OCCASION

This publication has been made available to the public on the occasion of the 50th anniversary of the United Nations Industrial Development Organisation.

DISCLAIMER

This document has been produced without formal United Nations editing. The designations employed and the presentation of the material in this document do not imply the expression of any opinion whatsoever on the part of the Secretariat of the United Nations Industrial Development Organization (UNIDO) concerning the legal status of any country, territory, city or area or of its authorities, or concerning the delimitation of its frontiers or boundaries, or its economic system or degree of development. Designations such as “developed”, “industrialized” and “developing” are intended for statistical convenience and do not necessarily express a judgment about the stage reached by a particular country or area in the development process. Mention of firm names or commercial products does not constitute an endorsement by UNIDO.

FAIR USE POLICY

Any part of this publication may be quoted and referenced for educational and research purposes without additional permission from UNIDO. However, those who make use of quoting and referencing this publication are requested to follow the Fair Use Policy of giving due credit to UNIDO.

CONTACT

Please contact publications@unido.org for further information concerning UNIDO publications.

For more information about UNIDO, please visit us at www.unido.org
ASSISTANCE TO LEATHER GARMENT INDUSTRY (BEDCO),
RP/LES/82/001

(Follow-up to RP/LES/82/001)

Terminal Report *

Prepared for the Government of Lesotho
by the United Nations Industrial Development Organization

Based on the work of Carlo Palizzotto,
Adviser on Styling - Pattern Making and
Processes of Production of Leather Garments

* This document has been reproduced without formal editing.
EXPLANATION NOTES

UNCTDC - UNITED NATIONS TECHNICAL CoNGRESSION

ENDC - ELECTRO NATIONAL DEVELOPMENT CORPORATION

UNDP - UNITED NATIONS DEVELOPMENT PROGRAMME

UNIDO - UNITED NATIONS INDUSTRIAL DEVELOPMENT ORGANIZATION

COUNTRY CURRENCY - MALOTI = US$ 0.35

SOUTH AFRICAN CURRENCY - RAND = US$ 0.35
ABSTRACT

The UNIDO Project LES/53/1243 implemented at HDBCO is the follow-up of a previous UNIDO Project LES/53/1240 of last year. The Project was started on the 1st of January 1973 by appointing the Italian Consultant Carlo Pizzinotto; subsequently the assignment was extended for 3 months, until 31st June 1973.

The aim of the Project was to introduce in Lesotho technology on design and processes of production for leather garment manufacturing. The Project was located at "Kati Leather Works" but open to all concerned manufacturers.

The UNIDO Consultant started his job at HDBCO on the 5th of January 1973. Owing to temporary shortage of leather at Kati the Project's activities were initiated by giving to the manufacturers of cloth garments two weeks cooperation on design of patterns for little girls' school uniforms. The activities according to the job-description began at Kati on January 10.

The expert supplied six styles of patterns for garments, namely:
- 2 styles for leather garments; annexes 5-7
- 2 styles for sheepskin garments; annexes 5-9
- 2 styles for fur garments; annexes 10-11

Soon after the extension of the assignment was materialized HDBCO assigned proper premises for the continuation of the activities. Kati supplied machinery, equipment, technicians and raw materials. The prototypes of garments made during the first stage of the project were tested in the near Republic of South Africa and also displayed at the International Hand Show in Johannesburg, with satisfactory success.

Until the end of the Project, the orders obtained were about 100 garments, almost all of them already delivered. It is estimated to produce about 500 garments before the current winter season will be over.
During the development of the activities no other companies joined the project, which was attributed to the fact that had supplied all machines, equipment and raw material for the activities of the project.

In a meeting held at BACC in April 1970, present Mr. B. A. Constantino, BACC's Managing Director, and Mr. A. Barry, Resident Representative, a.i.i. was realised that it was necessary for BACC to have its own Pilot and Demonstration Centre with equipment owned by BACC in order to enable any entrepreneur to avail himself of the services of the Centre without having to ask assistance from a possible competitor. It was decided that BACC in cooperation with the expert should prepare a Project Proposal for the establishment of a Pilot and Demonstration Centre for leather articles, clothing garments and a small tannery.

On leaving the country the expert is taking to UNIDO-Vienna the draft of the Project Proposal for technical evaluation.

Note (i.iii): Because at the end of 3 months assignment the expert compiled a "Preliminary Report" in this final report both findings and recommendations of the Preliminary Report are included in order to give the entire report in one single document.
activities concerning the production were actually initiated 10 days after the expert arrived at that station, the delay was due to the following:

- Some workers at Mali were still on vacation
- The workshop where to develop the activities had not been prepared for lack of knowledge.
- Kabi Leather products had not received raw material.

Workshop

The workshop was arranged in a corner of the factory in a space of about 30 square meters; machinery and equipment as follows:

- One sewing machine HEAW single needle, union feed. The right one for sewing leather garments.
- One sewing machine HEAW - two needles. This one was not used because out of order.
- One sewing machine - singer- move type, used for assembling lining.
- One table for pattern design 2.00 x 0.50 meter.
- One table for cutting 2.00 x 0.50 meter.
- One table for preparation of cement 2.00 x 0.50 meter.

Raw and Auxiliary Materials

- The leather, brown tanned, was just 16 hides, of about 12-13 square feet each; it came from Morocco, [...]
- Because up to now there are no tanneries, but a new tannery is expected to start activities in short time.
- There was available some good interlining, also imported, of low melting point so that it could be attached by a normal iron.

- The thread was not the proper one an thickness (No. 12) while for sewing leather garments it has to be 12-15-20. We managed to use it by putting two threads on top, but this also caused slow stitching.

- Buttons were made in the same factory by covering button shaves with leather.

- Cement for preparation was unknown at the beginning was used: bochtik but after 1 week it came from a near country.

Participants

Participants in the programme were 4 very good trainees:

- The owner of the firm, technical manager;
- The supervisor of the firm;
- One machine operator;
- One tailor appointed for the programme and to manage Kabi future leather garment section.

Mr. Kabi participated actively and was able to learn the main operations on cutting and assembling. All the participants learnt the process of production and all of them made at least one garment. All the garments (10 prototypes in styles in different sizes) were of high quality although the first ones ever made by them.

Although it can be said that the introduction of leather garments manufacturing in Kabi had been successful, if we consider that the expert initiated only 3 weeks to this job, it is self-evident that the time was very short to give full knowledge to technicians and to give full experience in the future of this new job.

In the factory were left just 13 styles of different models for production. However not to much new are styles supplied by expert, but they could change styles according to Kabi needs at any time. An expert was available able to design new designs and even more

For further details...
Fluxions in other activities (First item of a larger analysis)

Because the project has been giving assistance to manufacturers of garments, others than leather, the expert wishes to report some findings on this sector.

Apparel industry has developed by improvisation. There is no knowledge of design, at all. Dressmakers get patterns from local shops and try to make everything, i.e. dresses, shirts, blouses and so on. In order to achieve good results on being all that wide range of garments dressmakers should be over-qualified experts. In the "recommendations" are given some suggestion on how they should act.

The following information was supplied by B.N.O.:

Apparel industry is one of the few small scale center industries which has been able to stand on its own in Lesotho in the face of severe competition from other countries. The industry has the potential of providing opportunities for gainful employment for a larger number of workers while at the same time ensuring reasonable returns on investment.

Sewing and knitting units are located over the length and breadth of Lesotho. The main products of these units are custom made traditional and modern garments and school uniforms. Here and there an attempt has been made to enter more sophisticated fields of furnishing, but the number of units manufacturing exclusive ranges are few.

Empirical studies conducted recently show that the employment in the industry varies from 4 to 12. The number of units employing over 10 persons is only 1. The units are mainly located in the urban centers, the main concentration being in the Jhabulane Formal and Industrial Centre at B.L.O., where a number of units are located in one cluster. The bulk of the units employ on the job trained workers. Many units use power driven machines.
The bulk of the output is sold to individual customers by the units themselves. Supplies made to established marketing chains are almost negligible.

In so far as BIDC in concerned apparel industry has been one of the main industries to receive marketing, B and D, extensive raw materials and financial support from the Corporation. The following table indicates the number of units sponsored since 1977 by BIDC and the financial support provided to these units:

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Number of Units Sanctioned</td>
<td>7</td>
<td>4</td>
<td>11</td>
<td>3</td>
</tr>
<tr>
<td>Capital Assistance</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Committed M</td>
<td>16700</td>
<td>11500</td>
<td>13500</td>
<td>11500</td>
</tr>
<tr>
<td>Number of New</td>
<td>36</td>
<td>47</td>
<td>57</td>
<td>72</td>
</tr>
</tbody>
</table>

BIDC support to the apparel industry has not been confined to the financing of individual projects. Efforts have been made in the past to make available marketing as well as raw material support under the aegis of the marketing department and BIDC Export Division. Similarly the Extension Department has been providing Research and Development training and management support to the industry, while contributions made by individual departments have been significant, a break-through which could lead to a self-sustained growth has not been achieved. One of the factors appears to have been the non-availability of an integrated institutional approach towards the development of the garment industry.

Market Potential

The following table gives an indication of the value of imports of clothing items into narcotics over the year (1975–1977)
The total value of imported garments has risen by 69.5% over the past 5 years. The current trend points towards a steep rise in imports over the years 1960 and 1961. The trend is likely to continue at least in the foreseeable future. This trend of imports is sufficient to warrant an all-out effort to develop local industry and capture at least a reasonable fraction of the demand. While the range of products which can be taken up for development is fairly large, the following appear to be the most promising lines of future growth:

1. Institutional clothing
2. School uniforms
3. Regular wear
4. Casual wear
5. Fashion wear
6. Protective clothing
A section for assistance in plant input and processes of production.

A section equipped with special machines where manufacturers in turn can go for some operations, i.e., attaching facing interlining, final pressing, making buttonholes, sewing buttons and so on.

Dressmakers should:

Select and adopt one single line of production, i.e., blouses, shirts, dresses, trousers, jackets and skirts and so on; if they go on as two to now, they can never get good garments and good flow of production. They cannot acquire all the techniques for making every kind of garment so good as to compete in fitting and looking with the ones now been imported, which are made by industries specialised in one single item. If they do as above mentioned, they will get:

- Full exploitation of machinery
- Continuity of jobs
- High standard of quality
- Low cost of production
- Quick training of unskilled workers
- High possibility on local market and exportation
- Flexibility and confidence in financing sources

KMA should:

- Provide a more suitable workshop for the making of leather and sheepskin garments.
- Manage to get the right thread for leather garments i.e. 69-yarn according to availability.
- When production will be advanced, buy a 'Vifin' interlining, pre-embossing machines.
- Try to have some technicians in the factory trained in cutting and making.
- Provide some tailoring survey for the checking of garments at least the following:
  - Size 41 and 52 for gentlemen
  - Size 40 and 54 for ladies
Finishing - Second stage of a enroling Assignment

At the end of 6 months' enrolment the Project was extended for 3 months; that is until 3rd June 1975. Kabi assigned proper premises for the next continuing of the activities. Kabi supplied all machinery and equipment. Later on Kabi imported a new sewing machine for leather, which feed-walking presser-foot.

Since 1 March the Project's activities were carried on in the new premises.

The expert supplied other patterns of garments bringing the total amount of styles for the training at six namely:

- 2 styles for leather garments; annexes 6-7
- 2 styles for cheesepit garments; annexes 8-9
- 2 styles for fur garments; annexes 10-11

The prototypes of garments made for training are tried in the near Republic of South Africa and also displayed at the international Hand Show held at Johannesburg, with satisfactory success. Some orders from dealers were attained and a list prepared the necessary raw materials at the beginning a quantity for about 100 garments.

The commitment of Kabi to customers abroad for delivery in time the garments in order offered an opportunity to the Project to give Kabi assistance in an effective production, but the Project plant become Kabi Unit.

It was the first time for Lesotho exporting leather garments to external countries and Kabi's garments were to pass a test. After the first deliveries new orders were received; until the end of the expert's assignment the orders taken in were about 100 garments almost of them already delivered. Other orders were coming in every day. As other companies joined the Project, this was attributed to the fact that the project plant was equipped with Kabi machinery and to other technical advice also received to order for improvement, it also means that the Project is mainly on Kabi format.
A meeting was held at 11.30 on 15 April 1973, present were:

- Mr. A. Barry - Resident Representative, R.I.
- Mr. D. Cunliffe - R.I.I.C's Managing Director
- Mr. H. Honder - Acting Assistant UNICEF, S.L.T.B
- Mr. J. Milne-Smith - Expert in charge of the Project.

During the meeting it was realised that it was necessary for R.I.I.C to have its own Pilot and Demonstration Centre with equipment owned by R.I.I.C in order to enable any entrepreneur to avail himself of the services of the Centre without having to seek assistance from a possible competitor. It was decided that R.I.I.C in cooperation with the expert should prepare a project proposal for the establishment of a Pilot and Demonstration Centre for leather articles, clothing garments, and a small tannery.

**Raw Material (Sheepskin)**

Two styles of garments are two on annexes 8-9, were approved to be made from sheepskin, but although leather has considerable quantity of sheepskin garments were made in such a way to imitate sheepskin and were named and traded as "similar sheepskin". Actually the material is attained combining two layers of materials with cement. The outside is a layer of suede-jag祺iko and the inner side is a layer of woven pure-wool, or synthetic wool. The two layers of materials will cement stuck between them give the appearance of a double-face, sueded sheepskin. The outlook is not bad because the two materials are of good quality and the "similar sheepskin", in the end results more expensive than genuine sheepskin.

The experience is used in countries, where a great amount exists, with the aim to produce a cheap garment and the outside layer is obtained from split, while the inner layer is from sheep or synthetic material.

For Cua to be vital to resort to this excellent service as it is not able to get sheepskin, now "similar sheepskin" problems, the sale source of this kind of raw material in the country, is not able to supply even to local manufacturers. Giving in this view of sheepskin, Cua is not able to prepare and introduce the "similar sheepskin" for the later part of the "Cam, Sheepskin Miotic".
The above said report is extremely detrimental for the existing very limited manufactory in the very short time they will not be able to continue their activities and the manufacturer cannot export in this line of production, natural for reasons people and still trust the haluti genuine sheepskin.

**Raw Material (Cattle and Sheep)**

Suede and nappa were used for making two styles of garments, the one in Annex I-F. The suede of high quality was imported through the Republic of South Africa, it was made from pig-skin.

Cow and pig skin nappa leather, of good quality came also from the Republic of South Africa and its origin was Argentina. The obtaining of raw materials from abroad, created big problems and sometimes had resolved to go personally to take it from the suppliers.

The suppliers required payment cash advanced and although this was not the transfer operations through bank directly the authorities.

The problem from importation and the others already reported concerning the sheepskin prompts Rabi to start a small tannery in joint venture with Mr. Monare.

Mr. Monare is the tannery technical manager at Haluti Ancestors Products and the former counterpart to the UNIDO Consultant Mr. Palmer during 18 months in the Project LUS/25-32 in 1979/80. The output of the tannery has been:

- Sheep double-fine sheepskin; from sheep
- Skin for fur Coats; from goat and sheep

All the skin necessary for the production of the above raw materials are available in great quantity in the country.

The output of the tannery is mainly to export in skin production but other quantities will be utilized for local manufacture of
garments, shirts, shirt caps, caps and other articles. It was
planned to accumulate, at the beginning, the tannery in half
of the same premises to the project, and the part of process
requiring water right to be done at Vocation's house.

The annex D.I shows the layout of the Project's Plant with half
of the plant empty for the tannery. But until the end of the
expert's assignment the tannery was not started, presumably for
financial problem.

Raw Material (tanning for leather)

One style of garment was a fur coat for gentlemen but also unisex
and another polo for ladies; annex D.I. The fur coat was made
from springbok skins from the Republic of South Africa. Of this
cost were nine 5 garments, but other costs are in the way. The
price of the coat is South 50-00 at wholesale price.

The skins were made from Angora goat skins imported from the Republic
of South Africa. For lack of skins this garment cannot be made.
The introduction of the technology of how to use
fur coats will be very useful when in locating a tannery for the
tanning of skins for fur coats will be catastrophic. In addition
there are good goat-skins, also Angora, which up to now have wasted
not knowing how to use them, from them it is possible to make good
garments and to create jobs.

Training of National Technicians (Making)

The National Technicians trained during the development of the
project were five altogether, all from Isak Becher World Company
Annex D.I.
The training was extended to the making of several styles of garments into large ranges of sizes and from different kinds of raw materials namely:

**Style No. 1 (Annex No. 1 sketch and process of production)**
- Ladies Jacket
- Material: Nappa or suede
- Lined with silky lining
- Pockets on the seam sides
- Vent on the centre back
- Piped buttonholes
- Sizes: 36 to 42

**Style No. 2 (Annex No. 7 sketch and process of production)**
- Gents sportswear jacket (also unisex)
- Material: Nappa or suede
- Piped pockets
- Engageable zip
- Collar, belt and cuffs from knitted acrylic wool
- Sizes: 38 to 56

**Style No. 3 (Annex No. 5 sketch and process of production)**
- Gents jacket (also unisex)
- Material: Similar sheepskin (pig-skin suede doubled with pure wool cement-stock)
- Engageable zip
- Sizes: Extra small-small-medium-large-extra large

**Style No. 4 (Annex No. 3 sketch and process of production)**
- Gents waistcoat
- Material: Similar sheepskin (pig-skin suede doubled with pure wool cement-stock)
- Contrasting collars
- Press-stud fastening
- Sizes: Extra small-small-medium-large-extra large
Style No. 3 (Annex No. 10 Sketch and process of production)
- Center seam (Annex)
- Material: polyester
- Length: 30 inches = 76 cm
- Interlining channel
- Sizes: small-medium-large

Style No. 6 (Annex No. 11 Sketch and process of production)
- Ladies Bolero
- Material: Anorma goat, nappa trimmings
- Knitted wool lining
- Sizes: small-medium-large

Training of National Technicians (Design)
The vast training given to the National Technicians in the making of garments could not be the same as in design owing to the short time of the expert's appointment, but the training on design is centred on the "Grading Technology". The basic patterns were supplied by the expert, but all the different sizes were designed by Noel's supervisor Mrs. Nanocoba Mocholi who is now able to grade every size from a basic pattern.

The technology for "Grading" introduced in the country is the one which is taught in Technical Institutions in England and the United States. This technology is known as "Grading System" and is now accepted.

Other Activities
- Cooperation in EMICO in the preparation of the Project Proposal for the establishment of a Pilot and Demonstration Centre
- Visit to Hong Kong of the following companies:
  - Vimal Mitpat (Pty) Ltd.
  - Eastern Garments Ltd.
  - Raman & Co. Ltd.
The expert wishes to restate the recommendations already formulated in his "Preliminary report" of 30 October 1963 in a revised report in at pages 11 and 12.

The accomplishment of these recommendations can be achieved by approving and implementing the Project Proposal prepared by EEDCO and the expert for the establishment of a Pilot and Demonstrations Centre for Leather Articles - Clothing Garments and a Small Factory.

On leaving the country the expert is sending to UNIDO Headquarters the Project Proposal Draft, but they may need more information for a positive evaluation. If so, the expert recommends sending Government to invite in the country UNIDO's Officers in order to ensure them to formulate on the spot the most effective Project Document.
Annex No. 1

Expert's Activities

January

2 - 4 Travel Rome-Maseru
5 - 7 Briefing at UNDP and BECC
   Preparation of working programme.
10 - 18 Lecturers in BECC to Manufacturers of clothing garments.
19 Visits at Firm Kohalalitoe at Leribe
20 - 31 Activities of Project at Kabi.

February

1 - 23 Activities of Project at Kabi.

March

1 - 30 Activities of Project at Kabi.

April

1 - 15 Activities of Project at Kabi
16 - 20 Preparation of Final Report
23 - 26 Activities of Project at Kabi.
   Preparation of Final Report
27 - 29 Travel to Vienna-UNIDO Headquarters.
30 - 31 DEPARTURE AT UNIDO

June

1 - Final Travel Vienna-Rome (Home)
List of Participants in the lectures to manufacturers of clothing garments at NEDCO from 16 to 17 January 1979.

<table>
<thead>
<tr>
<th>No.</th>
<th>Business/Position</th>
<th>Name</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Seamstress Technician</td>
<td>N. Mokonele</td>
</tr>
<tr>
<td>2.</td>
<td>International Tailors</td>
<td>Mrs. Mano</td>
</tr>
<tr>
<td>3.</td>
<td>Khotso; Knitting</td>
<td>Mrs. Mokonele</td>
</tr>
<tr>
<td>4.</td>
<td>Birela Enterprises</td>
<td>M. M. Mokonele</td>
</tr>
<tr>
<td>5.</td>
<td>Retellsitsee Shop</td>
<td>C. Lebea</td>
</tr>
<tr>
<td>6.</td>
<td>Dresswell Shop</td>
<td>N. Ramone</td>
</tr>
<tr>
<td>7.</td>
<td>Queeny's Knitting</td>
<td>S. Mokone</td>
</tr>
<tr>
<td>8.</td>
<td>Williams and Sons</td>
<td>Mrs. Mokone</td>
</tr>
<tr>
<td>9.</td>
<td>Neilamalana Dresswell</td>
<td>L. Tshaka</td>
</tr>
<tr>
<td>10.</td>
<td>City Dressmakers</td>
<td>Moka</td>
</tr>
<tr>
<td>11.</td>
<td>M &amp; M Enterprises</td>
<td>M. Mokone</td>
</tr>
<tr>
<td>12.</td>
<td>Phuthatsetsa Project</td>
<td>Mrs. Pule</td>
</tr>
</tbody>
</table>
Promises and Layout for the Project at 35260
(1 cm = 1 mt)

SPACE FOR SMALL TANNERY
(FINISHING OPERATIONS)

No. 1 - Table for Patterns Making
No. 2 - Table for Cutting Fur Garments
No. 3 - Table for cutting Leather Garments
No. 4 - Table for Cutting Sheepskin Garments
No. 5 - Table for Cutting Operations
No. 6 - Sewing Machine - 1 Needle Union Feed
No. 7 - Sewing Machine - 1 Needle Union Feed
No. 8 - Sewing Machine - Special for Fur
No. 9 - Sewing Machine - (Arm-type)
No. 10 - Store-place for patterns and finished garments
No. 11 - Shelves for auxiliary material
No. 12 - Shelf for garments in process
Participants in the programme of the Project at Kabi:

1. Mr. Kobi - Owner and Technical Manager of Kabi Leather Works Company.


4. Mr. Malefane Monate - Tailor.

5. Mr. Malefane Khakhane - Cutter, from Kabi Company.
Methodology of Process developed in the Factory

Patterns

The patterns are copied on card board for a proper cutting of the leather by knife.

Cutting of Leather

Cutting is done on a flat table 2.20 x 0.60 meter, the hides (or skins) are fully spread and all pieces of the patterns properly placed on. At one end of table there is a sheet of zinc 1.00 x 0.60 meter, the cutting is done by knife on the sheet of zinc. Cutting of lining is done on a separate table.

Control and Marking

After cutting, the garment is controlled and all pieces numbered by attaching numbered stick-on's on the inner side. The garment is also given an "Identity number" (Progressional number) recorded on a chart; the progressional number, Ref. Number, size, colour and customer are listed on a cloth-label and attached in the right pocket-lining. All these items will be copied on the Tag attached to the garment, when finished.

Interlining

On the parts of the garment which need to be reinforced is attached on the inner side facing interlining.

Assembling the Outseam of the Garment

The outseam of the garment is completely assembled. This includes making of butt-ends of pockets, setting of gussets, under-stand, sleeves and laps, if any. Also all top-stitchings are done as necessary. The garment assembled as above said, is moved to the stitching table, every seam (the ones not top-stitched) are correct opened and outer edges are cutter-folded and hemmed on a water-sheer. After every step the outer view is also kept a check.
Attachment of the Lining

The lining is completely assembled, this includes setting of sleeves, label, and number of size. To the lining are assembled the facing and the upper collar. The lining is now moved to the cementing table and the seams along the upper collar with the facing are cut open. The lining is pressed by a normal iron.

Assembling the outer part to the inner-lining

Assemble the lining to the garment along the bottom edge allowance sleeves, vents. Assemble the lining along the arm-holes.
Cement-fold along the outer edges.
Top stitching around the buttonholes.

Finishing

Trim loose threads.
Press with iron, place a cloth between the lining and iron (Heat must not be more than 100-110 centigrade) for cross-thread nappy. Sew button.

Control

Final Inspection.

Note: The leather is pressed by iron or automatic pressing machine at 100-110 centigrade when it is cross-thread leather. In the case of vegetable-tanned leather molding cannot be used.
FEATURES
- LABELS' CLOTH
- WITH ZIPPER INNER BANDS
- LINING WITH ZIPPER BANDS
- POCKET - ZIPPER SHOULDER
- VEST OF THE CENTRE RISE
- PIPED BUTTON HOLES
- MEAS: 8 - 10 - 12 - 14

SPECIFICATIONS OF ORDER
- KIND OF LEATHER
- SPOON
- BELL
- DELIVERY DATE
- CONDITION
- ACRES
6. Attach facing interfacing according to chart.
7. Cut and fold buttonholes and mark points.
8. Baste pieces along the jacket pattern.
   Top stitching long the edge of the pipe.
9. Top stitching outside front pocket openings.
10. Sew darts.
    11. Top stitching on dart to outer edge as you
        sew and top stitching front edge (reinforce button ends)
        Sew and top stitching center back and vent.
        Place and top stitching four on the back.
        Sew and top stitching side and belted arm.
        Sew under collar along neck edge.
        Prepare sleeves with gathering along the head.
        Cut and sew sleeves on the armholes.
        Place and sew collar tabs.
        Prepare facing with upper collar assembled.
        Install lining to the button (see lining on jacket).
        Cut off edge of upper collar and termination of领带
        Insert open under sleeve seams and collar neck line.
        Insert pipes on buttonholes.
        Insert felt jacket and sleeves. Hem (leave 1 cm free along the
        inner outer edge for hemming). of lining.
        Assemble lining to pockets (see inside in the right pocket).
        Assemble lining elongated allowance as the jacket net, and
        also along buttonholes allowance.
        Assemble lining along the arm holes.
        Place felt along the outer edge.
        Top stitching along outer edge.
        Top stitching armhole buttonholes.
        From inside, collar lapel and buttonhole the elongated button
        Trim lining through.
        From with cloth (amount that not be more than 7 cm-
        10 cm maximum),
        Sew button.
        Final inspection.
1. Place pockets openings with cement
2. Reinforce and cement filling pieces
3. Cement piping for facing in the pocket openings
4. Topstitch around pocket openings
5. Sew and topstitch centre back and side vents
6. Sew and topstitch sleeves on back and front
7. Sew buttonholes on fronts and sleeves top parts (topstitch)
8. Sew and topstitch shoulders and outside parts of sleeves
9. Sew and topstitch sides and under sleeves (the topstitching must end in the armholes)
10. Assemble knitted collar and cuffs (join leather terminations on collar and beat)
11. Prepare lining with assembled facing and label
12. Assemble lining, to the pockets and label to the right position
13. Cement a one cm wide tape along the front lower edges on doing this match both fronts
14. Assemble lining to the placket along the bottom of the jacket sleeves and arm seam allowances
   The leather terminations must be left unitched in order to allow the air in place.
15. Cement the zip along the fronts, fold the ends of the facings
16. Topstitch along the zip on the edge of the facings fronts
17. Trim all loose threads
18. Join with clats (sewing must not be more than 0.75 mm)
19. Final inspection
sitting position. Place a layer of wool or synthetic filling over a layer of wool or synthetic filling. The filling is cut out as usually for leather jackets and then stuck over the inner layer of wool or synthetic filling. Subsequently it is cut out around the edge of the area. After that the garment is ready for assembly.

Preparation

1. Fold around pockets (trim the raw along the folding line).
2. Reinforce with interlining the front facing and seam roll them along the folding line.

Assembly

1. Topstitch the upper edge of the jacket.
2. Pin with a pin through the jacket and topstitch.
3. Sew and topstitch seams on the fronts.
4. Sew and topstitch the front facing on the fronts.
5. Sew and topstitch the sides on the centre back.
6. Sew and topstitch the yoke on the back.
7. Sew and topstitch the shoulder.
8. Sew and topstitch all pieces of the shoulder but leave unattached the under arm seam.
9. Set and sew the sleeves around the armholes.
10. Topstitch the armholes from right to left along the yoke.
11. Sew and topstitch the under side until the armholes.
12. Place the top with buttons (button must be on right).
13. Topstitch along the side of the top.
14. Sew and topstitch the other side and sew the back.
15. Sew and topstitch the shoulder and armholes.
16. Fold over the bottom of the jacket.
17. Place the jacket around the even of the top.
18. Topstitch the jacket.
Joint Front - Similar procedure - Invisible.

The term "similar structure" is prepared according to the instructions already reported in the section noted concerning the jacket front.

Finishing

1 - Stick with cement the facings on the fronts
2 - Cement-fall the edges around the pockets. The pockets are without fur.

Assembling

1 - Sew and topstitch the facing along the upper center back
2 - Place with cement the pockets and topstitch
3 - Sew and topstitch the sides
4 - Sew and topstitch the shoulders
5 - Sew and topstitch the facing at level of the V notch and the outer side of the garment
6 - Trimming excess evening
7 - Trim all loose threads
8 - Final inspection
Assembling:

1. Cut the armhole.
2. Cut the lower sleeve parts.
3. Set in and cut the sleeves.
4. Draw the inner collar to the neck lines.
5. Cement fold the allowances along the bottom of the garment and sleeves; leave 1 cm. free (unstuck) the outer edges for the assembling of the lining.
6. Prepare the lining with sleeves, facing and upper collar assembled.
7. Sew the lining of the pockets along the pocket openings.
8. Place the coat with the outside over and put on it the lining with the outside down.
9. Sew the lining along the bottom allowances of the coat.
10. Match the facings and upper collar with the fronts and inside collar and sew along the outer edges.
11. Sew the lining along the bottom allowances of the sleeves.
12. Unstick the back of one side of the lining, and lower the opening pull out the garment.
13. From the opening on the side of the lining, put cement along the edges of the fronts and the collar to cut that smooth.
14. Sow the opening on the side of the lining.
15. Cut all loose threads.
16. From the lining.
17. Final inspection.
(Features)
- Designstery
- Materials: Cotton, Wool, Other
- Style: Casual, Formal
- Colors: Beige, Black
- Sizes: S, M, L, XL

Description of Items:
- Collar
- Sleeves
- Pocket
- Buttons
- Zippers
- Lining

Specifications:
- Fabric: Cotton, Wool, Rayon
- Care: Machine Washable
- Size Measurement: S - 38 inches, M - 40 inches, L - 42 inches, XL - 44 inches
Assembling:

1. See the pattern
2. Cut the nappe-tacking strip around the outer edge of the garments.
3. Prepare the lining assembled.
4. Place the garment with the outside over and put on to the lining with the outside inward.
5. See the lining along the radius of the trimming around the outer edge.
6. See the lining around the garment.
7. Stitch the side to the front and from the opening roll out the garment.
8. See the open end of the side with a seam.
10. Prepare the box for flattening the section.
11. Sew the side to the corner between the front and the bottom of the garment.
12. Cut all lines through.
13. Final inspection.