

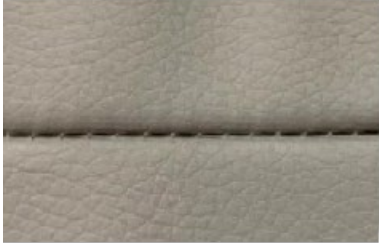



Sewing Recommendations

Needle	Brand	SCHMETZ (or similar)		
	Series	 SD1 - Round point with small triangular tip		 DI - Diamond point
	Size	#19 (134-35 SD1) (2134-35 SD1) (DP×35 SD1)	#18 (135×17 SD1) (DP×17 SD1)	#19 (134-35 DI) (DP×35 DI)
Seam types		 Superimposed seam/Plain seam	 Lapped seam/Decorative seam/ Flat-felled seam	
Thread		Select thread proportionate to needle size to ensure seam integrity.		
Stitches		The recommended stitch length is 5-7 stitches per inch.		
Note		<ol style="list-style-type: none"> 1) The recommendation above is only an example, you can use a similar way. 2) Adding a lock stitch to protect sewing. 3) Make sure timing on sewing machine is calibrated to prevent a needle drag on the way out of the hole. 4) Avoid machine with a sharp edge on pressor foot, it will cut the surface. 5) Sewing machines need to be calibrated for sewing speed and sewing foot guide settings so as to not grab the fabric and stretch the thread hole. In addition, needle drag can also cut into the materials causing a larger hole. Many newer machines have setting especially for coated fabrics. 		
Lamination tips		<ol style="list-style-type: none"> 1) We recommend our customers use PE/PP films to cover the foam (or use low-emission aliphatic polyester foam) to prevent the migration of volatile content of the foam to Sileather. Machine lamination or using a roller tool will be helpful to apply adhesives evenly. Avoid excessive residue on the backing which may sink into the top coating. 2) For marine applications, Sileather performs best when paired with an open cell, reticulated, quick drying foam. A waterproof barrier between the fabric and foam is recommended. 3) We recommend using water-based adhesives. 		