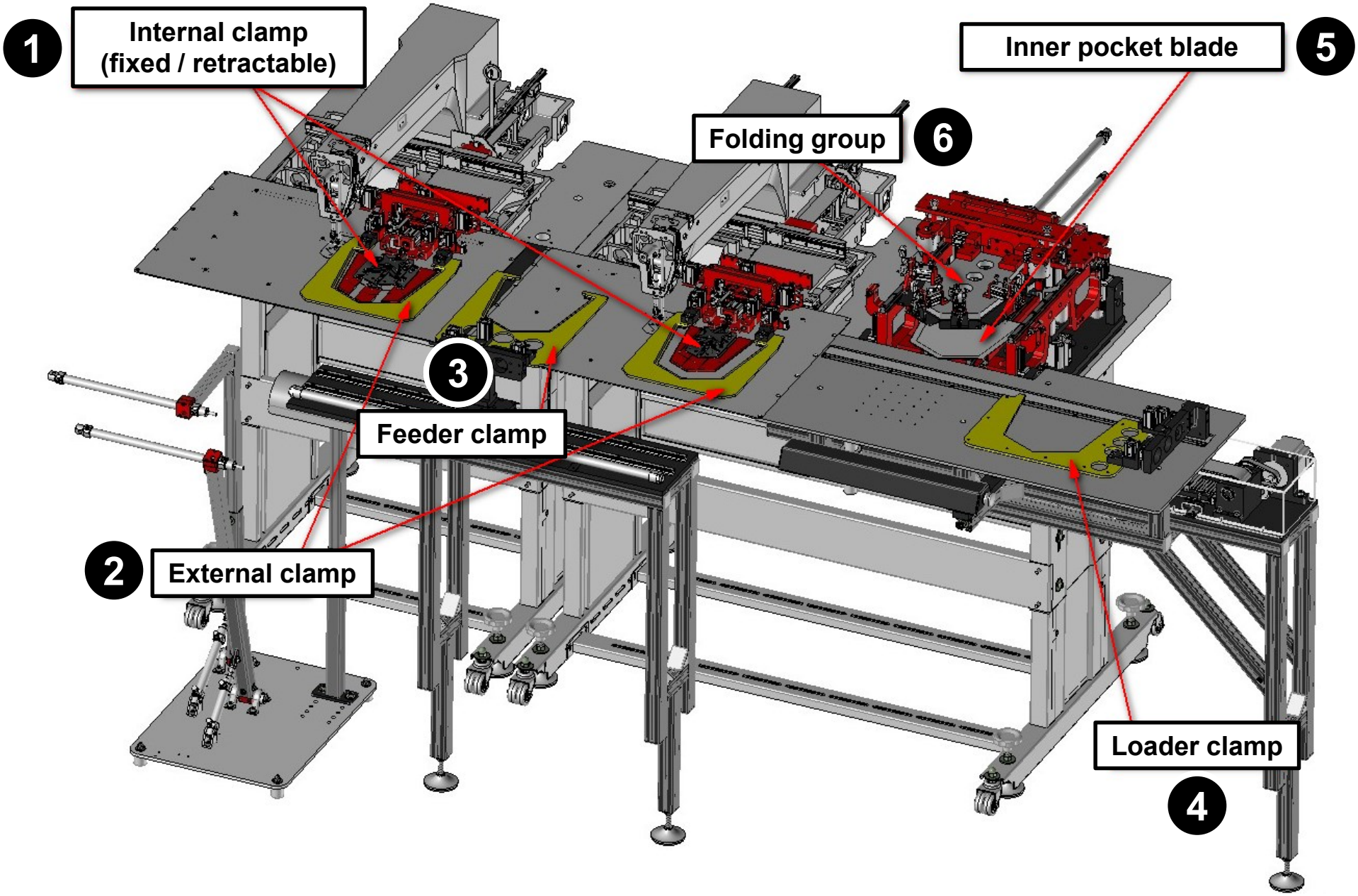
SEWING CLEVER

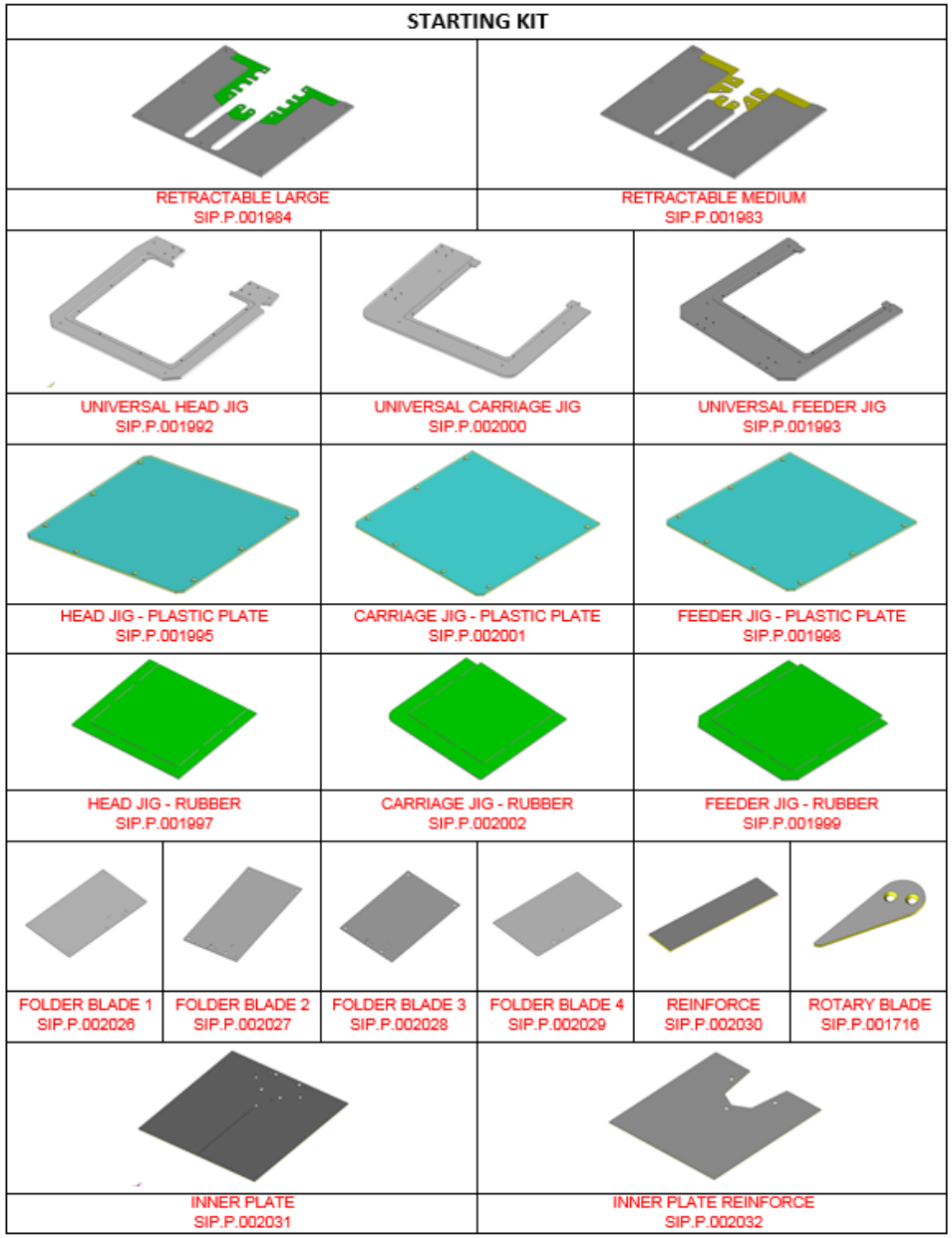
CUSTOMIZABLE SET FOR POCKET SETTER MACHINE PS342 SERIES:

CUTTING INSTRUCTION BOOK

CUSTOMIZABLE STARTER KIT FOR POCKET SETTER



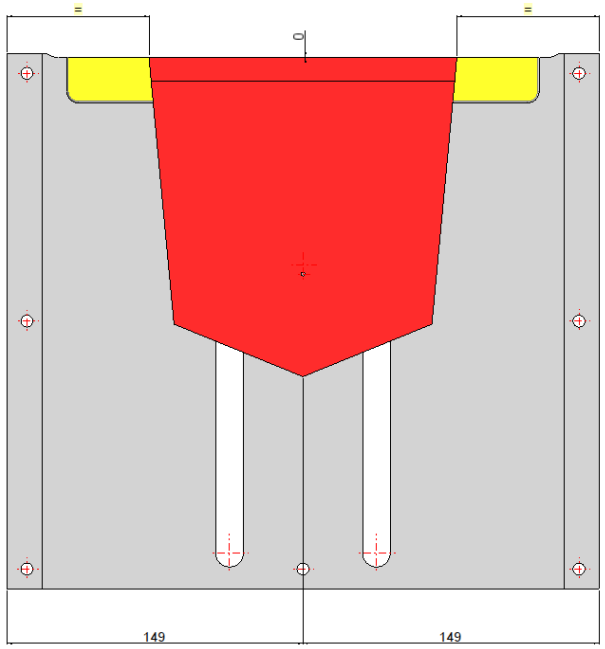
CUSTOMIZABLE STARTER KIT FOR POCKET SETTER

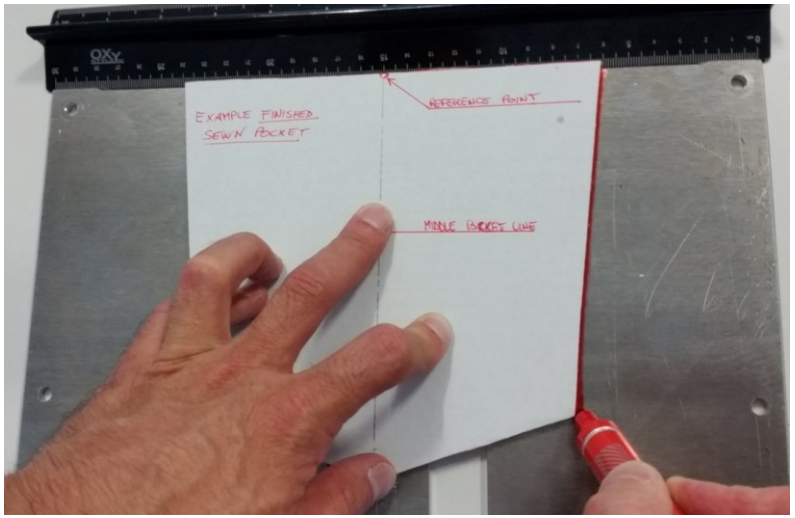


STANDARD EQUIPMENT SUPPLIED WITH POCKET SETTER UNIT PROVIDES:

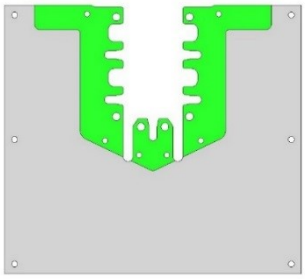
- Customizable pocket holder plate
- Standard jigs to hold the plastic clamps
- Plastic sheets
- Rubber
- Standard folding blade
- Standard plate for pocket support

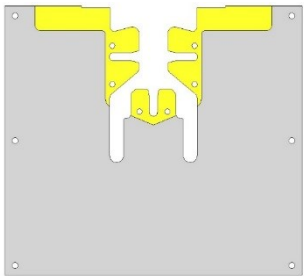
1 INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

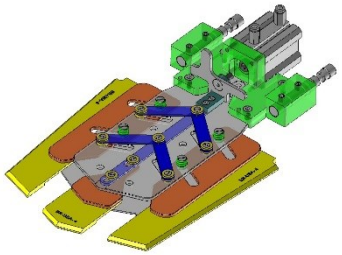


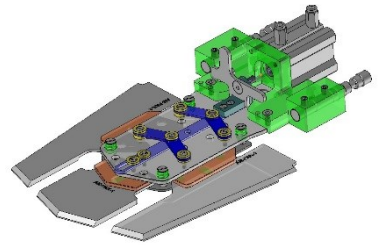


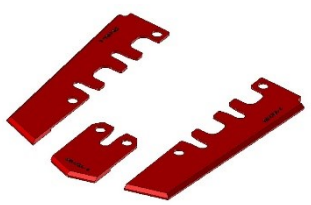
LARGE MEDIUM

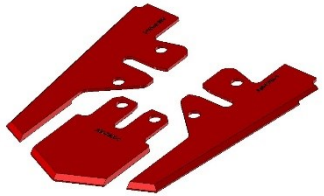


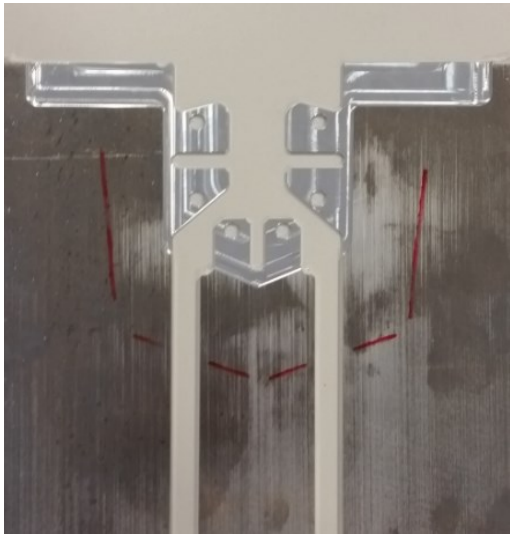






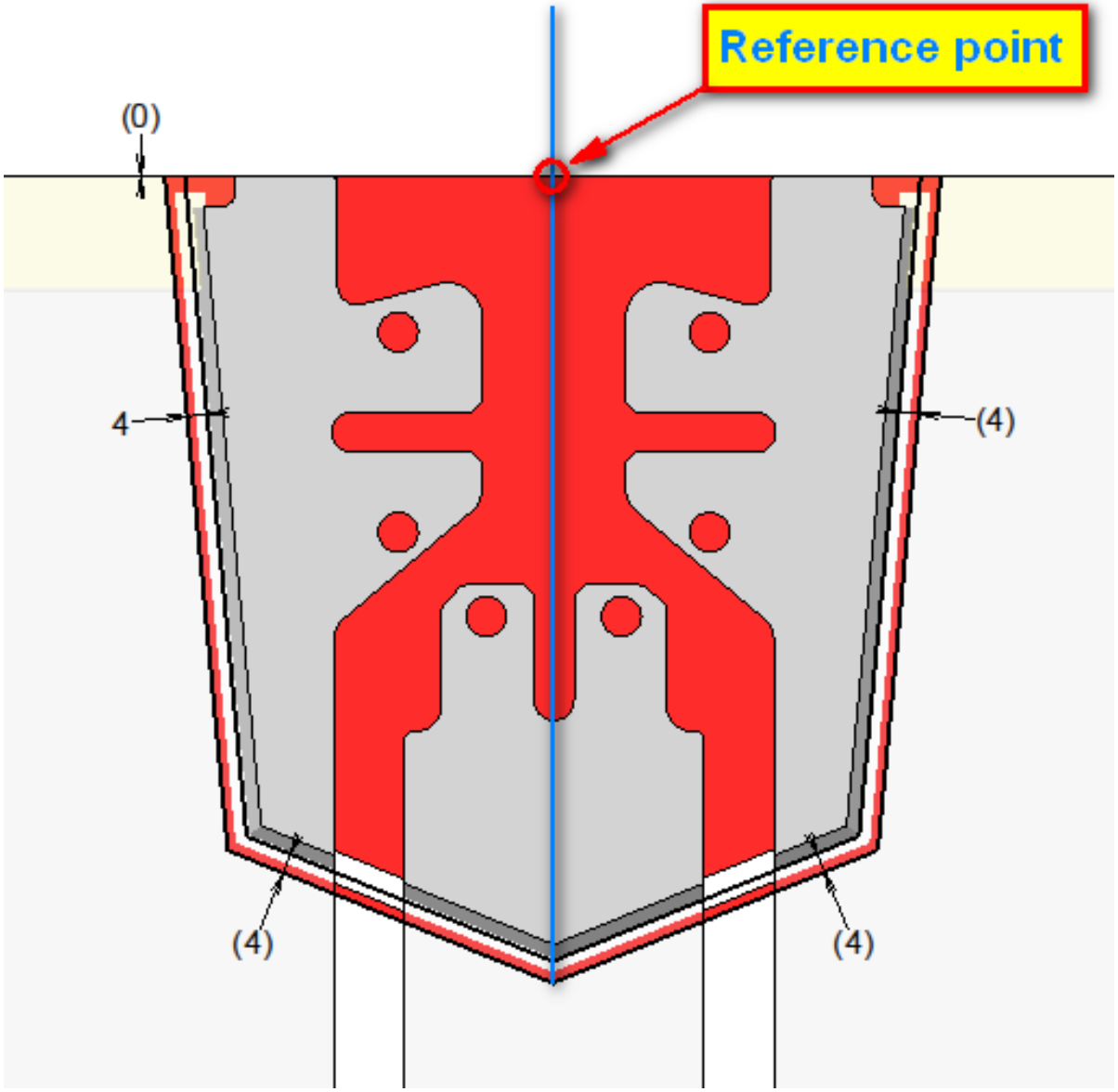






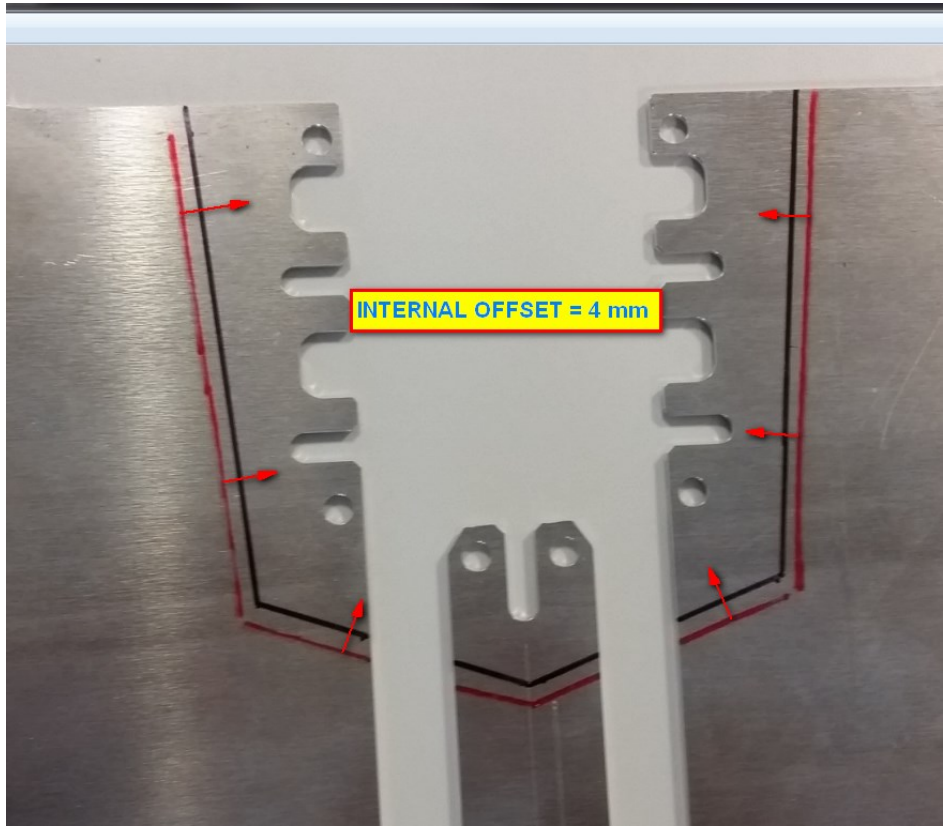
- Place the pocket sample at the centre of the plate and mark carefully the external profile;

1 INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM



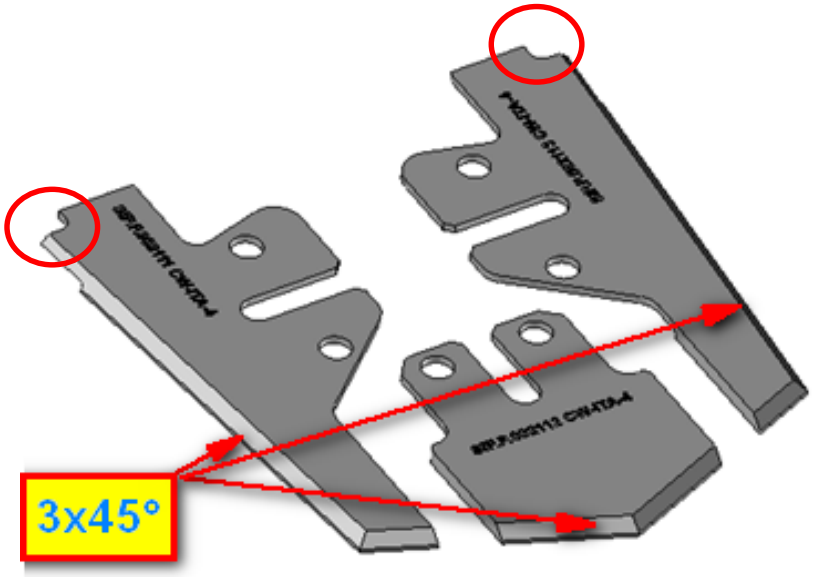
Draw an internal offset at 4 mm from the external line of the finished sewn pocket.

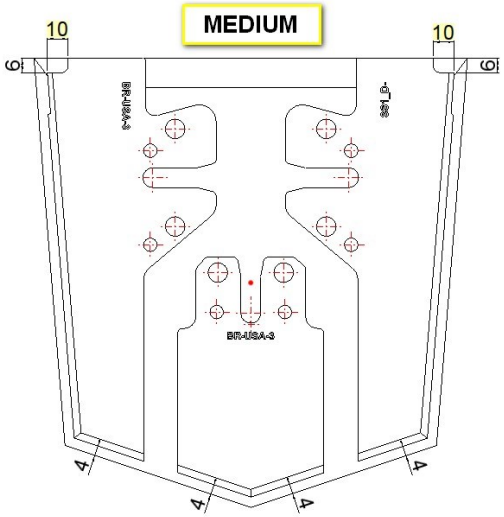
THE BLACK LINE IS THE CUTTING LINE

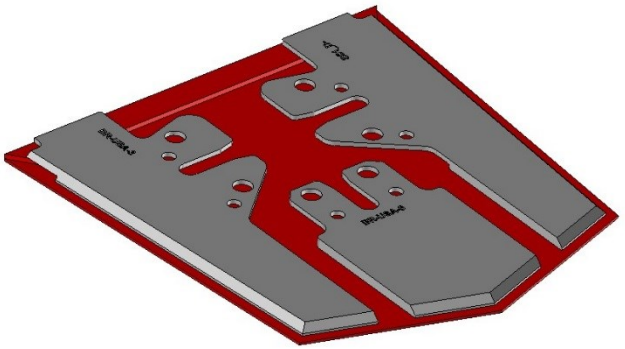


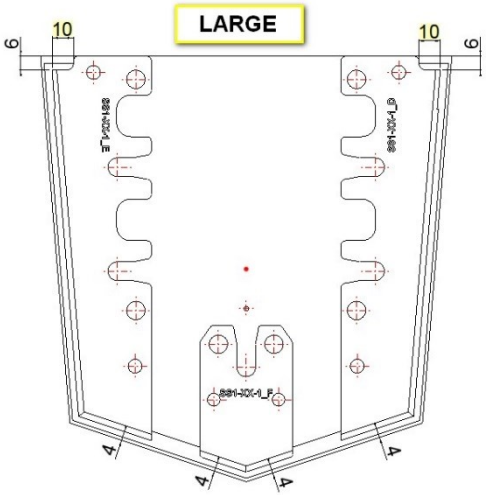
1 INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

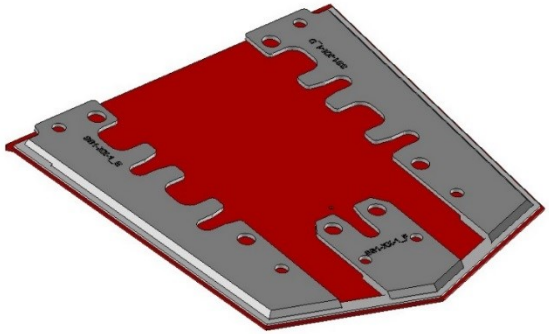
Cut out along the black line and make chamfer 3x45° and slots as specified below.





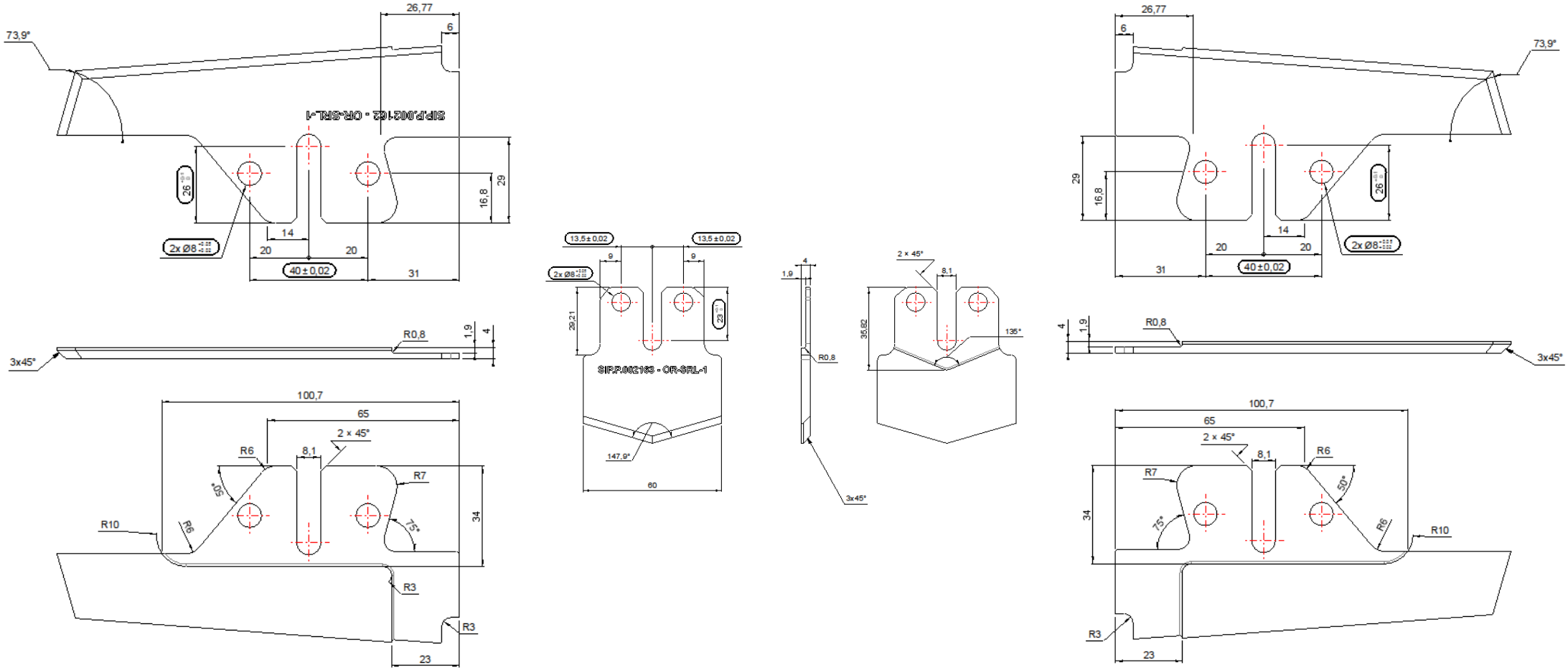






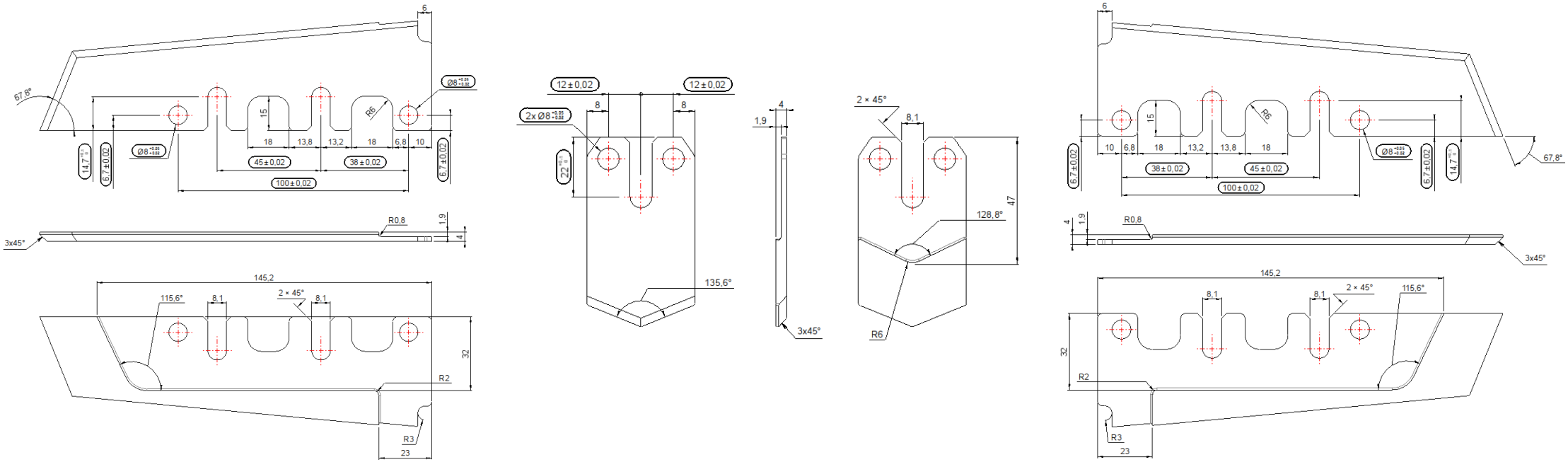
1 INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

DETAILED DRAWINGS MEDIUM KIT



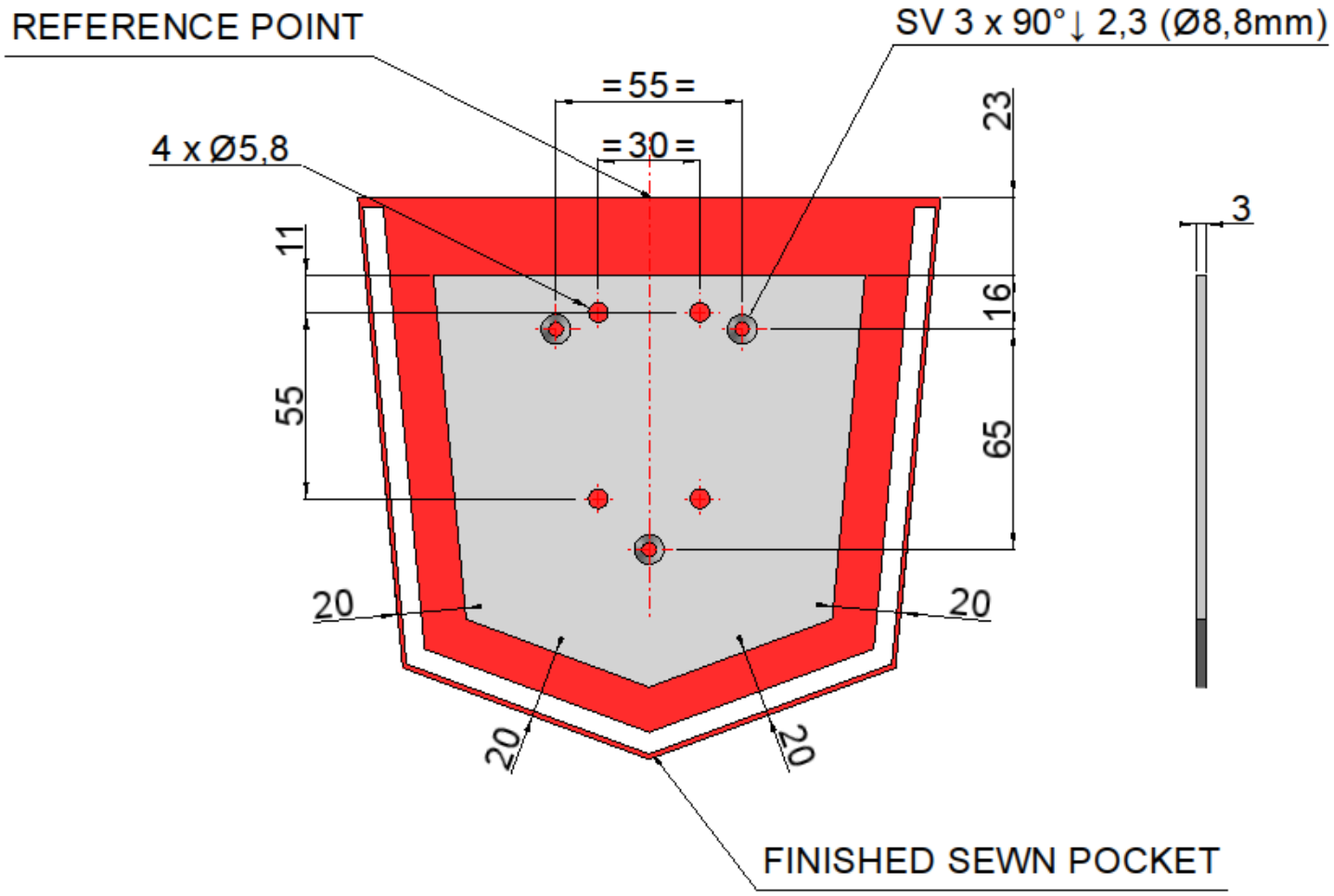
1 INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

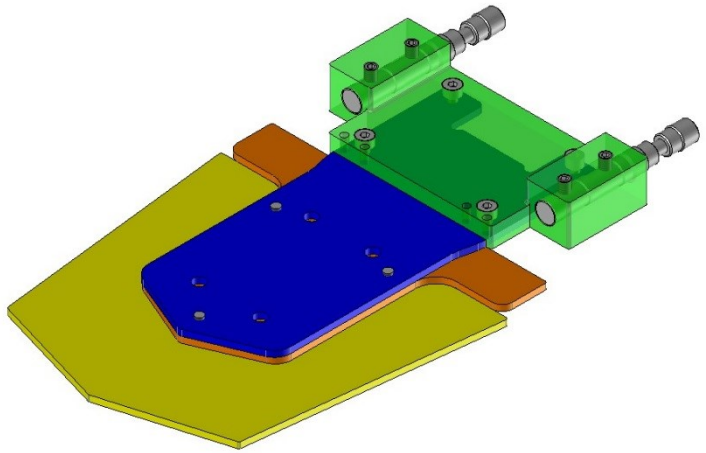
DETAILED DRAWINGS LARGE KIT

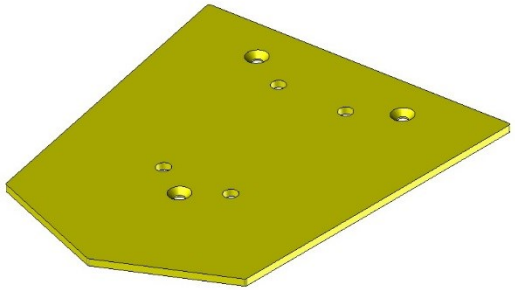


1 INTERNAL CLAMP FIXED (MEDIUM)

For internal sewing path



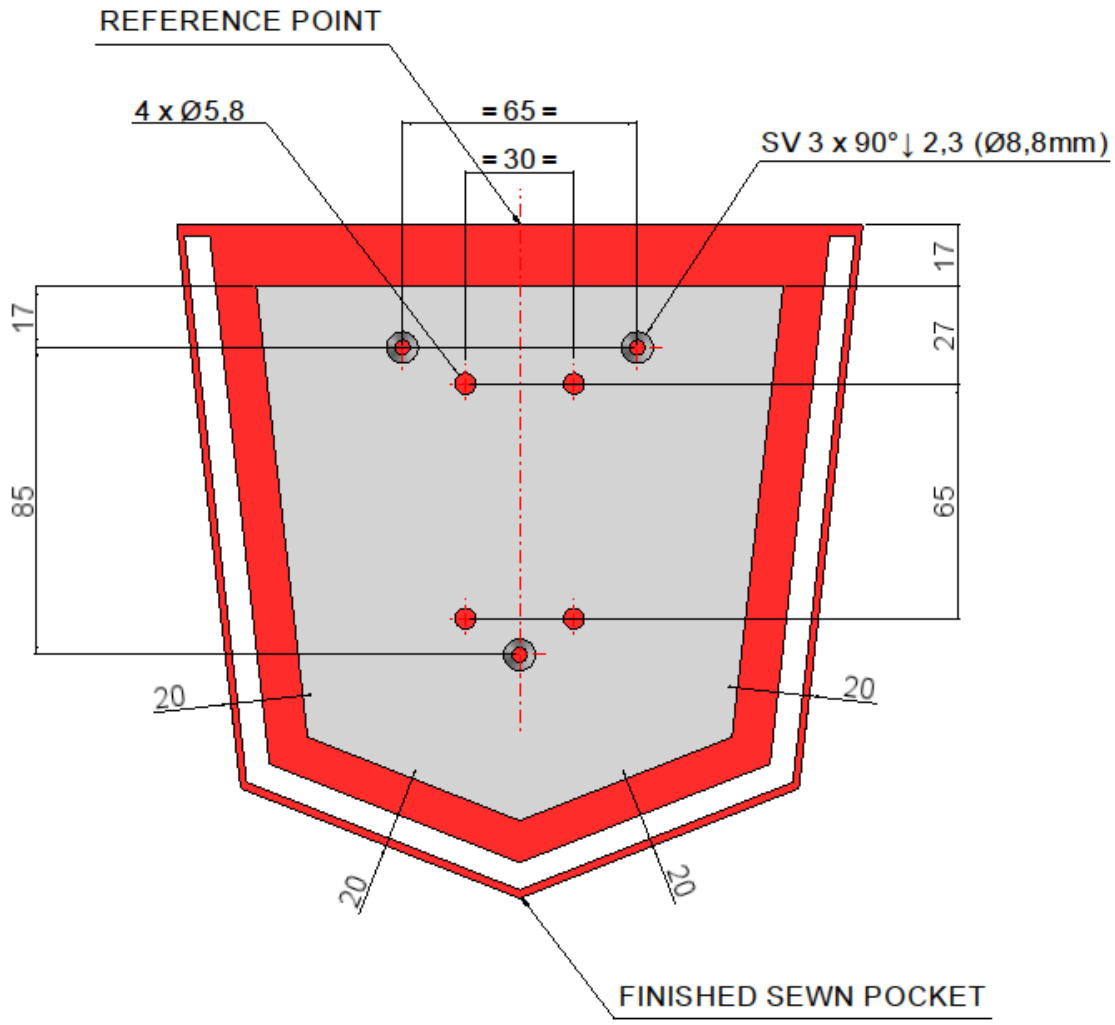


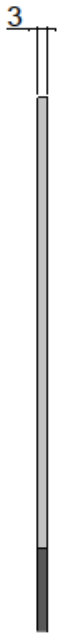


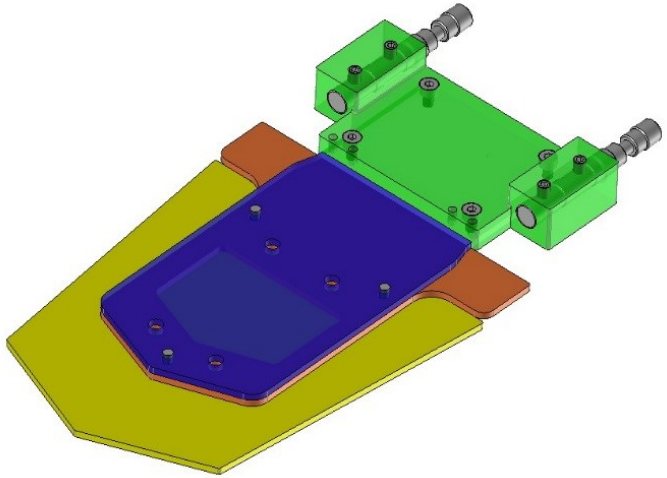
STAINLESS STEEL X6Cr17 – AISI430

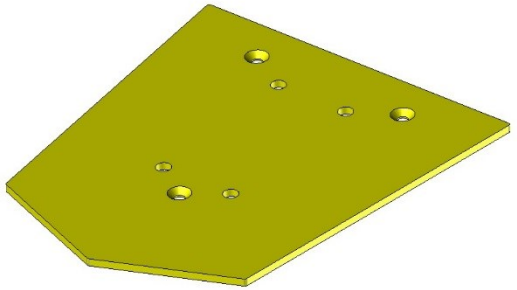
1 INTERNAL CLAMP FIXED (LARGE)

For internal sewing path







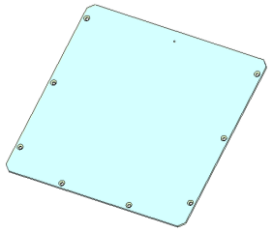


STAINLESS STEEL X6Cr17 – AISI430

2 EXTERNAL CLAMP (PLASTIC SHEET)

- ✓ Place the finished pocket sewn on the plate as specified in the picture below;
- ✓ Draw with a mark pen the pocket profile;
- ✓ Cut carefully the plate obtaining the pocket profile;
- ✓ The pocket **must fit exactly inside the cut line**;

PLASTIC CODE
SIP.P.001995



MASK CODE
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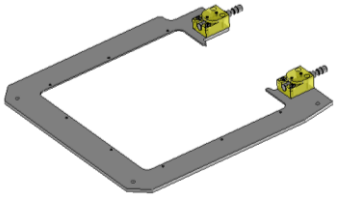
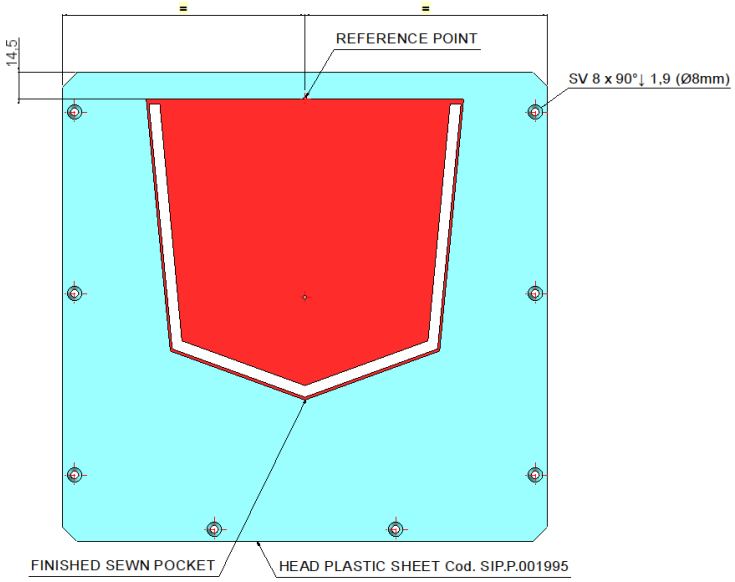
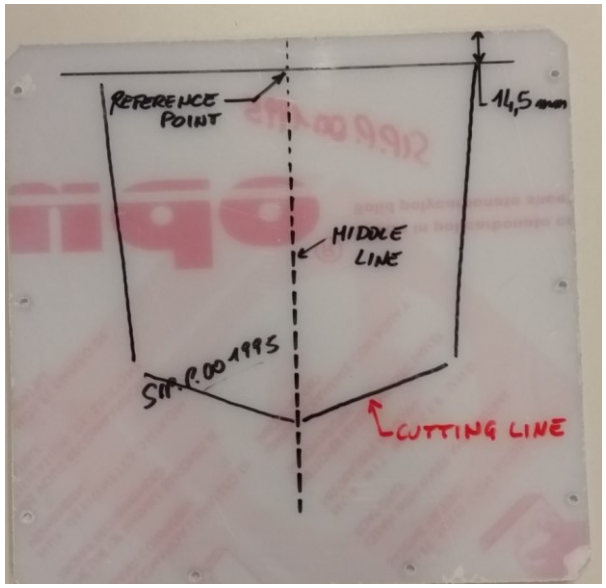
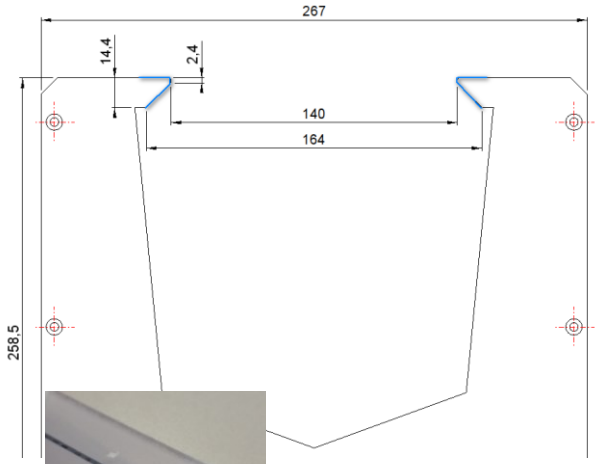
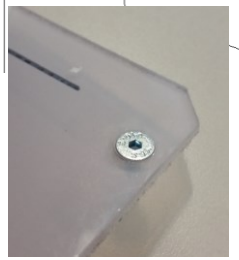
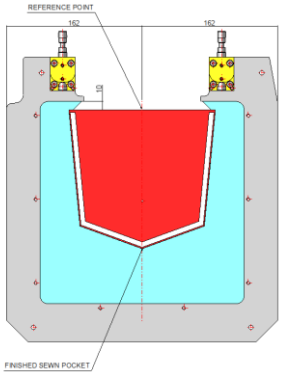










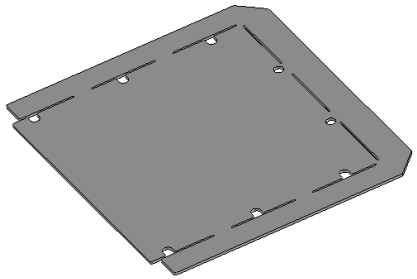


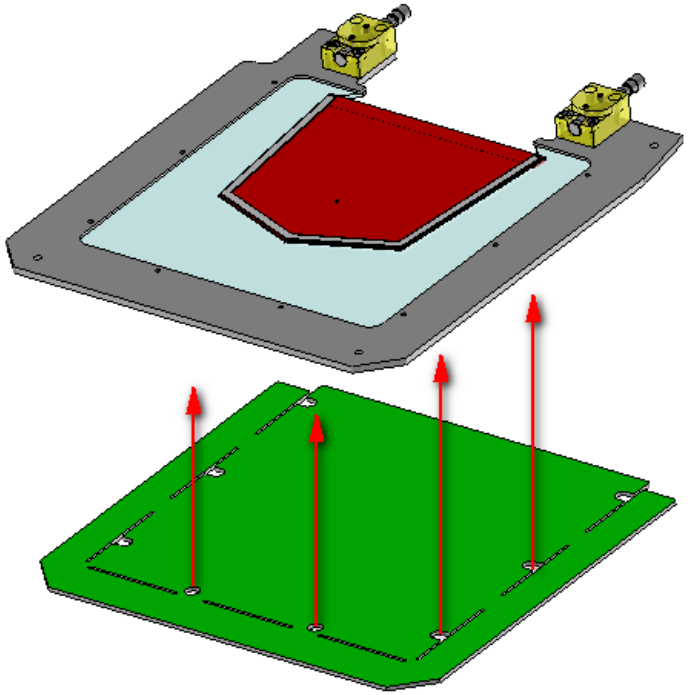
- ✓ Open the upper area of the plastic sheet according the picture above;
- ✓ Make countersink for M4 screw;
- ✓ Place the rubber as described on the next page;

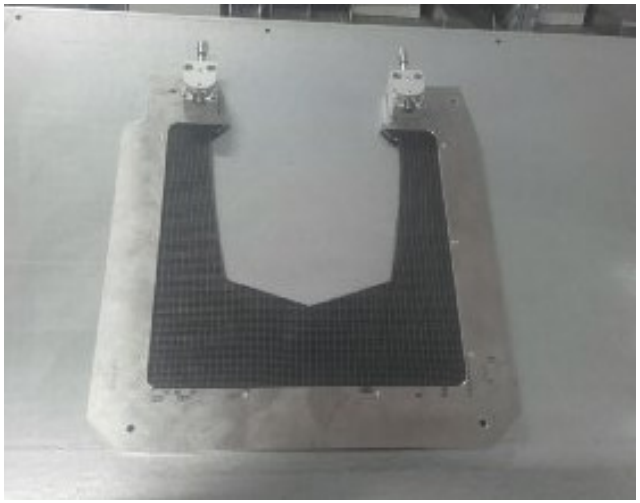
2 EXTERNAL CLAMP (RUBBER)

- ✓ Remove the film on the adhesive side;
- ✓ Place carefully the rubber on the lower side of the mask;
- ✓ Cut out carefully the rubber following the same profile of the pocket;

RUBBER CODE
SIP.P.001997



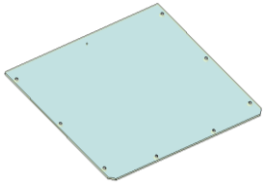




2 FEEDER CLAMP (PLASTIC SHEET)

- ✓ Place the finished pocket sewn on the plate as specified in the picture below;
- ✓ Draw with a mark pen the pocket profile;
- ✓ Cut carefully the plate obtaining the pocket profile;
- ✓ The pocket **must fit exactly inside the cut line**;

PLASTIC CODE
SIP.P.001998



MASK CODE
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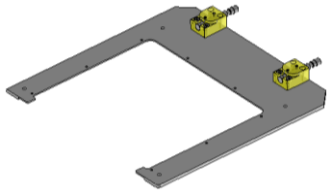
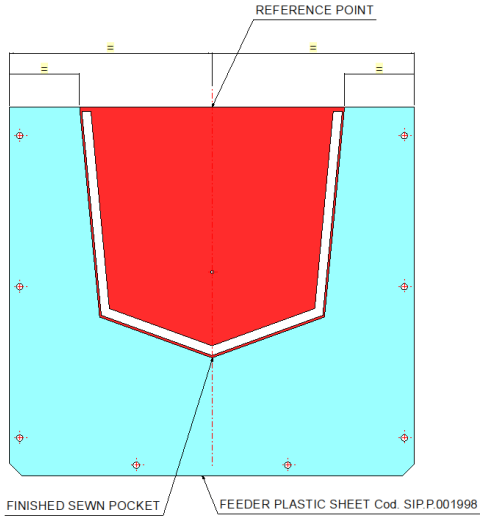
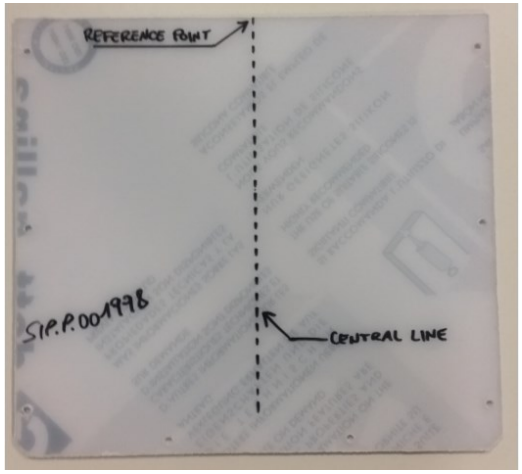
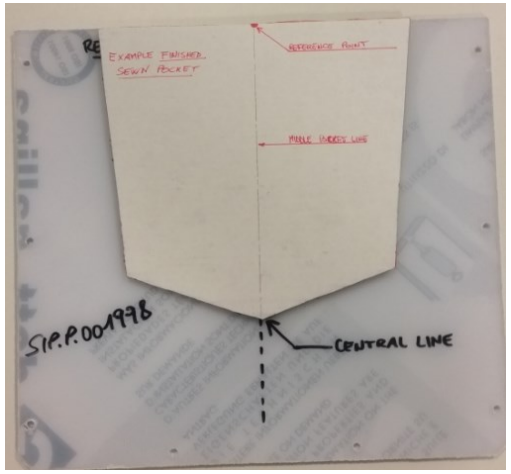
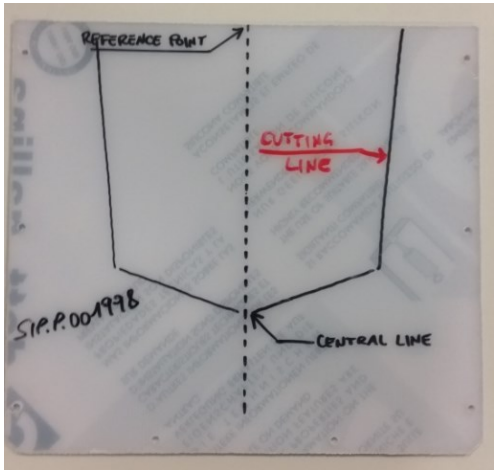


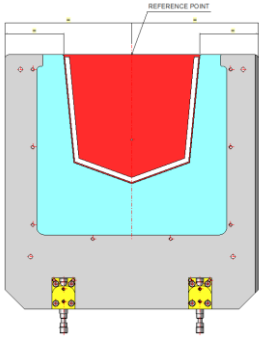


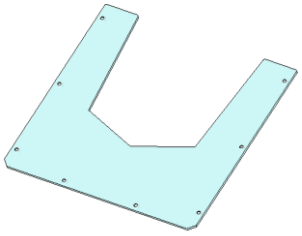


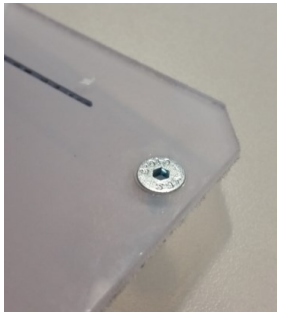




- ✓ Make countersink for M4 screw;
- ✓ Place the rubber as described on the next page;

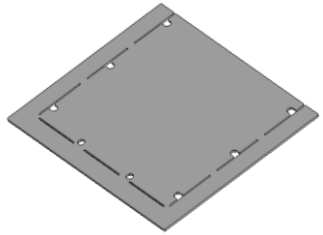




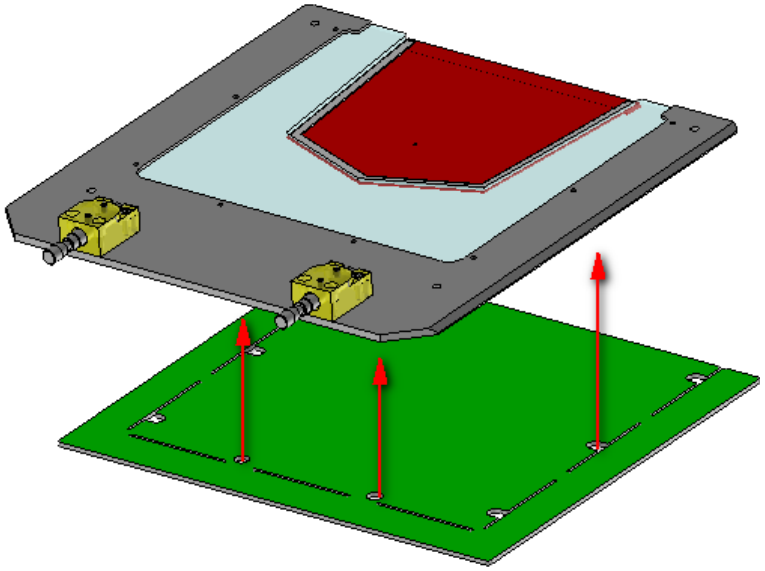


2 FEEDER CLAMP (RUBBER)

RUBBER CODE
SIP.P.001999

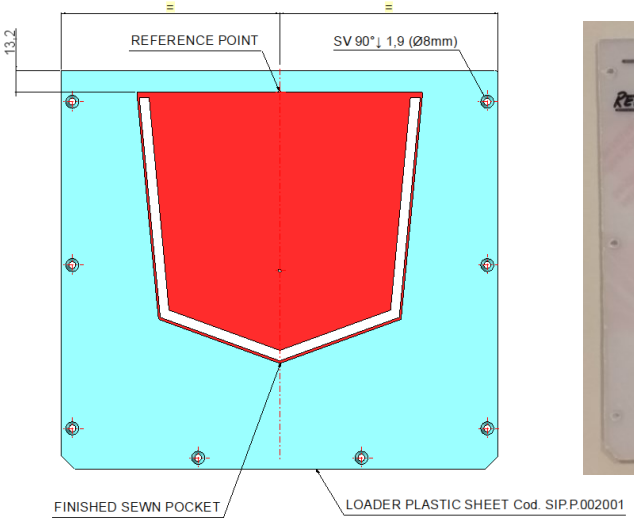


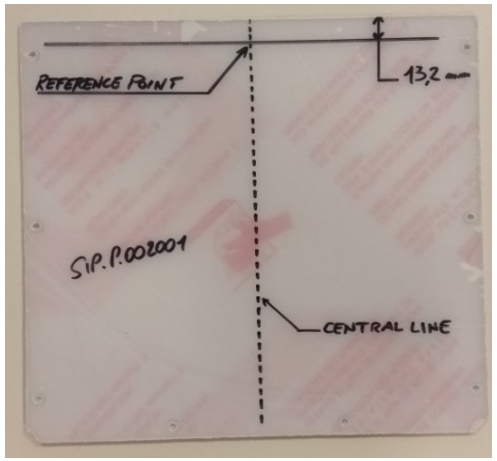
- ✓ Remove the film on the adhesive side;
- ✓ Place carefully the rubber on the lower side of the mask;
- ✓ Cut out carefully the rubber following the same profile of the pocket;

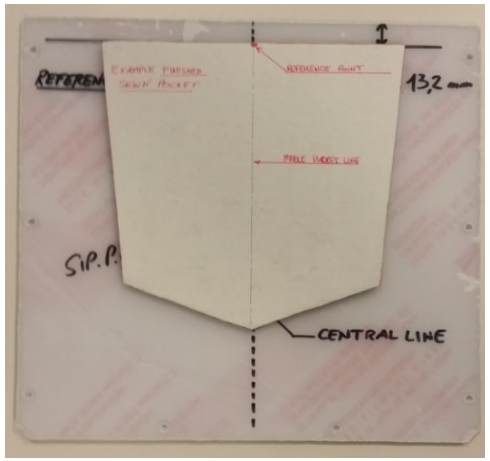


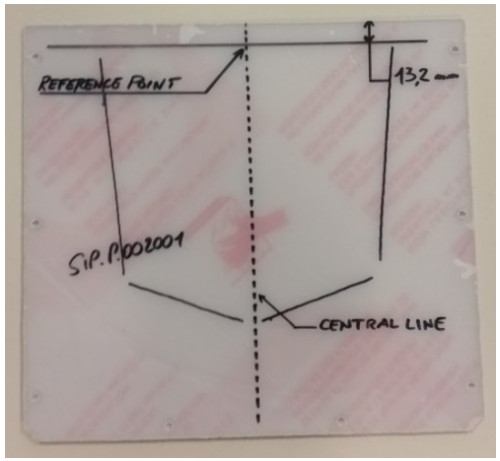
2 LOADER CLAMP (PLASTIC SHEET)

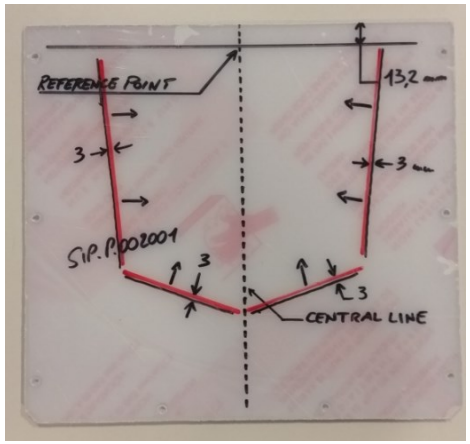
- ✓ Place the finished pocket sewn on the plate as specified in the picture below;
- ✓ Draw with a mark pen the pocket profile;
- ✓ Draw an **internal** offset of 3 mm;
- ✓ Cut carefully the plate obtaining the pocket profile 3 mm smaller ;











PLASTIC CODE
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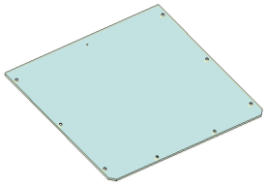

MASK CODE
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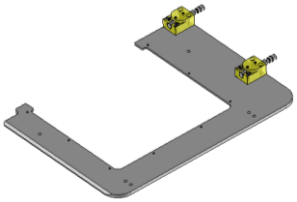
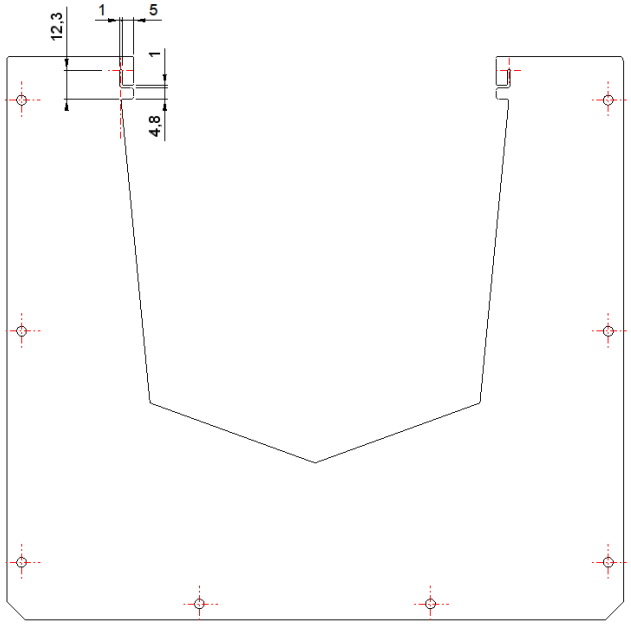
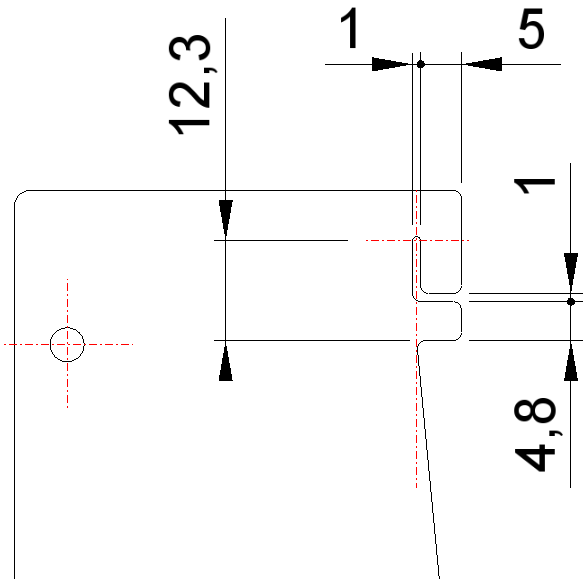
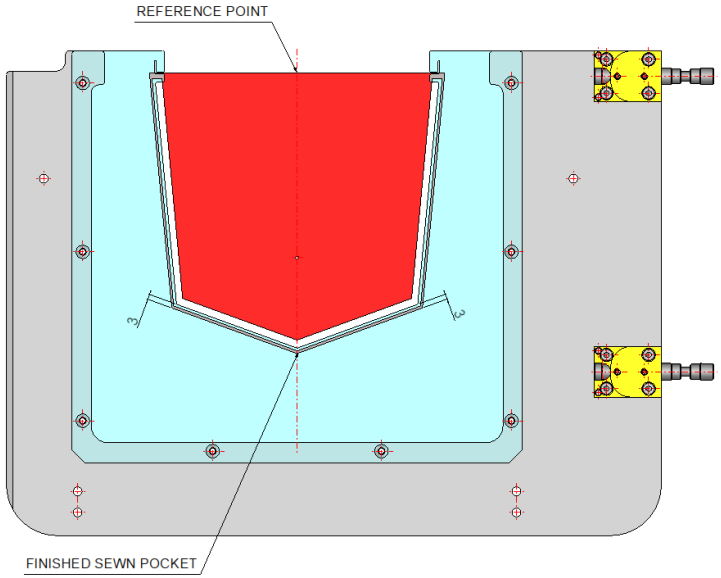


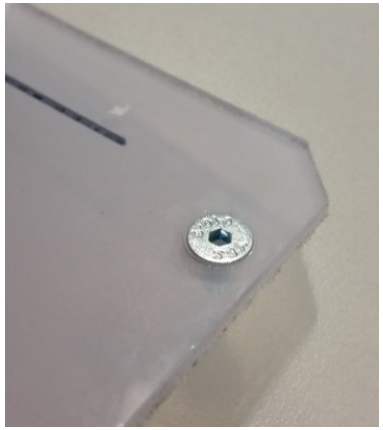
2 LOADER CLAMP (PLASTIC SHEET)

- ✓ Open the upper area of the plastic sheet according the following specifications;
- ✓ Make countersink for M4 screw;
- ✓ Place the rubber as described on the next page;





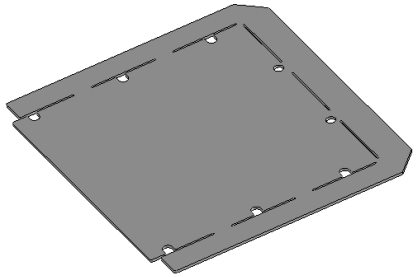


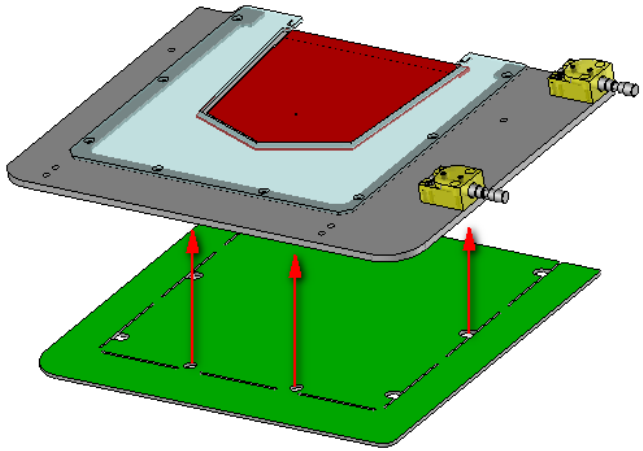


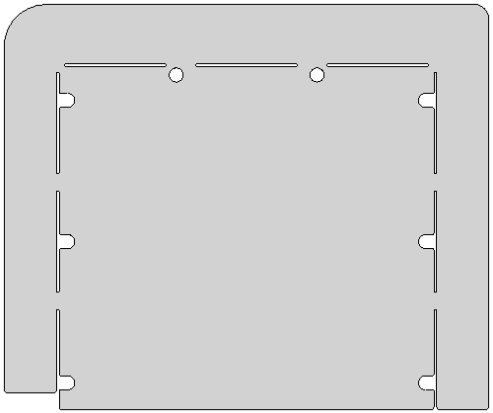
2 LOADER CLAMP (RUBBER)

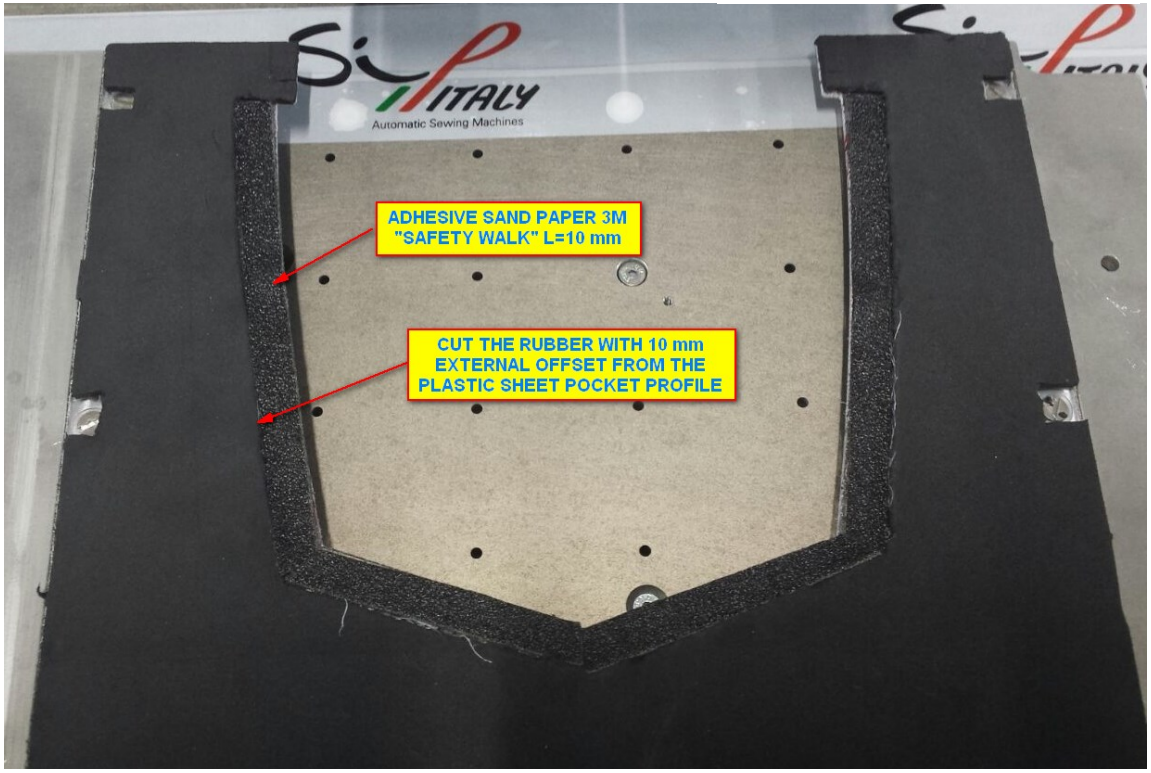
- ✓ Remove the film on the adhesive side;
- ✓ Place carefully the rubber on the lower side of the mask;
- ✓ Cut out carefully the rubber according the instruction below:

RUBBER CODE
SIP.P.002002

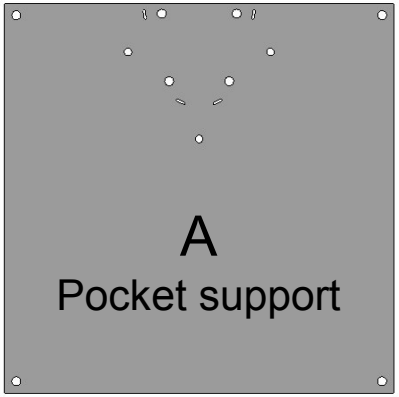


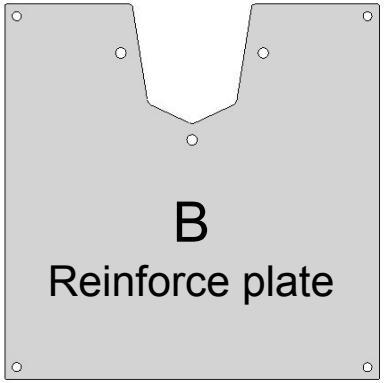


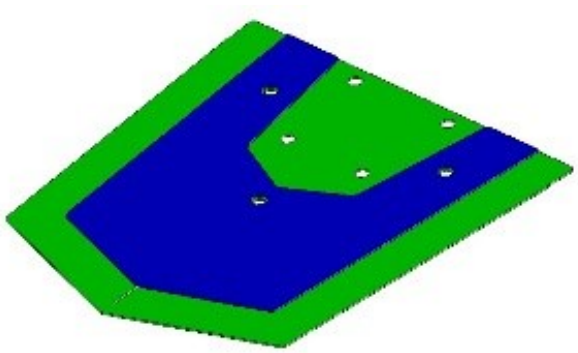


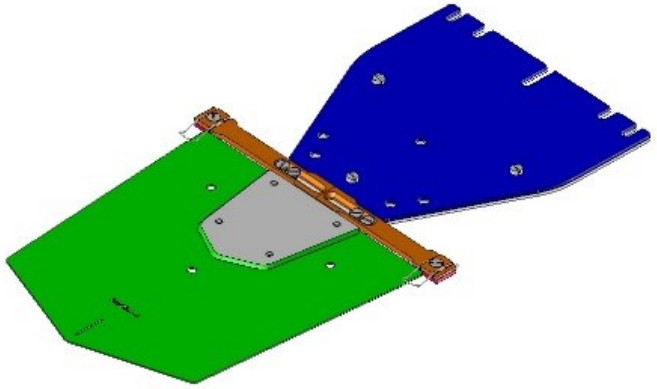


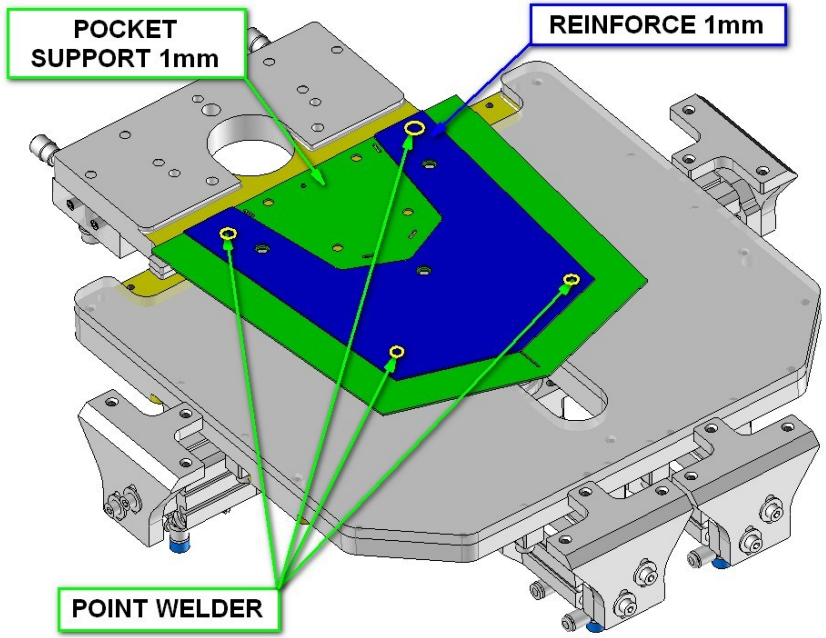
5 POCKET WELDED SUPPORT

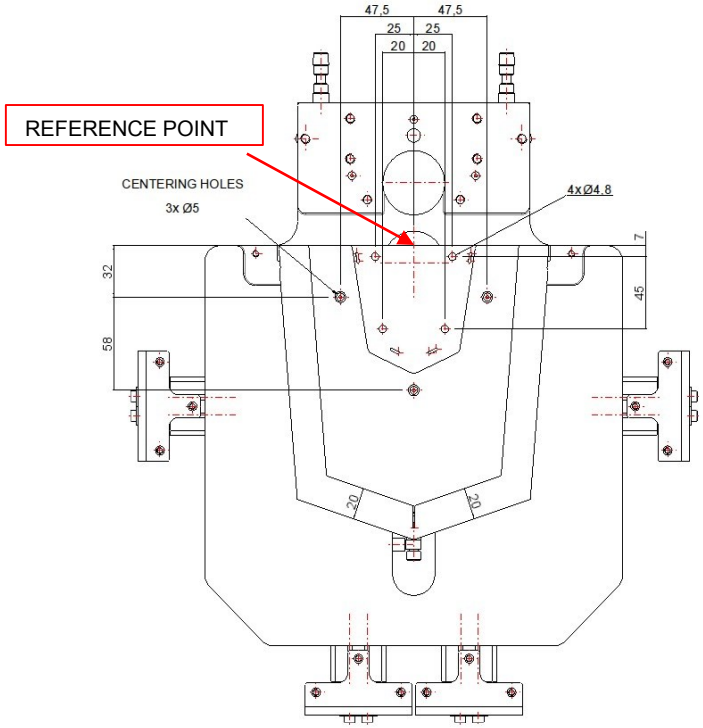






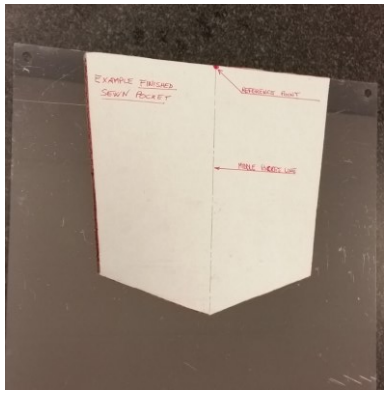


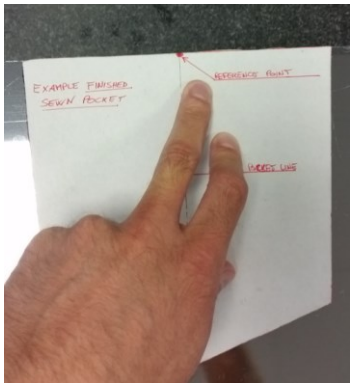


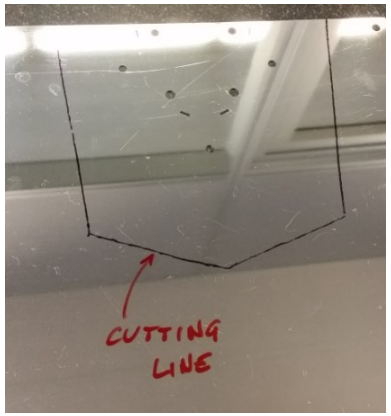


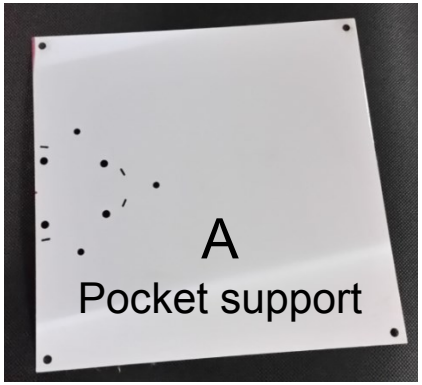
5 POCKET WELDED SUPPORT

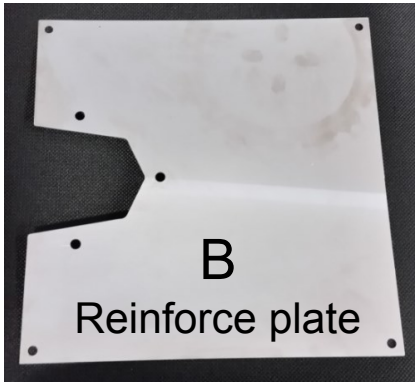
- ✓ Place the finished pocket sewn at the centre of the plate A;
- ✓ Align it on the top of the plate;
- ✓ Draw with a mark pen the pocket profile;
- ✓ Cut carefully the plate obtaining the pocket profile;



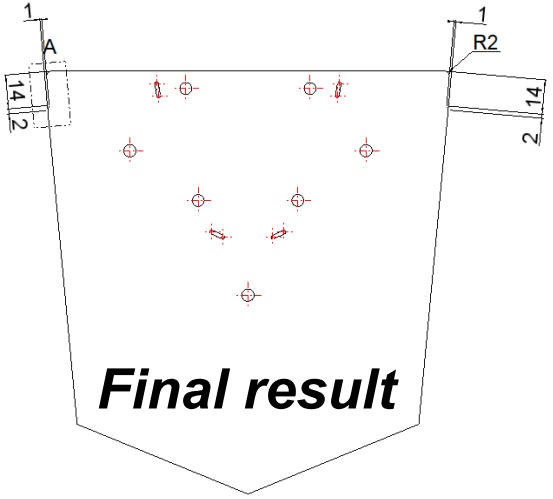


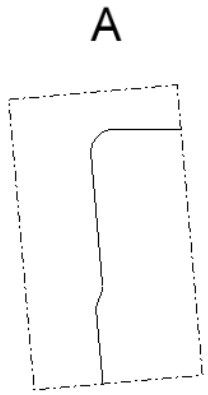






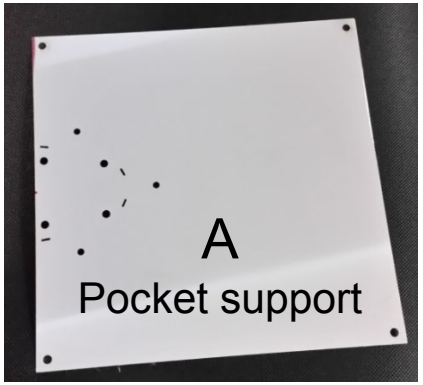
- ✓ Make the detailed modification according the following specification:
- ✓ Chamfering and deburring carefully all the sharp edges;

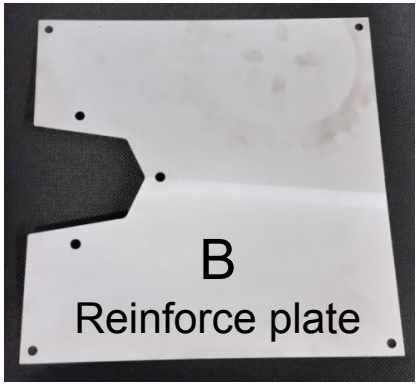


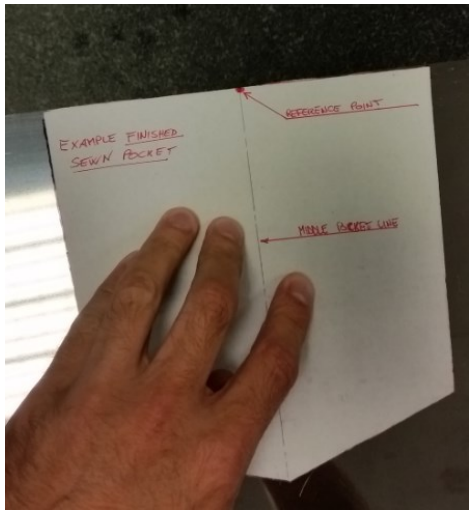


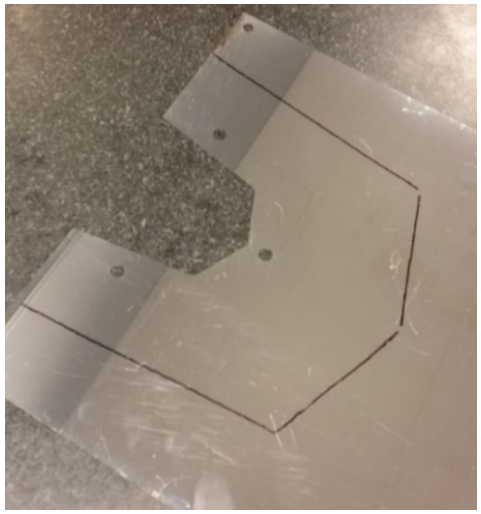
5 POCKET WELDED SUPPORT

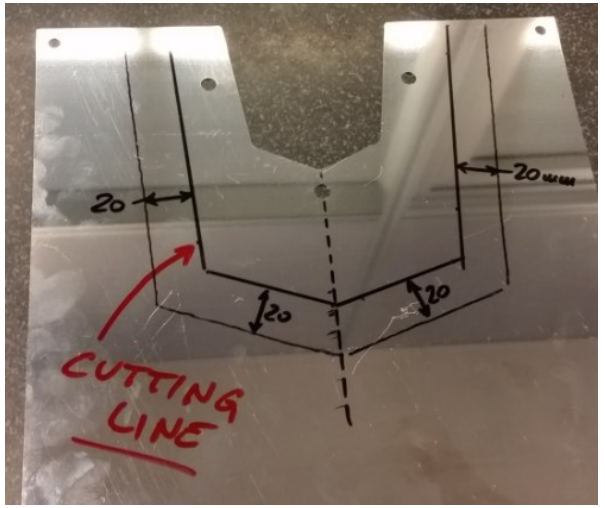
- ✓ Place the finished pocket sewn at the centre of the plate B;
- ✓ Align it on the top of the plate;
- ✓ Draw with a mark pen the pocket profile;
- ✓ Draw an INTERNAL offset of 20 mm;
- ✓ Cut carefully the plate obtaining the reinforcement element.



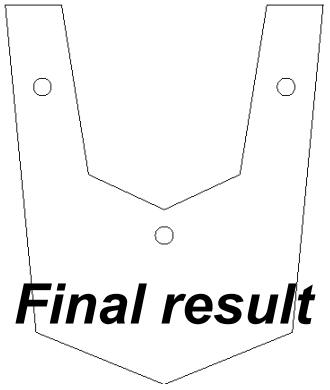








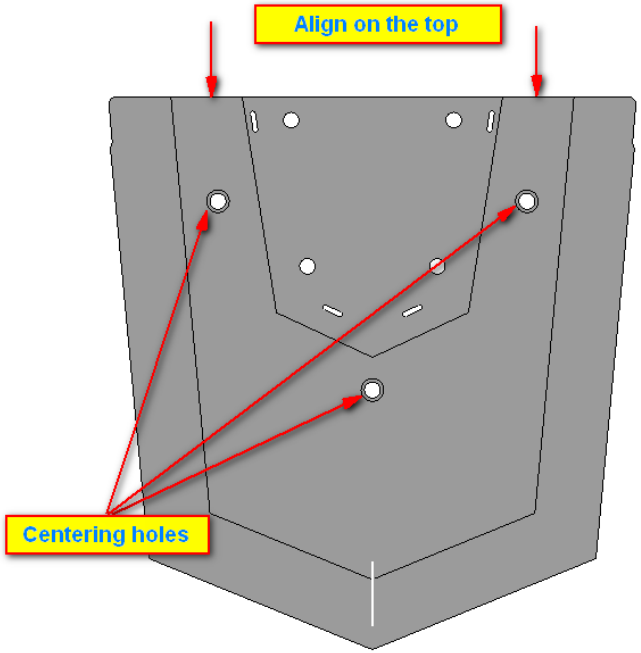
- ✓ Chamfering and deburring carefully all the sharp edges;

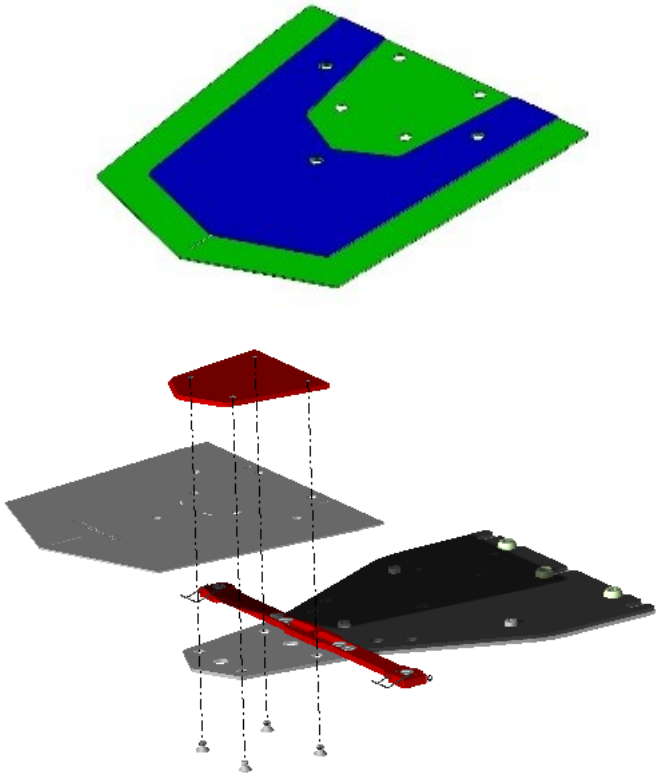


Final result

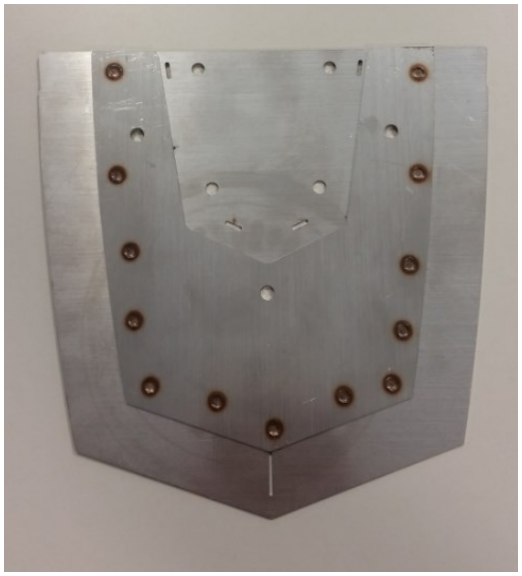
5 POCKET WELDED SUPPORT

- ✓ Weld together by using spot welding technology (or structural bonding) the plate with the reinforce;
- ✓ **PAY ATTENTION**: align the top line and centre the reference holes before weld;



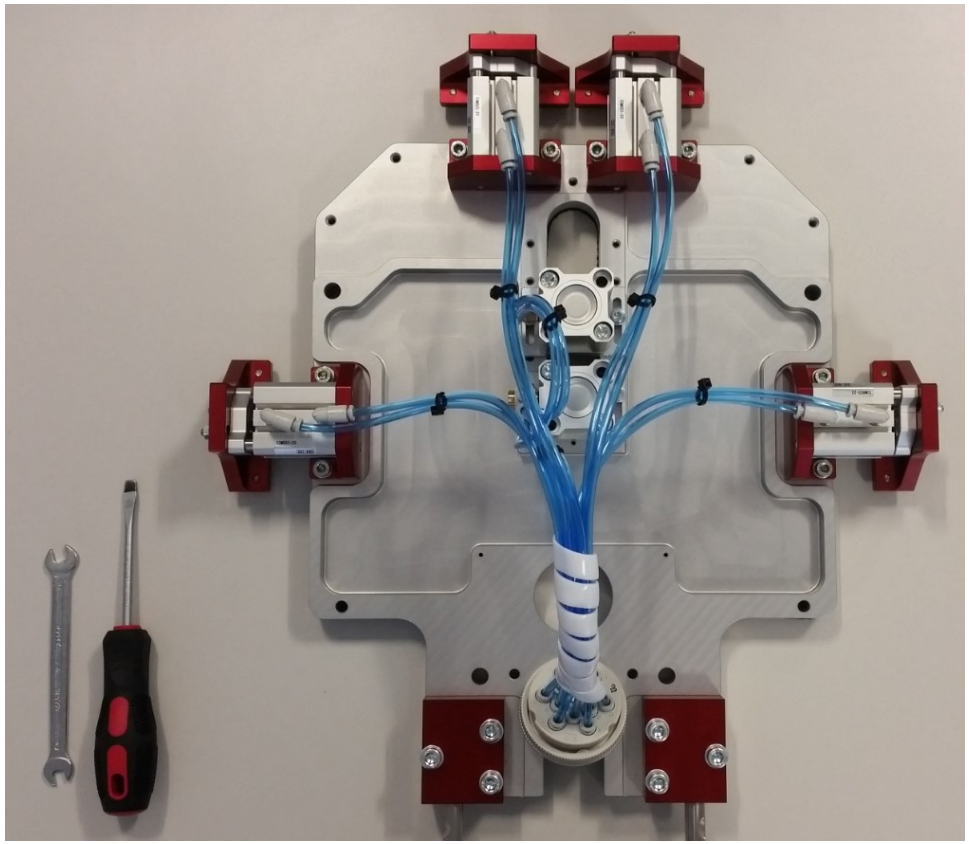


Final result



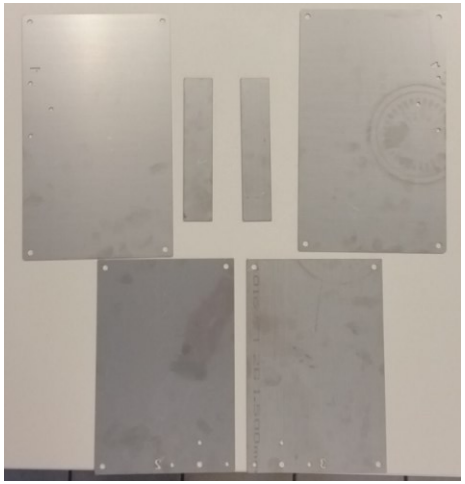
- ✓ Mount on the support between the lower plate and the upper element as shown on the picture above.

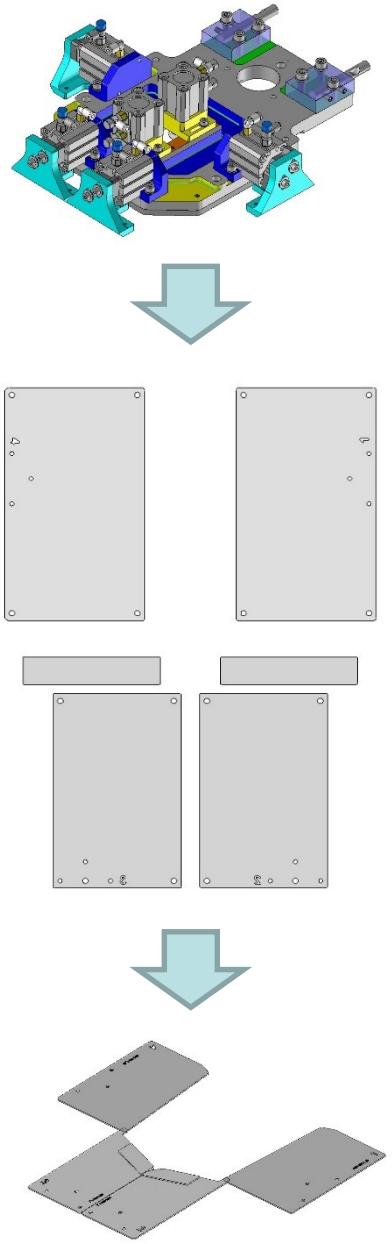
6 FOLDER GROUP 4C M-L/M-S



NEEDED MATERIAL:

1) Folding group
2) Flat screwdriver
3) Wrench CH#7
4) Folding plates set
5) Marking pen
6) Steel cutter
7) Welding set or structural glue

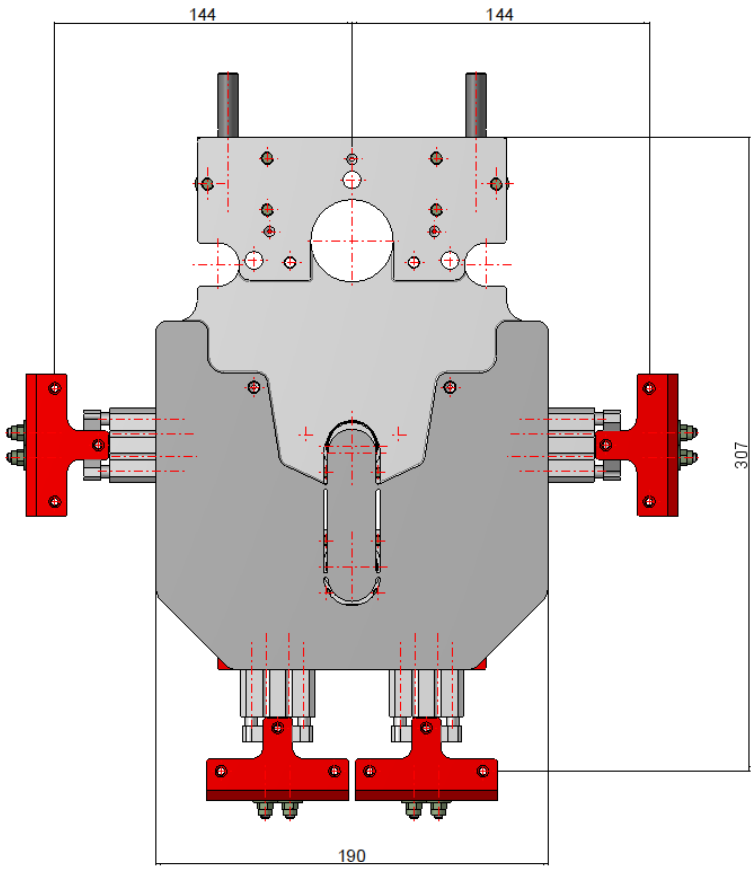




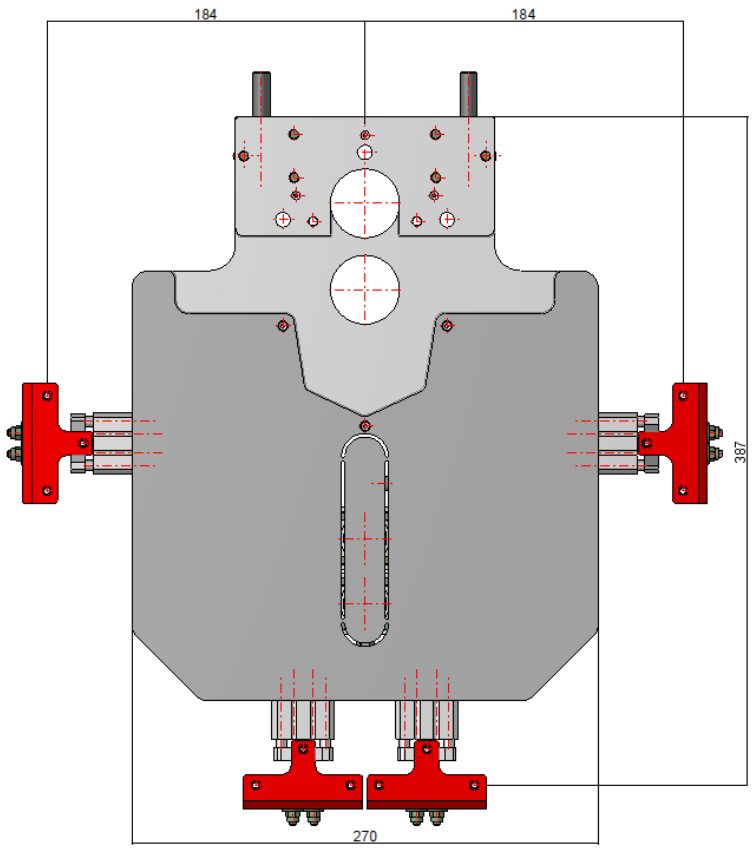
6 FOLDER GROUP 4C M-L/M-S

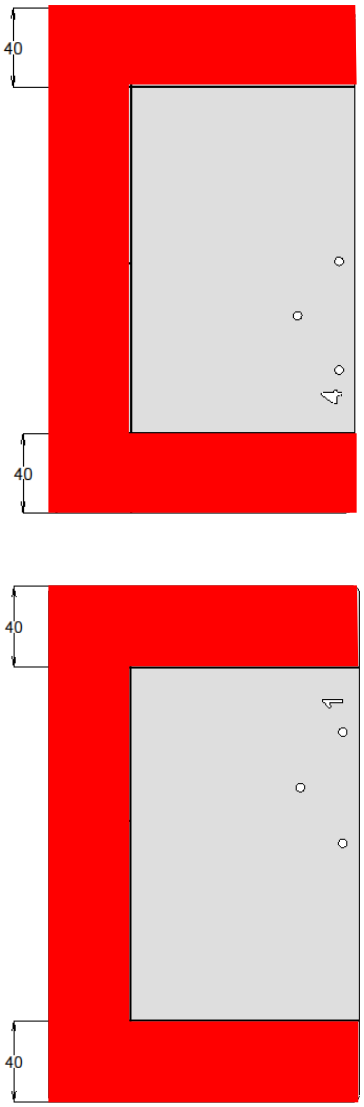
*** Pay attention**: ALL CILINDERS OPENED

SIZE M-S



SIZE M-L

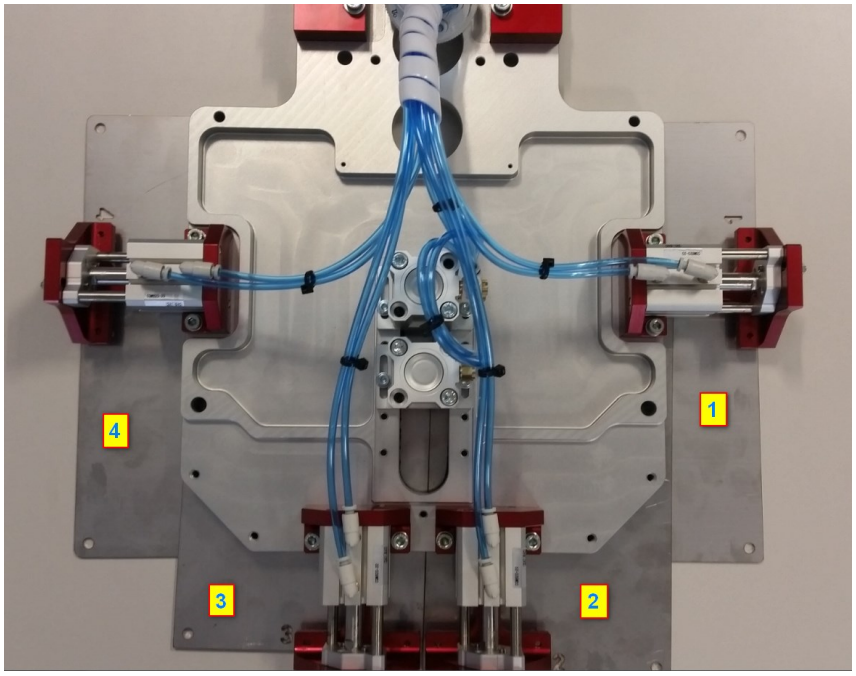


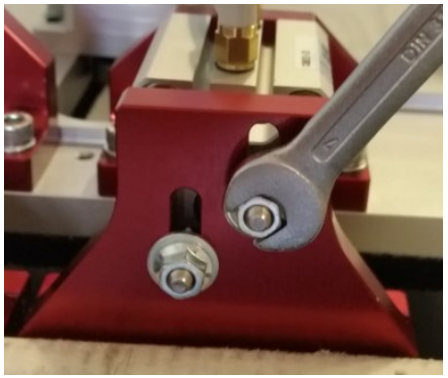


- ✓ IF your folding group size is M-L skip to the next page;
- ✓ IF your folding group size is M-S, you must cut 40 mm around the plates #1 and #4 as shown in the side picture:

6 FOLDER GROUP 4C M-L/M-S

- ✓ Make countersink on the plates for M4 screws;
- ✓ Remove screws from the folding group;
- ✓ Bring all cylinders in the open position;
- ✓ Place the plates as specified on the picture;



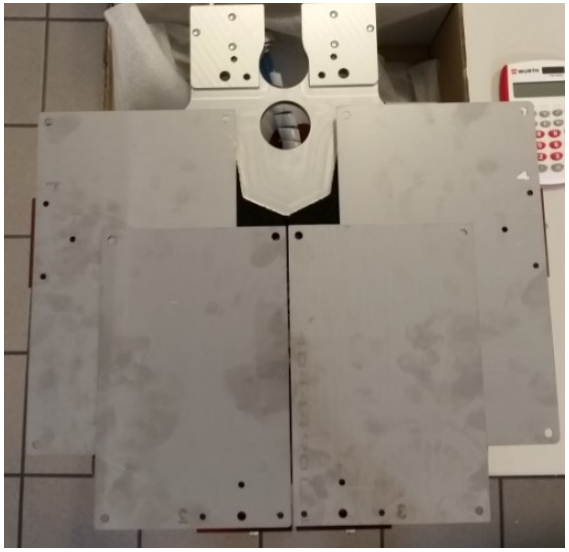


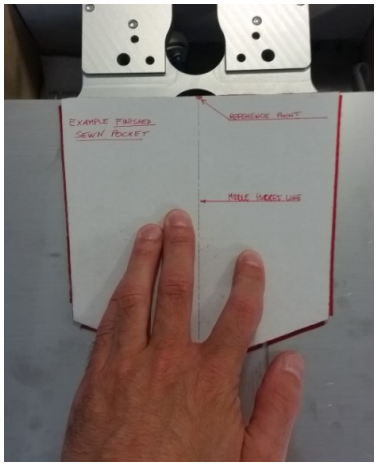
Adjust opportunely the plate's supports in order to have plates #1 and #4 in contact with rubber sponge, and above the plates #2 and #3;

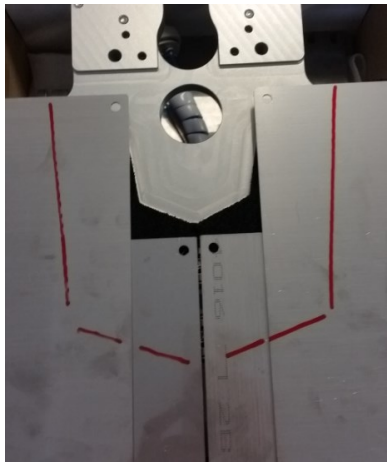
6 FOLDER GROUP 4C M-L/M-S

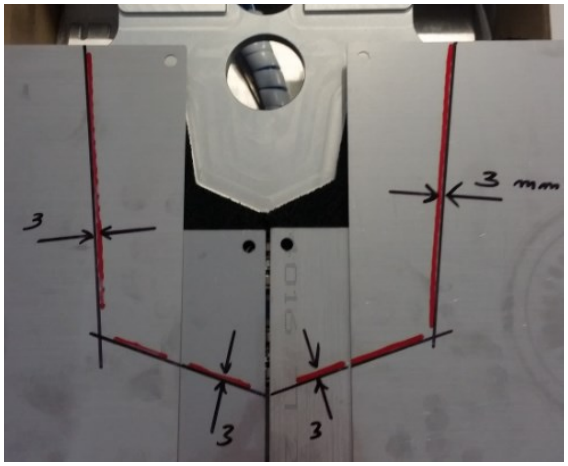
*** Pay attention**: ALL CILINDERS OPENED

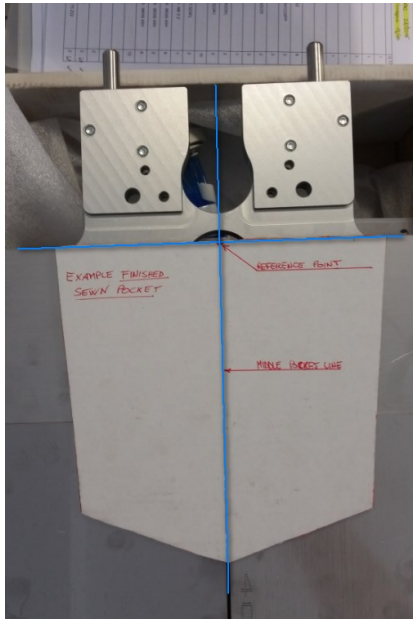
- ✓ Place the plates as specified on the picture (plates #1 and #4 below and plates #2 and #3 above);
- ✓ Place the pocket (finished sewn pocket) at the centre of the plates and aligned on the top;
- ✓ Draw the external profile with marker pen and then make an **external** offset of 3 mm on all the plates *.







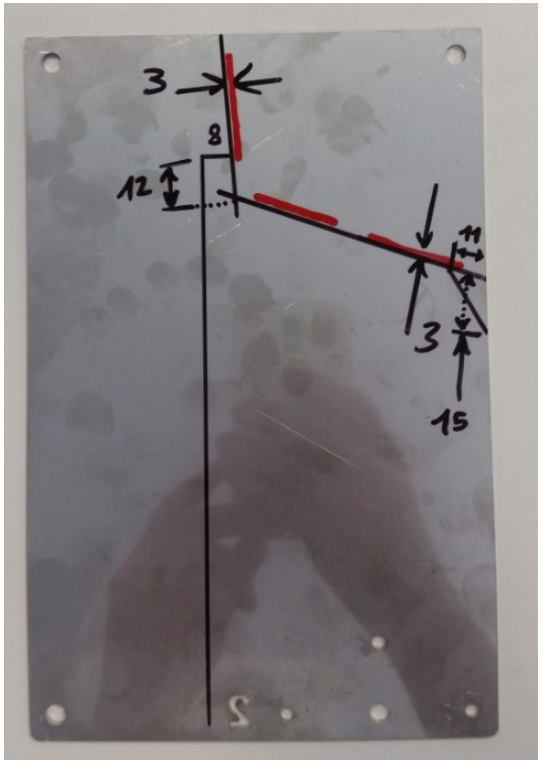




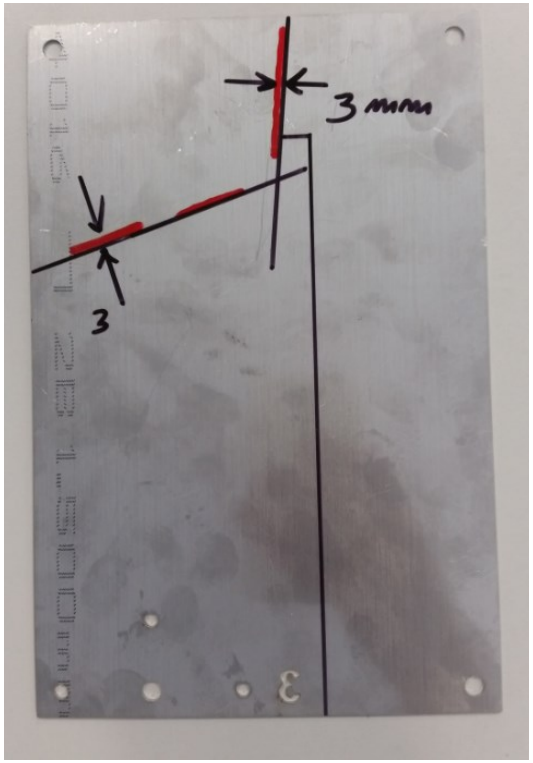
6 FOLDER GROUP 4C M-L/M-S

*** Pay attention**: ALL CILINDERS OPENED

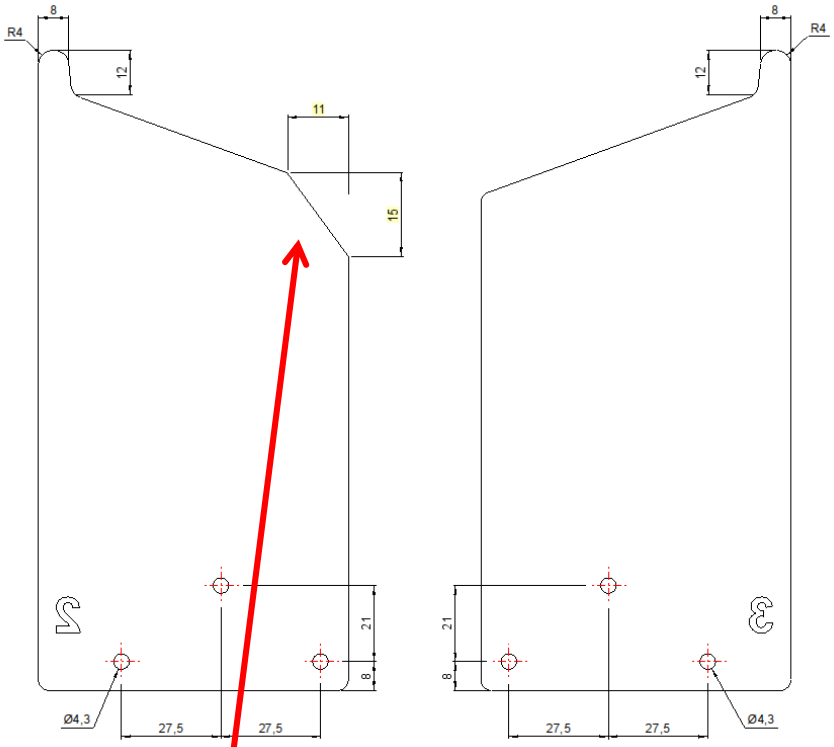
✓ Draw cutting line on plates #2 and #3 according to the following specification *:



Blades #2



Blades #3



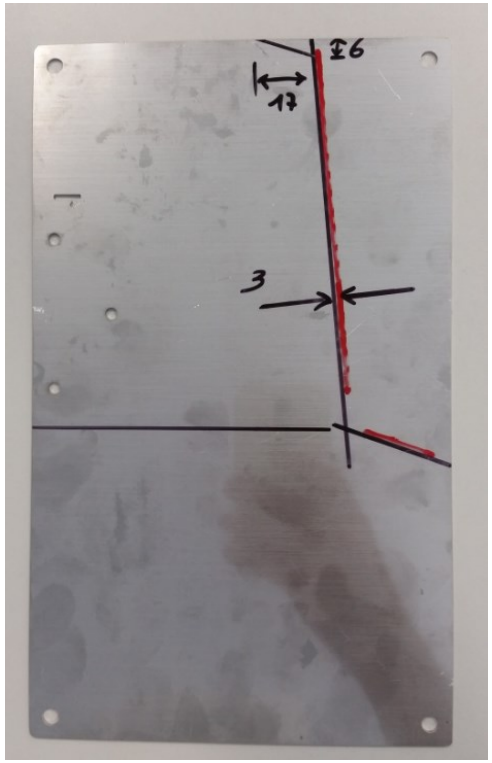
Final result

✓ **Pay attention**: chamfer 15x11 mm only on the plate #2;
✓ Chamfering and deburring carefully all the sharp edges;

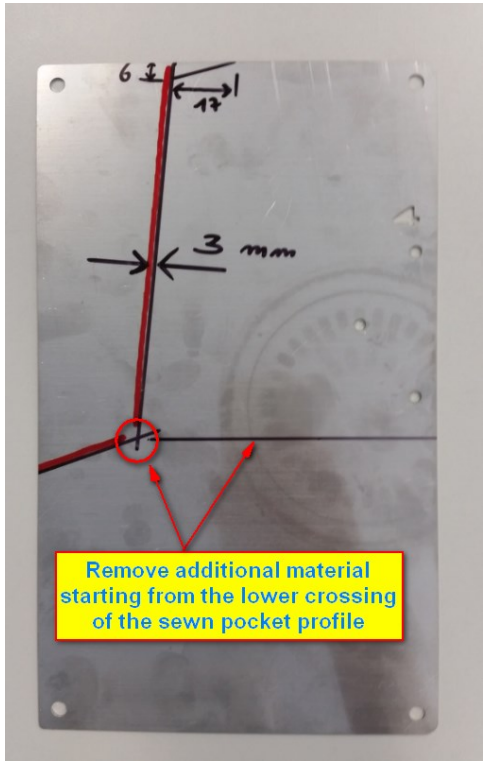
6 FOLDER GROUP 4C M-L/M-S

*** Pay attention**: ALL CILINDERS OPENED

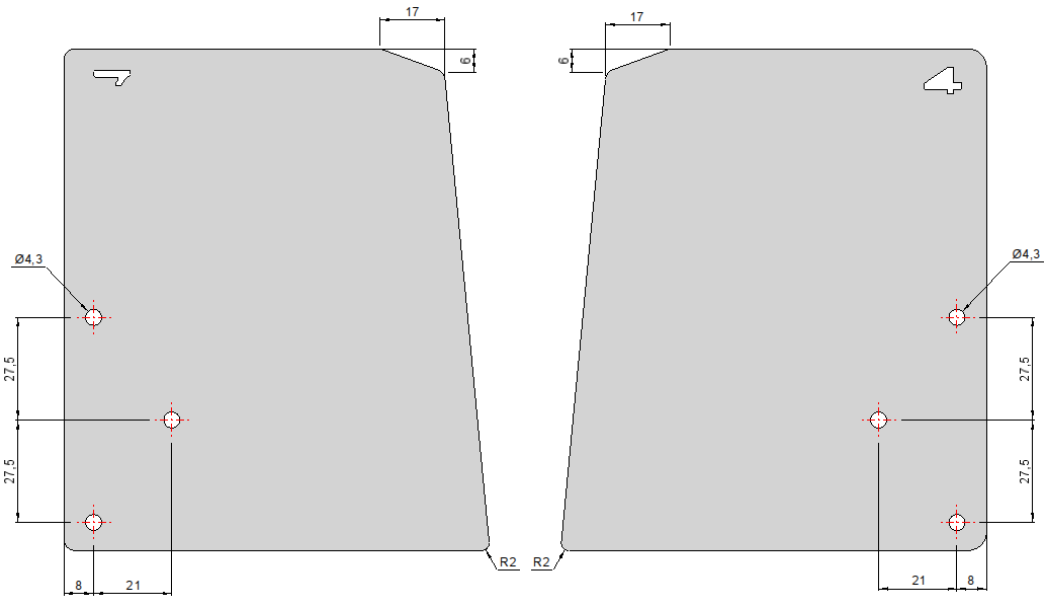
✓ Draw cutting line on plates #1 and #4 according to the following specification *:



Blades #1



Blades #4

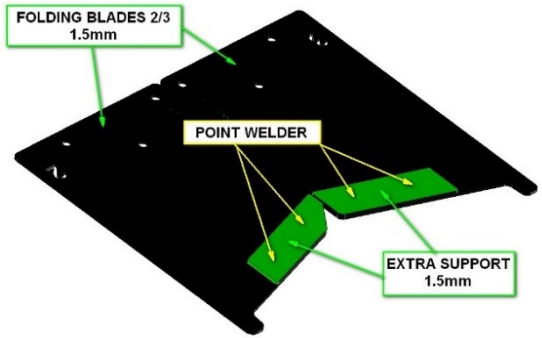


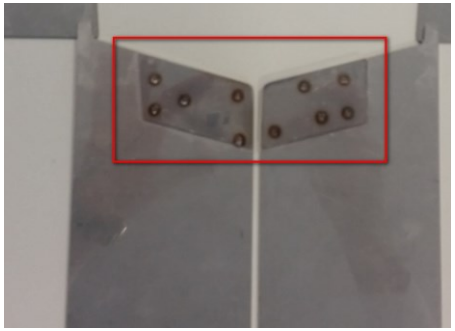
Final result

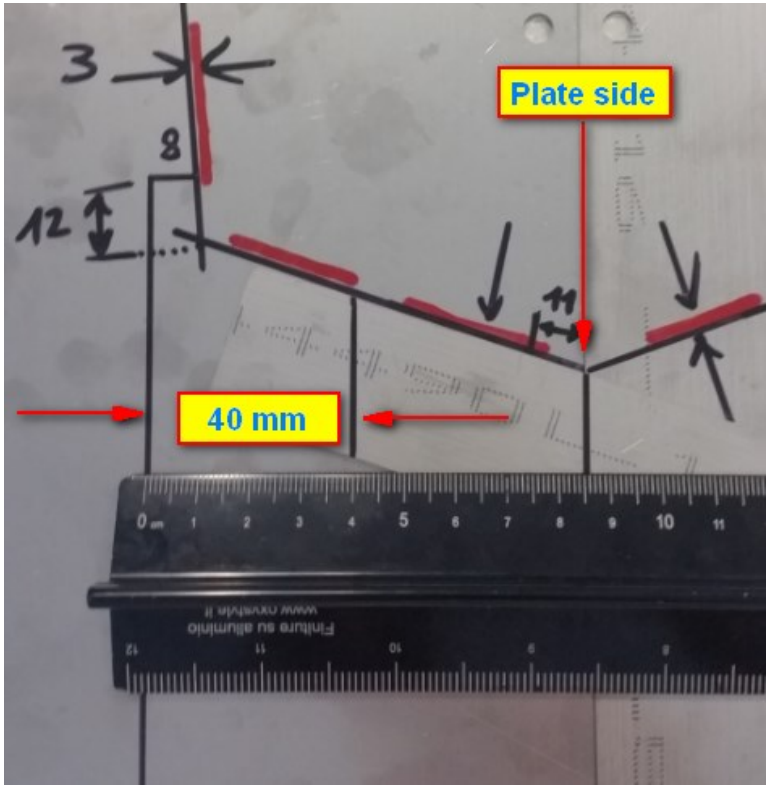
✓ **Pay attention**: lower surplus material depend on the pocket dimension;
✓ Chamfering and deburring carefully all the sharp edges;

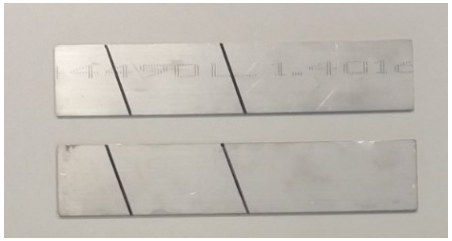
6 FOLDER GROUP 4C M-L/M-S

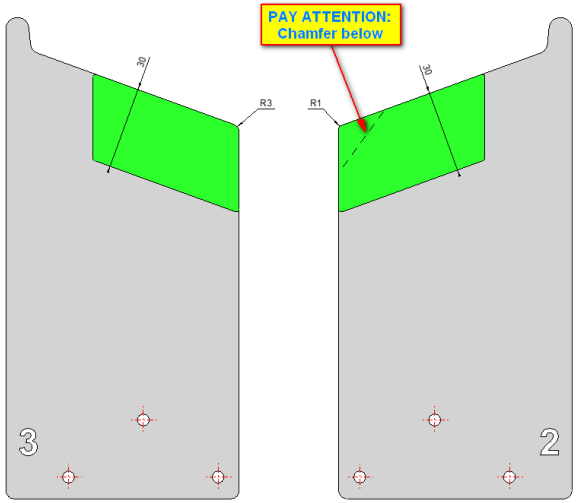
✓ Draw cutting line on reinforcement plates according to the following specification:











Final result

✓ Cut the strengthening plates;
✓ Point-weld (or structural bonding) the plates as specified;
✓ Chamfering and deburring carefully all the sharp edges;