader. (See items 3 or 4).   | 1. Pass the felt in the circuit to replace the other felt. |
| 3.                       |  | 1. Holding a used felt - unroll the leader and attach it to the used felt using the ropes.<br><br>Make sure that the felt is attached correctly without wrinkles. | 1. Replace the felt on the machine.                        |

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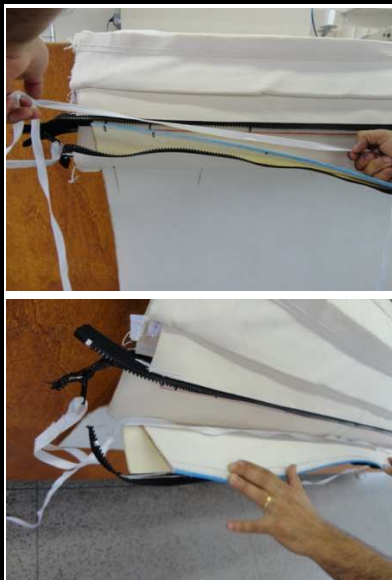

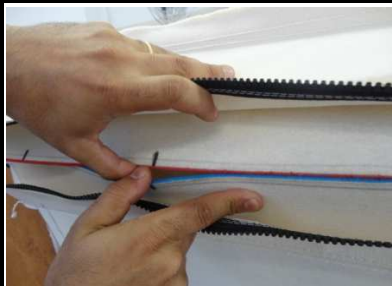



| JIB'S – WORK INSTRUCTION |   |   |  |
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| #                        | Process steps   | Action  | Reasons  |
| 4.                       |    | <p>1. Tied by ropes - hold ropes to the leader and guide them through the circuit.</p> <p>Make sure that the felt is attached correctly without wrinkles.</p>   | 1. Replace the felt on the machine.                  |
| 5.                       |   | 1. Close the inner zipper.  | 1. Pass the pintle of the 1st seam (bottom).         |
| 6.                       |  | <p>1. Remove the leader - Cut the label "Cut and Pull" of the leader and pull the seam line.</p> <p>BE CAREFUL NOT TO CUT THE LABEL OF ZIPPER.</p>  | 1. To make easy the installation on the machine.     |
| 7.                       |  | <p>1. Make sure that the leader rope is positioned at the end of the zipper yarn.</p> <p>Should be a double rope, covering the full width of the felt - accessory sent with the installation kit.</p> | 1. Method to assist the opening of the inner zipper. |

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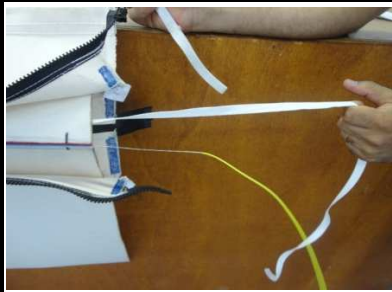


### JIB'S – WORK INSTRUCTION

| #   | Process steps   | Action   | Reasons   |
|-----|---|--|---|
| 8.  |   | <p>1. Leave one rope with the end of the zipper...</p> <p>... and position the second one, inside the seam until arrives on the other end.</p> | <p>1. Method to assist the opening of the inner zipper.</p> |
| 9.  |  | <p>1. Align the edge according to the marks.</p> <p>All marks must be aligned!</p>   | <p>1. Pass the installation pintle correctly.</p>           |
| 10. |  | <p>1. Close 1st seam.</p> <p>Note: Only pass the wire, leaving the pintle "out" if it's necessary to pass it again.</p>                        | <p>1. Install the felt - not to open in the seam area.</p>  |
| 11. |  | <p>1. Insert the installation pintle in the 1st seam (bottom).</p>   | <p>1. Close the seam.</p>                                   |

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| Department:  | Pin Seam Workstation | Review:     | 1 |
| Issued:      | December 5, 2012     | Attachment: | 0 |







### JIB'S – WORK INSTRUCTION

| #   | Process steps   | Action  | Reasons   |
|-----|---|---|---|
| 12. |    | 1. Ensure that the pintle has passed correctly in the seam. If it has any missing loop or marks not aligned, return the cable and pass it again with caution. | 1. Avoid problems after the installation of the seam - loops that were out of the seam can cause premature wear and irregularities in production. |
| 13. |   | 1. Pull rope to open the inner zipper.  | 1. Close 2nd seam (top).  |
| 14. |  | 1. With the zipper opened, check if there was part of the rope on the other end.  | 1. To close the zipper again, if you need.  |
| 15. |  | 1. Align the loops  | 1. To pass the pintle easily, fitting the loops of the seam.  |

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|--------------|----------------------|-------------|---|
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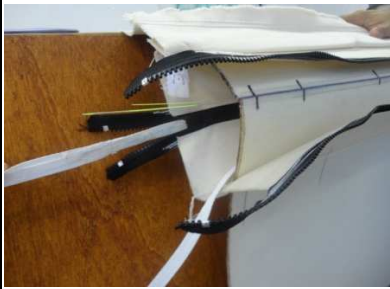
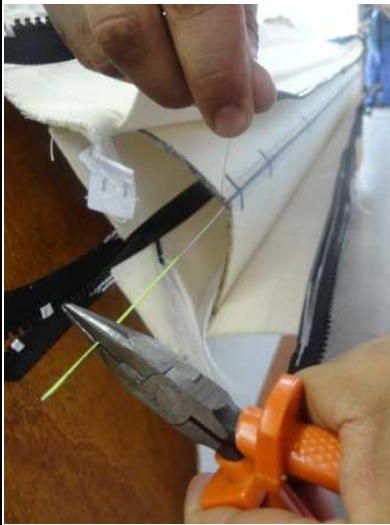

### JIB'S – WORK INSTRUCTION

| #   | Process steps   | Action  | Reasons   |
|-----|---|---|---|
| 16. |    | 1. Close the outer zipper.  | 1. Pass the installation pintle.                        |
| 17. |   | 1. Insert the installation pintle in the 2nd seam (top seam).   | 1. Close the seam.                                      |
| 18. |  | 1. During the pintle pass, if you have any trouble, open the zipper until the location of the problem and fix it. Close the zipper and continue to pass the pintle.<br><br>Note: Only pass the wire, leaving the pintle "out" if it's necessary to pass it again. | 1. Not to skip loops and does not cause irregularities. |
| 19. |  | 1. With the last pintle passed, open the top zipper.  | 1. Check the seam.                                      |



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| JIB'S – WORK INSTRUCTION |   |   |   |
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| #                        | Process steps   | Action  | Reasons   |
| 20.                      |    | <p>1. Close the bottom zipper to check the top seam.</p> <p>Pull the rope at the other end to close the zipper.</p> | 1. Facilitate checking the seam area.                 |
| 21.                      |   | 1. Pull the pintle of the bottom seam.  | 1. Tie a knot on the edge.                            |
| 22.                      |  | 1. Open the bottom zipper.  | 1. Pull the installation wire for the 2nd seam (top). |

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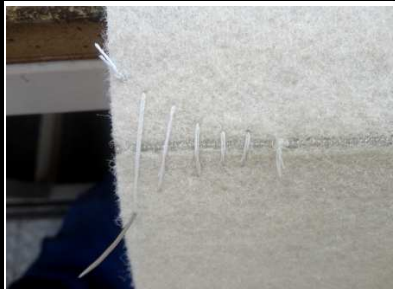



### JIB'S – WORK INSTRUCTION

| #   | Process steps   | Action  | Reasons   |
|-----|---|---|---|
| 23. |    | 1. Close the top zipper.  | 1. Facilitate the removal of the installation pintle. |
|     |   | 2. Pull the pintle from the top seam.   | 2. Tie a knot on the edge.                            |
| 24. |  | 1. Remove the zipper accessories.<br><br>Cut all labels "Cut and Pull" and pull the seam lines. | 1. Sew and seal the edges.                            |

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| JIB'S – WORK INSTRUCTION |   |   |   |
|--------------------------|---|---|---|
| #                        | Process steps   | Action  | Reasons   |
| 25.                      |    | 1. Tie knot on the edge and cut the ends  | 1. To hold the pintle and not open in the seam area.                                |
| 26.                      |   | 1. Insert line in the needle and tie a knot on the backside of the felt.<br><br>Accessories shipped with the kit - needle according to preference (curved or straight). | 1. Sew the edges seam.  |
| 27.                      |  | 1. Start the sewing using a triangular form.  | 1. Reinforce the seam area.   |
| 28.                      |  | 1. Tie the sewing line on the backside of the felt.   | 1. There cannot be a knot in the sheetside of the felt - risk for paper production. |



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| JIB'S – WORK INSTRUCTION |   |   |   |
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| #                        | Process steps   | Action  | Reasons                                       |
| 29.                      |    | 1. Pass silicone in sewing.                       | 1. Seal the seam and reinforce the seam area. |
|                          |   | It should be seal the face and backside.          |   |
| 30.                      |  | 1. Repeat actions of the items to the other side. | 1. Seal and reinforce both edged of the seam. |

Emitido por:

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Alessandra Fontoura

Aprovado por:

\_\_\_\_\_  
Carlos Henrique Pinton