

Introduction

We all want to look stylish and sophisticated. We ought to look impressive and appealing in order to survive in this highly exhibitiv world. When there is so much emphasis laid on the looks and style then it is important to keep ourselves equipped with the most outstanding and stylish fashion accessories. Leather handbags are one of the most impressive and sophisticated accessories that are considered as true hallmark of style and elegance.

The handbags made of leather are quite popular amongst the women. There are a wide variety of handbags available in the market these days. A number of fashion designers bring upon the new collections of designer bags. Most of the people admire leather bags due to their fine shine and wonderful looks. These bags are appropriate for everybody and specially women. People can use these elegant handbags for their offices, parties and even shopping; since these bags looks amazingly great; they add glamour and style to a woman's personality.

The Ladies handbags are ideal for even a professional woman who should look extremely sophisticated and niche, stylish & trendy in parties and even a highly job work These bags have ruled the fashion world with their impeccable looks, no other material like jute, plastic, rayon or cloth can replace the magic and grandeur of the leather bags. They look immensely stylish and classy.

The bags should also have durability along with style and beauty. It is important to select a bag from a reliable brand so as to ensure that it lasts longer and does not get worn out after a short time. The purse should have sufficient pockets and good quality buttons & zippers etc so that it can be used efficiently. Without a proper stitching and piping the bags would look cheap and unattractive. The fine quality bags can be made with the calf skin and thus they look extremely soft and supple

The ladies handbags are a perfect way to flaunt females as they simply cannot resist being wooed by the elegance and the beauty of these exquisite bags. You

can find amazing purses at various online shopping portals. Since the leather bags are expensive you should search for available discounts and offers so that you can get most beneficial deals.

The most appreciable aspect of leather is that it never goes out of fashion. All the other trends are momentary or seasonal and you would often notice that if you buy certain other item following the fashion trends, they would in the next season. You get really disappointed and do not feel like using the old accessory. However with elegant leather bag you would never face the problem of appear outdated as they are timeless and would always help you make the perfect style statement.

These leather bags are available in a number of colors and style. You can have amazing designs and great variety in these leather handbags. Based on your needs and preferences you can select different styles of bags. For traveling purposes stylish yet spacious bags are favorable however for party or formal celebrations elite and designer purses are appropriate. The leather purses look really elegant and absolutely incredible. They radiate a pure sense of style and class. You can create great impression with the stylish bags and win hearts of the people around you.

Designed in various artistic patterns that have grace and perfect blend of tradition with modernity, leather bags are durable and long lasting. Manufacturing of leather bags comprises of several processes such as follows:

Process of making leather handbags:

Design process: A variety of designing patterns are used in leather bags. Proper colors and combinations make an important part of making hand bags.

Tanning Process: mostly done by local people, this laborious job of tanning leather includes embossing and coloring

Weather proofing process: a special weather proofing chemical is used in leather handbags to make it resistant against extreme humidity and rain.

Hand skills: after the complete making of leather bags, the finishing look is decided such as embroidery, patchwork, or batik printing.

Aim of My Project

If you are fashion conscious, handbags is sure to be a must have in your wardrobe. A good stylish handbag can change and improve your personality hugely. The leather handbags make fabulous style statement with its fascinating hues, designs and graceful pattern. Not only for personal belonging, has beautiful leather handbag made a perfect gift to be given to near and dear ones. Here we provide you with thorough detail information on the craft of leather handbags and its related issues

Fashion bag is one of the important items of modern smart ladies. The modern ladies can not go in shopping, in party, in the park, in the office or in the house of a relative without a fashionable Bag. The main interesting thing is that the Bag obviously matches of her dress. So with the variety of dress, the Bag becomes a more fashionable one.

So My Aim is to Make this bags especially Party bags more durable, Fashionable and Chic with the modern age and fashion. In this view I've made this party bag to express my intellect and justify if it is comparable to the modern era.

Objectives of project work:

- To make various durable and fashionable party bag.
- To develop skills in perspective drawing.
- To develop skill in manufacturing according to the developed pattern.
- To develop skill in quality control during manufacturing.
- To acquire knowledge about the productivity improvements.
- To manage the product engineering software
- To expand Proper evaluation of the leather crafts.
- To encourage others to use the product engineering software in cutting patterns.

Definition of Leather Goods

The term “Leather goods are a misnomer. Literally the term’ leather goods is applied and confined generally to articles or goods made mainly of leather and intended for containing and carrying personal belongings, such as smaller items one finds it necessary to carry in the pocket or in the hand. Now-a-days, goods made of synthetics or man made fabrics are also termed as leather goods, but these goods are definitely much lower in price compared to “Genuine leather”. But the methods of construction or fabrication are the same for both. The products which are made out of leather and lend themselves to an enormous variety of both useful and essential and which are a need and asset in modern living are called leather goods.

Definition of leather goods:

The term “Leather Goods”, however, is applied and generally confined to articles made mainly of leather and intended for the containing of personal belongings, such as smaller things one finds it necessary to carry in the pocket or in the hand and the articles required when visiting or traveling. Some other forms of leather goods are purely decorative and yet others are designed for the writing table or office desk.

A vast range of articles is covered, from tiny cases for book matches, pins and needles and so on, to traveling trunks measuring perhaps 40 in. in length. Probably no other industry includes such a wide variety of articles which, apart from the basic material leather, differ so much in the components and supplementary materials used and in their styles and methods of construction.

Facts of classification:

Considering the economic condition and usage leather goods generally should be classified or separated into groups of articles of similar kind. The industry today is sectionalized in this way to very great extent, some manufacturing concerns confining their efforts entirely to one line of goods although it must be pointed out this does not limit their activities to one pattern.

The chief factors which operate in the division of manufacture into sections are primarily the kind of leather used and the machinery necessary for manufacture.

Leather is of two principles varieties, light leathers from the small animals and reptiles, which are known as skins, and heavier leathers from the larger species of animals, known as hides.

The former are highly finished and form the raw material for fancy leather goods manufacture, the latter are usually of plainer finish and are employed mainly for the solid leather articles.

This indicates the first separation of leather goods into fancy and solid leather articles. The use of skins for the former and hides for the latter must not be taken too literally for light hides are sometimes used for cheap varieties of fancy leather goods and heavy skins are frequently made into articles under the heading of solid leather goods.

The machinery necessary for the manufacture of fancy leather goods usually consists of paring or skiving machines to reduce the substance of leather parts, a guillotine for cutting reinforcement, a variety of light stitching, small machines for fixing metal fastenings, eyelets etc. and possibly machines for the polishing and plating of highly finished leathers.

The solid leather goods manufacturer requires power presses for cutting out and for blocking heavy leather parts to shape. Splitting machines for reduction of leather substance, strap cutting and punching machines, buffing machines for the finishing of edges, scoring and grooving machines etc.

Similarly, the personnel skilled in leather goods production is divided into two main groups. For the fancy section of the trade, in addition to men, numbers of female operatives are employed for the making and machine-stitching process, whereas for the solid section a large proportion of the work is performed by men, particularly in the making of the heavier types of goods and where the stitching of stout materials by hand is involved.

Classification of leather goods:

Considering the facts mentioned above, it is conspicuous that we have two main classes of leather goods which are distinct in themselves and which for reasons of economy in capital expenditure for stocks and plant and of differences in the type of labour required for each are best manufacture apart.

1. Fancy Leather Goods.
2. Solid Leather Goods.

Fancy leather goods:

Small goods or small case work in the fancy leather section includes articles which are usually carried in the pocket or hand bag such as purses, paper-money cases, card cases, letter cases, wallets, spectacle cases, tobacco pouches and cigar and cigarette cases.

Solid leather goods:

The heavier types of leather goods coming within the category of solid leather goods, as with fancy leather goods, may be resolved into three principal section or classes.

General Classification Of Leather Goods

There are wide variety of leather goods produced in the worldwide. The main groups are,

1. Small leather goods/Fancy Leather goods
2. Medium Leather Goods
3. Heavy leather Goods

1. Small Leather goods

Small leather goods or sometimes called personal leather goods which are usually carried in pocket or hand bags, includes purses, wallets, key case, passport case, note case, card case, cigarette case and cigar case, match box case and so others. Most of those products are made without any internal stiffening or reinforcement. These leather goods require leather having thickness of about 0.5 mm to 1.00 mm. different types of hides and skins which are usually used in making small leather goods are, cow softy, goat glaze, sheep Nappa, calf skin etc.

2. Medium Leather Goods

It includes hand Bags, Shopping Bags, Shoulder Bags, Document Cases Attach Case and so on. These bags are made from calf, Goat, Sheep and Exotic skins and Hides finished with range of colors those generates a good appearance and look sophistication and modernity. Leather, which has, a thickness of 0.8 mm to 1.2 mm is used in making of medium leather goods. Cow softy, Dry milled, Cow Napa, Sheep Napa, Goat and Buff Softy leather are widely used in making of medium leather goods.

3. Heavy Leather Goods

There are made generally from cow and buff hides, which are strong and durable. The hides have distance surface grain patterns and size ranges from 20 to 30 sq. ft in full hide. Cow and buff hides of thickness 1 to 1.5 mm are used for making heavy leather goods. The type to leather goods for making heavy leather goods are, box sides, Katti Leather, Split Leather, Cow Upper, Upholstery, Buff Softy, etc.

Leather Goods Classification Chart

Leather Products

Leather Footwear	Leather Garments	Leather Gloves	Leather Goods	Leather Sporting	Industrial Goods	Leather Upholstery
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<u>Ladies Bag</u> Handbags Shoulder bags Envelopes Evening Bags Cosmetic Bags Shopping Bags Beach Bags etc. Party Bags	<u>Travel and Sport Goods</u> Trunks Suitcases Attaché-cases Pilot-cases Vanity-cases Travel Bags Doctor's Bags Cosmetic Cases Toilet Cases	<u>Small Leather Goods</u> Wallets Key Cases Credit Cards Cases Cheque Book Cases Passport Cases Purses
<u>Stationary Articles</u> Waiting Cases Photo Frames Writing Pads Book Covers Blotters Pencil Cases	Wrist watch Straps	<u>Belts</u> Men's Belts Ladies' Belts Children's Belts Safety Belts Military Belts Fancy Belts
<u>Dogs/Cats Articles</u> Leashes Collars Muzziest	<u>Camera and Specific Cases</u> Camera Cases Radio Cases Binoculars Cases Instrument Cases	Jewellery, Game and Manicure Cases

General Classification of Leather Goods

Now we will study about leather goods. Leather goods refer to articles made mainly of leather & intended for the containing of personal belongings. Some leather goods are small in value & some special forms of leather goods are purely decorative. However, leather goods are classified according to the points into consideration.

- A) According to volume.
- B) According to the degree of reinforcements.

According to the volume, the different classes of leather goods are as follows.

1. Small leather goods.
2. Medium leather goods.
3. Heavy leather goods.

Small leather goods:

The goods are made from leather having sometimes of (0.5-1.00) mm falls under this category. Sometimes these goods are called Fancy leather goods or personal leather goods. The different type of skins which are used in animal in the suckling Calf is the terms generally used to describe stage. Then making light leather goods are-

Calf Skin: average size of the skin is from 6 to 10 sft. It is used for making wallets, coin purses, passport covers, key cases etc.

Goat skin: Its average size is 4 to 6 sft when dyed, when dyed it is very rich in appearance. It is used for making wallets, bill folds, passport covers etc.

Glance kid: It is made from goat skin and tanned with a smooth, bright glossy finish. It is used for making wallets, bill folds, passport covers etc.

Morroco: It is goat skin tanned with a characteristic grain developed naturally. It is used mainly for making wallets, coin purse, underarm cases etc.

Medium leather goods:

Medium leather goods indicates the proposal thickness of (0.8-1.2) mm. ladies bags, side bags, shoulder bags etc are called medium leather goods.

Calf skin: Dyed calf skins cow/butt is best suited to make flap over & framed hand bags.

Nappa: Soft, full grains of clothing leather made from cow, calf, sheep or goat are extensively used in hand bags manufacturing. This leather is glossy and more dirt resistant than suede leather. Nappa leather are best suited for making leather garments and turn type of hand bags like shoulder bags, disco bags etc.

Suede leather: suede leathers are mostly made from goat & sheep. These leathers are finished with a nap on the flesh side. These are finished with a nap on the flesh side. These are mainly used in making novelty hand bags.

Exotic skins:

a) Reptiles: Reptiles are the skins of crocodile, alligator lizard & snake skins. These are largely used to make exclusive bags.

b) Lizard skin: Lizard skins with beautiful grain are finished in charming shades. These are used in framed purses, hand bags etc.

c) Snake skin: Python skins with its striking pattern of attractive shades are used in hand bags, framed purses etc.

d) Crocodile skin: The belly of the skin is used as the heavily scaled back being too coarse & horny. The beauties of the scale are best suited to make wallets, hand bags & other novelty goods.

Heavy leather goods:

These are made generally from cow & butt hides which are strong & durable. The hide has distinct surface grain patterns & the size ranges from 20 to 30 sft. These types of goods are made from heavy leather bearing the thickness of (1-1.5) mm. Suitcase; Luggage etc are the examples of the class.

a) Box sides: These are black in colour with distinct surface grain & are used for making documents cases, attaché case etc.

b) Willow sides: These are brown in colour with distinct surface grain. These are used for making briefcase, travel suitcase etc.

c) Care sides: These are firmly dressed leather, stained or otherwise coloured having a smooth more or less glossy surface finish. These are used for making document cases, travel suit cases etc.

d) Kattai: These are finished in black or brown colours with fine smooth surface grain. These are used mainly for making transistor cases, instrumental cases, medical representative bags etc.

e) Split leather: These are the under layer of the sides. The split are sometimes finished with pigments coating & an artificial grain is produced by embossing. Naturally finished split are used for making wall hangers, patch bags etc. Coloured split are used for making shopping bags, shoulder bags, shaving kit etc.

According to the degree of reinforcements being used, leather goods are three types. Namely:-

1. Limp leather goods.
2. Semi-Limp leather goods.
3. Stiffened leather goods.

Limp leather goods:

The leather goods are made without applying any internal stiffener or reinforcement, are simply known as the limp leather goods. Most pocket goods are made in this way.

Semi-Limp leather goods:

The articles for various reasons have a paper or stiff fabric material as a foundation between the leather & lining, so imparting a degree of reinforcement or firmness. These goods belong to the class of semi-limp leather goods or semi-stiffened leather goods.

Stiffened leather goods:

Others are built up on a foundation of stout pulp board, so making the completed article quite coming under the heading of stiffened leather goods.

Stiffened leather goods are sub-divided into the groups, such as:-

1. Moulded leather goods.
2. Box or Built up leather goods.

1) Moulded leather goods:

Moulded work is the class of goods of the container type, in which the foundation is made by gluing successive layers of paper around a block of the required shape & size; the “Moulding” thus formed being covered. Moulded work is within the province of both small & large goods.

2) Box or Built up leather goods:

The articles are made on a foundation of sheet pulp board, the pieces being cut to definite sizes & “Built-up” to form a box, then strengthened with fabric & afterwards covered with leather & lined. These classes of goods are said to box or built-up leather goods. They are subjected to fancy leather goods.

According to the utility, the classification of leather goods is given below. It may be noted that this classification is also called modern classification.

Party bag as leather goods:

According to the above classification leather goods, party bag is in the category of medium leather goods.

Terms Used In Leather Goods Manufacture

1. Outer top:

The component, which forms the exterior of an article and has been on the outside is called outer top. In wallets, key cases and other personal and jacket pocket articles it is generally leather. In bags, it may be either leather or a combination of leather and fabric.

2. Asther:

The portion of jacket pocket articles like wallets and card holders which shows when the article is opened is called aster. It may have pockets to hold cars, a window, a gusseted coin pocket etc.

3. Step pocket:

It is a pocket to keep the credit cards.

4. Stamp pocket:

It is pocket where stamp are kept.

5. Coin Pocket:

It is pocket for keeping coins. Generally it is a gusseted construction.

6. Flap:

It is the piece of material that folds or tamps to cover the opening of a pocket or a bag. It serves to kept the contents of the pocket/bag securely.

7. Divider:

The component which is used to divide inner portion of an article e.g. wallet, bag, etc to create an additional component, is called divider.

8. Beeding:

To improve the appearance sometimes of the outer top assemblies are the raw edges using this strap of bound together leather or fabric with a U bind stitching. This is called Beeding..

9. Handle:

It helps to carry the articles conveniently. Handles are provided to articles using ropes, wooden / metallic fittings etc. Sometimes the fittings are covered with leather to provide a better look to the products.

10. Facing

Supporting piece of leather which attached to the top of any part like outer top, divider etc...

11. Shoulder Strap

Usually used in the Shoulder bags. The leather will be strong by which the Shoulder strap made.

12. Gusset

The pocket that has extra space resulting of a uneven part hidden inside the pockets.

Leather used in party bag:

Calf Skin: Calf skin is a close-fibred and it has a fine grain and smooth surface.

Goat skin: Goat skins provide a large proportion of the fancy leather used.

Cow hide: Generally for wrist watch belt cow hide is spitted up and the thickness is kept in 01-1.2 mm.

Sheep skin: They are the most extensive used of fancy leather

Nappa: This leather is glossy and more dirt resistant than suede leather.

Suede leather: These leathers are finished with a nap on the flesh side. These are finished with a nap on the flesh side.

NOTE: Generally vegetable tanned leather is suitable for making party bag.

FIG. fancy leather grainings-37p (Mosley)

Fashion and Designing

Definition of design

The term design has been expressed in different ways, such as

1. Design an operational art having involving in production through technology, management and marketing.
2. Modern Designers explaining design as their dimensional art related in production, Technology, fulfilling human needs, wants and demands.
3. Design is the duplication of art though technology.

So there is a close relation between art and design. Art is a outline of merit, genius and mental focus of an art. When this art is duplicated by technology for many times for commercial purposes, then it is called design.

Classification of Design:

1. Micro design : Handicrafts
2. Macro Design: Products, garment, Footwear etc.

Definition of Fashion:

Fashion is the replacement of personality for a particular purpose to enhance or to maintain life styles.

Fashion is a limited deviation from the folkways to try for something new to better represent our personality. The limit of Boundary of deviation is solely determined by our culture.

The basic aspects of Fashion

There are three basic aspects of fashion .these are

Ideological Aspect: This does not change much from purpose to purpose. We Have some basic Ideology and in representing our personality. This is quite in case of religious and ethnic ideology.

Tangible Aspect: These aspects are material aspects which we can touch, buy or sell. Examples are apparels, shoes, facial, make ups.

Intangible aspect: These can not touch, we can only feel it. Examples, the way we talk, behave, walk, treat, others etc.

Evaluation of Design and Fashion in Leather Goods

Before dealing with the concept of design in detail, a broad outline of what have originated before the advent of design in dealt with, it started first with the purpose of utility. During the pre-historic times, man was exposed to a lot of natural hostile forces from the environment such as cold, heat and rain. Initially, he started using large leaves to cover himself and palm leaves to protect his feet but when demand for these increased, he looked for alternatives with a longer durability.

Then started the emergency of using the skin of animals. As he hunted for his food, he discovered a number of applications of the skin including protecting himself the elements.

Hence, from the crude utility stage, it moved, in the later stages to a higher level of designing. Design took different from another, to differentiate life styles,

occupation and so on. As civilization progressed, simultaneously population grew and demand also increased. Market paved its way to competition. Competitions vied with one other and it was them that DESIGN took stronger roots. Design plays a major role in a number of fields. It is not limited and has application in diverse fields like architecture, scientific equipment etc.

A study of design in the leather industry would show that of late there has been a dramatic change. A number of design schools have been started to meet the growing demands of the trade. The designer's works are exhibited in fairs organized by the leather industry. It goes into the various attributes and a jury is formed to evaluate the displayed designs. The displayed designs are then awarded a ranking. It is then selected for a period of two years to be the fashion. Designs are selected two years in advanced before coming into market.

In the western countries fashion changes twice a year, due to their climatic conditions. Hence, we find that winter wear has its own fashion vary different from that of summer. Here we also find that purchase power is vary high and hence we find there are designers like Pierre Cardin, J. C. Penny and so on who bring out a total range of wear consisting of clothes to footwear, together with leather accessories.

Clothes and footwear change are attributed to formal occasions, such as an informal party dress to a formal dinner wear. Colors also play a very vital role in fashion trend. When a particular design is selected by the jury, rights are granted to the manufacture for production which finally comes to the market, it is at this stage, it is seen whether the level of acceptance by the public is high, which in turn determined by the sales and successful it becomes a trend of that time.

The foregoing indicated market that pertains to the western countries. There is a complete absence of these trends in a developing country like India. Only now there exists a very marginal awareness of design in the minds of the younger generation. With the advent of multinationals among the major business houses, there seems to be a positive outlook even though it might not be as successful as their western counterpart.

Design and Pattern Development

In the processing and marketing of leather goods, design & development (pattern development is the off – shoot of design & development) is of utmost importance. Without proper conception or grasp of functional value, no design could be converted into a fabricated product and such as the work relating to the design and pattern development aspect of leather goods manufacture cannot be over emphasized.

In the first instance, a design should be as simple as possible and easily workable and saleable. The function of the design should be crystal clear before pattern making. Multipurpose functions (end use) with too many components joined or assembled should be avoided to the extent possible, as it cuts into other important aspects of the design namely size, appearance, shape and aesthetic value. A compromise or judicious or imaginative blend of elegance and performance, quite in harmony with the function use is suggested for the best creative designs.

As the sole intention of design is to meet the requirements of its basic functions, its performance could be better built around its generic character rather than its additive character. A good leather goods designer has to foresee the fashion trend / change and style in the coming seasons usually a year ahead and form an idea of what things are in store for the market. In fact, designer stands between the market and the manufacture. He is the creator of fashions and fashioner of creations. Some of the important factors are color matching, texture, feel embellishments and so on but the most important parameter being the functional value.

Another important aspect of design and pattern development is that the design should be easily translated or transformed into production schedule. Further production and productivity are the key factors for a successful commercial venture. That is why it has been advocated that too many components have to be avoided. For instance, from the author's experience, a wallet could be made out of one single component of leather in less than three minutes, here the design and pattern making

of the wallet plays a stellar role, but the consumptions of leather in pattern cutting is high but the compensated with the ease of operation and the productivity is very high in this case. On the other hand, the same wallet could be made with 5 or 6 components assembled together. Here we care saving leather, but production schedule is long and productivity slows down within its ambit. So in design and development of leather goods (the above is only in illustration to drive home the point) a judicious blend of production technique and productivity, cost saving, value addition and quality control aspects should be taken into consideration.

The pattern maker, next to the designer should have sound knowledge about the design chosen, the various materials of construction that are to be used and the different. In each pattern, allowances for seam and turnover are to be provided. The pattern size varies for leather, lining, foam and reinforcements. It is always the practice to have distinct markings in the patterns itself for button holes and other fasteners. Normally the patterns are made of thick strong paperboard with metallic piping around the edges or made of metal like aluminum and zinc. These are known as templates in technical parlance. The individual patterns of an article are numbered and kept together and stored properly for easy identification and reproduction at a later stage.

Undoubtedly, pattern cutting is an art, but it is scientific in the sense that it required elementary mathematics and geometry as symmetrical (sometimes odd) shapes of pattern are to be fitted in the area of leather judiciously to get the maximum advantage of cutting. The art of pattern cutting requires anticipation, sound judgment, and cultivated style of approach with a sense of quality control.

After going through the scientific system of designing pattern development, one feels inclined that the principles of designing are based purely on mathematical calculations and geometrical drawings.

In the beginning, it is so; angle, degrees, dividers, set squares is necessary. But by identifying one self within such limits, one cannot become a perfect pattern marker. Experience, practical knowledge and keen observation are the ingredients to become efficient to give perfect, vital shape to the patterns and this requires training.

Role of raw materials for the making of leather goods

Man has come a long way from the days of his primitiveness and so has leather. In today's life the role of leather is varied and vast. The products made out of leather lend themselves to an enormous variety of both useful and fashionable items which bare a need and asset in modern living. An extensive range of colors and designs widen the selection range which encourage the prospective consumers to put these products to use in a multitude of ways, be it fashionable or functional. Hence, the study of materials is very important in the manufacture of leather products.

Finished Leathers:

These are the basic materials required in leather goods manufacture. Finished leathers of different types are used in the fabrication of a wide variety of leather goods. Goat, sheep or calfskins are used in the manufacture of light leather goods. Cow and Buff hides are used in heavy and luggage goods. Softy uppers, sheep and goat nape or suede leathers are used in making handbags. Softy leathers are exclusively used in "Turn Type" of articles.

Light leather goods:

These are mostly made from skins such as calf, goat, sheep etc. These leather goods require leathers having thickness of about 0.8 mm to 1.00 mm. The different types of skins which are used in making light leather goods are,

(i) Calf Skin:

Calf is a terms generally used to describe an animal in the sucking stage. The average size of the skin is from 6 to 10 sq-ft. Natural finish of the skins is used for tooling work. It is used for making wallets, coin purses, passport covers, key cases, etc.

(ii) Goat Skin:

Its average size is 4 to 6 sq-ft. When dyed, it is very rich in appearance. In natural finish, it can be used for tooling. It is used for making wallets, bill folds, passport covers, etc.

(iii) Glace kid:

It is made from goat skin and tanned with a smooth, bright glossy finish. It is used for making wallets, bill folds, passports covers, etc.

(iv) Morocco:

It is goatskin tanned with a characteristic grain developed naturally. It is used mainly for making wallets, coin purses, underarm cases, etc.

Materials That generally Applied

Accessories:

Accessories play a vital role in designing & production of leather goods as well as shoulder bag. An accessory not only gives richness to the design but also durable the products. For the manufacture of leather goods accessories are grouped into

Fitting:

Fitting comprise are following

a) Locks: These are fitting which may or may not have locking arrangement. Locks are used as a closing device in a variety of leather goods. They are may be either made of brass or chromium plated.

b) Hand bag frame: Frame are either made of brass or plated with chromium. These are available in size from 3" to 12". 3" to 5" are used in framed purses. Frames are manufactures are different shapes.

c) Strap fitting:

d) O rings: They are metallic rings available in brass chromium are anodized steel. The D rings hold the strap of the bags. D rings are used in a variety of leather goods

e) Round rings: These are similar to D ring except they are round shape. These are also chromium plated, brass & and anodized iron. The function of this fitting is the same as D rings. These are also available in size from ½" to 1½"

f) Buckle fittings: Belt buckles come in a variety of design. They may or may not have hooks. They are extensively used in making belts with different styles.

g) Adjustment fitting: These are plated with chromium or anodized or made of brass. The buckles have center stem. The length of the strap can be adjusted by sliding the buckle. These are available in size from ¾" to 1½" these are usually used in shoulder bags.

Fasteners:

Attaching part with different varieties of fittings are called fasteners. These are to followings-

a) Rivets: Rivets are used for attaching two pieces of materials where considerable strength is required these are metal fastening pins with split end. These are two types of rivets available & lock rivets.

b) Rivet button: Rivet button otherwise called chappal buttons are extensively used as a fastener in a variety of leather goods. They are available in a variety of color.

c) Eye lets: Eyelets come in a variety of color & also brass or chromium plated. Small eyelets are use in footwear industry.

d) Studs: Studs are available in small. Medium & big sizes with different shapes. The studs may be metallic or synthetic. Metallic stud have split stem while synthetic stud have a hole or filled with metal thread. These are extensively used in heavy luggage, goods like travel bags, suitcase etc.

e) Zippers: Zipper may be metallic or synthetic & come in matching colour, zippers come in different sizes. It is a closing device & used in a variety of leather goods & leather garments. Zippers are sold according to length & quality.

Lining:

Lining of different kinds is used in a variety of leather goods. Lining is a inner coverage of leather Product linings have functional & consumer appeal objectives. Making a lining pattern for leather products is like making a lining for different leather goods.

Some skins, such as lamb suede, feel rough or look unsightly on the inside. Designers usually will add a lining to conceal the imperfections.

To make unlined leather goods, purchase specially processed leathers with insides as nice as outsides.

Objectives of lining:

The purposes of lining are:

- a) To cover any defects on the flesh side of leather used in the article.
- b) To conceal seam and folding allowances
- c) To enrich esthetic appeal
- d) To elegance the garment
- e) To add strength to the weaker type of leather.
- f) To match the outside and inside colors of the article

Variety:

- Cotton
- Printed cotton
- Brushed cotton
- Polyester
- Printed polyester
- Satin
- Poly satin
- Taffeta
- Polyononic
- MM Dabu (viscous polyeste
- Twilted (Polyester, Sattin, Cotton)
- Wool and fur. (Natural and synthetic)
- Crepe
- Canvas

Viscose

Viscose is made from cellulose which is derived from wood pulp, and like most other synthetic fibers, it goes through a number of chemical and mechanical processes until the filaments are ready for spinning into yarns. Linings constructed from viscose fibres have strength, luster, softness and an affinity for dyes.

Rayon

Originally rayon was produced as a cheap substitute for silk and the fibers were known as “artificial silk”. Rayon linings have similar properties to those of viscose linings but are somewhat weaker.

Polyamide

Derived from nylon, polyamide produces linings with excellent tensile strength and a relatively high degree of elasticity, and it takes dye stuffs very well. A drawback with polyamide linings is that some solvents used for dry cleaning can have a detrimental effect on the fabric.

Polyester

Polyester fibers are closely related to polyamides and linings made from polyester fibers have many similar properties. The first polyester linings had a tendency to soften when pressed with a hot iron, but fibers with a high melting point have since been developed and these withstand regular pressing temperatures.

Consumer appeal

An important factor of consumer appeal is to present a garment whose inside has an attractive appearance. The surface and luster properties of the lining have a considerable influence on this, and those properties for linings most widely used are:

- Taffeta a crisp fabric woven with a faint warp pattern which produces a shiny surface. These linings are generally piece - dyed which helps to soften them and make them able to withstand normal washing and dry cleaning process.
- Crepe Made from specially processed yarns, mostly viscose acetate, the finished surface of this lining has a minute and uniformly

crinkled appearance.

- Satin (sateen) this lining is characterized by a smooth and highly lustrous surface and a dull back. Satin is the name of a weave pattern and all - cotton fabrics that were once constructed with this weave pattern were called sateen.

Color also plays an important role and linings with a woven, printed or embossed pattern can give an extra fillip to a garment. Some large companies incorporate their logo in the weave pattern of their linings.

Needles

Needle is an important tool of the sewing machine which pierces the material to be stitched and facilitates to stitch during stitching the selection of correct needle depends upon the needle size needle system as well as the needle point.

The main functions of the sewing machine needle are:

- The needle has to be able to penetrate the material being sewn, without damaging it by pushing the yarns a side.
- The needle thread can wholly or partially pass and form a loop which can be picked up by the looper or hook mechanisms

Needle point plays a crucial role in aesthetic finish of the seam. Further, the point is important for penetrating the Leather / material with ease. In leather, the seam style is determined by the point.

Points and tips have a decisive bearing on the performance of the needle and the various types of combinations can be divided into two groups.

Round Points

- Normal round point
- Slim Set point
- Stub point

- Light ball point
- Medium ball point
- Heavy ball point
- Special ball point
- Extra - heavy ball point

Cutting points

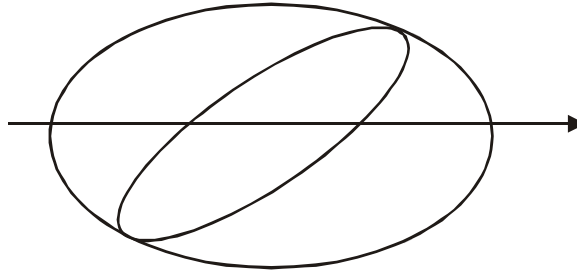
- Wedge point
- Cross point
- Reverse twist point
- Twist point
- Triangular point
- Square point

Shape of the Needle

Consultation of the needle manufactures, catalogues reveals a bewildering choice of needles and even in the leather section a wide choice is available. For leather, a needle with a cutting point is essential so that the material is pierced with the minimum of friction. Two basic shapes are recommended.

The wedge shaped needle is the most popular. The cutting edge is 70% of the diameter of the needle which is generally 1.2 mm wide at the maximum. The needle leaves a hole approximately 1 mm long. The orientation of the wedge can be perpendicular to the line of sewing which gives the maximum number of stitches per inch and the strongest seam for a given stitch length. It is, unfortunately, a somewhat unsightly seam. The neatest seam is produced with the wedge parallel to the direction of sewing, but this type of seam is also the weakest and there must be a limitation on the number of stitches per inch otherwise the leather can be completely cut. The compromise of appearance and performance is obtained using the reverse twist needle where the wedge is at 45° to the line of stitching (that is on a South west to north east line) with the threading from West to East, as shown below.

The needle should be designed so that the thread lies within its overall dimensions.



The very small triangular point needle is a more recent introduction. It is essentially a round needle with a small triangular shaped tip with very short cutting edges. It has a better piercing action through the leather than the round needle and gives a more uniform stitch formation. It requires a somewhat greater force for penetration than does the wedge but leaves a neater hole.

As with the wedge shaped needle, it should be designed so that the thread lies smoothly within its overall dimensions.

Threads

Almost all leather products produced have one component in common: the sewing thread. Whilst sewing threads are usually a relatively small percentage of the cost of leather goods, they have an extremely significant influence on the appearance and durability of the finished product. The production of sewing threads is an extensive and complex subject.

Sew ability

This describes the basic all round properties of the thread, including.

- Not breaking when used for high speed sewing
- Facilitating the consistent formation of stitches
- The minimum occurrence of skipped stretches.
- In order to prevent changes in tension during sewing, the thread must have a uniform diameter.
- A high level of resistance to abrasion is essential due to the friction

of the thread in the needle eye and with other mechanisms.

- The thread has to have sufficient surface smoothness to pass easily through the guides on the machine. This ensures the uniformity of stitch formation.

Durability

The main thread related factors under this heading are:

- The thread has to have sufficient elasticity to withstand the normal pressures imposed on seams during wear. This is particularly important for knitted fabrics because of their inherent extensibility.
- Thread shrinkage should be minimal after the garment has been washed or dry - cleaned be minimal after the garment has been washed or dry cleaned. Seam puckering is often caused by unstable thread.
- It is important that the thread maintains its original color after being subjected to cleaning processes. In particular, this applies to the threads used for top stretching and other decorative purposes such as embroidery.

Twist directions

Sewing threads are made by twisting single yarns together to form a stronger thread. The twisting of thread is made in two directions known as “S” and “Z” twists. The “Z” type twist (Twisting towards left) is most widely used as it is suitable for most machines some special machines however requires “S” type twist.

The threads are wound and packed to form a variety of tubular or conical shapes. The purpose of these is to allow the thread to leave from the “COP”, “CONE”, “VICONE” etc., easily without applying any tension to the thread.

The thread cop label has the following details

- The brand name of the manufacturer
- Color code number of name of the color

- Thread contents meter wise or yard wise
- Number of plied threads - details
- Strength of the thread.
- Maximum retail price
- Type of thread.

The following types have been offered for leather products

Mercerised Cotton	:	Approximately 10% stronger than normal cotton and probably the most widely used for leather garments.
Nylon	:	Its main advantage is greater tensile strength permitting a finer thread and finer needle for a seam of the same strength.
Nylon / Cotton	:	Smooth running and soft.
Polyester / Cotton	:	Superior in strength to cotton. The cotton covering provides improved flow through the needle, reduced cutting of the leather by the polyester and also protects the stretches during heat treatments.
Linen thread, double twist	:	This is traditionally used for protective clothing made from chrome tanned splits.

In an extensive series of tests, the polyester / cotton threads gave the best overall performance with request to seam strengths both initially and after various ageing tests. Cotton suffered considerable losses in strength on artificial ageing and storage.

Relation between needle, thread & material

Thread Thickness TKT No.	Light Material		Medium to heavy material	
	Needle Size		Needle Size	
	NM	SIZE	NM	SIZE
80	65-70	9-10	70-80	10-12
60	80-90	12-14	90-100	14-16
40	90-100	14-16	100-110	16-18
30	110-120	18-19	120-130	19-21
35	110-120	18-19	120-130	19-21
20	120-130	19-21	130-140	21-22
25	130-140	21-22	140-160	22-23
15	130-140	22-22	140-160	22-23
10	140-160	22-23	160-180	23-24
8	160-170	23-24	180-200	24-25

Adhesives

Adhesives are primarily used for two purposes. They can firstly be used as a temporary bond holding components for subsequent sewing and secondly for gluing hems or laminating components where the bond is accepted to be permanent.

Problems arise in wear if the adhesive degrades and migrates to the outer surface. In dry-cleaning the adhesive can be softened resulting in partial, temporary loss of adhesion followed by movement of the glued components and finally re-adhesion, followed by movement of the glued components and finally re-adhesion in an undesired location.

Adhesives based on natural latex have given rise to a considerable number of individual complaints. They are very convenient to use in manufacture and have been used widely in the past because of their instant tack, ease of removal from unwanted areas and washability or brushes. However, certain leather dyes, heat and general oxidation have all resulted in break-down of this type of adhesive with consequent migration through the leather. Their use is not recommended.

Most problems have, however, been caused by the use of adhesive in closed seams. Partial solubility during dry-cleaning has resulted in the adhesive oozing out of stitch holes and being "Printed" on to other areas of the same garment or contaminating other garments with which the glue seams come into contact.

All structural adhesives are cross linked.

Adhesives may be classified by mode of application and setting, chemical composition, cost and suitability for various adhered and end products. They are:

1. Anaerobic
2. Aerobic
3. Radiation curable, and
4. Pressure sensitive adhesives.

Adhesives can be also classified according to their origin:

1. Natural adhesives: Starch, animal and vegetable proteins, natural rubber and shellac.
2. Semi synthetic: Cellulose materials, phenolic resins, polyamide, PU from castor oil.
3. Synthetics:
 - (a) Vinyl type: Polyvinyl alcohol, acrylic, unsaturated polyester, NBR, SBR, Chloroprene, butyl rubber.
 - (b) Condensation & other: Polyurethane, phenol formaldehyde urea-formaldehyde etc.

Adhesives can be also classified based on their performance,

1. Temporary work
2. Permanent work.

Based on the hardening adhesives types are described here:

1. Adhesives which harden by loss of solvent/solvent based types:-

The adhesive is basically a solution of natural or synthetic polymer in organic solvents, which is applied to both surfaces to be bonded. Some time is allowed for the solvent and the surfaces are then press tighter. Polychloroprene (Neoprene) adhesives are prominent examples.

- (a) Rubber solutions
- (b) Polychloroprene (Neoprene) solutions

(c) Polyurethane solutions.

The general principle in gluing is to use the minimum quantity required for the purpose and to choose an adhesive which is resistant to constituents of the leather such as dyes and fat liquors and the maintenance treatment of the leather products. See table for a list of suitable adhesives.

Adhesive	Comment
Water based adhesives Natural rubber lattices	Not recommended
Colle OB	Suitable for leather bag
Solvent based adhesives I part adhesives requiring no mixing before use: Bostik clear Evostick 5004	Suitable for leather bag

Tools use in leather Party bag manufacture:

A good craftsman/woman is always most particular in her choice of tools & equipment. He/She will be capable of her best work only if they are good & to use. However, a short description of different tools for leather product manufacturing are given below-

Knife: knives are the most important tools. There are many types knife like survel knife, xacto knife utility knife, and shoe making knife. It has a slightly tapered blade finishing with a pointed end, generally with a wooden handle.

Skiving knife: For skiving edge of leather using this tool requires. Skills & Experience can be also done more easily with a skiving machine.



Creaser: It is steel tools for finishing the outer edge leather goods. It compresses the leather, giving it a slightly darker and shiny line. It is in different sizes & design.



Oil stone: Oil stone is made by carbonandum or silicon carbide. It is used to remove the wire edge formed in the cutting knife. It is also two sides soft & rough. To get fine cutting edge rub the knife on the soft side of the oilstone.

Leather shears: These are used for cutting leather of any thickness.

Edge beveller: For cutting away a portion of the edge of heavy leather.

Revolving punches: The revolving punch has a magazine of punches of different diameter. It is used to make holes close to the edge of the fabric.

Awl: It is used for sewing leather in order to make leather goods. They are known by different names diamond, harness or bucking awls. It is used to making hole in leather.



Hammer: It is used for hammering. There are many kind of hammer such as heavy hammer, light hammer & medium hammer. Hammer for leather worker are of two types. Generally they are used for nailing pounding & creasing.



Square scale: For measuring a straight edge for trimming & for measuring & 90° angle. It may be used.

Stitch marker: It is an important tools for making leather goods. It is necessary to the leather. Available in several sizes or with removable. Wheel number on the wheel means quality of stitches per inch, the higher the number, the smaller stitch length.

Folding hammer: these are used for hammering after cementing & stitching. Also when folding gusset heavy leather not to be used for punching.



Bone folder: Made of wood or bone used when turning edges over. Also used when pattern making.

Springs divider: Used in designing departments for measuring various allowances of patterns.

Thickness gauge: Used for same purpose as thickness gauge.

Sharpening stone: Used for sharpening various kinds of knives .

Scissors: Used by the worker of the closing room for trimming thread ends, cutting slots & for other similar works.



Cutting knife: Generally used for cutting leather of heavy type.

Wooden mallet rubberized: Used for hammering the punches wherever hand punches are used.

Types of construction of party bag:

In the manufacture of Leather based wrist watch belt there are different types of construction to be used, according to the need of the market & orders from customer. These are,

1. Cut Edge Construction.
2. Folded Edge Construction.
3. Butted Edge Construction.
4. Mixed Edge Construction.
5. Thong Edge Construction.
6. Binding Edge Construction.

1) Cut Edge Construction:

All components of the shoulder bag are assembled without any folding on the edge. So that outer edges are absolutely level when stitched. For this type of construction work mostly vegetable tanned leather of good quality finish with firm close texture is preferred. Because of it is raw edge after finishing; the edges are visible as raw cut. To impart a good finish to these articles all the edges are stained by similar or contrast color, polished & creased.

2) Folded Edge Construction:

This term refers to all articles whose components are cut with additional margins, which may be skived if it is necessary. Then the margin is applied with an adhesive & turned or folded over on to the lining or other inner parts to cover the edges. Then they are secured by stitching as any construction if necessary. This

method of construction, impart a greater durability and neatness to the article.

3) Butted Edge Construction:

In butted edge construction two turned over (Folded) edges are placed together by keeping the grain side out & stitched. It gives a double layer of folded edge on all round the edge.

4) Mixed Edge Construction:

This type of product is produced by mixing of folded edge & raw edge constructions in the final assembly.

5) Thong edge construction:

Mostly we are using on the crafts work of production. In thong edge construction the edge of the goods are, webbed by similar or contrast strips of leather. Thong edge construction is made through direct punch slots or holes, to stitch (close) by means of leather lace (leather thong). This adds beauty to the belt.

6) Binding Edge Construction:

These are type of construction, which gives the list & decorative finish of the product. After assembling of all components as raw edge construction, to cover the edges of the product & at the same time to give decorative effect some product we have to bind in same or different color of strip leather. There are three types of binding edge construction. They are:

a) French Binding:

This is stitch one edge of strip with outer edge of product and turned over the binding to the inner part and stitched again.

b) English Binding:

Simply by attaching the binding at the edge of the product and stitch.
After stitching of each binding some times if it is necessary we have to trim the excess of the binding.

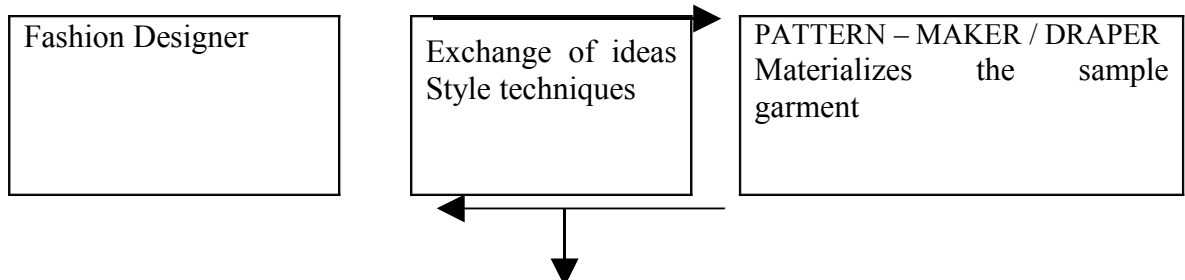
Unit operations

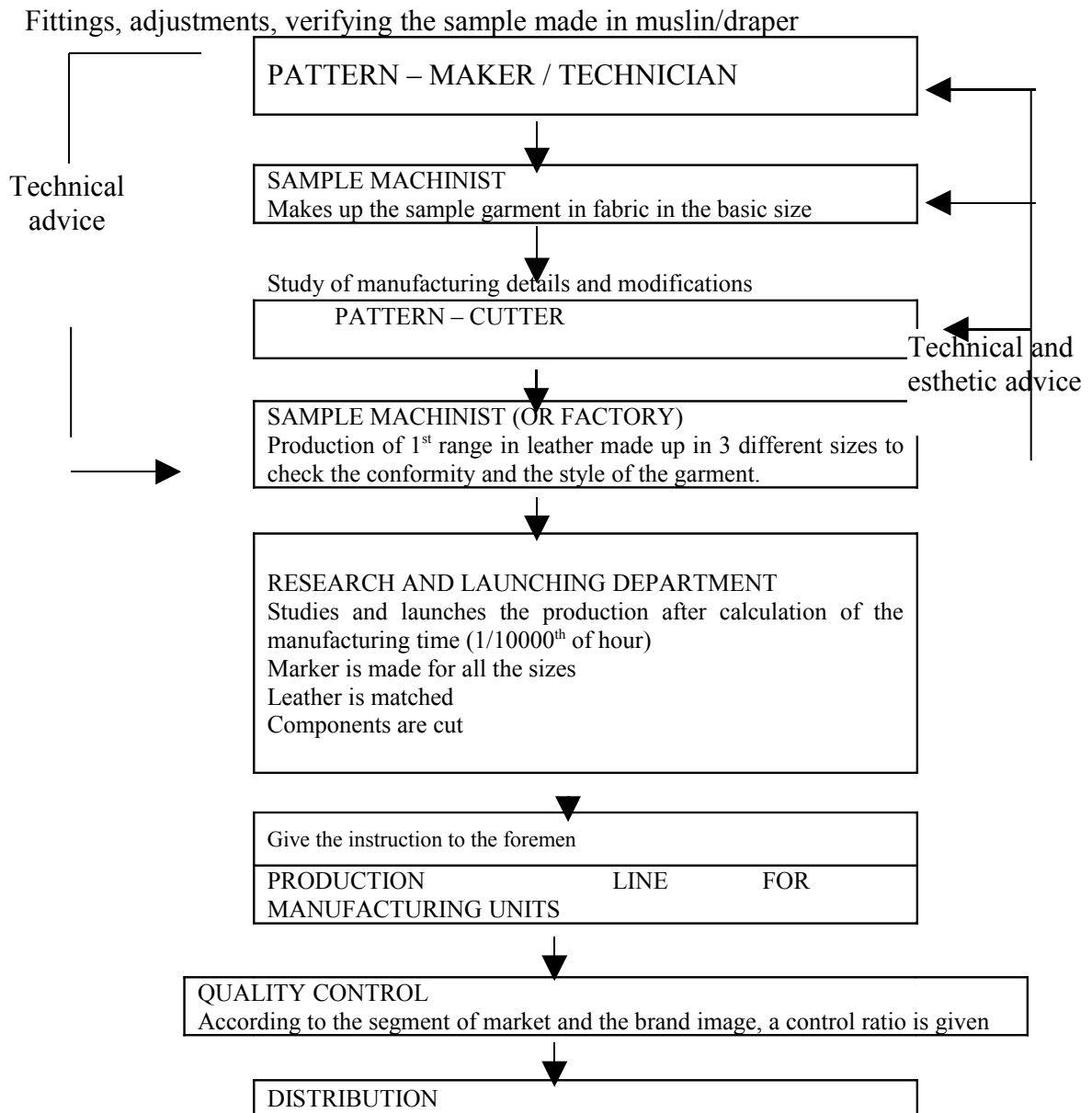
Manufacture of Party PARTY consists of a multitude of different operations. Some of them are essential for all types of manufacturing process & some may be skipped depending on the design & types of construction. It is absolutely necessary to know following sequences of operations involved in the manufacturing of wrist watch belt. These are,

- a) Pattern Engineering
- b) Cutting.
- c) Pre-Assembling & Assembling.
- d) Finishing & Packing.

a)PATTERN ENGINEERING

Stages of Collection





Designing

Design is the duplication of art through technology. A designer must have a clear concept of art, motive style and fashion. He always thinks about the culture of a particular community. A product design comes through several stages of collection.

Designing is an important process in the manufacture of shoulder bag. In the principal of designing, a good design should be easy for fabrication & saleable.

The design should be simple when it is converted into production as much as possible, because production & productivity are the sky factors for successful commercial venture. Assembling of too many components for multi-purpose functions must be avoided as much as possible. It affects the important aspects of designing namely, size, shape, structure attraction & value appearance. In good designing, techniques & technical skills very important. A good design should not impart the functions of the products for which they are manufactured.

A good designer must have creative & hi-tech skills to product to international standards. He has to foresee the fashion trends & frequent change of styles & designs. He must be aware of the quality of the materials, color matching, texture, feel, etc...& the quality of other fittings such as accessories, decorations, fittings, etc...In fact, the designer stands between the market & the manufacturer.

Pattern Cutting:

Pattern is the flat representation of a three dimensional figure into a view dimensional form. And pattern making is a science and engineering. The pattern is the primary link between design and production and so must communicate accurately with all the function that has to use the pattern. The pattern has clearly and precisely conveys the information necessary to perform each of the operation. This information is conveyed by numbers marks, nips and notches etc and not by written instruction. New sample patterns always require some explanation but there should be no necessity for verbal or written working instruction when it comes to production.

In leather goods production the most important operation next to designing is pattern cutting. The pattern master(pattern cutter) next to designer should have sound knowledge about the design chosen, various materials & tools that are to be used & different types of construction that are contemplated.

According to the type of construction the pattern & its size very, & allowances to be provided are different. In each pattern, allowances for seam & turnover should be provided. The pattern size varies for leather, lining, foam & other reinforcements. It is always the practice to have distinct marking in the patterns itself for fixing of accessories, attaching of reinforcements at the place of folding. Normally, the patterns are made of thick & strong hard boards, most of the time to make number of production, hard board patterns are fixed into aluminum or galvanized metal piping

around the edge or completely made on them (Aluminum, Zinc, etc...) These are known as templates in technical parlance.

In leather goods making there are three kinds of pattern are used. Normally,

1. Basic pattern
2. Making pattern
3. Cutting pattern

1) Basic pattern:

Basic pattern is plan, which is an ideal of designer demonstrated. Only from this pattern the making pattern is developed. The size & shape of product are determined by basic pattern.

2) Making pattern:

The patterns which are cut to be correct size & shapes of components of leather goods product are called making patterns. Making pattern is some times called working pattern. The main purpose of these patterns are to help in the production of cutting patterns, & also in the production process to help the bench work operation for further makings of place of folding, place of button fixing, & any other making. These patterns are largely used for making cut edge construction types of product to cut leather components.

3) Cutting pattern:

The patterns which are cut with allowance, for folding, over lapping (seam), stitching etc... of the components of the product are called cutting patterns. From the making pattern, a set of cutting pattern made generally. Each set includes patterns for cutting component, pattern for lining, pattern for reinforce materials or stiffening materials, & pattern for padding (foam). As mentioned above, in simple cut edge construction & some of binding edge construction product patterns, the making pattern & cutting pattern are one & the same.

A good pattern master must be aware of different types of finished leather, & their suitability in making different types of leather goods; he must be well versed with the technology & technique of fabrication & types of constructions. He must have the essential knowledge in elementary mathematics, reading of measuring scales, & use of geometrical instruments for drawing geometrical shapes such as rectangle,

triangle, square, circle, parallelogram & other odd shapes. He must have knowledge about different types of fittings & accessories, linings & reinforcement materials, which are used in leather goods making.

The pattern maker must give in each pattern the following information, which would help the cutter to cut materials easily & accurately.

- a) Model number/Code number of the product,
- b) Name of the pattern/Back, Front, Gusset, Pocket, Handle, etc.../,
- c) Number of components to be cut,
- d) Name of the raw material/Leather, Lining, Foam, etc.../,
- e) Center point for perfect joining of the components,
- f) Marks or slots for fixing fittings, accessories, decorations, zip, etc,
- g) Good components, defective components, partly good & partly defective component. (That is the visual part must have good surface, & invisible parts has defective surface).

b) CUTTING:

Selection of leather

The raw material for leather goods production is obtained from processed or semi-processed hides & skins. These raw materials (finished Leather) are dependent on the ever-fluctuating price & demand of the meat industry. In addition, the raw material is highly heterogeneous in nature. Each hide or skin vary in structure & chemical compositions, quality from another, species to species, & within the skin or hide. Hence it poses a greater challenge to the technologists in selection of good quality finished leather for particular type of leather good.

Important operation in the fabrication of leather goods is the cutting department. In a factory it should be mannered by experts & highly skilled personnel's as the very nature of finished article depends on the method of cutting room techniques. Awareness has to be created on the sound principles of cutting room practice. It is always born in mind that the whole costing of leather goods depends on the way of

cutting patterns in the cutting department, since saving leather (with least wastage) means saving in cost of production.

For successful cutting, the cutter must be aware of sections & quality variations of skin.

Grain Matching

Most of the time the panel of leather goods is sectioned. In this case the grain of each component should be matched; otherwise the articles will appear odd & doesn't have good appearance.

Matching grain is an important factor, particularly for the high grade articles proper consideration of grain matching is necessary. Of course for minimization of wastage & cost reduction some times grain matching has been difficult, but in all articles the front panel of article is usually have well matched grain pattern.

Color Matching

In aniline dye batch, the leather should have to be matched for shade & the components of the article have to be cut from the matched grain of same shade.

In case of pigment finished leather the defects would have been covered due to a thick color coating. In this case, especially the backbone area is measured & any mark is visible, it is not advisable to use these portions in the front panel of the article.

Common Defects

A cutter/selector must examine each hide or skin both on the grain side & flesh side for defects. Before cutting operation begins the following defects has to be marked.

1. Deep Flesh Cut
2. Uneven Grain
- 3 Glazing Fold
- 4 Color Variation

6. Excessive stretch

Cutting is considered to be one of the most important operations in the manufacture of leather goods operation. Cutting is the term used for cutting leather components, linings, foam & other reinforcement materials using for production of leather goods.

The essential operation involved in cutting room are done by the two methods

1. By Manual
2. By Machine.

Manual Work in Cutting Room

In olden days all the operation of leather goods has been done manually. Today because of high demands & modern practice of these articles, machinery work becomes essential.

In small-scale industries, cutting operations had been done manually and also in some rural area on addition to hand cutting, skiving operation is also done manually.

1. Hand cutting:

Hand cutting is done usually in small leather goods industries using either cardboard patterns or metal templates. Hand cutting is done on an inclined wooden table fitted with a galvanized iron sheet or zinc sheet on the top. Hand cutting is done by a sharp hacksaw blade knife made of 1.2 cm width and about 30 cm length or other fabricated adjustable hand knife. In the case of hacksaw blade knife, it is essential to rub with emery stone whenever the knife becomes blunt to make it sharp and pointed.

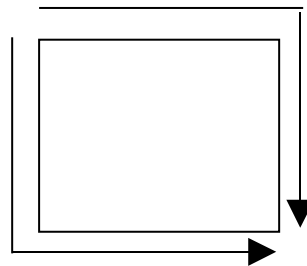
Basically the pattern is placed on the required position of the material and the shape cut all -round with a cutting knife. Good sharp and pointed cutting tool (knife) is essential for successful work.

Key points to be remembered during cutting:

1. Make sure that it is the correct pattern of the article you desired to cut,
2. Examine for defects, size and shape of hides/ skins,
3. Selective cutting must be practiced; the best part of the article demands the best part of hide/ skin.

4. visible parts should have good grain surface and section covered could contain grain defects,
5. Good cutting begins with a sharp knife. Less sharpened knife or blunt knife cuts the leather with ragged edge,
6. The angle between the edge of the knife and the cutting board depends up on the hardness of the materials being cut. A small angle for a very soft materials like fabric and a greater angle for hard material like leather and reinforcements, may be used,
7. Over cutting and under cutting must be avoided.
8. Patterns must be placed in such a way to ensure quality, economy and minimum wastage.
9. Straight - line cuttings must be done first with steel scale/ruler /. Curved line cuttings or irregular shapes must be cut with templates,
10. Cutting , must be done on a smooth surface of soft wood or plywood or galvanized iron plate or zinc plate for accurate cutting,
11. Pattern must be placed on the leather and initialize cutting from left to r ight,
12. Start cutting from left top corner of the pattern and end at the right bottom corner,

Cutting Direction



13. Use the least number of cutting strokes.
14. Cut through the leather in one stroke.
15. Intermittent cutting must be avoided, as it may damage the components.

1. Hand skiving:

Hand skiving requires a greater deal of skill. It is done on a smooth surface like grait stone, as it does not absorb either dyes or moister. Smooth stones enable smooth skiving. Skiving is done with a pairing knife in which one side of the edge is beveled, having high quality tempered high speed steel blade of about 2.5c.m wide, oblique end, slightly curved and sharpened to a bevel on one face. The knife is held in such away that it removes the required thickness at the edges. care must be taken that the edge of the component are thinned down more than the required thickness as it may weaken the components and also make the components unfit for fabrication.

2. Machine work in cutting room:

In large-scale industries, different types of machines do cutting room operations. Those machines are mentioned below:

1. Clicking Machine
2. Splitting Machine
3. Skiving Machine
4. Strap Cutting Machine
5. Board Cutting/ Sharing Machine
6. Embossing

1. Clicking Machine

The sequence of operations to fabricate an article begins with the clicking machine. Different panels or components of leather goods are cut in this machine. Here, a press knife is used which is in the shape of patterns. So a set of dies is required for each article. The leather is placed one by one on the cutting Teflon board of the machine and cutting dies with the shape of component is placed on leather and by clicking.

On an average of 300 components can be cut in an hour. This machine could be either mechanical or hydraulic operation.

The press knife (dies) should be:

- Sharp edge in order to give a clean edge cut
- kept separately and not stacked one over the other
- Stored and handled to ensure that fine edges are not damaged.

2. Splitting:

Splitting is the second machine operation after cutting. Leather that is available for leather goods productions are mostly found to be thicker than the requirement. Splitting enables reduction of thickness of the leather components to the required degree that helps early in assembling of components. Excepting heavy leather goods, medium and small leather goods require leather components of thickness less than 1.00mm. So, splitting is necessary for the leather that is obtained from the market having thickness of 1.2mm and more. The splitting can be done to a thickness that can be obtained in 0.5mm using a presser roller and 0.2mm using a presser bar. The top grain layer is used in the fabrication while the bottom-split layer is left off. (fig)

3. Plating/embossing:

Plating is done in hydraulic press by which has a polished plate that can be heated to the desired temperature.

Plating is necessary for some components, which have, fold marks to give perfect appearance to the cut components. By changing the plate different designs can be embossed on the components.

4. Strap cutting:

Strap for belt production, are cut using strap cutting machine. The machine is fitted with circular disc knife with spacers in between them. The width between knives can be adjusted using suitable spacers.

5. Skiving:

The third unit operation inside cutting room is skiving. The term skiving means decreasing or reducing the substance at the edge of the components of leather mostly at the flesh side. Skiving is synonymous with the turned over edge, folded

edge and budded edge construction work in leather goods technology and this type of construction is mostly practiced as it adds not only elegance at the articles but avoid frying at the edge.

Skiving is an operation that is done either by machine or by hand. Hand skiving is a labor process and needs high skill to be perfect and to acquire uniform skive edge. In other hand it takes more time to produce bulk quantity, today in modern factories skiving operation is done by machine very accurately and at the same time it is useful to increase productivity.

There are three types of skiving, which is commonly used in **Party bag** production.

1. Edge skiving or feather edge skiving:

This is thinning down on the double width of the required edge. By adjusting the pressure foot adjusting screw to required depth of skiving, fine edge skiving is obtained. Fine edge skiving is done in most of the articles.

2. Dart Skiving (Parallel Skiving)

Narrow thinning down some of the thickness of the edge. The substance is removed parallel with uniform thickness. The skiving is continued till the end of the component is reached. Parallel skiving is used in turn over works.

3. Bevel skiving:

Thinning down of variable thickness (thickness from edge to zero). By adjusting the presser foot and the feed roller at the suitable angle, bevel skiving is obtained. This type of skiving is most suitable for wrist watch belt making.

Bench operations /Pre-Assembly and Assembly / Preparation Process:

There are certain operations to be done on the cut component materials before

& during the course of the assembling & these jobs, carried on benches or tables are known as bench operations in leather goods technology. The work carried out on benches (**Party bag**) consists of:

- 1) Marking
- 2) Creasing
- 3) Edge dyeing or staining
- 4) Punching
- 5) Eyeleting
- 6) Cementing
- 7) Edge Folding

In the past, all these operations were done by hand, but now-a-days, machines have replaced the hand labour. These machines are simple presses, either operated by foot or hand. Such machines are known as universal press & the advantages are manifold. Operations done on these machines contribute to:

- 1) Cut the monotony or drudgery of labour
- 2) Assure uniformity of product range
- 3) Least rejection
- 4) Higher productivity
- 5) In-built quality control

Some of the bench operations are described below, in simple manner for easy understanding:

1) Marking:

After receiving each component in bulk quantity in bundled condition by using of marking pattern on each component has been marked for placing reinforcement materials, fixing decoration, lock, buckle, frame and other fittings.

Process control:

1. Choose the right marking pen/pencil.

2. Ensure the proper lighting.

Procedure:

1. Keep the cut components pair wise on the table.
2. Check for color marking.
3. Check the components size with pattern.
 4. Then write job card number, size, pair number (if necessary) on each components and every pieces by silver marker/pencil.
 5. The match marked, pieces are grouped in sized and stored in the plastic covers.

Acceptance criteria:

1. The pair should be matched properly and numbered clearly as per job card.

2) Creasing:

The creasing operation consists of lines with a heated iron & is used in both cut edge & turned over edge construction. Creasing helps in compressing the fibres at the edges & thus strength the edge. Incidentally it gives also a decorative & aesthetic appearance. There are many varieties of creasing irons, used depending upon the work on hand. There is single line creaser, double line creaser, some with adjustable guides etc. Care is taken to see that the working or ironing edges of all creasers must be smoothly finished avoid scratching during creasing operation & the forepart & heel is slightly rounded off. Some of the points to be noted while creasing are:

- a) The creasing line is close to the edge say 1/16" within the edge &
- b) The line marked should be distinct & of polished appearance
- c) For this, the iron is heated to the correct temperature.
- d) The straight line must be creased first and then followed by concave or convex lines.

3) Edge dyeing:

In order to give bright appearance to the edges of the shoulder bag, staining or

dyeing of edges is done. The coloring is normally done by applying the dye with a wooden split with a piece of sponge, cloth or cotton can also be used, but is care taken to see that the felt or the sponge is not loaded too much with dye solution as otherwise it will run over the edge & spoil the flat leather surface. Edge dyeing by hand is never done on cut components on a single piece basis at a time, as it is a time wasting exercise. A group or bundle of cut components is taken at a time & one stroke, all the edges are stained. When the fibres are found to be a little coarse along the edges, a thin wax coat is applied before polishing with a cloth. A mixture of carnauba wax & bee wax is ideal for this purpose. When the leather is very fibrous & fray at the edges, coloring is difficult & to overcome this difficulty, a mixture of paste & stain is used & this makes fibers adhere together.

In the case of bulk production, edge staining is done on machine called 'edge stainer'.

4) Punching:

Punching is the process of making hole in leather component using asset of a hole punches for various size of holes needed for fixing of buckles, locks, decoration, eyeleting and any other accessories and fittings.

Mostly punching is done in the stage of preparation, but it can also do at the stage of assembling. In bulk production punching has been done in machine.

In the preparation (Pre Assembly), after creasing and punching operation is finished leather components are attached with reinforcement materials depending on the design to be done.

First, if it has any reinforce material on the design, we have to attach reinforce materials with foam (to get spongy and comfort feel) by applying adhesive gently.

4) Eyeletting:

The eyeletting operation consists of first punching a hole in the leather by means of a punch and mallet and inserting the eyelet in the hole and than with the aid of a small gadget (rod with around nipple at the end) the free end of the eyelet is

uniformly spread out along the perimeter of the hole. The spread out tiny metal corners bind themselves firmly into the flesh side of the leather. Now a day, eyeleting is done fast by an automatic machine.

5) Cementing:

Cementing is an important operation the manufacture of shoulder bag as at this stage only, the different components of leather and reinforcements are joined together by means of application of an adhesive and on the strength of the joints depend the very existence or in other words, the retention of the shape of the article, For further strengthening, the joined parts are invariably stitched.

Cement or adhesive used in the fabrication of Party bag of two type's i.e.

a) Temporary adhesive

When stitching does the final assembly, temporary adhesive is just hold the various parts - temporarily.

b) Permanent adhesive

Where stitch is not possible/ not used for decoration there should be used permanent adhesive.

Rubber in the form of rubber solution, (rubber dissolve in petrol) in the form of natural latex or in some other water based emulsion systems is used generally. It is applied on both sides and after allowing drying a little to have a dry tack, the surfaces are struck or hammered together lightly. These adhesive are applied by means of brush. Just like edge dyeing, when a series of edges of a number of Articles have to be cemented, they are arranged in a row so that the edge of the one component lies next to the edge of the others and so on arranged on the bench. The brush with the cement is then used to coat al the edges in one operation and the stack passed on to the next table where another side of the stacked edges will be given the coating of adhesive. Thus in one or to operations, we are to able cover edges of say twp or three dozen articles at a time, thereby cutting down the time factor.

Process control:

1. The brush should be clean.
2. Ensure that the bowl is clean without any contaminants.

Procedure:

1. Choose the right brush and adhesive.
2. Apply adhesive at the marked places of both components to be attached.
3. Apply adhesive fully on the leather boards and upper area to be attached (in case of leather board).
4. attached the components together.
5. Check for proper attaching.
6. Hammer the attached portion well.

Acceptance criteria:

1. Apply the adhesive evenly.
2. Component should be attached perfectly to the marking.

6) Edge Folding:

Folding is one of the operations that come across frequently in the course of fabrication of shoulder bag. It is simply an operation or devise of folding the edge of the leather uniformly along the edges to a pre-determined width either in straight line or in curves. The folding is done to improve overall appearance of the product.

Fixing of accessories and fittings:

Fixing of locks, decorations and other fittings is done manually or by machine. Fixing operation is done with two types of tolls one with hollow dip at one side and the other with ting protruding nipple at the end. When fixing the decoration, care is taken to hammer the accessories and fittings as heavy hammering may damage the

lock, decoration, etc.

c) Assembling:

After pre-assembling (preparation) process is done, the next step is assembling various individual to get structure of articles. To assemble this component before cementing of edges that are folded at the stage of preparation, a grain part of fold edge are properly scratched to ensure bonding strength of adhesive and then is applied adhesives gently. Applying of adhesive on unnecessary part of component affects cost, time and quality of production. After a while component affects cost, time and quality of production. After a while components stack together and hammered gently and transferred to stitching operation.

Stitching:

Stitching is the most important operation that decides the quality of the end products. So, stitching is tested on a waste piece of leather before stitching on the product. Basically in shoulder bag production **Flat bed, Post bed and Cylinder bed** sewing machine is used.

To stitch this type of heavy goods, we have to use **Heavy duty machines**.

Flat bed sewing machines are provided with two needles to make two parallel lock stitch seams and also, flat bed machine is provided with a zigzag stitching operation for decoration.

Stitching length- 3 st/c.m

Stitch gauge - 3m.m from the edge.

D) Finishing and Packing

Thread Burning

After stitching, the articles are checked carefully. Excess thread is removed either by trimming with a scissor or soldering in case of nylon thread. Thread burning is done carefully in case the soldering stick damages the stitch of the articles.

Trimming

At the stage of finishing some product, which is produced by fold, edge construction and binding edge construction may have excess material (leather) on the edge of articles. In this case edge trimming is done by using sharp knives. Highly skilled persons should do trimming in case it damages the whole product become waste.

Coloring

Trimmed edges and any part of articles that needs color are colored by hand or edge coloring machine. As mentioned in pre-assembly stage, coloring is done carefully and after coloring excess paints are cleaned immediately.

Creasing

Creasing operation is applied in shoulder bag for decoration. This operation is done by hand or in case of bulk production it has to be done by universal stamping (creasing) machine.

Final Inspection

Before the articles are sent to packing, strict quality control is observed for perfection in assembling, stitching, accurate and smooth functioning of fittings. Strict quality control mechanism is observed from the beginning to the end at every stage of operation for producing high quality product.

Packing

Shoulder bag items, which can be damaged, molded or chapped, must therefore be packed carefully and securely.

Points To Be Considering While Packing

- Do not fill the boxes just with the product, but pack a number of similar items in smaller box, or use some cardboard layers.

- Carefully indicate which products and in which quality is packed in each box, so that it won't be a mystery to the importer.

- Before packing, products should be protected by plastic bags in order to avoid damage from rain or moisture.

- Each box should have a packing list, which gives a specification of all products in terms of quality, type color, etc.....

2.2) Raw materials used in Party bag production:

* Leather

* Artificial leather (poromerics)

* Synthetic materials (PVC, PU)

* Plastics

* Metals

Comparison between Leather & another material as Party bag:

- Leather is a natural product. Its physical & chemical properties are similar to the human skin. So, it is more suitable than any other materials as wrist watch belt.

- The tensile strength of leather is higher than most other materials of Party bag.

- Leather has various types of decorative grain surface which may improve the quality of Party bag.

- The physical properties of leather like- softness, hardness, flexibility, etc can be easily changed by different types of tanning process.

- Leather is more expensive than most other materials used as Party bag.

Properties of leather used as Party bag:

- For Party bag, leather should have a high tensile strength.

- It should be also flexible, pliable, and non-cracky.

- It should have high resistance to abrasion so that it does not wear out easily as a result of friction.
- It should be non-stretchy, tough and yet with enough elasticity.
- The raw materials should be full & plummy, free from flay cuts, brand marks, scratches & warble holes.
- It should have sufficient dry and wet rub fastness
- It should have reasonable perspiration resistance.
- It should have the properties of resist from water.
- It should be light weight.

Unit Operations

Manufacturing of leather goods consists of a multitude of different operations. Some of them essential for all types of goods and some may be skipped, depending on the design and method of constructions.

The essential operations are:

1. Sorting
2. Cutting or clicking
3. Splitting
4. Skiving
5. Sewing

Other supplementary operations are:

1. Creasing
2. Staining (Coloring)
3. Cementing
4. Folding
5. Embossing
6. Stamping

7. Punching
8. Eyeleting
9. Buttoning
10. Reverting etc.

Definition:

Party bags are the most fashionable and comfortable bags or purses made of leather especially used by women of upper class to go to a fun party, or to an evening party or any other parties. Actually it is a symbol of, pride, status and satisfaction. So that it is made from leather. Different designs and quality leather may be applied for the thrust of the customers. These bags are always demanding to glide with the modern culture.

Some explanations of the Party bag

Glamorizing the overall persona of ladies, hand bags suit well with western outfits. Flower, leaf, animal and cartoon characters can be the theme of the ladies hand bags. Embroidery, print and bead work enhance their appeal to a large extent. The Manufacturers offer ladies leather bags, fashion beaded bags, ladies beaded bags, leather beaded bag, beaded leather bag, embroidered beaded bags, beaded embroidered bags and many more.

Whether you are homemaker or working woman, fascinating array of leather bags will certainly steal your heart at first glance. Shape and designs of the leather bags are so alluring, that they draw the eyes of everyone spontaneously. Meticulously used colors exhibit the designers' high creative sense. Pure and top quality leather provides them optimum durability. Come ahead, choose and make non owners feel envy by showcasing these bags.

Designer handbags can be used for various occasions such as **dinner party**, **evening party**, fun time party, **home** satisfaction and lots more. There are handbags for different purposes in the market that you can avail. With technological advancement, people love to set fashion statement in all spheres of life. Hence, whatever be the purpose of handbags, demand for fashionable handbags of different usage categories is making increasing rapidly and fast.

The leather handbags make fabulous style statement with its fascinating hues, designs and graceful pattern. Not only for personal belonging, has beautiful leather handbag made a perfect gift to be given to near and dear ones.

The [handbags](#) made of leather are quite popular amongst the women. There are a wide variety of handbags available in the market these days. A number of retailers and [fashion designers](#) bring upon the new collections of designer bags that are really classic in looks and design. Most of the people admire [leather bags](#) due to their subtle sheen and wonderful looks. These bags are appropriate for everybody and specially women. People can use these elegant handbags for their offices, parties and

even shopping; since these bags look amazingly great; they add glamour and style to a woman's personality.

Bags are available in a number of colors and style. You can have amazing designs and great variety in these leather handbags. Based on your needs and preferences you can select different styles of bags. For traveling purposes stylish yet spacious bags are favorable however for party or formal celebrations elite and designer purses are appropriate. The leather purses look really elegant and absolutely incredible. They exude a sheer sense of style and class. You can create great impression with the stylish bags and win hearts of the people around you.

Demand in Market:

The handbags made of leather are quite popular amongst the women. There are a wide variety of handbags available in the market these days. A number of fashion designers bring upon the new collections of designer bags. Most of the people admire leather bags due to their fine shine and wonderful looks. These bags are appropriate for everybody and specially women. People can use these elegant handbags for their offices, parties and even shopping; since these bags look amazingly great; they add glamour and style to a woman's personality.

The Ladies handbags are ideal for even a professional woman who should look extremely sophisticated and niche, stylish & trendy in parties and even a highly job work. These bags have ruled the fashion world with their impeccable looks, no other material like jute, plastic, rayon or cloth can replace the magic and grandeur of the leather bags. They look immensely stylish and classy.

However with elegant leather bag you would never face the problem of appear outdated as they are timeless and would always help you make the perfect style statement.

These leather bags are available in a number of colors and style. You can have amazing designs and great variety in these leather handbags. Based on your

needs and preferences you can select different styles of bags. For traveling purposes stylish yet spacious bags are favorable however for party or formal celebrations elite and designer purses are appropriate. The leather purses look really elegant and absolutely incredible. They exude a sheer sense of style and class. You can create great impression with the stylish bags and win hearts of the people around you. The Demand of the party bags is increasing cause of the various quality leather is produced. If the designs and styles will transform repeated in order, the demand will raise apart.

Some Fashionable Leather Party Bags:







Reference Picture of the Party Bag





Figure : Ladies Party Bag With Ornamentation.

Perspective PhotoGraphs:



Figure: Outer Top Front view

Figure: Outer Top Back view

List of Components

I) Outer-Leather

Serial no.	Component	Exact size in cm	Folding allowance	No of pieces
01	Outer top front	24.2 x 16.5	10mm-all side	01
02	Outer top back	24.2 x 16.5	10mm-all side	01
03	Bottom gusset	23 x 17.1	10mm-all side	02
04	Trimming part	34.5 x 5	10mm-all side	02
05	Facing	41.2 x 8.2	10mm-all side	02
06	Handle	48.6 x 3.5		02

07	Handle loop facing	10 x3.5		04
08	Loop	9x2.8		04

II) Lining-Concod:

Serial no.	Component	Exact size in cm	No of pieces
01	Body	42 x 19.4	02
02	Back zipper pocket	36 x21	01

III) Other materials- (EVA sheet)

Serial no.	Component	Exact size in cm	No of pieces
01	Front & back Outer top	23.6 x 15.5	02
02	Gusset	45 x 16.6	01

IV) Other materials- Rabush

Serial no.	Component	Exact size in cm	No of pieces
01	Facing	21 x 4.4	02
02	Handle Loop	10 x 3.5	04
03	Loop (body)	9 x 2.8	04

IV)Other materials

Serial no.	Component	No of pieces
01	O - ring	04
02	Rivet	10
03	Zipper (size-5)	01
04	Zipper (size-3)	01
05	Runner	01
06	Stone	25
07	Pipe	01

Raw material:

Leather material : Metallic finished leather.

Substance : .45mm.

Color : Silver Golden color.

Lining material : Concod.

Lining color : Red brown.

Tools:

- 1) Designing knife.
- 2) Scale.
- 3) Measuring tape.
- 4) Awl.
- 5) Cutting knife.
- 6) Thickness gauge.
- 7) Scissor.
- 8) Creasing tools.

Machines & Equipments:

1. Skiving Machine.
- 2 Punching Machine
- 3 Flat bed sewing machines.
- 4 Cylinder bed sewing machines.
- 5 Post bed sewing machines.
- 6 Thread (15, Z twist).
- 7 Adhesive (Latex, Rubber solution).
- 8 Needle (60, 80/20, 134/LR, 110; 18NM)

Manufacturing of Party Bag:

Pattern Classification of leather

1. Outer top and back

Add folding allowance of 0.8 mm and 0.6 mm on three sides of leather.

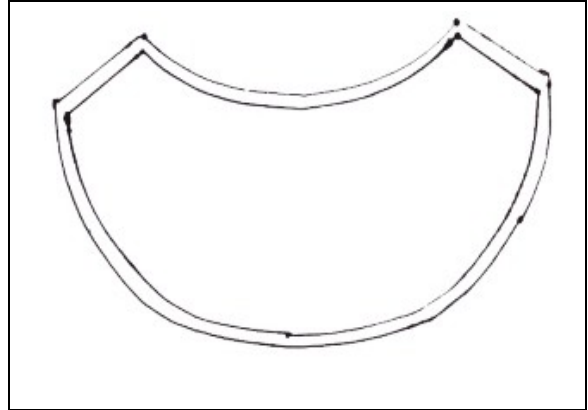
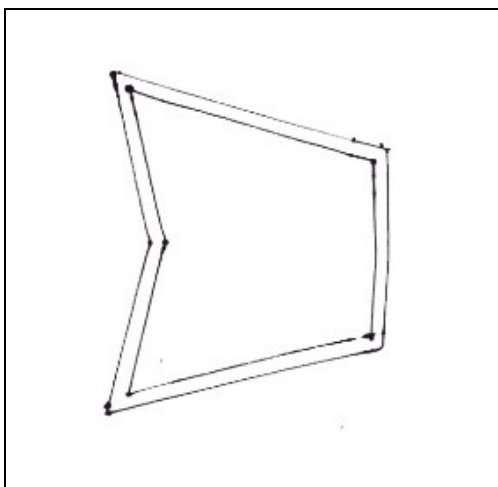


Fig : Outer top and back

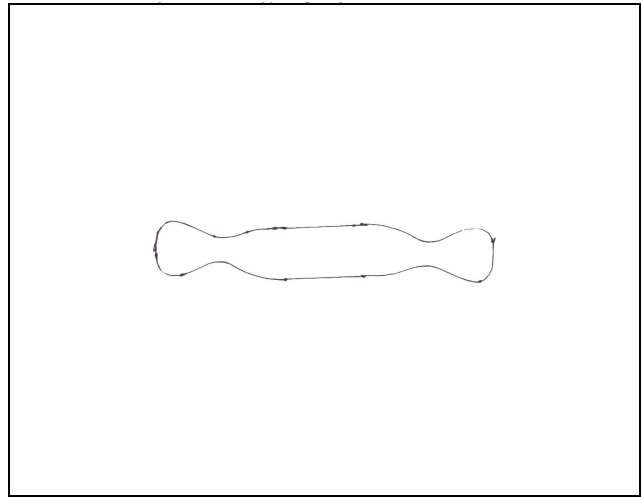


2. Gusset

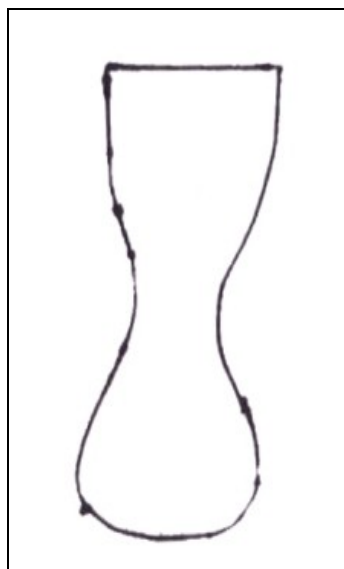
Add folding allowance of 0.8 mm on top and bottom and 0.6 mm on two sides

3. Handle

There is no seam allowance i.e. net pattern



:



4. Handle facing

There is no seam allowance i.e. net pattern

5. Loop

There is no seam allowance i.e. net Pattern

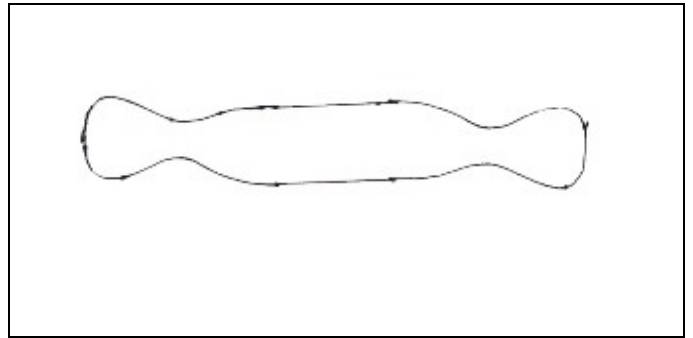


Fig: Loop

6. Trimming part



Fig; trimming part

7. Facing Part

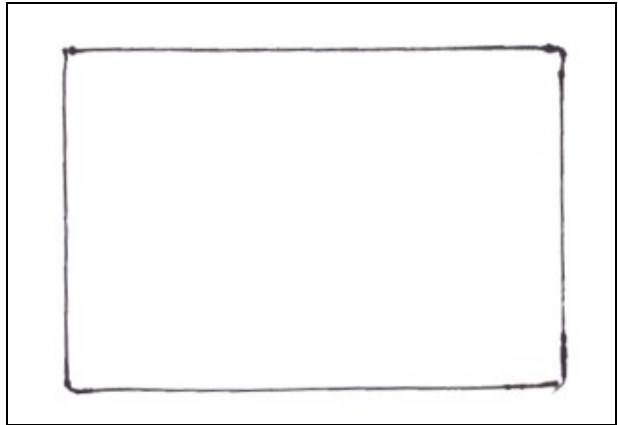


Fig: facing part

Pattern classification of Lining Leather

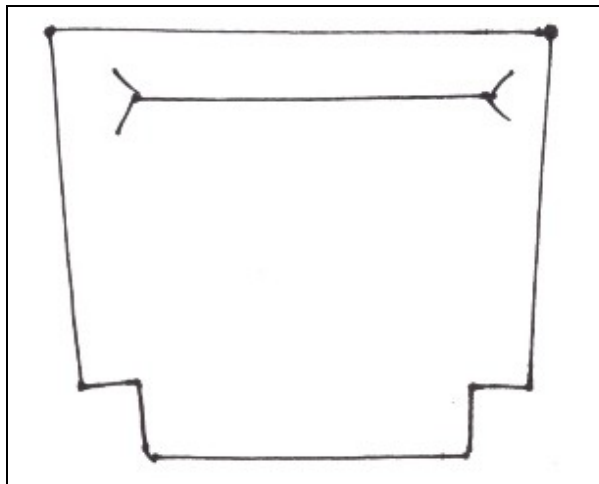
1. Back side Outer pocket

Add seam allowance of 1 mm all around the Pattern.



2. Body Lining

Add seam allowance of 1 cm all around the pattern



Pattern classification of Reinforcement

EVA

Outer top and back
Reduce of 0.8 mm on from all around
the Master Pattern

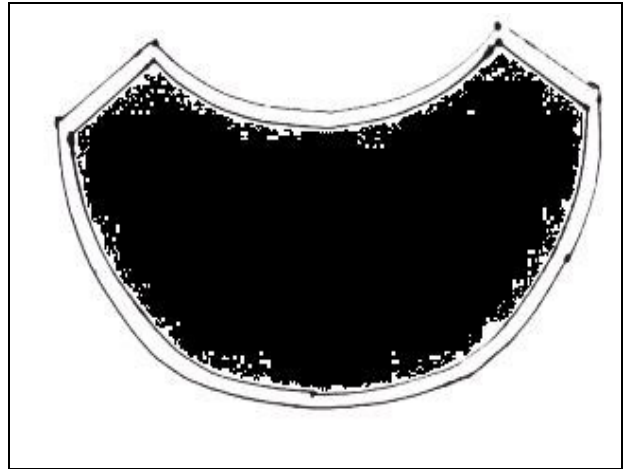
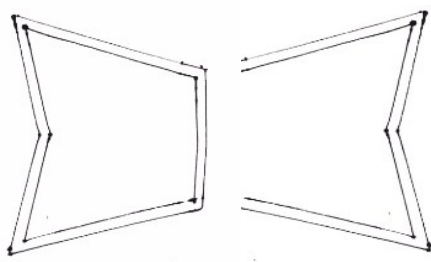


Fig: Outer top and back
(Reinforcement)



Gusset
Reduce of 0.8 mm on from all around
the Master Pattern

Fig: Gusset (Reinforcement)

Rabush

Handle Facing: Net pattern

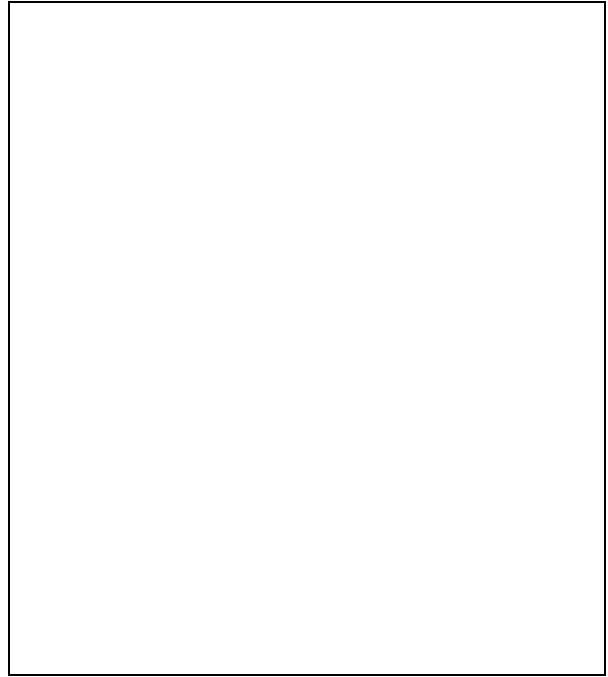


Fig : Handle Facing (Reinforcement)



Loop: Net pattern

Fig : Loop (Reinforcement)

Facing
Reduce 0.8 mm from the master
Pattern.

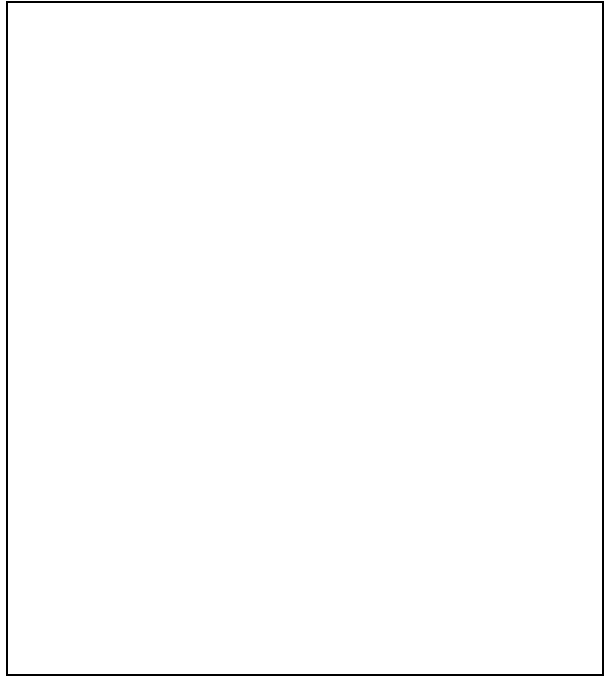


Fig: Facing (Reinforcement)

Specification sheet

i. Outer materials:

Component	Materials	Thickness	Color	Tanning	Origin	Type
Outer top	Leather	0.45 mm	Golden	Full chrome	Goat	Goods leather
Outer back	"	"	"	"	"	"
Gusset	"	"	"	"	"	"
Trimming Part	"	"	"	"	"	"
Facing	"	"	"	"	"	"
Handle	"	"	"	"	"	"
Handle loop Facing	"	"	"	"	"	"
Body loop	"	"	"	"	"	"

ii. Lining materials:

Component	Materials	Thickness	Color	Type
Body	Cloth	0.5 mm	Red brown	Concod
Back Zipper Pocket	"	"	"	"

Note: Soft light weight, sufficient durability, uniformity of substances.

iii. Thread specification:

Thread	Type	Thread No.	Ply	Color
Top	100% spun polyester	15	3	Pink
Bottom	"	"	"	"

Note: Extensibility, sew ability, durable

iv. Needle specification:

Size	System	Point	Shank diameter
------	--------	-------	----------------

18 mm	134	LR	2 mm
-------	-----	----	------

Note: Durability, adequate strength, heat resistance, abrasion resistance

v. Stitch specification:

Types of stitch	Stitch distance	Stitch gauge
Lock stitch	3 stitches per cm	2.5 mm from the edge

Note: Decoration, joining, reinforcing

vi. Zipper specification:

Types of zipper	Brand	Size
Plastic	-	3 ; 5

vii. Adhesive:

Types of adhesive	Brand
Solvent based	Swan

viii. Quality specification:

- ❖ Edge stitching not to more than 2.5 mm from the edge.
- ❖ No missed stitches acceptable.
- ❖ No access thread loop acceptable.
- ❖ No dirty upper acceptable.
- ❖ Use rubber solution for lining fitting with outer materials.

Skiving Instructions

Serial No	Component	Sides to be Skived	Width	Thickness	Types of Skiving
1	Outer top	All sides	11 mm	0.5	Parallel

2	Outer back	All sides	11 mm	0.5	Parallel
3	Gusset	All sides	11 mm	0.5	Parallel
4	Trimming part	3 sides except bottom	11 mm	0.5	Parallel
5	Facing	Bottom	11 mm	0.5	Parallel

Making / Construction:

Making/construction

Cut all the components –outer leather, lining and reinforcement as per cutting patterns.

Assembling and stitching:

a) **Outer top front preparation:**

By keeping the working patterns trace the outline on the flesh side of the outer top front. Cut one piece of EVA sheet 1 mm shorter than working pattern. Apply adhesive on the edge EVA sheet and on the four sides of the outer top front inside the trace. Then attach the EVA with the front. Finally mark on the front for attaching loop.

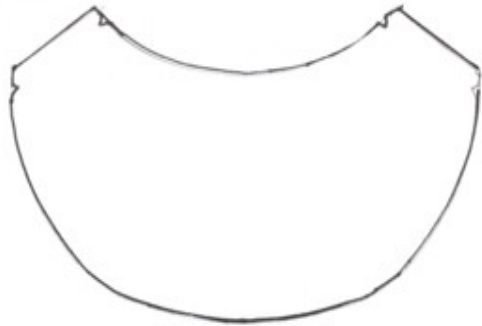


Figure: outer top

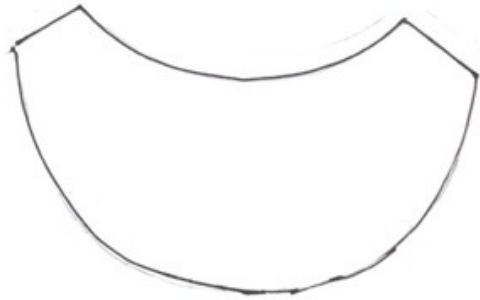


Figure: EVA

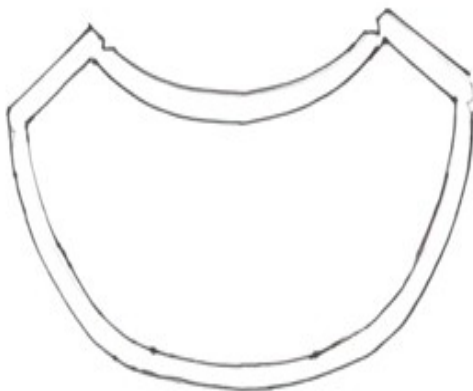


Figure: EVA on outer top

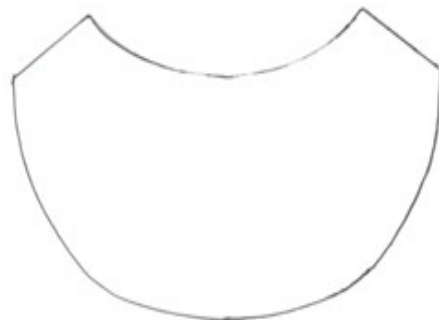
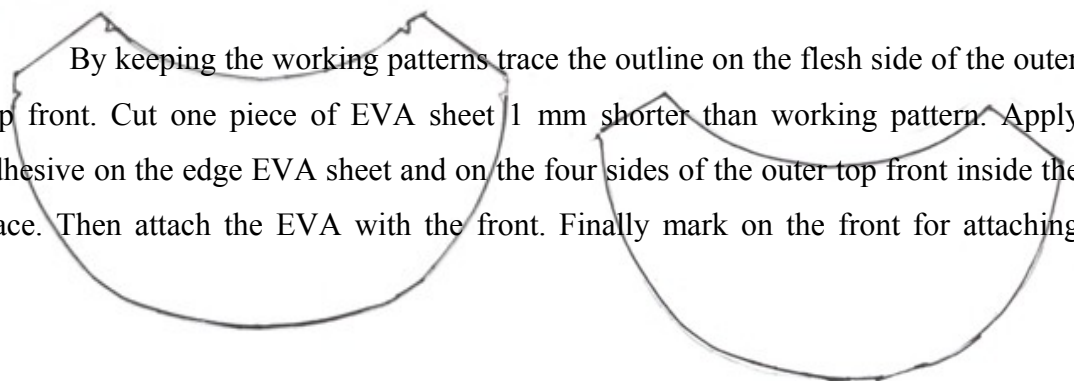


Figure: Completed outer top

b) Outer top back preparation:

By keeping the working patterns trace the outline on the flesh side of the outer top front. Cut one piece of EVA sheet 1 mm shorter than working pattern. Apply adhesive on the edge EVA sheet and on the four sides of the outer top front inside the trace. Then attach the EVA with the front. Finally mark on the front for attaching



loop.

Figure: outer top

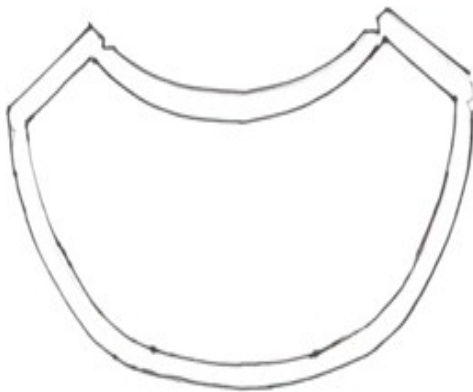


Figure: EVA

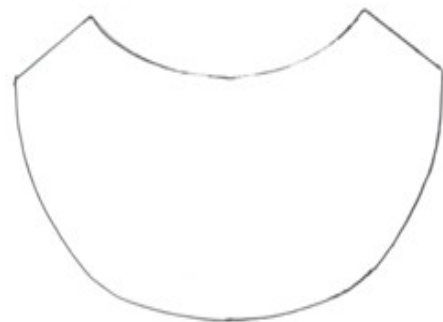
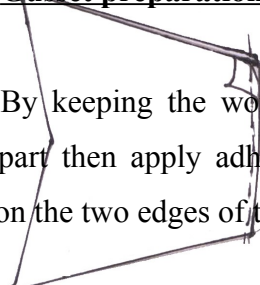


Figure: EVA on outer top

Figure: Completed outer top

c) Gusset preparation:

By keeping the working patterns trace the outline on the flesh side of the gusset part then apply adhesive to all side according to the mark. Then stitch the piping on the two edges of the Gusset.



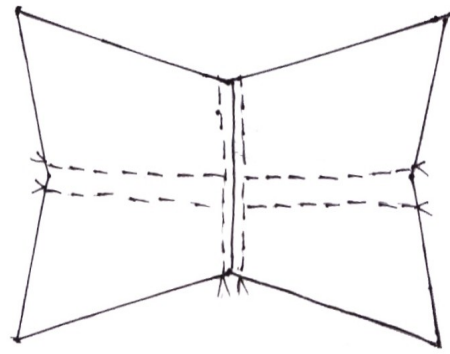


Figure: Joining 2 parts Face to face

Figure: top stitch 2 mm& 5mm on the middle part of the gusset.

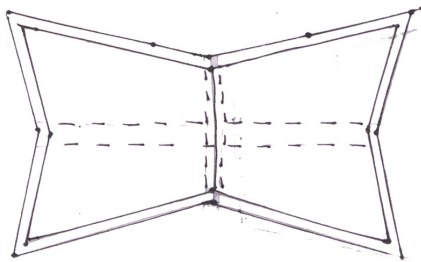


Figure: Attach EVA sheet on wrong side

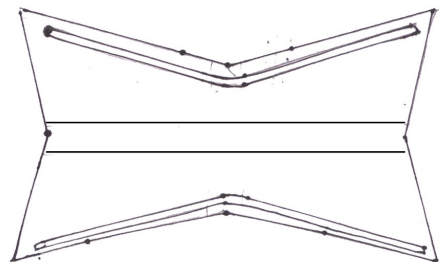


Figure: piping preparation

d) Handle preparation:

Cut the Handle according to the length. Attach a Running O-ring in the Two ends and join with rivets. Then edge of the handles is colored.

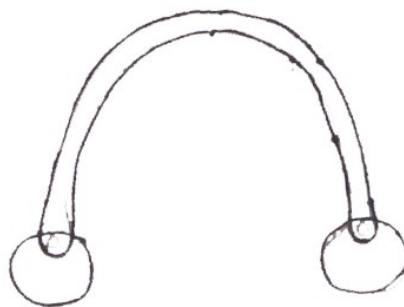


Figure : Handle preparation

e) **Joining loop with the Body:**

Mark the loop on the outer front and back. The loop is colored first and then attached the loop on the front and back applying adhesive and stitching.

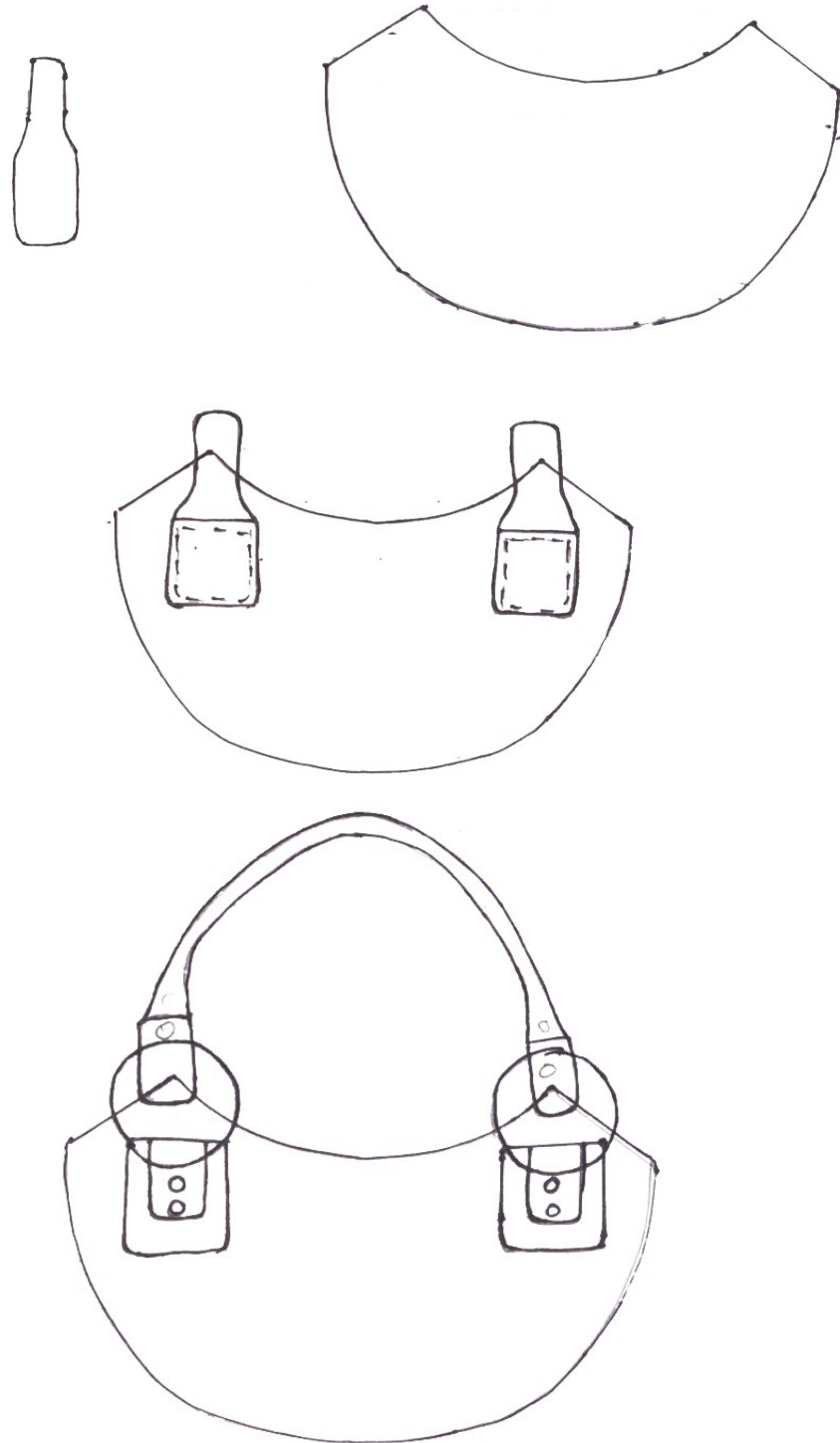


Figure: Joining loop with the Body

f) Assemble of gusset with the outer top and back part:

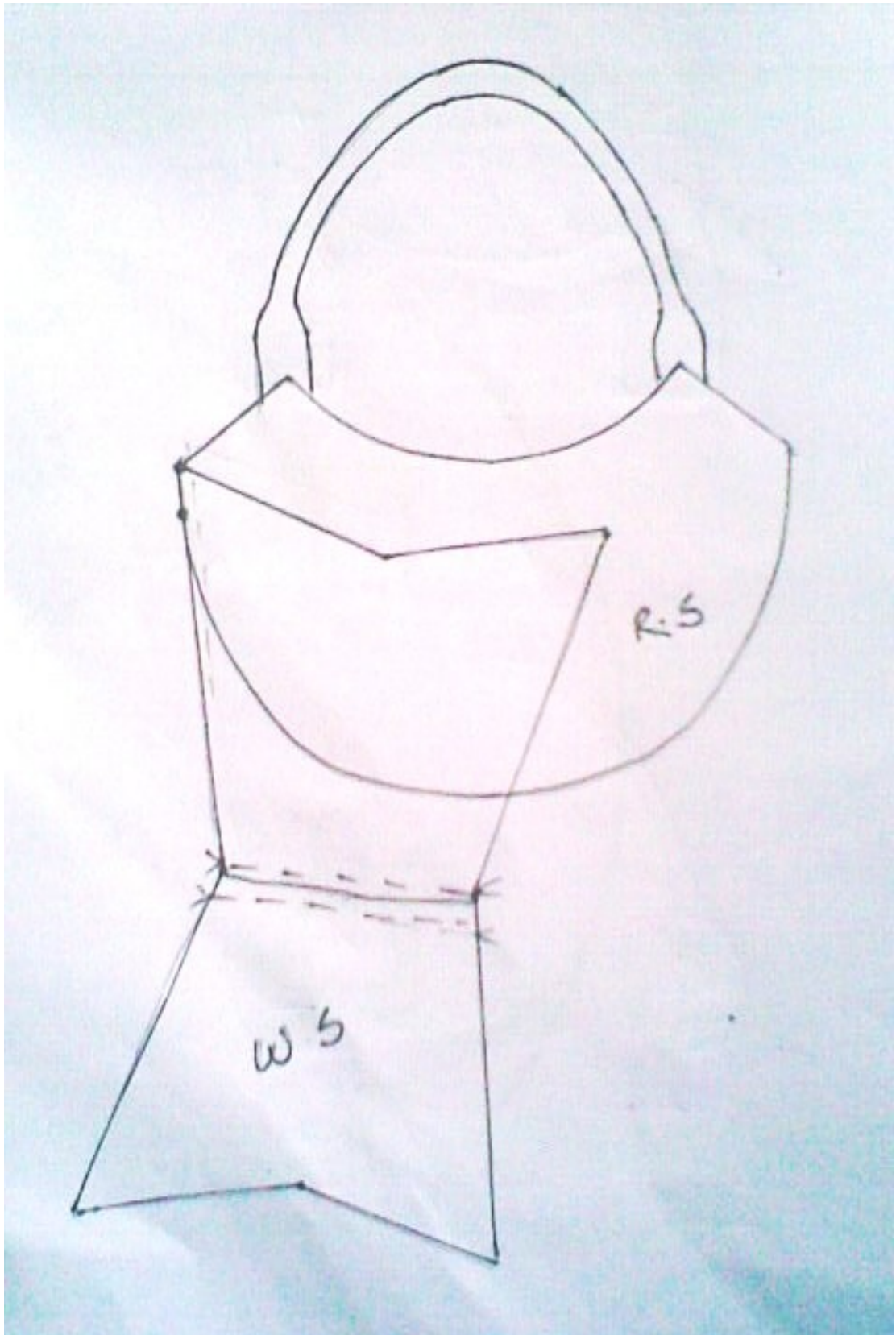


Figure: Assemble of gusset with the outer top and back part

g) **Lining preparation:**

At first prepare the back inside pocket. Then fold the topside of lining and trimming part. Join the Trimming part with the effacing of the bag. Finally stitch the Sides of the lining to make a bag.

h) **Assemble the lining bag with the leather body:**

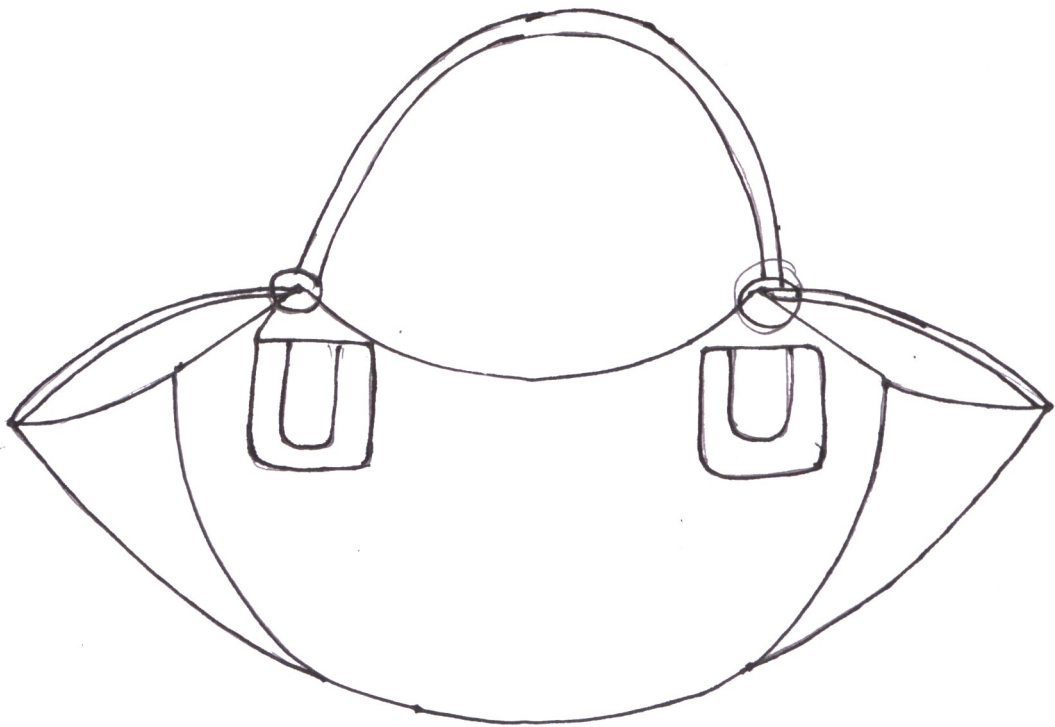


Figure: Complete Leather party bag

