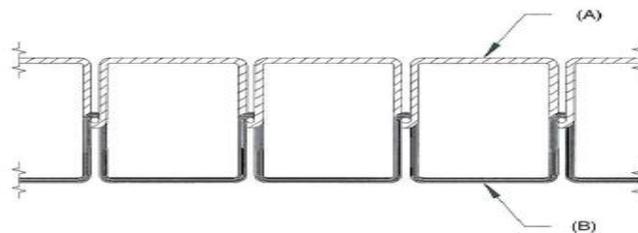


(2) Sew patches as follows:

(a) Obtain the following materials:

- It is acceptable to cut patches from previously used door curtains provided you do not use damaged areas and it is the identical material.
- Thread – Black. Refer to Parts List section (CS-XXXXX) Bulk Purchase and Repair Parts listing for part number.

(b) Stitching shall be in accordance with US 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.



Stitch Type 301

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 US 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 inch (38 mm) 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 inch.
- (f) The damage behind this type of repair should be trimmed out and an additional row of stitching should be sewn around the damaged area to better secure the repair. When trimming out the damaged area, round the corners of the areas to prevent further tearing. Maintain the edge distance no less than 3/16 inch.

(3) Welded (Bonded) Patch Method.

As an alternative to sewing, the patch may be welded to the door fabric as follows:

- (a) Patch overlap 1.5 inch (40 mm) minimum
- (b) Set the temperature in the high heat gun type blower to a minimum of 170°C and a maximum of 200°C.
- (c) Apply firm pressure during welding
- (d) Melt the door and the patch together
- (e) Use a wooden or ceramic rolling tool to cool it
- (f) Press the layers together and smooth the bonded patch.

B. Door Curtain Hook and Loop Strap Assemblies.

NOTE: The repair company can replace the hook and loop materials by matching material part numbers. Stitch patterns must be the same as original. Hook and Loop fasteners are specified in the parts list and will generally be supplied as Velcro® or 3M Scotchmate™ brands.

- (1) Remove seams on the damaged or missing strap assembly and detach the strap assembly from the door curtain.
- (2) Attach a new strap assembly to the door curtain using P/N 8000180 thread.
- (3) Sew single seams (5 stitches per inch minimum) on each edge of the strap across the entire door width.
- (4) Sew double or triple seams (5 stitches per inch minimum) across the strap at each door edge, keeping the stitching on the strap itself and as close to