

the door edge as practicable without allowing the stitches to drop over the edge of the door fabric (i.e., be sure that the stitches go through both the strap and the door fabric).

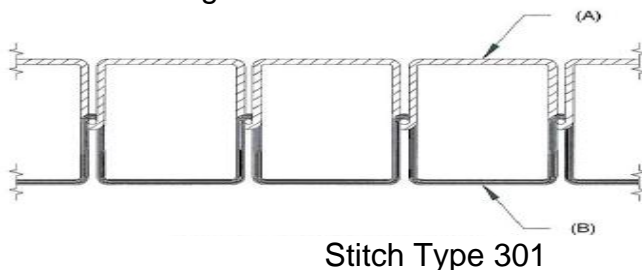
C. Aerotuf High Strength Curtain Assemblies.

(1) Fabric Door Curtain Patch - Sewing a patch cut from door curtain fabric or replacement door curtain fabric from ACS (Refer to CS-XXXXX for P/N)

a) Obtain the following materials:

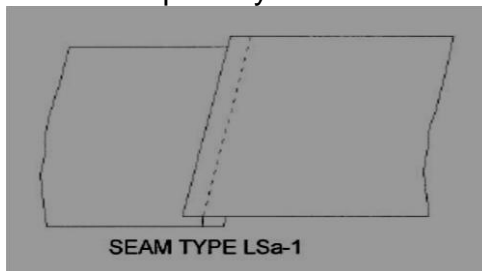
- i. It is acceptable to cut patches from previously used door curtains provided it is the identical material (do not use damaged areas of the curtain to cut patches) and the patch weave direction matched that of curtain.
- ii. Thread, Spectra – white (ACS P/N 8000212).

b) Stitching shall be in accordance with Federal Standard 751, using thread specified in parts list. The actual stitch type to be used is a Type 301 and is illustrated in the diagram below.



This type of stitch shall be formed with two threads: One needle thread (A) and one bobbin thread (B). A loop of thread shall be passed through the material and interlaced with thread (B). Thread (A) shall be pulled back so that the interlacing shall be midway between surfaces of the material or materials being sewn.

The seam type to be used in all repairs must also be in accordance with Federal Standard 751. The primary seam is illustrated in the diagram below.



c) Cut a patch of material which is a minimum of 1.5 inches (3.8 cm) beyond edges of tear or hole in each direction.



- d) Align weave of the patch with that of the area being repaired.
- e) Stitch over damaged area using a type 301 (LSa-1) single needle and 7-11 stitches per inch and an edge distance no less than 3/16 inches.



## (2) Repair of Curtain Pockets –

When Curtain pocket stitching become loose or damaged exceeding the 25% damage limit on either sides of the pocket, ACS recommends returning the Aerotuf Curtain back to ACS for service.

