

This learning guide is developed to provide you the necessary information regarding the following content coverage and topics –

- Undertaking repair work to restore the leather garment to optimum condition using appropriate equipment, tools, processes and materials
  - Checking repaired leather garment against the requirement
  - Perform finishing operations on the repaired leather garment
  - Preparing all relevant document in accordance with enterprise procedures
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This guide will also assist you to attain the learning outcome stated in the cover page. Specifically, upon completion of this Learning Guide, you will be able to –

- Restore Repair work undertake to the leather garment to optimum condition using appropriate equipment, tools, processes and materials
- Check Repaired leather garment against requirement
- Repair Finishing operations performed on the leather garment
- prepare All relevant paperwork and documentation in accordance with enterprise procedures

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### Learning Instructions:

1. Read the specific objectives of this Learning Guide.
  2. Follow the instructions described in number 3 to 20.
  3. Read the information written in the “Information Sheets 1”. Try to understand what are being discussed. Ask you teacher for assistance if you have hard time understanding them.
  4. Accomplish the “Self-check 1” in page 13.
  5. Ask from your teacher the key to correction (key answers) or you can request your teacher to correct your work. (You are to get the key answer only after you finished answering the Self-check 1).
  6. If you earned a satisfactory evaluation proceed to “Information Sheet 2”. However, if your rating is unsatisfactory, see your teacher for further instructions or go back to Learning Instruction #2.
  7. Submit your accomplished Self-check. This will form part of your training portfolio.
  8. Read the information written in the “Information Sheet 2”. Try to understand what are being discussed. Ask you teacher for assistance if you have hard time understanding them.
  9. Accomplish the “Self-check 2” in page 18.
  10. Ask from your teacher the key to correction (key answers) or you can request your teacher to correct your work. (You are to get the key answer only after you finished answering the Self-check 2).
  11. Read the information written in the “Information Sheets 3 and 4”. Try to understand what are being discussed. Ask you teacher for assistance if you have hard time understanding them.
  12. Accomplish the “Self-check 3 & 4” in page 28& 34 respectively.
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13. Ask from your teacher the key to correction (key answers) or you can request your teacher to correct your work. (You are to get the key answer only after you finished answering the Self-check 3 & 4).
  14. If you earned a satisfactory evaluation proceed to “Operation Sheet 1” in page 33. However, if your rating is unsatisfactory, see your teacher for further instructions or go back to Learning Instruction #6.
  15. Read the “Operation Sheet 1” and try to understand the procedures discussed.
  16. You are provided with a CD containing lessons on how to clean and maintain equipment. Before you open the CD read the information written in the “Information Sheets 1-2” in pages 4-18. You will be also provided with additional reference reading materials regarding the cleaning of masonry handtools.
  17. Request a desktop computer or laptop from your teacher. Make sure the unit is plugged to a power source before turning on the power|O. Then insert the CD in the CD drive located in your computer. Access the information as described in the Operation Sheet 1 in page 33.
  18. Read all the contents of the CD and try to understand the procedures discussed.
  19. Request access to the equipment and software described in the CD. Practice the steps or procedures as illustrated in your CD. Go to your teacher if you need clarification or you want answers to your questions or you need assistance in understanding a particular step or procedure.
- 
20. Do the “LAP test” in page 56 (if you are ready). Request your teacher to evaluate your performance and outputs. Your teacher will give you feedback and the evaluation will be either satisfactory or unsatisfactory. If unsatisfactory, your teacher shall advice you on additional work. But if satisfactory you can proceed to Learning Guide #37.

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<b>Information Sheet-1</b>	<b>Undertaking repair work</b>
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**Dry Cleaning of Leather**

With modern cleaning techniques, cleaning leathers garments has never been safer. While it is generally safe, and desirable, to clean most leathers, it is important to understand that leathers are not the same as manufactured fabrics. Thus, the you can't expect leathers to come through the cleaning process as uniformly as garments made from standardized, manufactured fabrics. Thus, expecting a leather or suede to look "just like new" after cleaning is a little like expecting well-worn shoes to appear like new after having been polished. Leathers are very durable, but they can stretch, shrink, scrape, scar, crack, peel, and lose their natural or dyed colors.

Normal dry cleaning of leather and suede garments will not generally yield the good results. Two-piece leather and suede garments should be cleaned at the same time to avoid the slight variation in color or texture that might occur as a result of the cleaning process. A water-repellent is also recommended to prevent the absorption of moisture during rainy weather, and to protect the surface of the garment. Use professional leather cleaner to apply this.

**The following are common problems in cleaning leather garments**

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### **Color Changes:**

Among the most common problems with cleaning leather is color change. Some garments have the "natural" colors of the original tanned skins, while others are treated in dye baths during the tanning and finishing of the leathers or are sprayed with dyes after manufacturing. Each manufacturer uses different dyes, and dyes can vary considerably in their color fastness. While cleaning, we usually don't know which dyes are colorfast and which dyes will run or bleed until we actually clean the garment. Colorfastness can vary from one garment to the next, even coming from the same manufacturer, sometimes due to the differences in individual skins or in the defects in individual skins. During the fabrication process, the manufacturer tries to match the skins so that a garment is consistent in color, texture, and feel. The better quality the garment, the more care was generally taken in both the tanning process and in the selection and processing of skins. However, even in the best garments, some change and variation in texture, color, and feel is normal and expected.

The different types of color changes include: Color fading, uneven color in one area of the garment, uneven color in different areas of the garment, severe color loss, color or dye transfer.

### **Color Fading:**

Mild fading of color can result from exposure of the garment to sun and air. This is a natural part of the oxidation process of the skins that occurs with the aging of the garment. Frequently it may become more apparent after a garment has been cleaned. Sometimes the soil in the garment before cleaning will give the illusion that the garment was darker in color than it may have been, and the removal of the soil gives the appearance of fading during cleaning. Fading as a result of the loss of dye during the cleaning process is a less common problem if proper cleaning system is adopted. In the petroleum cleaning processes, the garment is routinely denuded of its color, with the color being restored by spraying after cleaning. Generally approximation is made based

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upon the color that appears under the collar, where the leather has had less exposure to the sun and other elements.

**Uneven color in one area of the garment:**

On occasion, color may appear to be uneven in one section of the garment. This is frequently a result of uneven oils or fats in the original skin or uneven absorption of oils, fats, or dyes during the tanning process. Sometimes the cleaner can correct this though frequently he cannot. Use cleaning process, which is less harsh and does not remove the natural skin oils to the same extent as solvents.

**Uneven color in different sections of the garment:**

When a garment is manufactured, skins or hides are used from different parts of the animal, or from different animals altogether. These different, unmatched skins may have very different properties with regard to natural oil or fat content or absorption and retention of impregnated tanning oils and dyes. This can result in unevenness of color that only becomes apparent after cleaning. Sometimes this can be corrected.

**Severe color loss:**

This is a common problem when a garment is cleaned in solvent and it is routinely corrected by spraying.

**Color or dye transfer:**

Color or dye transfer is most frequently seen in multi-color garments cleaned in solvent. This problem occurs because one or more of the colors was not colorfast and bled from one section of the garment to another, generally a result of a manufacturer not using colorfast dyes. This is a far less frequent problem with garments cleaned by a water-based system. A similar problem can occur with cloth garments, especially those with light colors that have leather trim. The trim may bleed, leaving color on the fabric. Sometimes this can be corrected.

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**Texture Changes:**

Changes in texture or feel of the garment are common in garments cleaned by solvents. The natural and tannery-added oils are removed along with the soil and stains, and are partially restored with oils dissolved in the cleaning solvents. Still, however, texture change is frequent. This is generally a less severe and less frequent problem with garments cleaned by water-based systems.

**Wrinkles:**

Skins and hides taken from the neck and belly of an animal are generally more wrinkled than those taken elsewhere. Therefore, in the tanning process, neck and belly skins are stretched more than skins from other areas to give a smooth appearance. In the cleaning process, the skin may "relax" back into its normal, wrinkly state, which can make the garment looked wrinkled (and sometimes also make the garment feel more snug). This can be exacerbated with age and the natural loss of oils from the skin over time, or in repeated cleanings. The leather can usually correct, if not too severe, wrinkling and snugness.

**Shrinkage:**

Most leather garments gradually conform to the body when worn (like shoes to a foot). Slight shrinkage and resulting snugness is routine and should be expected of nearly all garments in all cleaning agents. Wearing the garment for a few days or weeks will cause the leather to loosen and once again conform to a customer's body. This will solve most instances of mild shrinkage. A small numbers of garments come back "very" snug. The reason for this is that leathers "relax" in the cleaning process. In the original tanning of the skins, leathers are subjected to both caustic chemicals and physical stretching to obtain the proper shape, feel and texture.

In the manufacturing of the garment itself, the skin may be stretched further again. Also many garments are manufactured overseas today, and the manufacturer may stretch the skin more than he should to get a little extra "yardage." When the garment is introduced into a cleaning agent, the leather "relaxes", meaning that it may return to its

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more natural, pre-stretched state. Three out of four garments that "over-relax" can be restored to the original size by a re-cleaning, and by proper pressing the garment's original size can be retained.

**Stains & Spots:**

Every stain is unique. The same spill will react differently with different garments. On a smooth-skinned garment, salad oil might wipe off with almost no apparent effect, or it might mar the surface of the leather in such a manner that the surface cannot be easily restored. On a suede leather, the same oil will be soaked up by the skin, leaving a stain that can be either easily cleaned or a stain that is highly resistant to cleaning. Pre-spotting agents are used to help remove the stain before the garment is cleaned. Pre-spotting is used on oil stains, vegetable stains, protein stains (eggs, milk products, etc.), and inks.

Generally, though the longer a stain is allowed to set and oxidize, the more resistant it will be to removal. With woven fabrics, stains can be "pushed through" the fabric during the cleaning process. With leathers, stains must be dissolved (at the surface) and absorbed back out of the skin. Frequently it is seen that the stain can be removed at the surface of the skin, only to find that, after sometime, the stain has re-appeared from the leaching back out of the stain from deeper within the leather. On occasion, it is difficult to remove the deeper stain without risking damage to the garment.

The most common stains on leather and suede and sometimes the most difficult to remove are sweat and perspiration stains at the collar and cuffs. These stains are deeply impregnated; they are repeated stains caused by sweat at the neck, a combination of both water-based dirt combined with skin oils. The water evaporates, leaving the oil and dirt. This is repeated over and over, allowing the stain to both penetrate and set repeatedly. Collars and cuffs are usually treated with a pre-spotting agent, whether cleaned in petroleum solvents, or by other cleaning agents. Petroleum solvents are sometimes more capable of removing these oil-based stains along with dye colors.

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**Mold & Mildew:**

Leather is a natural material and should never be stored in plastic because it traps moisture, which encourages the growth of mildew and bacteria that will ruin the leather. Never store leather wet. If applicable, remove any dirt, mud, or other stains with a cleaning agent while the garment is still wet or damp, then condition while the pores are still fully responsive. It is critical to let leather air-dry away from heat. Always store leather in a dry place away from heat, in a breathable bag. If the leather item is a garment, keep it on a padded hanger to avoid distorting the shoulder line, and stuff the garment with paper to retain shape.

**Blood Stains:** Any protein stain, such as blood, eggs, or milk, has a special affinity for leather, which is also composed of proteins. However, there is a very good chance of safely removing these types of stains with a special process when the garment is cleaned. The age of the stain may affect the results.

**Pet Odors:** Leather cleaning, with use of a special process, will remove pet urine and its odor, almost every time. Cats especially can be attracted to products used during the tanning stage, and this attraction may continue after the cleaning process, so it is important to store garments away from pets. The type of leather, and the type of leather finish, may impact the cleaning results.

**Skin Defects:**

The following are some common skin defects that become more apparent after cleaning:

- **Tick bites:** ticks buried in the hide when the animal was alive can result in small holes appearing as the hide is tanned and stretched.
- **Vein marks:** marks that are the result of blood veins running through the original hide or skin.

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- **Cuts and scar tissue:** defects in hides from injuries when the animal was alive; if the animal's skin was cut or damaged, a mark will appear in the skin; if a cut healed, it may have left scar tissue in the skin.

- **Thin skins:** a skin may be naturally thin in certain areas, causing a variation in the absorption of tanning oils or dyes; this thin section may become visually apparent in the cleaning process, and is also subject to tearing as it is subjected to agitation in the tumbling machine

#### 4.1.1 Fusing

- confirm correct fusing materials used or not
- Check evenly fusing requires or not
- the excess outcome fusing cut and cleans
- If the jacket having button hole (front, cuff), the fusing material should not show outside after cutting the hole

#### 1.1.2 Cutting

The leather cutting job is very precise work for the productions. The components pattern included all over allowances such as Folding allowances, Underlay allowances and Stitching allowances. In the leather cutting section the Labor or staffs has to maintain the quality of the leather/ material – grain, color, size, and quantity according to the requirements of the client. They have to maintain proper norms for cutting the leather and wastage has to be minimized. The safety norms have to be maintained according to the industry act. To make less number of products, cardboard patterns are used for cutting components. To make more number of products, aluminum or galvanized metal patterns are used for cutting components. To manufacture in bulk, the cardboard patterns of the product are converted into clicking dies and the components are cut in the hydraulic clicking press. The Leather Cutting Pattern has to be marked by the RED PEN/ COLOUR.

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The cut components should be inspect for the following defects.

- Loose or fibrous material
- Brand marks operation scars and open flaws.
- Closed flaws wire marks and scratches
- Growth marks or fat wrinkles
- Veins
- Fly cuts
- Discolored areas

Insects the parasitic damage.

- Any other defect that may render an area of leather unusable.
  - check each panel, grains
  - compare with sketch
  - left and right panels equal
  - The loose grain must be used invisible place or in side panel
  - finished garment look without any defect



### 1.1.3 Assembling and stitching

In the process of assembling, the prepared components are assembled part by part.

The assembled components are then joined to give a shape to the article. In assembling process, different techniques of constructions are used depending upon the types of

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articles to be stitched according to the construction. After assembling, the assembling of the components are checked for quality and then sent for stitching operations. In the process of sewing, sewing is the most important operation, which decides the quality of the end products. The highly skilled stitchery who are well versed in operating various types of sewing machines do sewing. Sewing the finished products. are carried out in flat bed sewing machine. Stitching thread should have good tensile strength, abrasive resistance to moisture, heat and ability to withstand oils, solvents and adhesives. A correct thread for specific use is essential to achieve efficient production. Commonly used threads are cotton, nylon, nylon cotton, and polyester cotton. Before stitching of the products, the stitches are tested on a piece of leather. If necessary, suitable adjustments are made for perfect stitching. In stitching leather products, two types of stitches are commonly used. They are lock stitches and chain stitches. In lock stitches, the thread from the needle and bobbin lock together and fix firmly in the material. In chain stitching, the stitch is formed by single thread. It is not as strong as lock stitches. When the thread breaks, the seams become weak. The products are stitched carefully. After stitching of the products, they are checked for quality of stitching and then sent for finishing.

- check the garment component with design
- confirm that single and double stitch
- check the stitch length
- Check thread used
- check any jump stitching on the garment
- check missing stitching component with the style
- check panel joint stitching
- check inner lining stitching according to requirement

#### 4.1.4 Finishing

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Finishing is the final process in the manufacture of leather goods. A team of semi-skilled technicians and helpers headed by a quality control supervisor does finishing. After stitching, the articles are checked carefully. Excess thread is removed by fusing with a soldering tool. Excess adhesive is removed with a piece of crepe rubber sheet. The whole product is cleaned both inside and outside with a clean piece of cloth. Before the articles are sent for packing, strict quality control is observed for perfection in assembling, stitching accuracy and smooth functioning of fittings.

- clean unnecessary thread, glue, and others from finished garment
- use polishing cream if required plane
- Iron finished garment, use ironing table and cotton cloth
- put tag and brand label
- put finishes garment in poly bag

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<b>Self-Check 1</b>	<b>Written Test</b>
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**Directions:** Answer all the questions listed below. Use the Answer sheet provided in the next page:

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1. List down the common problems in cleaning leather garments. (2pts)
2. List down a few colour related problems in cleaning leather garments. (2pts)
3. Write notes on shrinkage & wrinkles with regard to cleaning of leather garments.(4pts)
4. List down some common skin defects that become more apparent after cleaning. (2pts)

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**Note: Satisfactory rating - 6 points**

**Unsatisfactory - below 6 points**

**Answer Sheet**

Score = _____
Rating: _____

Name: \_\_\_\_\_

Date: \_\_\_\_\_

**Short Answer Questions**

1 \_\_\_\_\_

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2 \_\_\_\_\_

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3 \_\_\_\_\_

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<b>Information Sheet- 2</b>	<b>Checking repaired leather garment against the requirement</b>
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Checking of leather garment totally depends upon the quality control in different stages. This system is based on the following principles:

- 1- Well defined specifications.
- 2- Checking and testing all input materials.
- 3- In- process quality control.
- 4- Final quality check.
- 5- Monitoring quality.

The main objective is to achieve a consistent quality standard for the product.

#### 1- INCONSISTANT QUALITY-

Some consignment are above the required standard and some below the standard. The variation is too large and not acceptable to customers.

#### 2- LACK OF CLEAR UNDERSTANDING OF QUALITY-

Each staff member of a company has a different view on quality and there is

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no clear company standard for materials or clear identification of major and minor faults.

### 3- TENDENCY TO SAVE MONEY ON TESTING-

Testing is the fix parameter of the company. If the company doing not testing, then it will cause a great loss of the company.

- 1- Insufficient planning to ensure quality.
- 2- Lack of Top management commitment to quality.
- 3- Tendency to monitor quality at the end of the line instead of in- process quality control.
- 4- Poor Documentation.
- 5- Tendency to take only corrective action but not preventive action.
- 6- Lack of understanding on how to achieve quality.
- 7- In most factory good quality is only a matter of chance.

## MAIN AREAS OF QUALITY CONTROL

In the manufacturing units, the main areas of quality control are –

- a. Material,
- b. Cutting section,
- c. Stitching and Assembling section,
- d. Repairing, cleaning and checking,
- e. Dispatching.

## LEATHER Garment QUALITY CONTROL

1. The main responsibility of a company to produce a better quality to the manager ( Production ) and production supervisor of each line is to improve the quality in their product.
2. The objective of the quality system should be to prevent a problem rather than a postmortem after garment are made. This means a shift from end of line

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quality checks to one that anticipates problems and corrective action taken before major damage occurs.

3. Continuous improvement and involvement of the workforce is essential for success. Schemes that operate in fits and start like quality week are not likely to have long term benefits.

4. It is possible to measure quality and managements should watch the quality index chart every month to ensure upward progress.

5. Why quality important for us?

During the last few years increased competition, recession in many countries and over capacity in leather garment manufacturing worldwide have put great pressure on manufacturers to either improve quality or perish.

1. It is the recent survey that manufacturers lose 10- 15% of their sales due to poor quality. These quality improvements can bring about genuine cost reductions.

2. The biggest problems in world is inconsistent quality. Variations in quality from lot to create major problems for leather garment chains to sell merchandise.

3. Most companies lack of testing centre. They look at laboratory tests as additional costs rather than a way to plug major losses. Cost of quality is rarely measured for e.g., rejections, rework, recur orders etc.

- checking measurement According to the given specification
- confirm back length from center back neck to bottom
- checked front length from neck(zip length)
- checked sleeve length from shoulder point (or from center back neck)
- confirm all given measurement like pocket, collar, cuffs, neck...etc
- label position
- confirm correct material and size

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- confirm outer shell and inner shell balanced

**Parameters to be seen in a repaired garment**

- Colour and grain matching
- Visible Defects
- Shape
- Dimension (length, breadth, depth and width)
- Quality of stitch
- No of stitches per cm
- Seam allowance
- Cleaning
- Fusing
- Trimmin

<b>Self-Check 2</b>	<b>Written Test</b>
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**Instructions:** Answer all the questions listed below. Illustrations may be necessary to aid some explanations/answers. Write your answers in the sheet provided in the next page.

1. Write the principles of checking of leather garment quality control (4pt)

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2. write the main objective of consistent standard for the product (3pt)
3. what are the main area of quality control (5pt)
4. explain the objective of quality system (3pt)
5. write down the Parameters to be seen in a repaired garment (5pts)

**Note: Satisfactory rating - 11 points**

**Unsatisfactory - below 151points**

**Answer Sheet**

Score = _____
Rating: _____

Name: \_\_\_\_\_

Date: \_\_\_\_\_

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## Short Answer Questions

1 \_\_\_\_\_

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3 \_\_\_\_\_

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<b>Information Sheet- 3</b>	<b>Perform finishing operations on the repaired leather garment</b>
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### **Performing finishing operation on the repaired leather garments**

This procedure encompasses a great variety of possibilities and will include:

- Pressing and ironing
- Colour spraying
- Surface repair
- Fleece treatment
- Grain leather colouring
- Use of adhesives
- Improvement or repair to applied finishes
- Waxing and polishing techniques

Obviously it will not be necessary to apply the above to all garments but the need for variants on different garments has to be understood and the necessary materials, methods and techniques must be available.

It is important to know how to finish leather correctly so that the customer can be advised of the eventual outcome. As a matter of routine, it is always advisable to check with the customer before attempting any extraordinary refinishing work.

### **Pressing and Ironing**

Leather garments, which are correctly conditioned and contain the requisite amount of oil, can be pressed using either a polished head press or a free steam press. However, considerable care is necessary.

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Leather will shrink fairly readily under the combined effect of moisture and heat, this damage being more pronounced at higher temperatures, Steam from a free steam press (4 bars) produces moist heat at a temperature in excess of 100 degree Celsius which will affect most leathers severely. If the leather is damp, this effect will be enhanced.

Where free steam presses are used, steam must be used sparingly (see pressing method below)

Polished head presses are more suited to the pressing of leather, since no free steam is employed, but the leather must not be damp.

It must be emphasized that leather which has not been properly conditioned is likely to shrink even under dry heat.

Some Shearlings and most suede's can benefit from steam pressing on a free steam, general purpose press. The buck and head of the press should be well covered with resilient press clothing in good condition in order to avoid impressions in the thicker areas of the leather. If the garment has not previously been shaped on a steam/air former it must be completely finished on a press.

The principal of the steam pressing technique is as follows:

The garment is laid on the buck of the press, stretched into position and held there by vacuum. Steam may be blown through the raised press head to moisten its covering and to increase its surface temperature. Free steam must not be used when the garment and the press head are in contact. Head steam is shut off and the head brought down under light pressure for 10-15 seconds to set the shape of the leather.

Whilst the head is down, the vacuum must be released but it should be reapplied before lifting the head.

The vacuum is maintained until the leather is thoroughly cool and during this procedure light brushing can be used to develop a uniform pile or surface effects on suedes.

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Sleeves are difficult to press properly but the best result is obtained by using a sleeve pad. Un-covered sleeve-pad. Uncovered sleeve-shaped bolts or puff irons must not be used.

If a garment requires considerable stretching to restore its shape, a preliminary treatment on the press is necessary before the final pressing, as described above. Short bursts of steam from the buck warm and moisten the garment which is kept on the move (the operator uses a flapping action) to make the leather warm and pliable. The vacuum is applied and the leather stretched to a good shape and flat appearance. Normal pressing follows.

It is unsafe to use much steam from the buck on leather because of the risk of heat damage.

Grain leather is pressed in similar way to dry suede leather, although better results can be obtained using a polished head press.

When steam/air formers are used to shape the garments, the quantity of steam is carefully regulated by shortening the normal steaming time. The garment may be shaped by manipulating it during the steaming process.

The suede surface is brushed to develop a uniform pile effect when the warm air is passing through the garment after steaming. Many Shearlings do not need any further pressing treatment.

### **Ironing**

If it is not possible to finish all parts of a garment on a press buck, or where areas do not lend themselves to press or steam/air finishing, ironing might be employed.

Leather can be ironed successfully using electric irons set to the correct temperature. 'Teflon' sole plate covers can be employed but quite often the use of white paper

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between the iron and the leather can be helpful, especially where some thermoplastic finishes are present.

Ironing can often develop a fine polished effect on grain leather but it can also be used to good effect on suede surfaces as well as splits and many miner skins. Care must be taken not to produce pressure effects by using either a heavy iron or excessive pressure.

Especially, where ironing is used as a correctly conditioned to prevent shrinkage and irreversible damage. Free steam irons are not recommended for use on leather.

The pressing of leather garments with embossed patterns must be undertaken with skill and care and expert training is essential. Some leathers may be impossible to finish further. Many embossed patterns seek to imitate more expensive leathers (e.g. crocodile), others to produce patterns to enhance the fashion aspect and, in some cases, embossing is used to mask imperfections in the leather itself. Imitation snakeskin, or other reptile scales, can be produced by the leather manufacturer.

The embossing process usually demands heat and pressure but quite often wear during use will diminish the embossed effect, especially where garments are used for long periods between cleaning processes. Obviously, expert examinations are required to determine the necessary action or restraint by the leather cleaner.

Some dye patterns on printed leathers are susceptible to heat, especially if their application has been inferior-or has been affected by solvent action.

### **Application of color and Surface Repairs**

Before leather garments are put aside to be re-coloured, It is important that the following procedure is followed.

Examine the garment to determine its suitability for colouring. Often areas where rubbing and wear have occurred are not suitable to accept dyestuffs.

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Many such areas will also produce marked variations in shade.

**Procedure for Suede finishes:**

- Spray the garment with water
- Brush the leather
- Press/iron the garment
- Examine
- Rebrush
- Dye if absolutely necessary

If poor results are obtained, the garment must be re-cleaned and the procedure recommenced.

The systems of re-colouring suede leather may be divided into two categories:  
Redevelopment of the original colour by re-oiling correctly.

Colouring the leather by spraying with solutions or emulsions of dyestuff

Broadly speaking, dyeing by spraying is suitable for re-tanning garments which have lost some, but not all, of their colour. When colour loss is great, particularly from dark coloured suede, this method is preferred.

It must be recognized that lighter areas on garments due to the action of light fading cannot be obliterated by a thin application of dyestuff. Such re colouring only serves to modify the general tone of the garment and enrich existing colours. Application of dyestuff can only make a garment a darker shade or colour.

It is not normal to find colour uniformity on a worn garment. Areas which have faded in the light or reddened, residual dirt, areas where the original colour has rubbed away partly or even completely and similar imperfections provide a leather surface which

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cannot be uniformly coloured by a single application of colour. Whitish insect marks, which had not been dyed originally but only tinted-in locally, must be touched-up with pigment colour to match the surrounding leather.

Naturally, re-colouring is not a quick or simple operation as linings must be masked to prevent colour getting on to them. Only small areas are sprayed at a time with a fairly dilute application of a colour rather than a misting-on of strong colour. The garment is dried off and the process repeated perhaps two or three times until the work is complete. A light brushing and a touch-up on the press gives the garment its final finish.

### Grain leathers

Many garments are very dirty and cannot be cleaned satisfactorily other than by a drycleaning process. Moreover, the pigmented surface coating is often worn and broken and drycleaning is then advisable. Before pressing a garment, any flaking finish is removed with a special deglazing fluid and very deep scratches or scars are filled with a suitable paste, available specifically for this purpose. After pressing, the subsequent process depends on the condition of the pigmented film on the leather surface. If it is bad, the whole surface is treated with an aqueous formulation of pigmented resin which may be applied by sponging or by spraying depending on the type of formulations used. This treatment provides an 'undercoat' which seals the leather in readiness for the 'top coat' of lacquer. In cases where the original plastic film is intact, the pigmented 'undercoat' may be omitted but, in cases where a garment has been drycleaned, it may still be necessary to apply transparent 'undercoat' in order to seal the surface prior to lacquering.

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After the 'undercoat' is thoroughly dry, the garment must be pressed to seal the surface before it is sprayed with a pigmented lacquer of the desired colour to obtain the finished effect. The lacquer is plasticized to prevent cracking of the leather surface during wear. If transparent colours are required, a thin coat of pigmented lacquers may be applied, followed by an application of clear lacquer. Lacquers are available to provide a shiny or matt finish.

For garments in good condition, colouring with pigmented resin or lacquer is unnecessary and directly after pressing, they may be sprayed with a clear lacquer to provide the final finish..

Articles which have not been drycleaned but have only been sponged with detergent and water may be finished with pigmented or clear lacquers, as required.

In a re-colouring process, decorative stitching effects are lost, although two tone effects can be simulated. Pigment finishes manufacturers and other suppliers will provide the basic resins, pigments and cellulose top emulsions either separately, with recommended formulations, or as ready mixed materials suitable for spray applications. Note that grain leather edges may have to be hand-tinted with a small brush to prevent contamination of suede or lining material.

Current interest in the refurbishing of leather garments has led several supply companies to produce and market 'leather Systems', either by franchise or by the supply of reagents (and equipment) in Kit form. Whilst these can be helpful, it must be remembered that their application is only as effective as the training the operator has received. Repellency has deteriorated; the surface may be sprayed with a solution of a water repelling agent, such as an organic chromium compound, fluorochemical or a silicone. This operation should not be undertaken until it is certain that no further oiling or colour spraying is necessary. The surface may require a light brushing to develop the final finish.

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## Rain Spotting

The problem of rain spotting sometimes occurs on a new garment but appears much more commonly after drycleaning. Spots of water falling on the garment form a darker wet mark which, when it dries out, still remains as a dark spot. Often the darker colour can be eliminated by a simple brushing process, particularly if the leather is re-humidified first. Sometimes, however, this is not so and on drycleaned garments it is usually an indication that insufficient oil is present. Increasing the oil content by spraying normally overcomes the problem of rain spotting but, in cases where this is not effective, the suede surface can be sprayed with a water repellent substance,.

The latter treatment is invariably effective.

## Replacement of Adhesives

Hems, collars, lapels, facings and cuffs which need re-sticking are dealt with at this stage. A syringe is useful for applying adhesive to inaccessible parts of the garment. Lightly pressing the parts which have been stuck provides a good finished appearance. There are cases when hems should be purposely pulled apart and re-stuck in order to make the garment more presentable. This applies particularly when there has been some partial loss of adhesion or excessive relaxation Shrinkage of the leather adjacent to the garment hem.

Some leather garments will benefit by using adhesives on seam turnings to produce a flatter seam effect but this obviously depends on the effect required.

The question of interlinings should perhaps be considered at this point.

It is sometimes possible, using the correct types of adhesive, to re-apply loosened or detached interlinings, or, in fact, to replace interlinings with new. Pieces using heat set methods (iron-on interlinings). Training and practice are needed in such cases since partially detached interlinings can re-adhere in the most unwanted places. It should be remembered that the interlinings is often applied to 'set' the leather and to lessen the

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effect of wrinkling on the leather surface. If re-adhesion is attempted, these points must be considered.

Shrinkage of interlinings or leather may produce puckering of the leather and, if an interlining which is stuck firmly to the leather cannot be stretched to size during pressing, it must be detached and re fixed later using a solvent resistant adhesive.

Some type of adhesive may completely dissolve in the solvent. Others may only soften or partly dissolve and migrate through the seams or sewing thread holes to the surface. Even those which do not migrate in this way may wipe often on the leather surface from an unstuck hem. Adhesive marking-off can often be removed by simply re-cleaning the garment, particularly if this can be done in a more active solvent than that originally used. Stubborn marks can be eliminated by applying thick lubricating oil to the mark and spotting with perchloro ethylene until the adhesive soften. As much as possible can then be scraped off. The garment is then folded inwards so that tacky areas cannot touch the surface and is soaked in solvent for a period. A further re-clean will normally dissolve the remaining traces of adhesive very stubborn traces cannot easily be removed

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<b>Self-Check 3</b>	<b>Written Test</b>
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**Instructions:** Answer all the questions listed below. Illustrations may be necessary to aid some explanations/answers. Write your answers in the sheet provided in the next page.

---

**Test: Short Answer Questions**

**Directions:** Answer all the questions listed below. Examples may be necessary to aid some explanations/answers.

1. List down the finishing operations performed on a leather garment. (5 pts)
2. List the procedures for colour and surface repair of a suede leather garment. (5 pts)

**Note: Satisfactory rating - 6 points**

**Unsatisfactory - below 6 points**

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**Answer Sheet**

Score = _____
Rating: _____

Name: \_\_\_\_\_

Date: \_\_\_\_\_

**Short Answer Questions**

1 \_\_\_\_\_

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2 \_\_\_\_\_

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<b>Information Sheet 4</b>	<b>Preparing all relevant document in accordance with enterprise procedures</b>
----------------------------	---

The relevant documents are prepared in accordance with the enterprise procedures with respect to the following

1. In selection of appropriate tools and equipment required to perform finishing operations according to supervisor's instructions
2. In cleaning excess materials from the leather garment surface
3. To perform Thread trimming
4. Pressing the leather garment accordingly
5. Polishing the leather garment accordingly
6. Attaching labels according to specification
7. Examining/assessing leather garments for repair
8. Determination of requirements for restoration
9. To calculate cost to determine feasibility of restoration/repair
10. Leather garment preparation in appropriate manner for restoration or repair work
11. Obtaining materials and/or equipment required for the repair work
12. Undertaking repair work to restore the leather garment to optimum condition using appropriate equipment, tools, processes and materials
13. Checking repaired leather garment against the requirement
14. Perform finishing operations on the repaired leather garment

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<b>Self-Check 4</b>	<b>Written Test</b>
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**Instructions:** Answer all the questions listed below. Illustrations may be necessary to aid some explanations/answers. Write your answers in the sheet provided in the next page.

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List and describe how to prepared documents as enterprise requirements (5pts)

**Note: Satisfactory rating - 3 points**

**Unsatisfactory - below 3 points**

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**Answer Sheet**

Score = _____
Rating: _____

Name: \_\_\_\_\_

Date: \_\_\_\_\_

**Short Answer Questions**

1 \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

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Operation Sheet 1	Undertaking Repair Work to Restore the Leather Garment
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**Purpose:** to show how to remove worn out parts from double piping pocket

**CONDITIONS OR SITUTATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

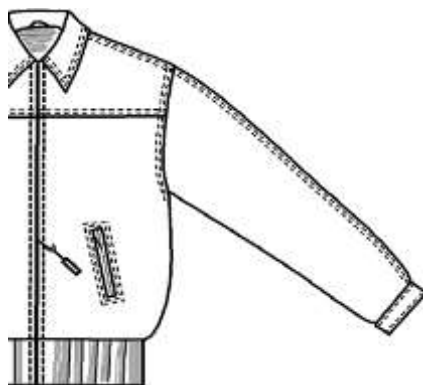
**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics leather,

**PROCEDURES:**

**Steps**

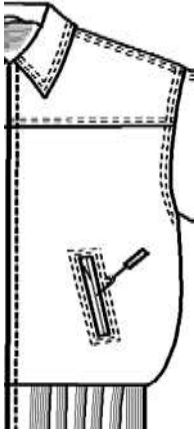
**Removal of worn out parts from the garment from double piping pockets**

1. Remove the top stitch of center front zipper using stitch remover

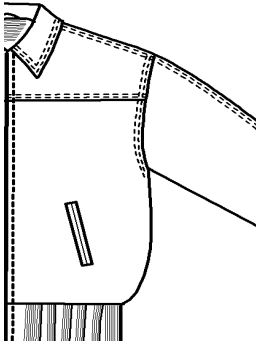


2. Then remove the top stitch of the pocket using stitch remover and take the pocket piping, facing and lining out

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1. View of the pocket after removing the piping.



Take a new leather specimen and cut piping, facing according to the pocket dimension

#### 4. Fixing of fusing paper on pocket components (leather)

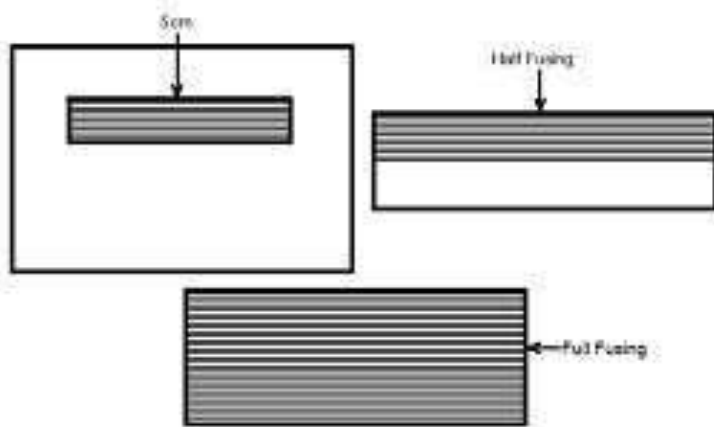
- Take the fusing paper and cut according to the measurement shown in fig1.
- Place the fusing paper on the flesh side of the panel as shown in fig1.
- Fix the fusing paper by ironing.

#### Note:

List of components to be fused:

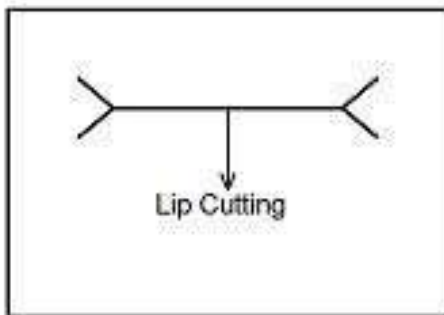
1. Panel – 5 cm
2. Piping – half fusing
3. Pocket facing – full fusing

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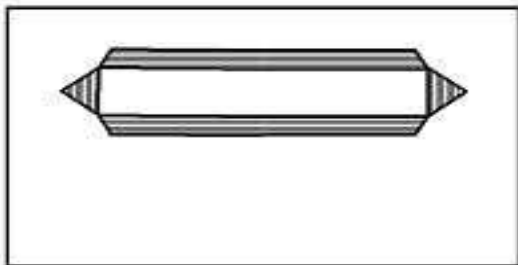


### 5. Fabrication of double piping pocket

- Complete step 4.
- Cut pocket lip on panel as shown in below fig.



Edging of pocket is to done as shown in below fig. using adhesive.



Self folding of both the piping using adhesive and hammering as shown in below fig.

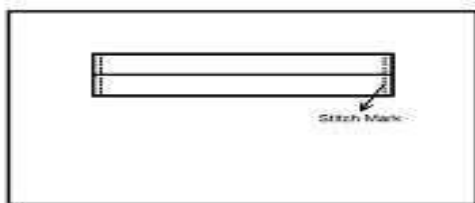
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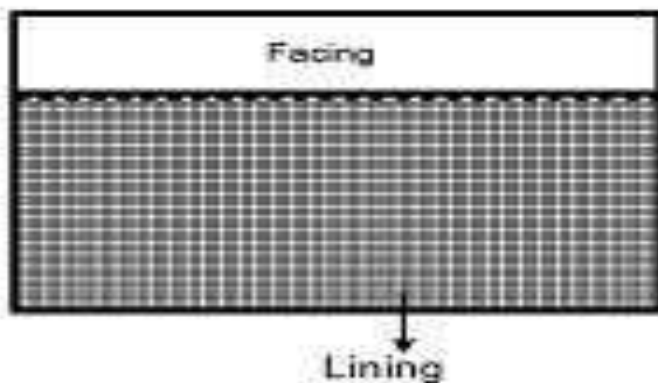
- Align both the piping together by false stitch of 5mm at edge or stick it with double sided adhesive tape as shown in below fig.



- Assemble the double piping on panel using double sided adhesive tape as shown in below fig.

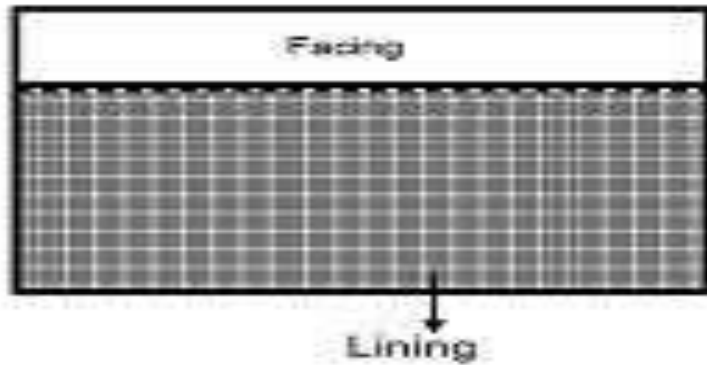


Place the lining at bottom piping and over seam on lining as shown in below fig. (2mm and 4mm) and put a knot at the back side of the pocket.

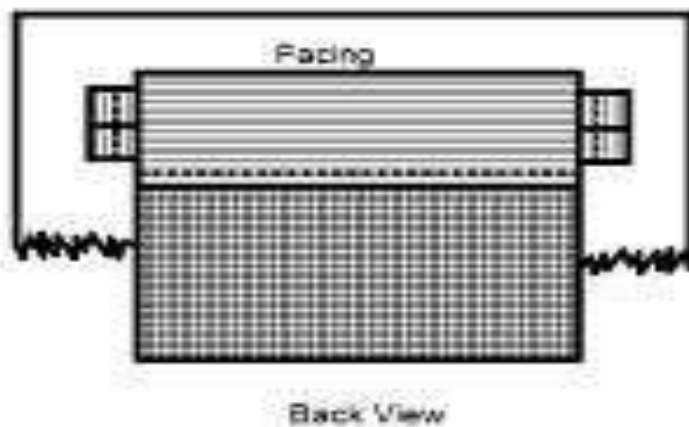


Place the other lining on facing (grain side) and stitch 1cm inner seam and 2mm over seam on lining as shown in below fig.

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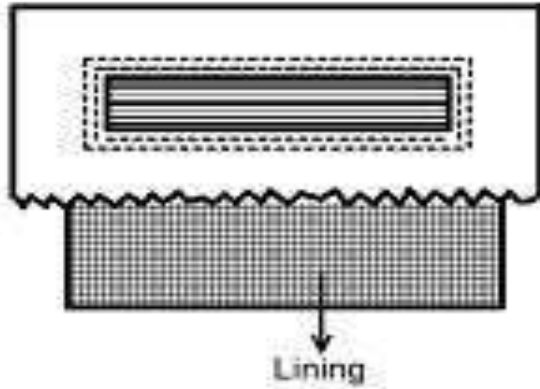
Fix the facing on the back side of the pocket using double sided adhesive tape as shown in below fig.



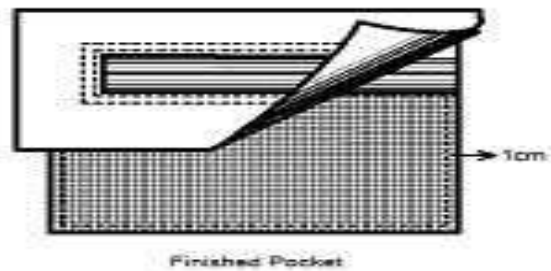
- Stitch 2mm and 4mm over seam on the 3sides and put a knot at back side of the pocket as shown in below fig.

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Close the pocket by stitching 1cm seam starting from piping and lining as shown in below fig.



## 6. Finishing process

- Trim the excess thread.
- Remove the excess adhesive and chalk mark on leather using crepe rubber.
- Press the panel by ironing.

### PRECAUTIONS:

- Use the right tools when required

### QUALITY CRITERIA:

All steps were completed in the correct sequence,

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**Purpose:** to show how to remove worn out cuff from leather garment

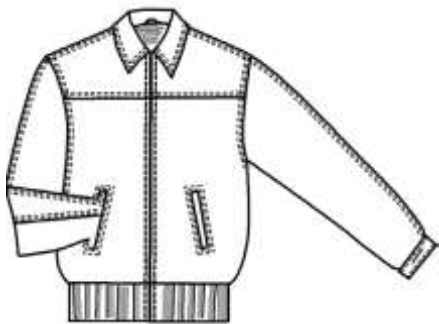
**CONDITIONS OR SITUATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics leather,

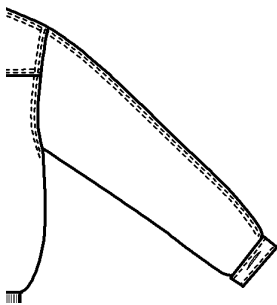
**PROCEDURES:**

Steps

**Removal of worn out cuff from the garment:**

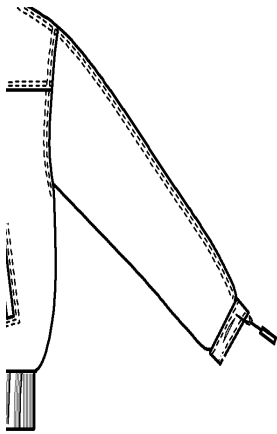


1. A defect in cuff

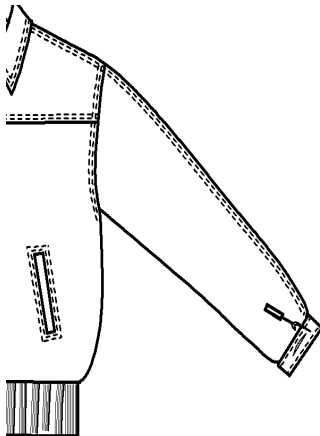


2. Close up view

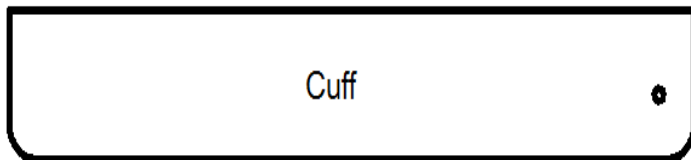
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3. Remove the cuff edge stitch using stitch remover. Remove the inner cuff and lining.



4. Remove the cuff top stitch using stitch remover. Then remove the cuff joint stitch with sleeve.

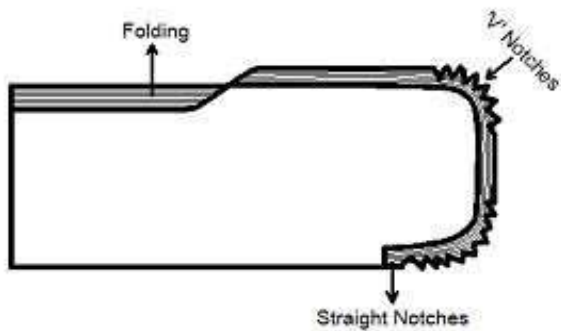


3. Take out the damaged cuff.

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## 6. Preparation of new cuff

- Place the cuff net pattern (without allowance) on grain side of the cuff.
- Make a straight notch at under lay and "V" notches at cross over round corners as shown in below fig.
- Fold the cuff by applying adhesive and make sure that the two round corners are similar as shown in below fig.



Remove the pattern and repeat the same procedure for folding cuff facing.

### Mounting of cuff on sleeve

Reverse the sleeve to lining side.

Mount the cuff on sleeve open side by stitch and turn method as shown in below fig.



Stick both the cuffs to each other on 3 sides using double sided adhesive tape (butt edge).

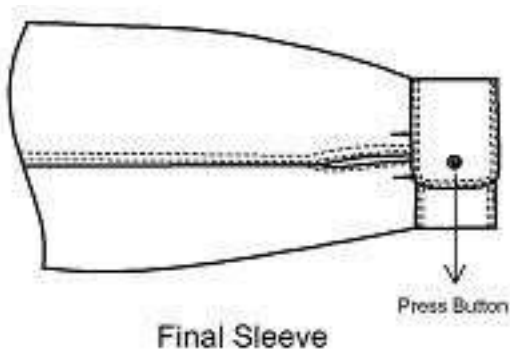
- Stitch over seam of 2mm and 4mm on all the sides of cuff.

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## 8. Finishing process

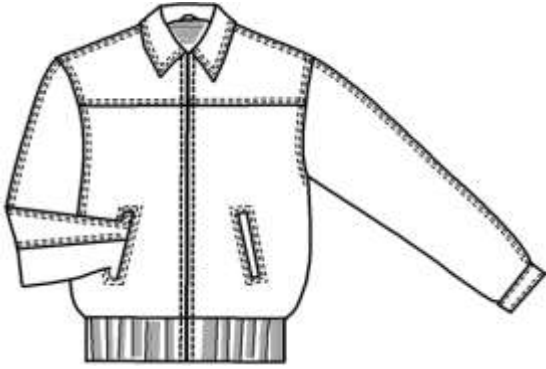
- Trim the excess thread.
- Remove the glue and chalk mark on leather and lining using crepe rubber.
- Press the sleeve and cuff on proper ironing stand.



### Note:

- 1cm seam allowance for inner seam to be maintained.
- For parallel stitches,
- First seam - 2mm from the edge.
- Second seam – 4mm from first seam.
- Folding allowance 1cm (slit and cuff) to be maintained.

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After replacement of new cuff,

**PRECAUTIONS:**

- Use the right tools when required

**QUALITY CRITERIA:**

All steps were completed in the correct sequence,  
The part should fit to the original.

<b>Operation Sheet 3</b>	<b>Undertaking Repair Work to Restore the Leather</b>
--------------------------	---

**Purpose:** to show how to replace the worn out zipper

**CONDITIONS OR SITUATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics, leather, **zipper, thread**

**PROCEDURES:**

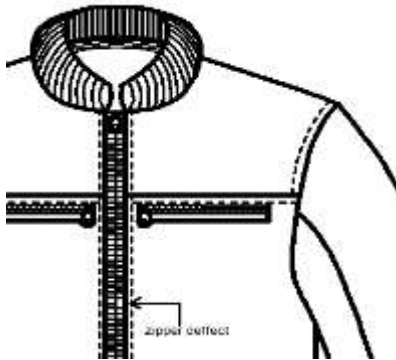
**Steps**

**Replacing the worn out zipper:**

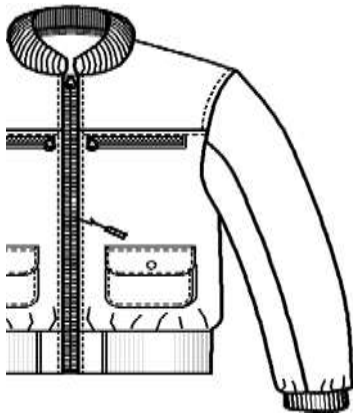
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1. Defective Zip



2. Showing the defective part

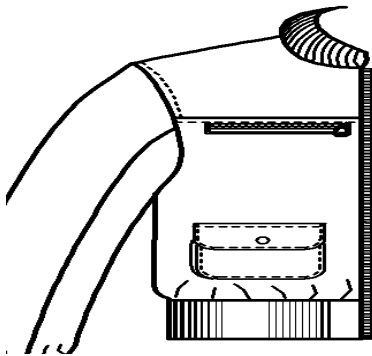


3. Remove the stitch on both sides of the zipper using stitch remover. Then take out the defect zip.

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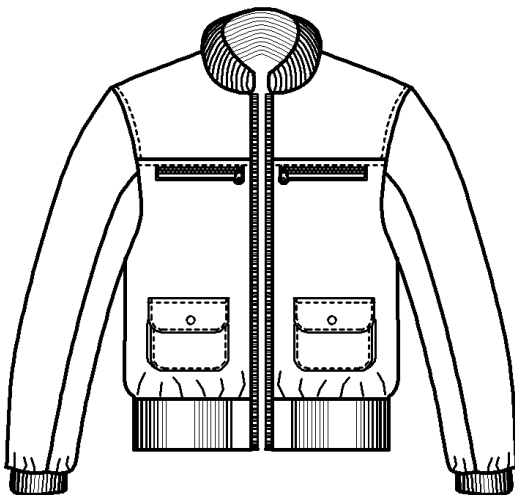
4. After removing the zip the view of the product.



Insert the new zip in between the folded center front panel and facing as concealed method.

• Seam operation:

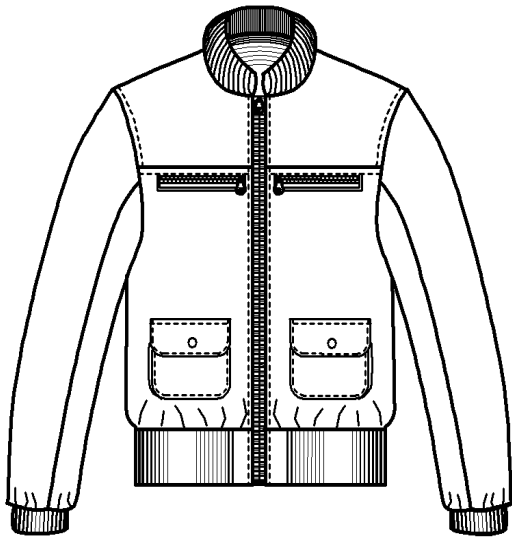
Over seam – 6 mm from the edge



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5. After attaching the zip stitch it carefully on the same stitch hole



6. After replacing the zip the product view

**PRECAUTIONS:**

- Use the right tools when required

**QUALITY CRITERIA:**

All steps were completed in the correct sequence,  
The part should fit to the original

<b>Operation Sheet—4</b>	<b>Undertaking Repair Work to Restore the Leather Garment</b>
--------------------------	---

**Purpose:** to show how to replace the worn out sleeve

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**CONDITIONS OR SITUATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics, leather, **thread**

**PROCEDURES:**

**Steps**

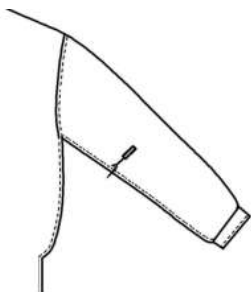
**Replacing the worn out sleeve:**



1. A tear in sleeve

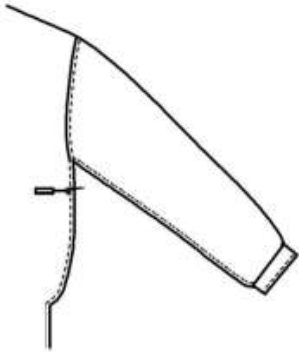


2. Remove the cuff stitch and to take out the sleeve inner lining from sleeve

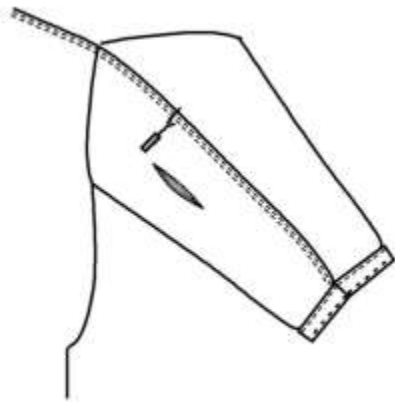


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3. Remove the inside sleeve side stitch using stitch remover

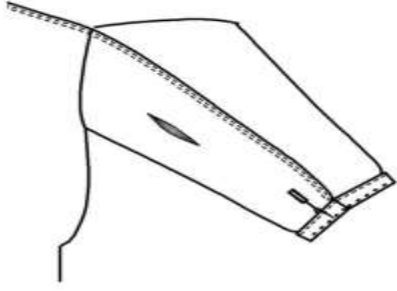


4. Remove the underarm hole side seam stitch

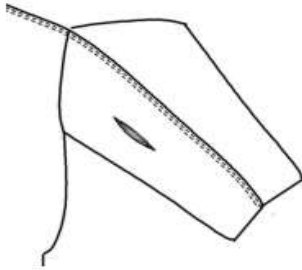


5. Remove the top parallel stitch

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6. Remove the cuff stitch and take out the cuff



7. After removing the cuff

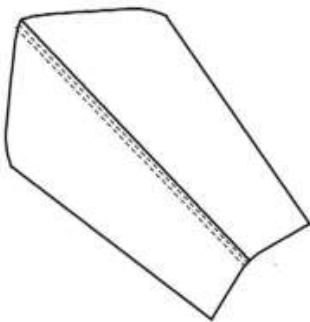


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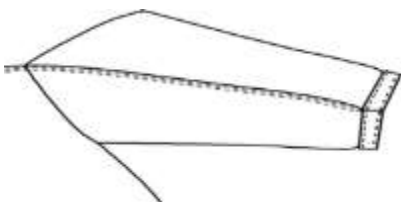
8. Remove the front and back sleeve side stitch. Then take out the damage component.



9. Then replace and stitch the side seam of the sleeve with new one



10. Sew parallel stitch on the top side



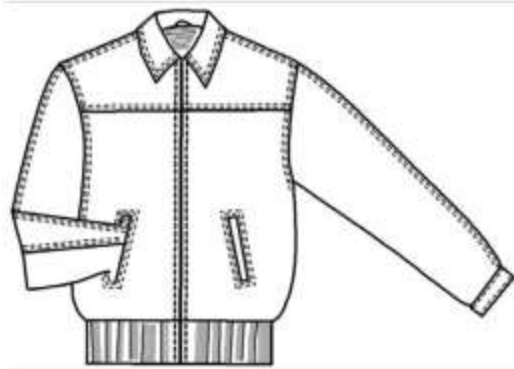
11. Attach the cuff and stitch with sleeve

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12. Then stitch the inside sleeve side stitch and inner armhole stitch. Turn the sleeve. Attach the lining with cuff and sew on the cuff edge.

- After replacing the worn out sleeve the look of the product.



- After replacing the worn out sleeve the look of the product.

**PRECAUTIONS:**

- Use the right tools when required

**QUALITY CRITERIA:**

All steps were completed in the correct sequence,  
The part should fit to the original

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<b>Operation Sheet—5</b>	<b>Undertaking Repair Work to Restore the Leather Garment</b>
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**Purpose:** to show how to replace the worn collar

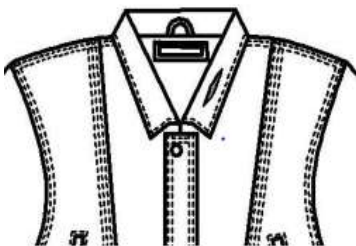
**CONDITIONS OR SITUATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics, leather, **thread**

**PROCEDURES:**

**Steps**

**Replacing the worn out collar**



Defect in collar(close view )

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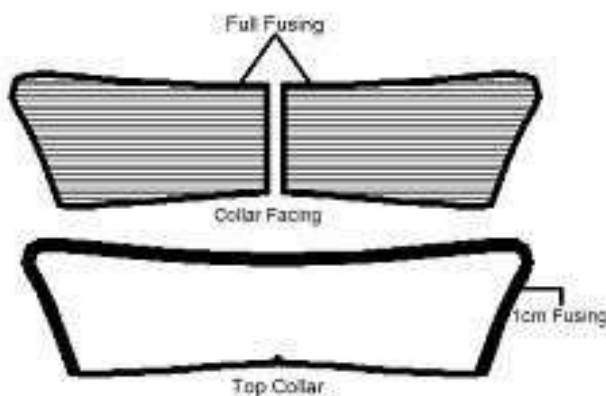


1. Remove the stitch on one side of zipper fully using stitch remover
2. Remove only 10cm stitch on collar side of the zipper fully using stitch remover
3. Turn back the jacket and remove the neck stitch
4. Take away the damaged collar out
5. Take a new leather specimen and cut according to the collar dimensions

### Preparation of new collar

#### Fixing of fusing paper

1. Take the fusing paper and cut according to the measurement shown in fig.1.
2. Place the fusing paper on the flesh side of the panel as shown in fig.1.
3. Fix the fusing paper by ironing.



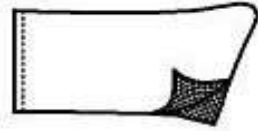
### 4. Assembling & stitching of collar

- Complete Task 1.

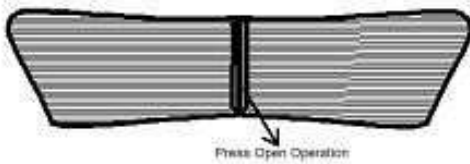
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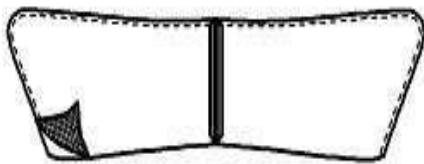
- Place collar facing grain to grain side and stitch 1cm and lock the stitch at start and end point as shown in below fig.



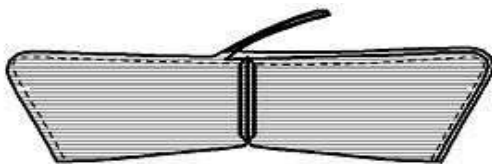
Press open operation the inner seamed collar facing by applying adhesive and hammering as shown in below fig.



Place the collar facing on top collar and stitch 1cm inner seam on 3 sides and lock the stitch at start and end point as shown in below fig.



Trim out 3 sides seamed edges of collar facing for easy folding as shown in below fig.



Make V-notches at the coners to avoid wrinkles and also to get smooth curves as shown in below fig.

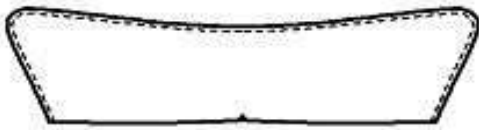
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Fold the edges of top collar by applying adhesive and hammering as shown in below fig.

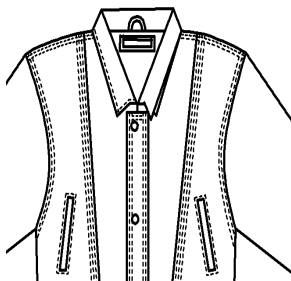


- Reverse the collar on grain side and make sure that both round corners are similar in shape.
- Stitch over seam 4mm or 6mm on top collar and lock the stitch at start and end point as shown in below fig.



## 5. Finishing process

4. Trim the excess thread.
5. Remove the excess glue and chalk mark on leather using crepe rubber.
6. Press the collar by ironing for smooth finishing.
7. Attach top collar to the neck lining and bottom collar to the neck leather
8. Stick the adhesive tape on the open zipper sides.
9. Fix the collar-butted edge.
10. Finally stitch the opened areas.



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. View after replacing the worn out collar

**PRECAUTIONS:**

- Use the right tools when required

**QUALITY CRITERIA:**

All steps were completed in the correct sequence,

The part should fit to the original

<b>Operation Sheet—6</b>	<b>Undertaking Repair Work to Restore the Leather Garment</b>
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**Purpose:** to show how to replace lining from leather garment

**CONDITIONS OR SITUATIONS FOR THE OPERATION:** Trainees should know the different tools and equipment and their use.

**EQUIPMENT, TOOLS AND MATERIALS:** scissor, fabrics, leather, **thread**

**PROCEDURES:**

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## Steps

### Replacing the body lining

- Remove the stitches on side seams, shoulder, neck, sleeve armholes and on bottom side of the lining.
- Take a new lining piece and cut according to the body dimension

### 3. Inner shell preparation

#### 4. Pocket preparation on front lining

Assembling & stitching of double piping pocket with zipper on left side

Assembling & stitching of single piping pocket without zipper on right side

Front lining is to be joined with center front inner facing as shown in fig.15.

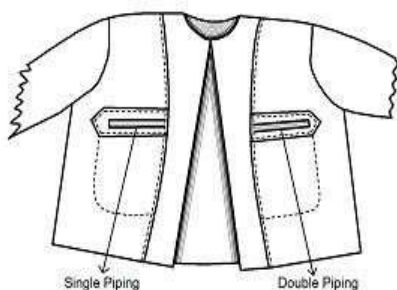
Seam operation:

- a. Inner seam – 1 cm
- b. Over seam – 2 mm

Back lining is to be joined with front lining at shoulder as shown in fig 16.

Seam operation:

- a. Inner seam – 1 cm



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**5. Inner shell mounting on outer shell**

- First join at the bottom side.
- Now join at the neck side.
  - o Method of construction – Press open operation
  - o Seam operation: Inner seam – 1 cm for first and second mounting
- Third mounting at sleeve slit. (Stick sleeve lining on slit using double sided adhesive tape and stitch 2 mm over seam on it.).
- Stitch the lining on the shoulder side, sleeve armholes, neck side and on one side seam
- Stitch 10cms from bottom on the other side seam
- Stitch the lining and leather in the bottom side
- Turn around the lining and then stitch the remaining side seam.

**PRECAUTIONS:**

- Use the right tools when required

**QUALITY CRITERIA:**

All steps were completed in the correct sequence,

The part should fit to the original

<b>LAP Test</b>	<b>Practical Demonstration</b>

**Name:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Time started:** \_\_\_\_\_

**Time finished:** \_\_\_\_\_

**Instructions:** Answer all the questions listed below.

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Task1: Repair and restore a worn out sleeve in the given leather garment

Task2: Repair and restore a worn out collar in the given leather garment

task3: Repair and restore a worn out piping pocket in the given leather garment

**Note:** All the leather components should be documented as per teacher's instructions.

### List of Reference Materials

<https://leatherrepaircompany.com>

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www.modernleathergoods.com

<https://en.m.wikipedia.org/wiki/ironing>

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