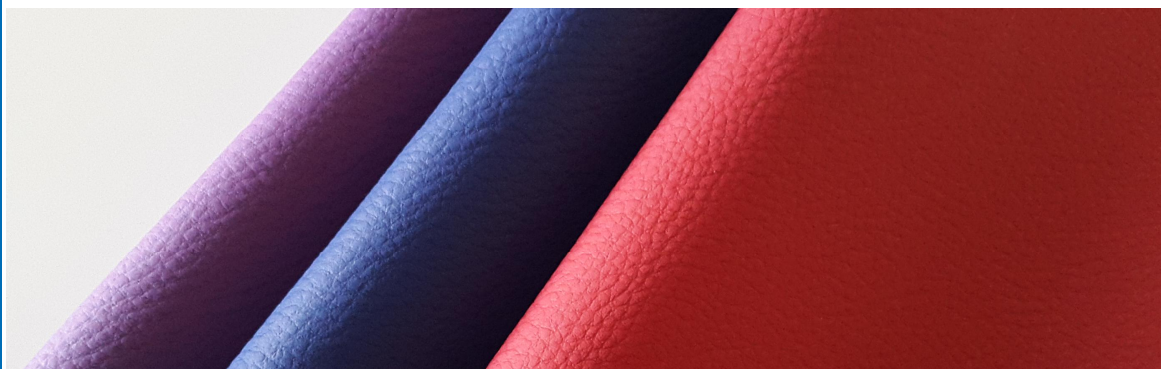


## Aircraft

### Cut & Sew Guidelines for TEC-Leather



## Cut & Sew Guidelines

*This documentation is based on our latest knowledge and experience and is intended to provide general information on our products and their applications.*

*This documentation is a recommendation and thus not legally binding..*

### Sizing

TEC-Leather's unmatched elasticity facilitates curve creation and making up of complex forms.

### Cutting

A single thickness of TEC-Leather can be cut by hand. We recommend superimposing several thicknesses, when cutting with electric scissors or on a cutting table to ensure a clean-cut finish.

### Sewing

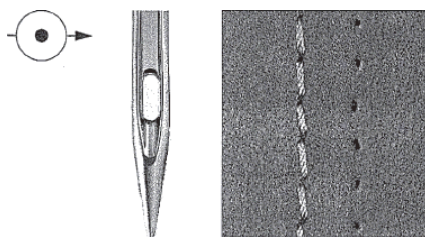
Our experience has shown that a reinforced double stitch is the best stitching process compatible with our product to ensure the optimum durability. Adding textile tape along the stitch on the invisible side of the product has also proved to reinforce the stitch in the difficult zones.

We recommend assembling panels in the warp direction.

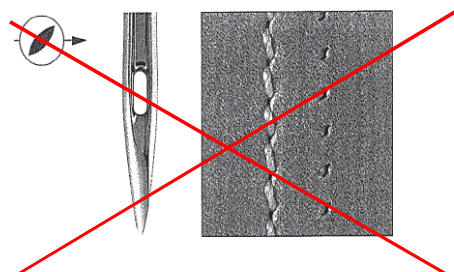
Incorporating a reinforcing strip in the top-stitching will improve assembly quality and robustness.

We recommend using:

- Triple sewing machine
- An R (round), fine (110 or 120) needle
- 30 or 40 gauge thread



R shaped round tip

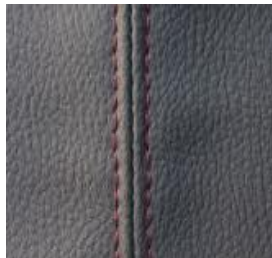


LR (sharp tip)  
usually used for real leather stitching.  
can damage the surface

### Seam formations



pic 1: decorative stitching  
30 gauge thread, fine 110 needle (l)  
20 gauge thread, fine 120 needle (r)



pic 2: flat felled seam  
30 gauge thread, fine 110 needle



pic 3: eyelets & buttons  
reinforcement necessary

### Markers

For cutting marks on the back of the fabric, we recommend not to use pencils or markers with fluid ink which can transfer through the jersey and be visible on the surface of the fabric. We recommend using only dry ink markers such as ball pens, chalk or pencils.

### Stapling

Recommended parameters:

- Gun air pressure: 6 to 7 bar
- Do not press hard on the gun to prevent cutting the material
- Avoid small staple widths: Width > 380 mm
- Lay on a bias to staple properly the warp and weft.

### Gluing

Neoprene or water-based adhesives should always be applied evenly to the foam and to the textile side of the TEC-Leather.

Lantal recommends preliminary tests with glues.

### Installation

We recommend to implement TEC-leather on soft materials (foam, cotton ...).

### Welding

TEC-Leather cannot be welded.