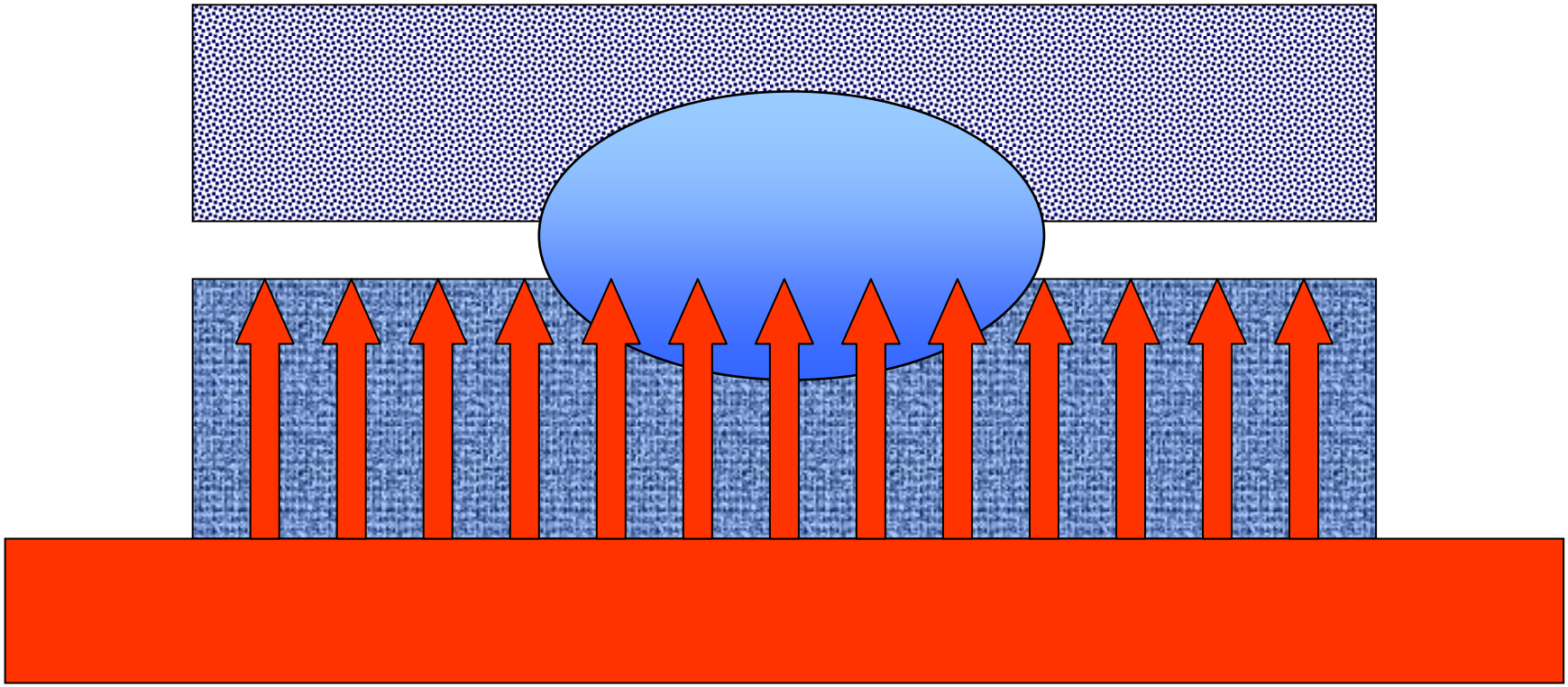
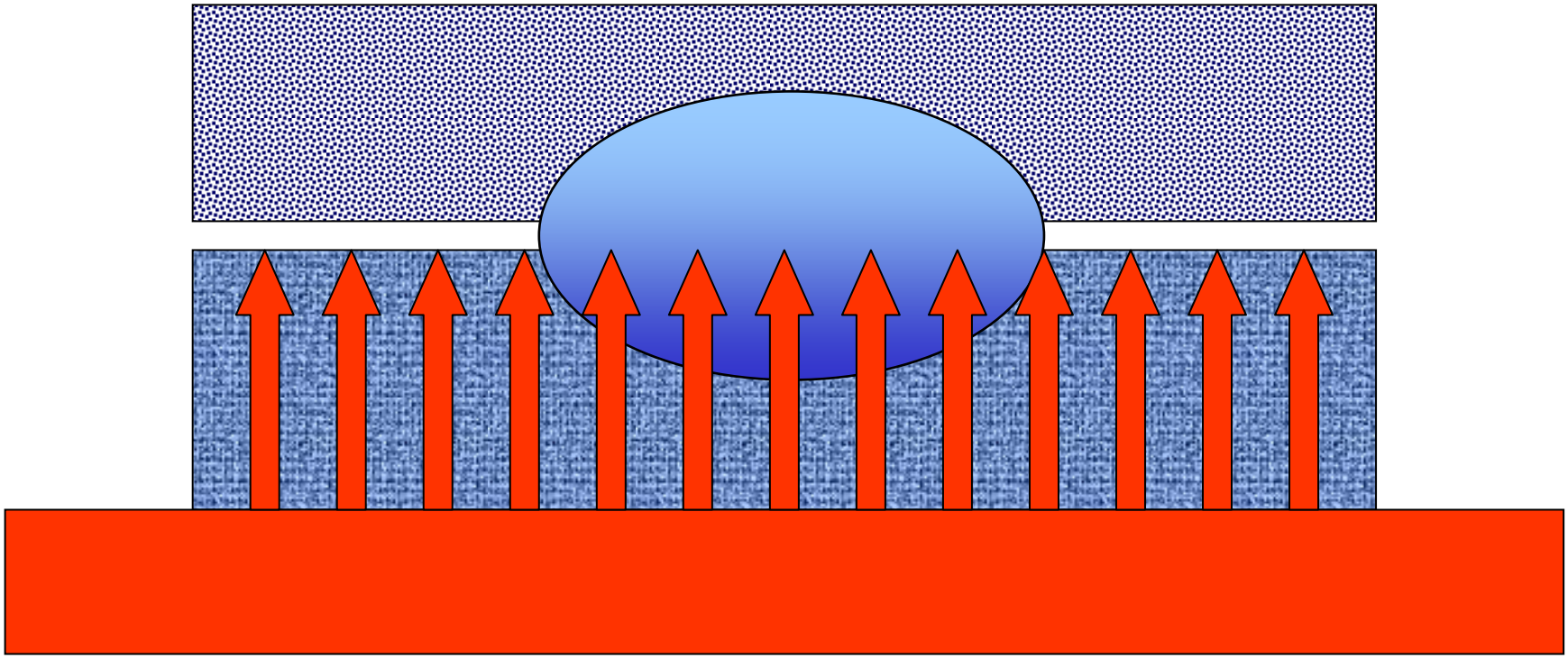
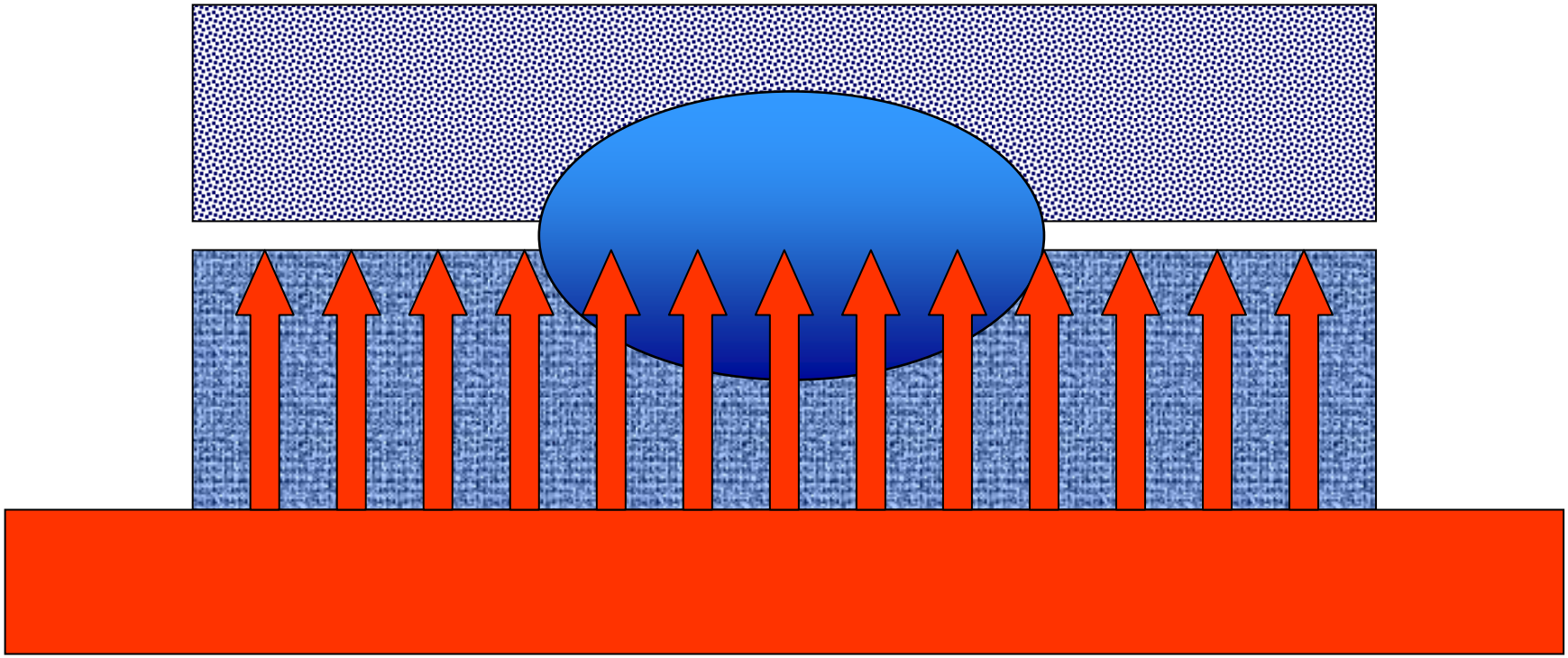
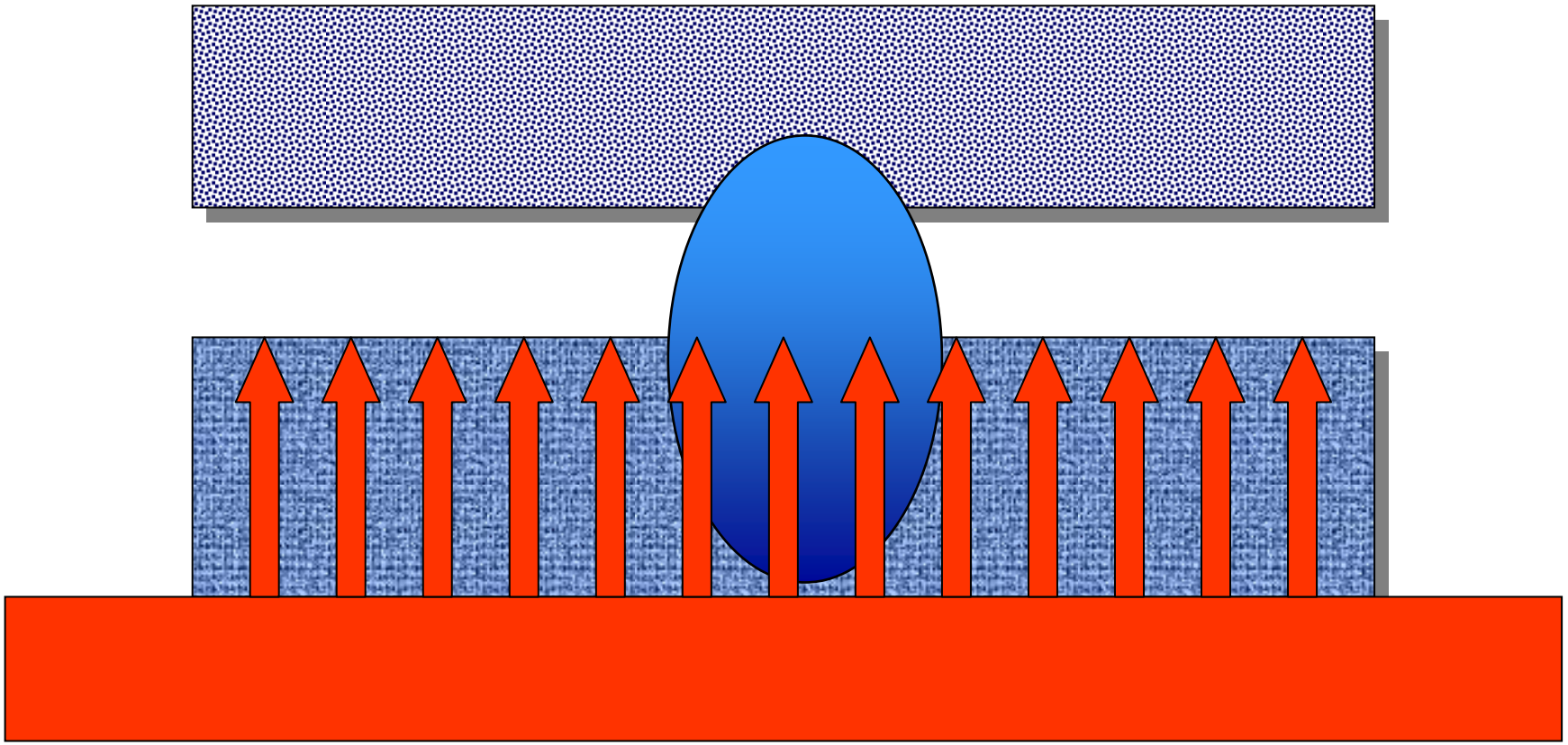
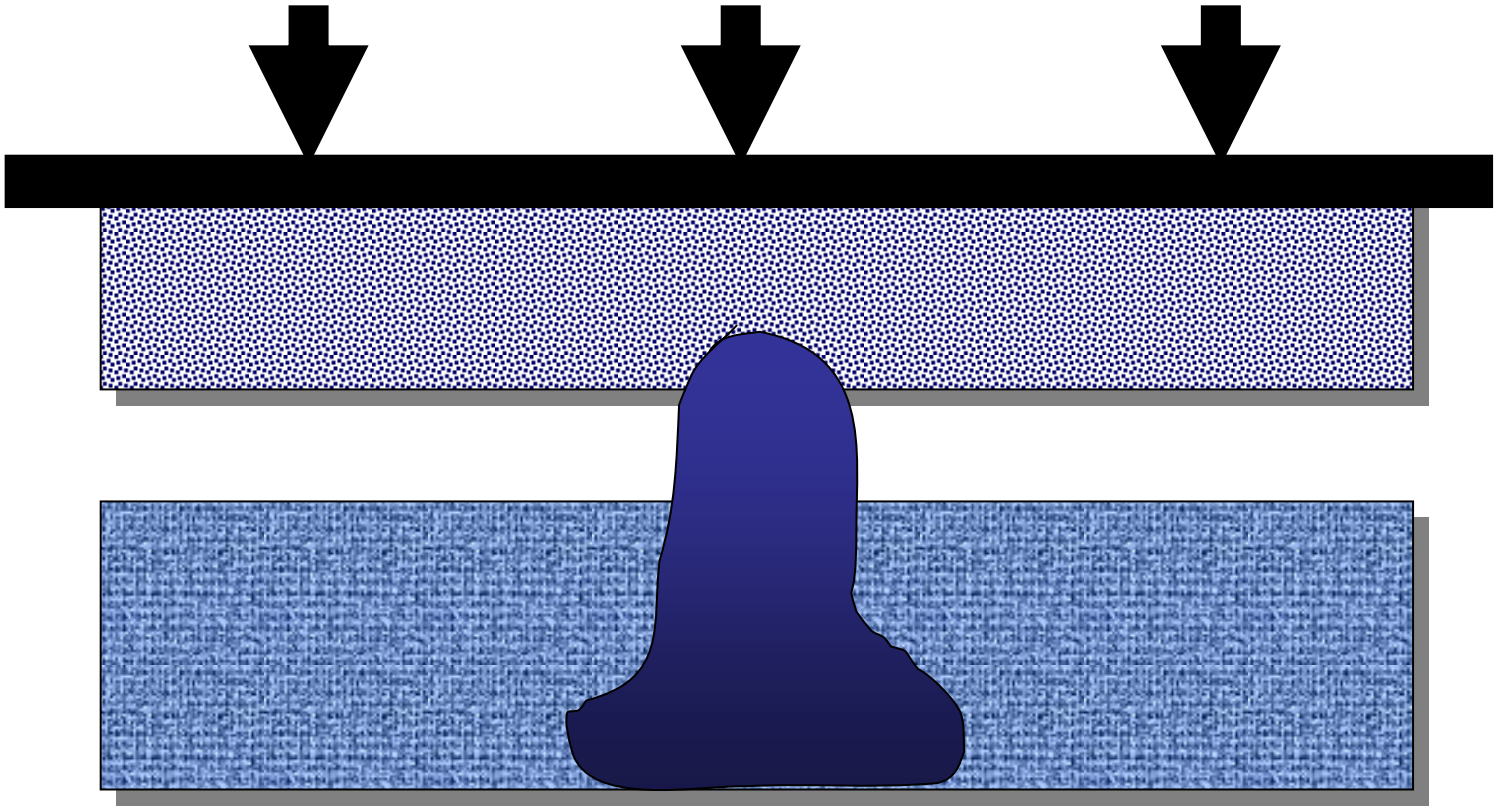


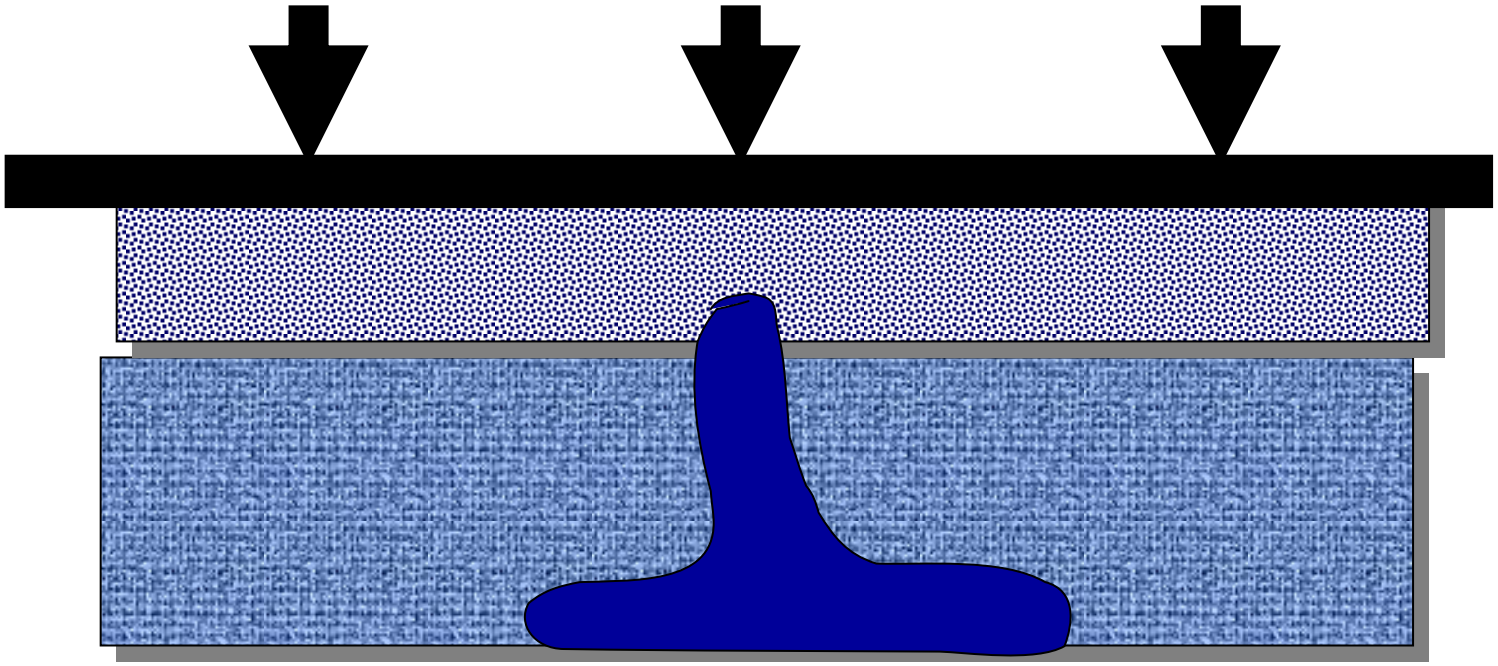


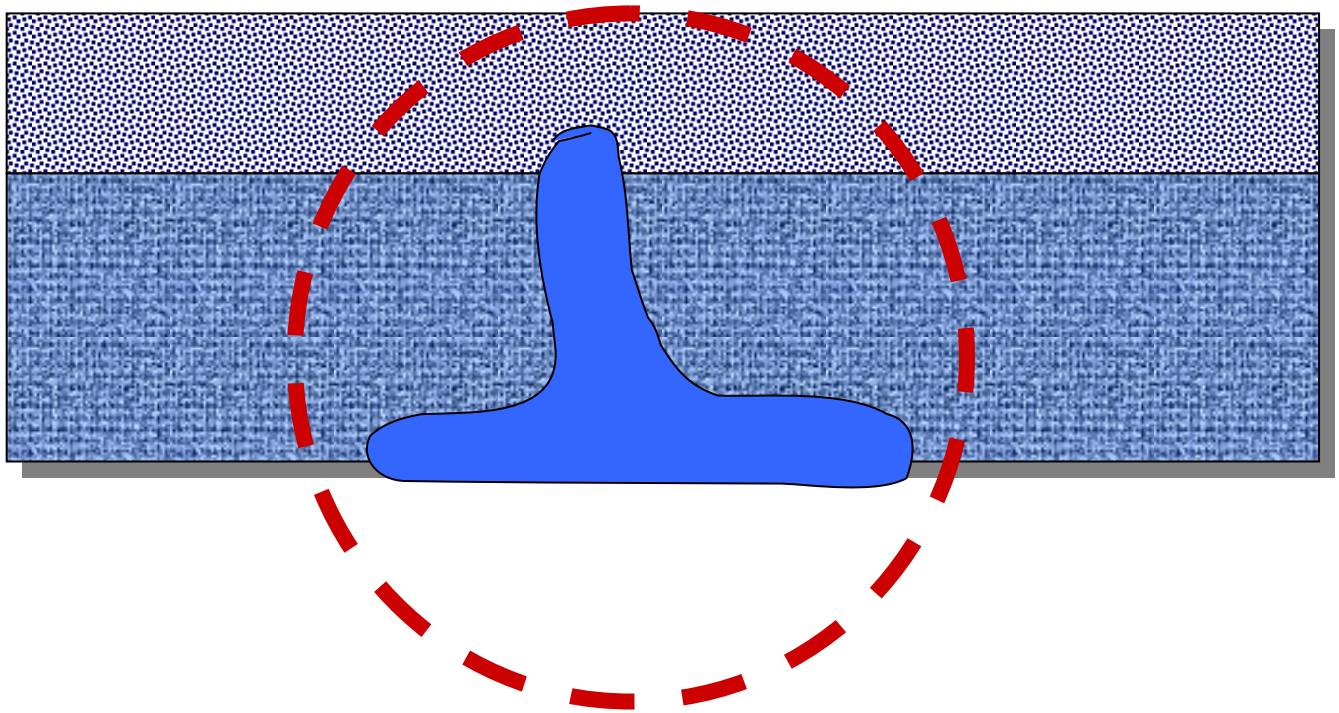


Strike Through

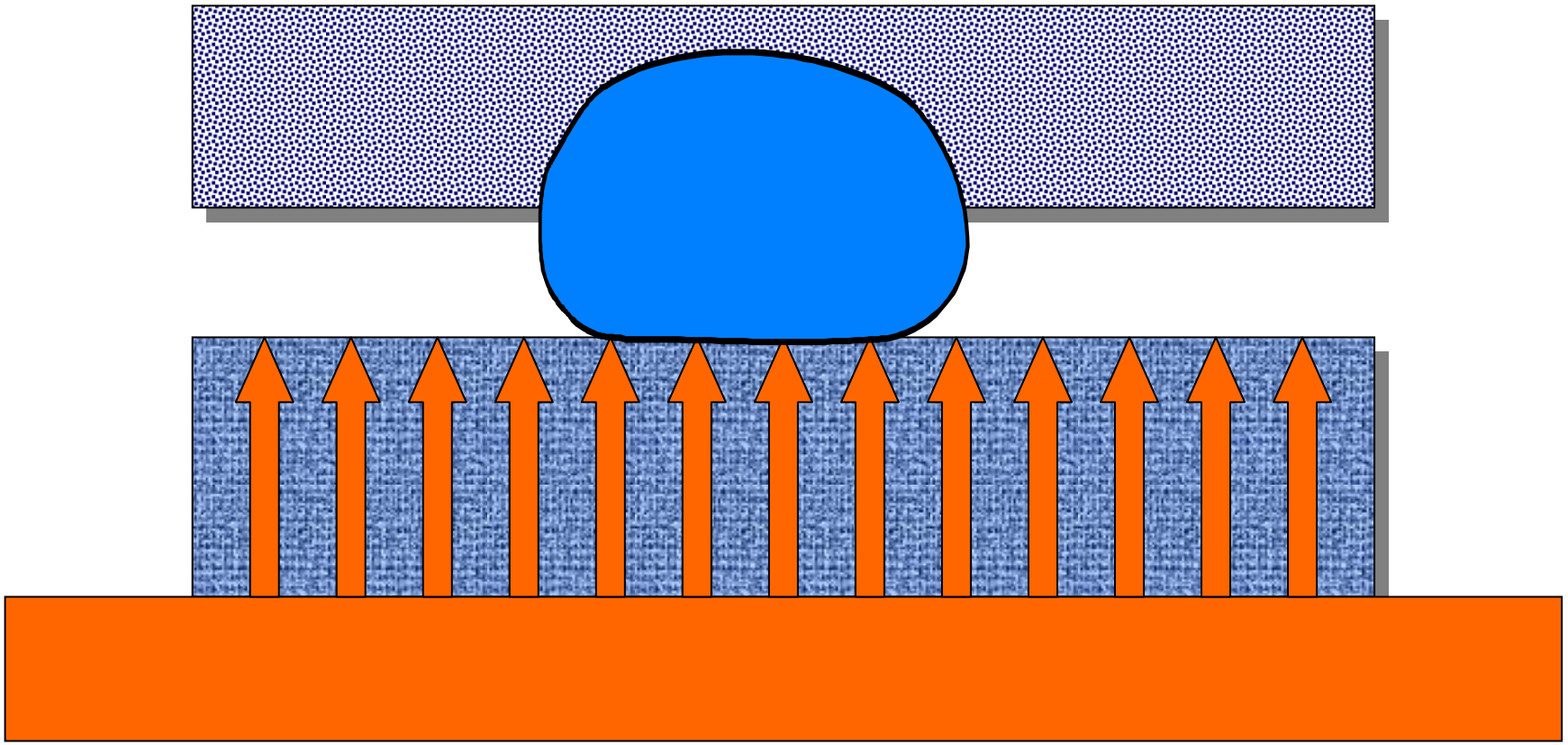


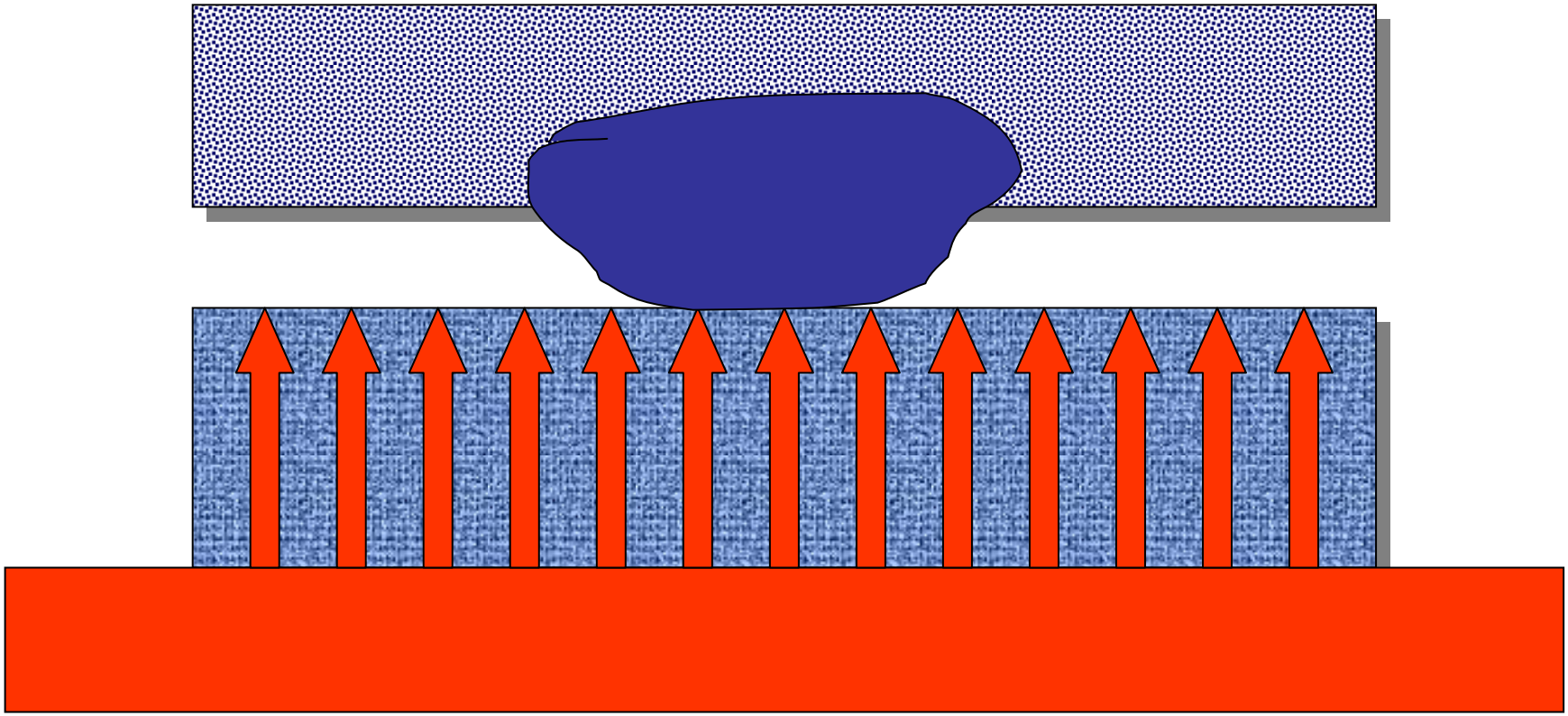


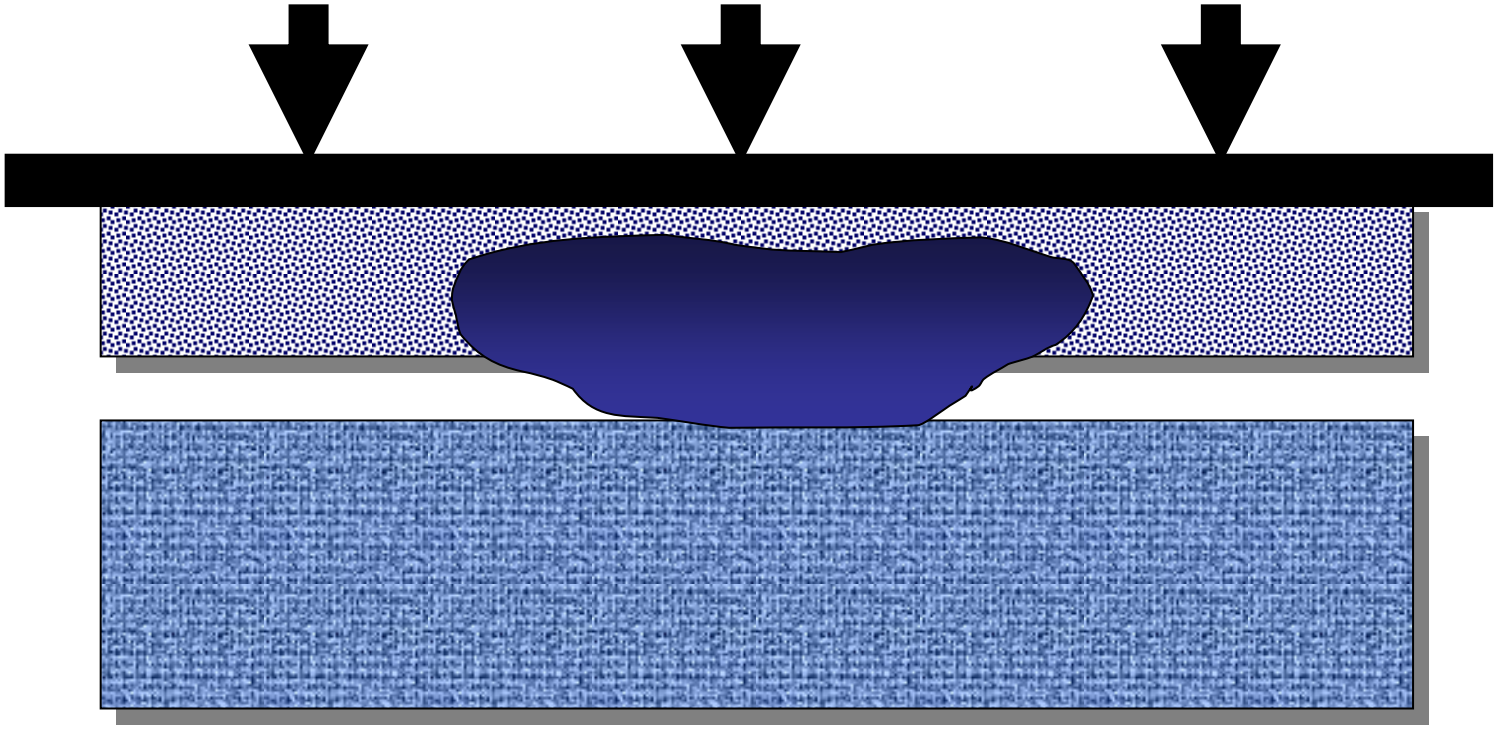


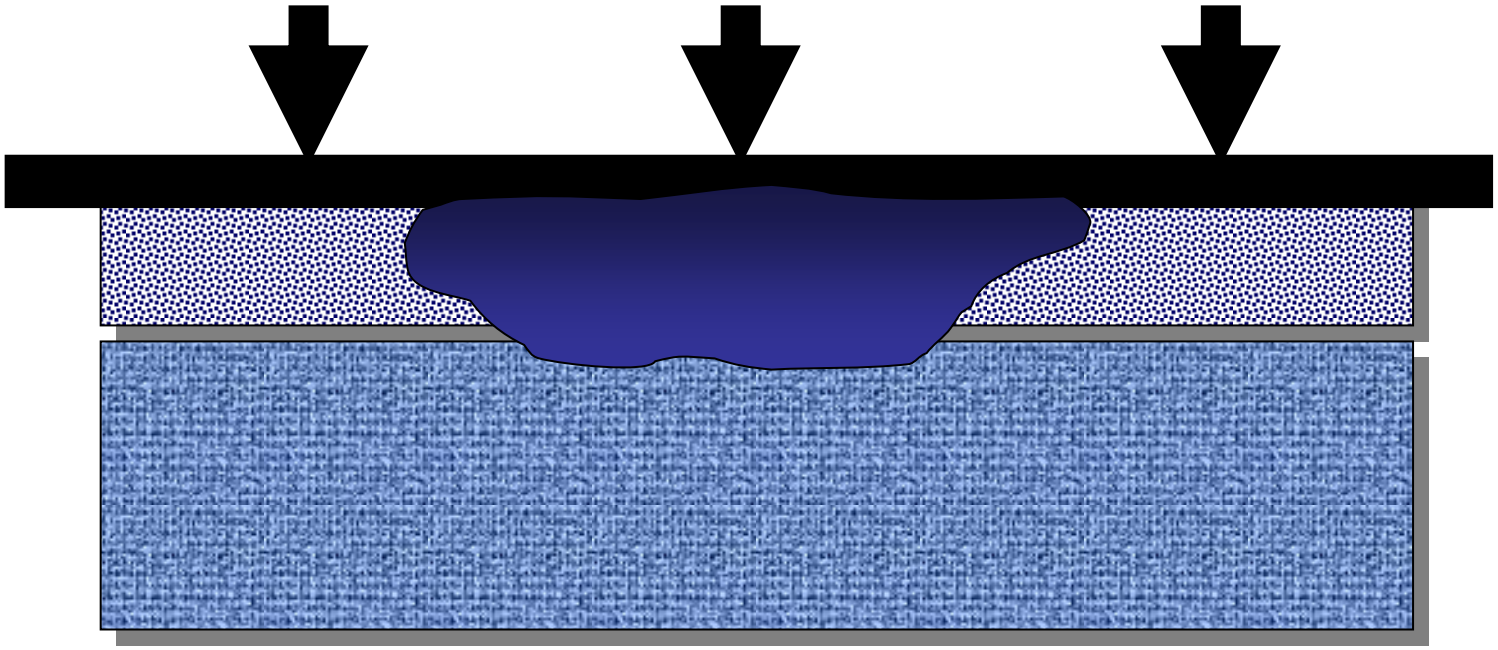


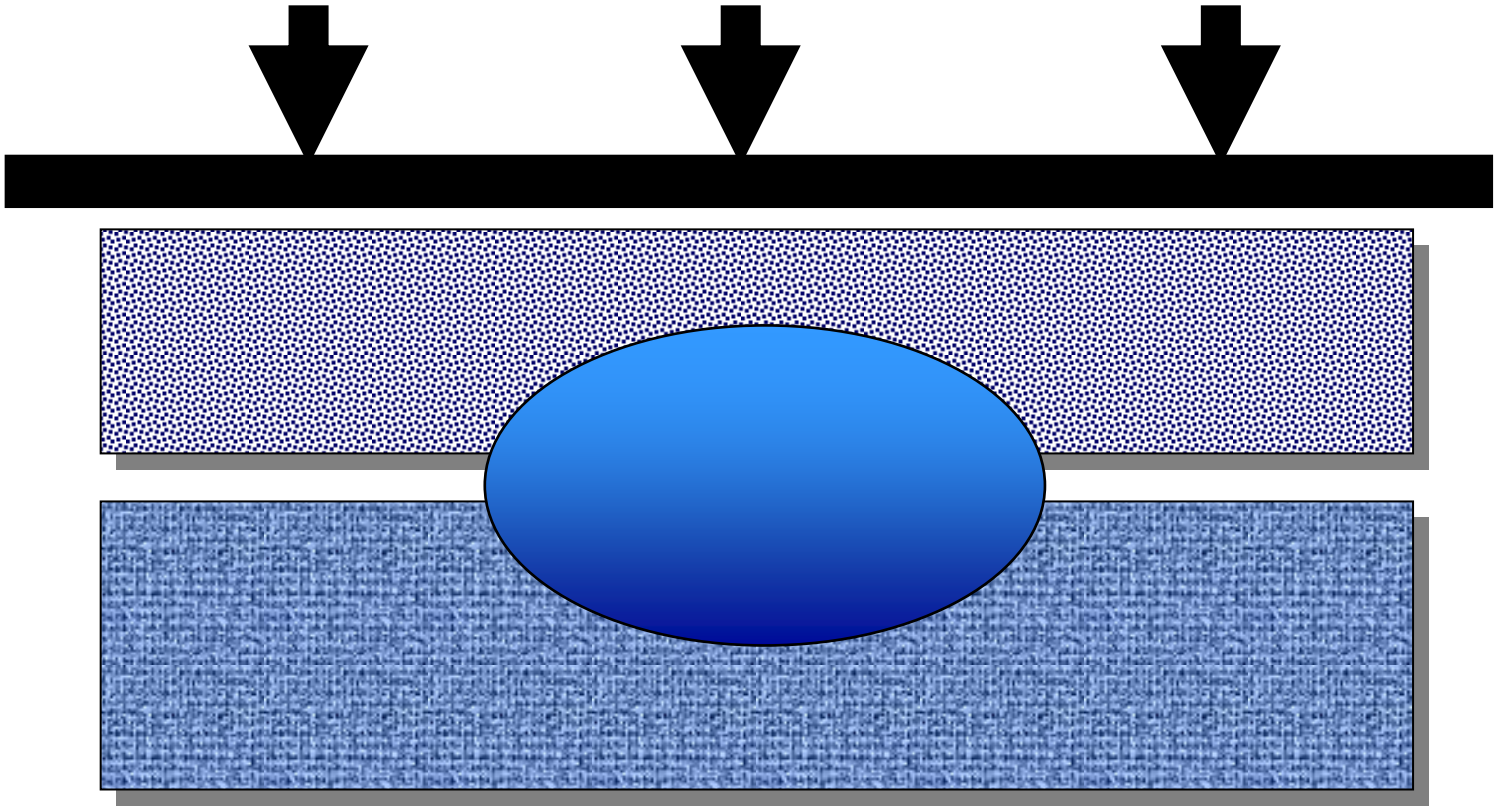
Strike Back

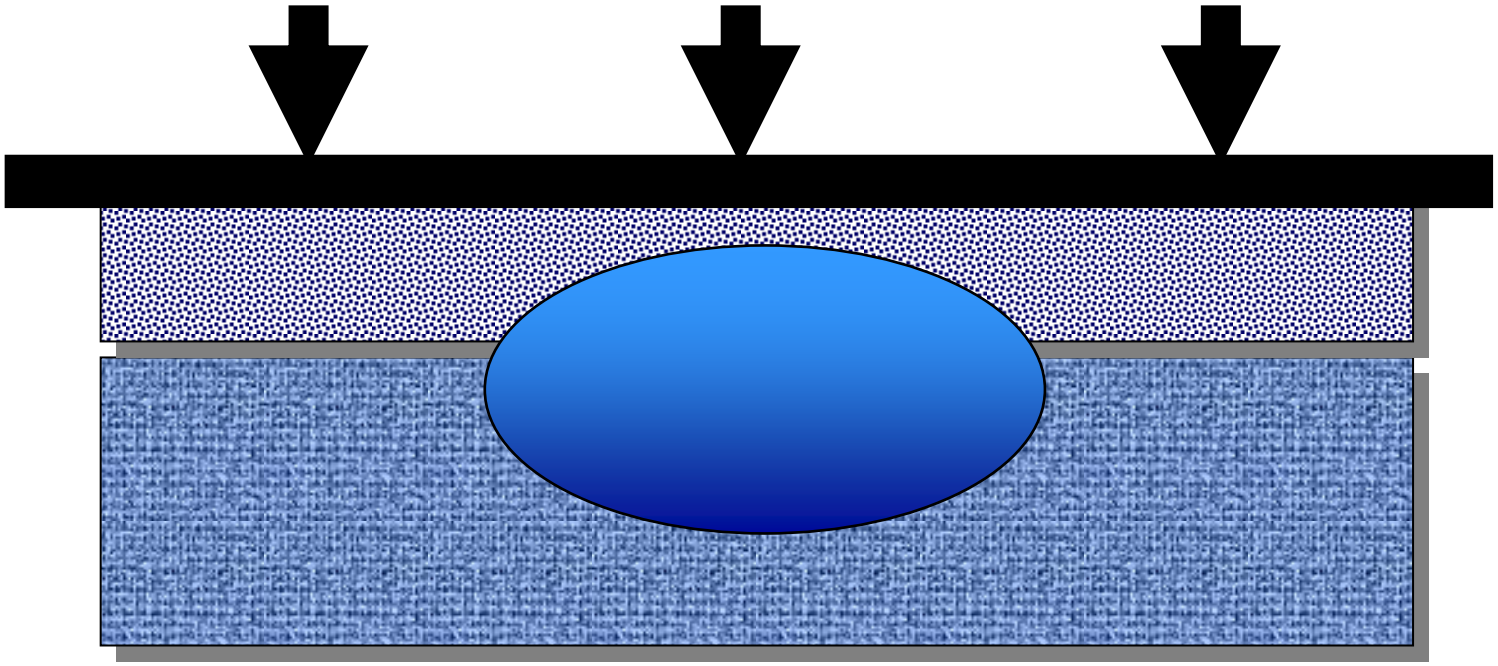


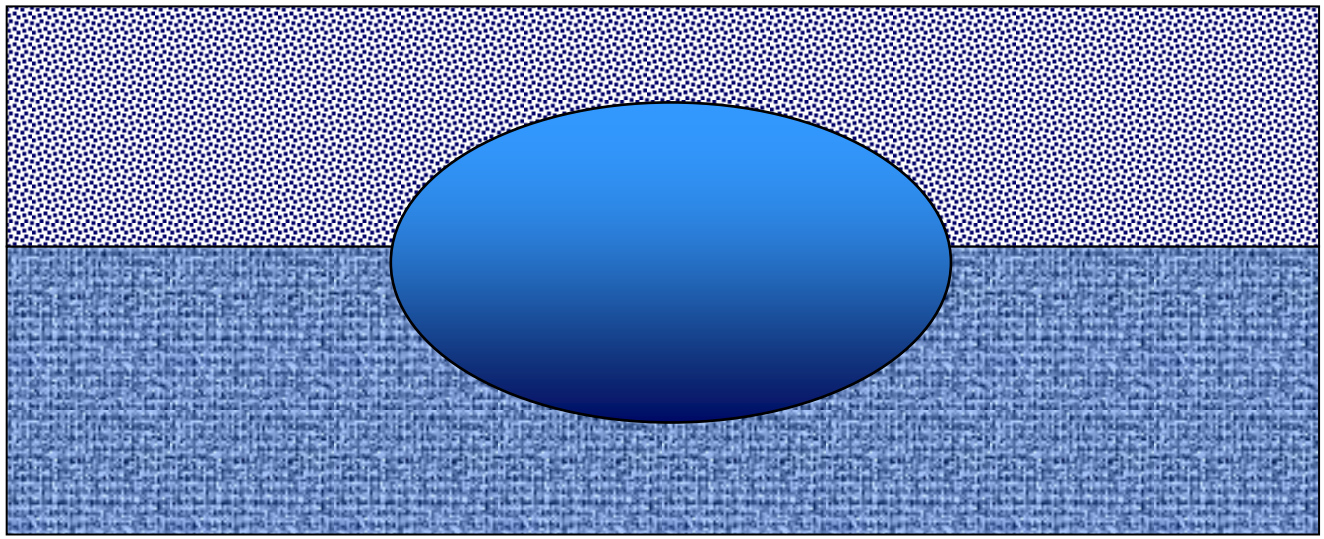


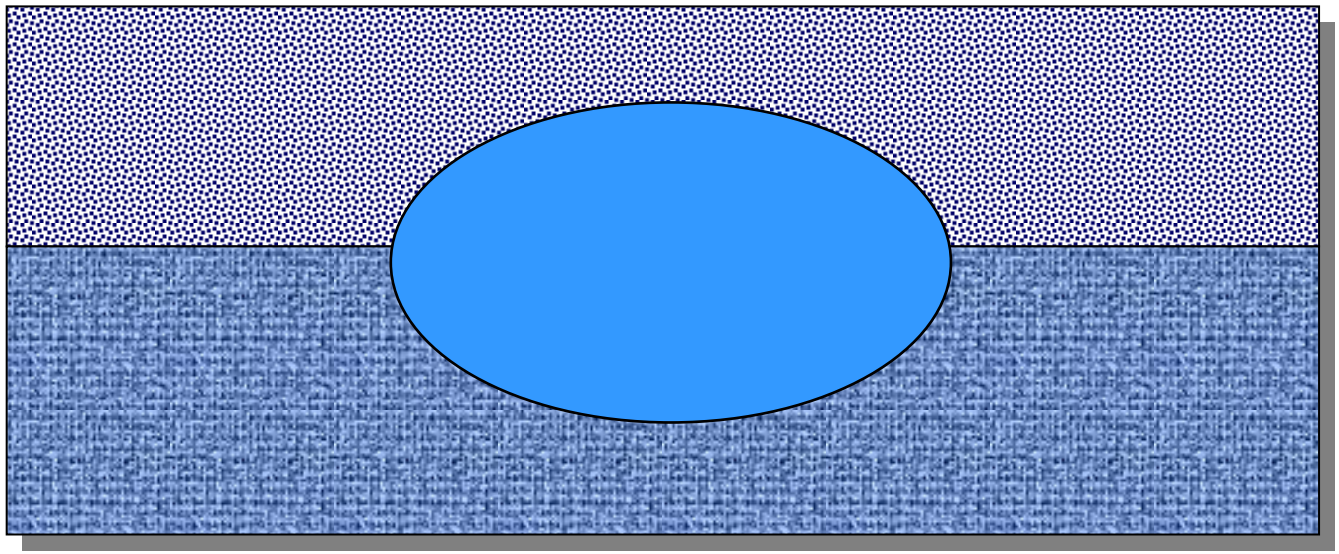


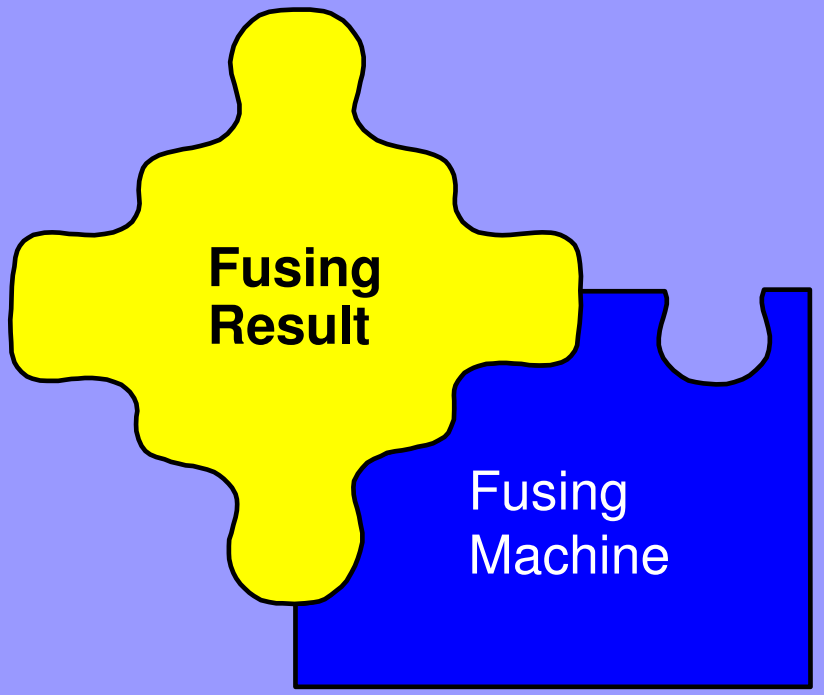








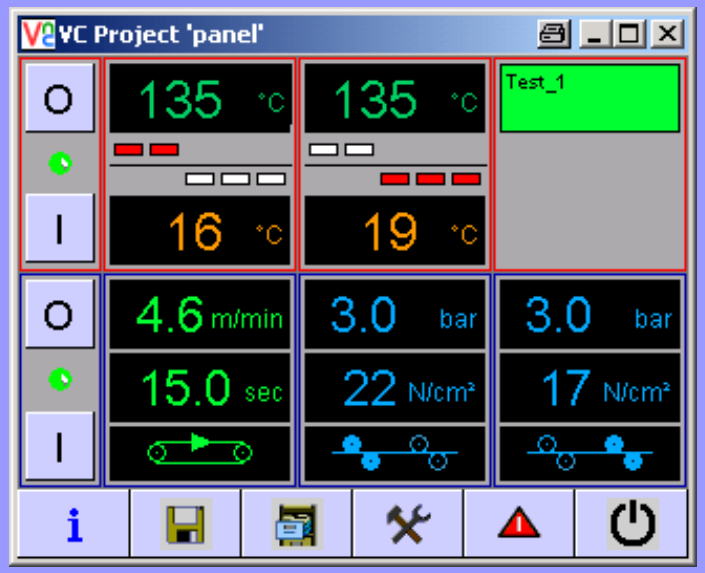


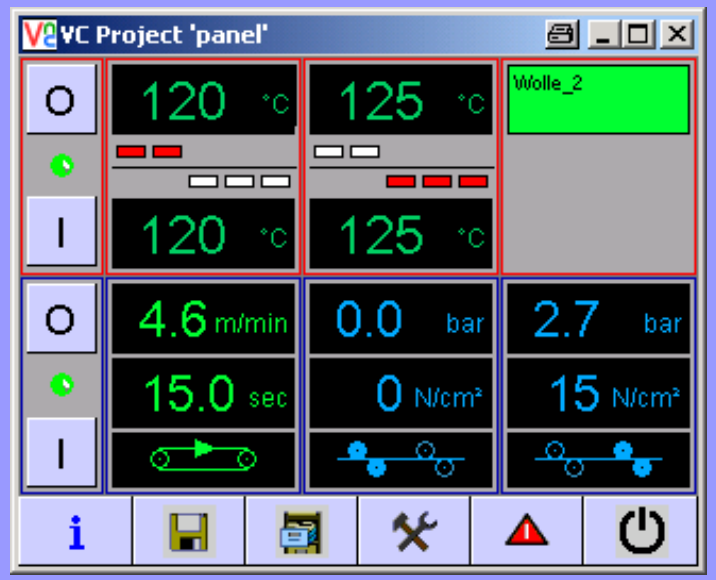


Sustainable Fusing Quality

Fusing Machine, Management:

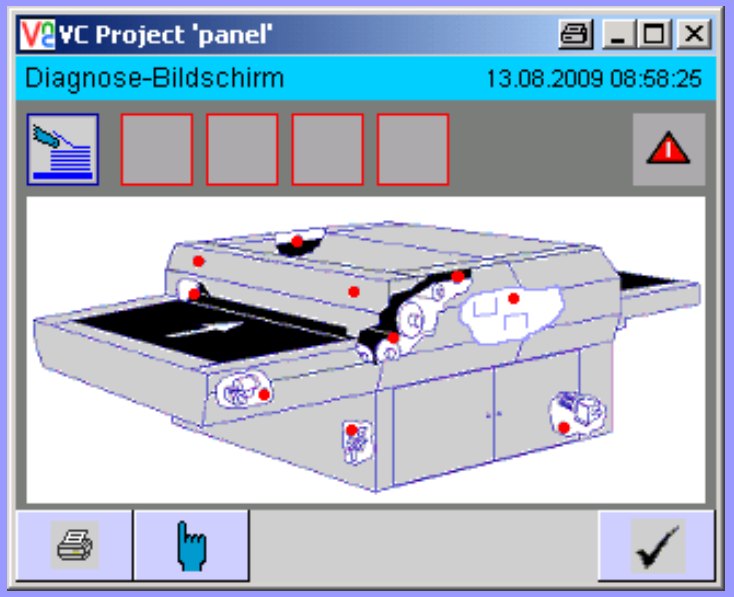
Colour Coding

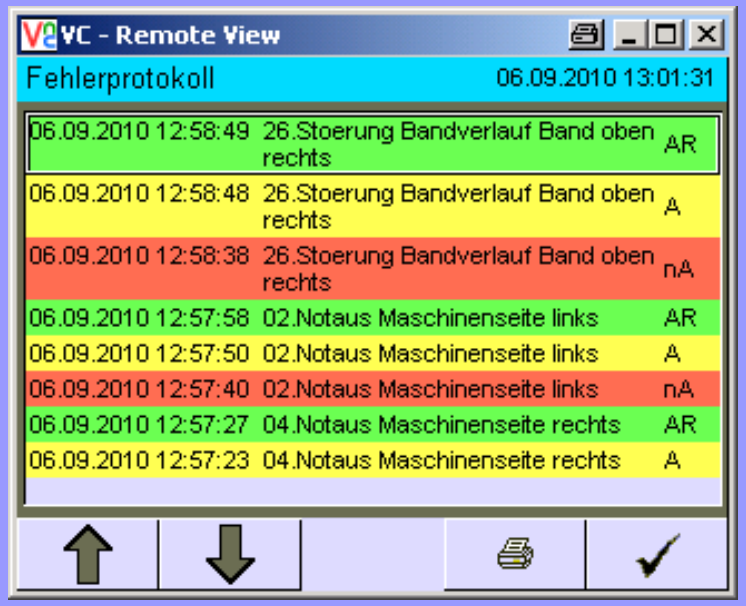




Fusing Machine, Management:

Error Protocol





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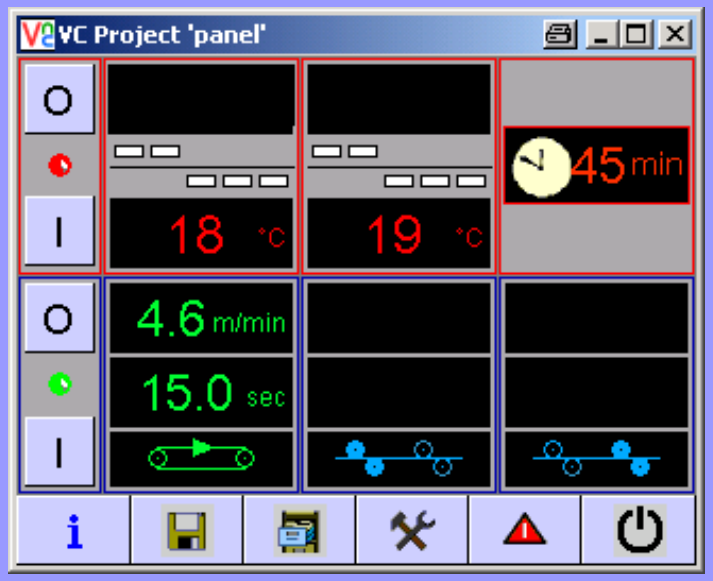
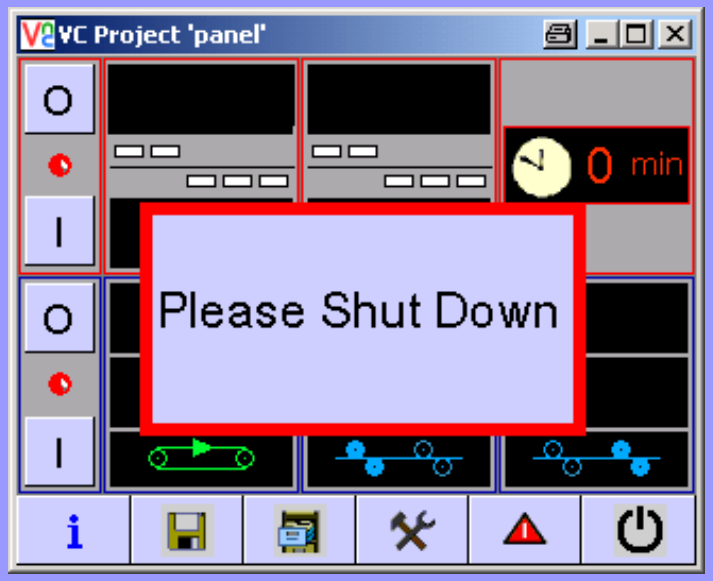
Fusing Machine, Management:

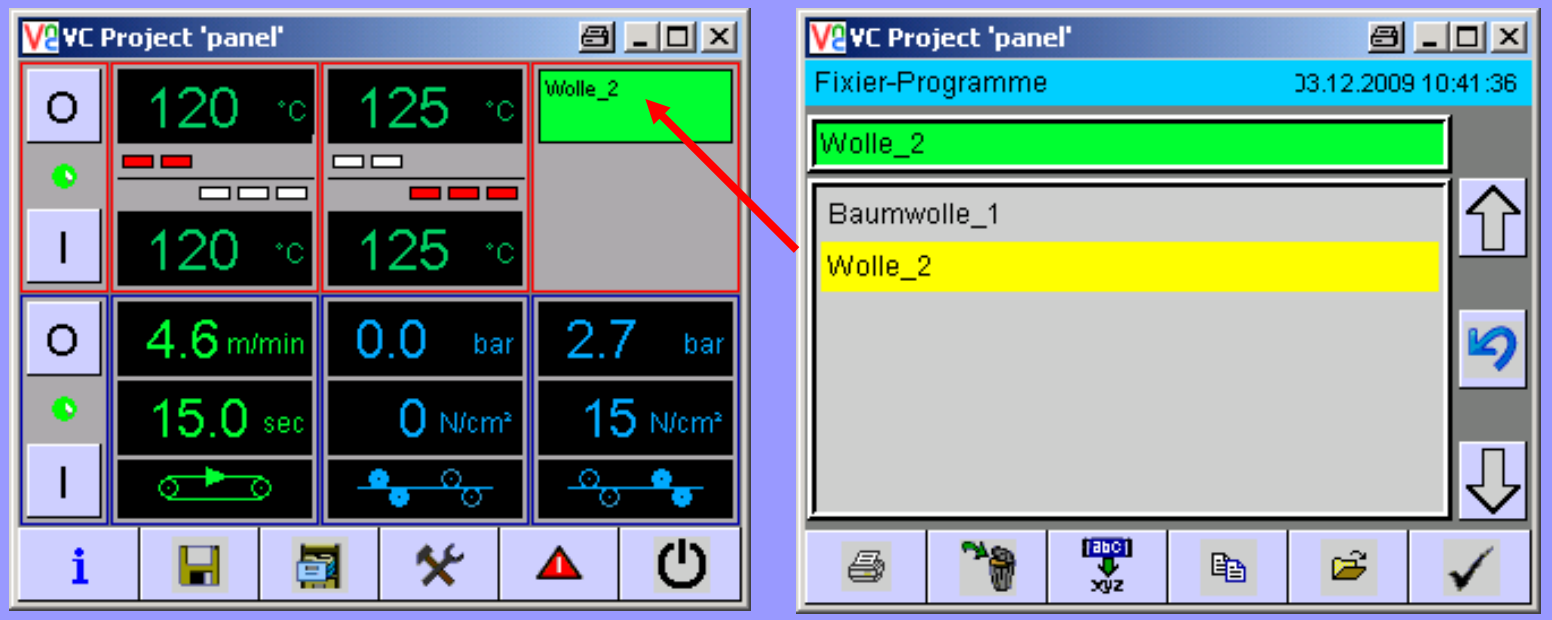
Switch off control





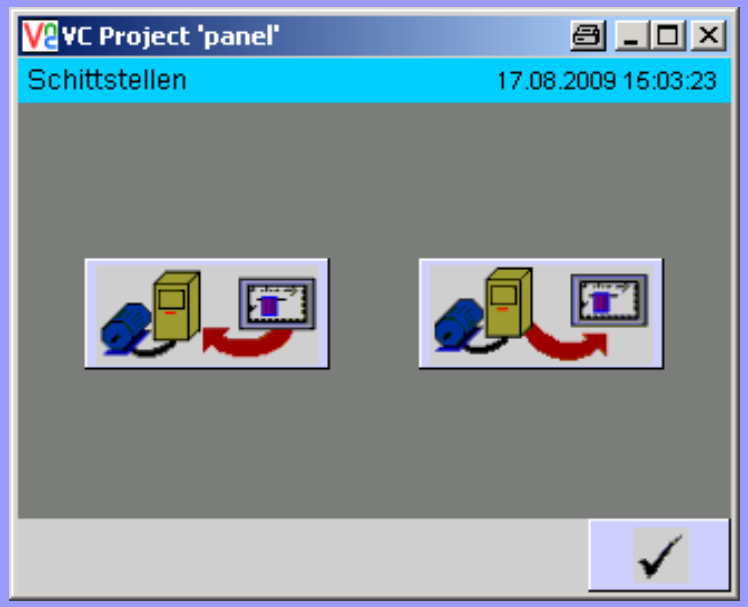
Fusing Machine, Management:

Alpha-Numeric Storage



Fusing Machine, Management:

Copy of fusing programs



Fusing Machine, Management:

Start/Stop function

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Fusing Machine, Management:

Machine data protocol

Maschinentyp: DXT 1400K CFC/B/FE															
Benutzer	Datum	Uhrzeit	Programmname	Sollwert Heizzone 1 in °C	Sollwert Heizzone 2 in °C	Sollwert Heizzone 3 in °C	Istwert Heizzone 1 in °C	Istwert Heizzone 2 in °C	Istwert Heizzone 3 in °C	Sollwert Druck 1 in bar	Sollwert Druck 2 in bar	Istwert Druck 1 in N/cm²	Istwert Druck 2 in N/cm²	Geschwindigkeit in m/min : 10	Laufzeit in sec : 10
name_1	27.11.2007	07:10:00	Test_02	120	120	0	120	120	0	30	30	18	23	46	148
name_1	27.11.2007	07:11:00	Test_02	120	120	0	120	120	0	30	30	18	23	46	148
name_1	27.11.2007	07:12:00	Test_02	120	120	0	120	120	0	30	30	18	23	46	148
name_1	27.11.2007	07:13:00	Test_02	120	120	0	120	120	0	30	30	18	23	46	148

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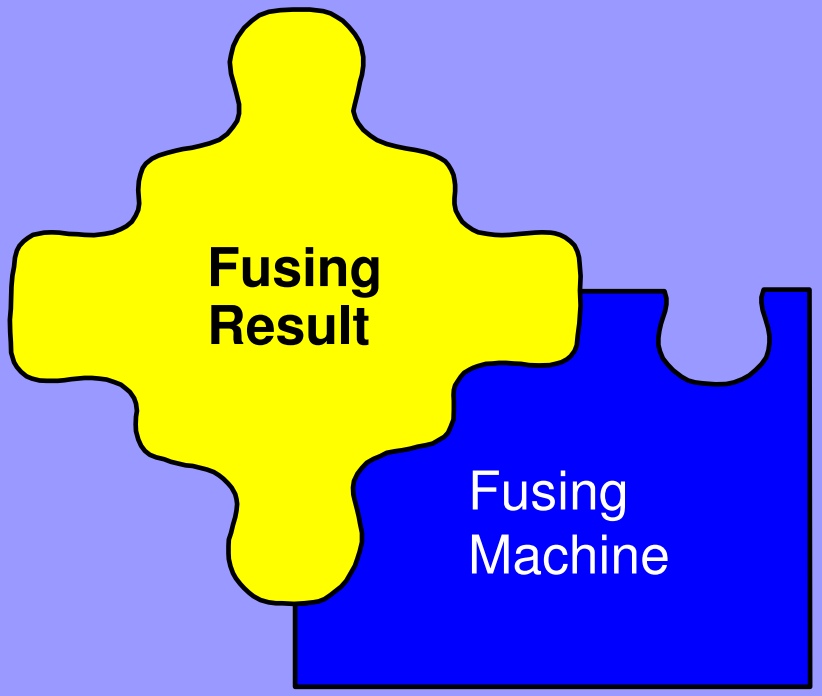
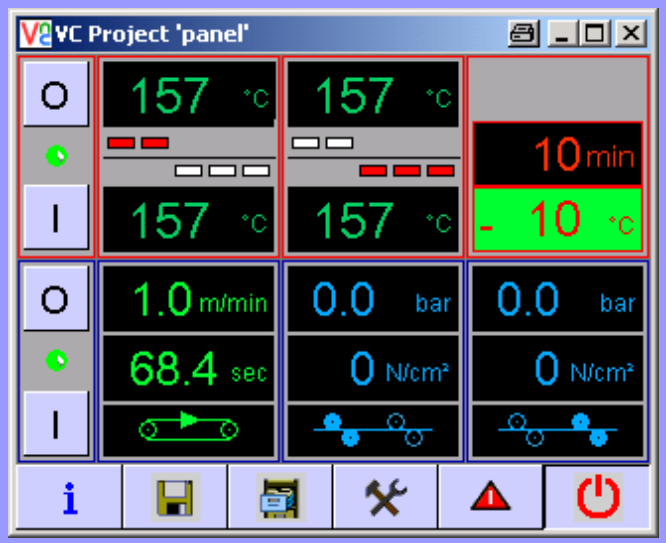


Saving Energy

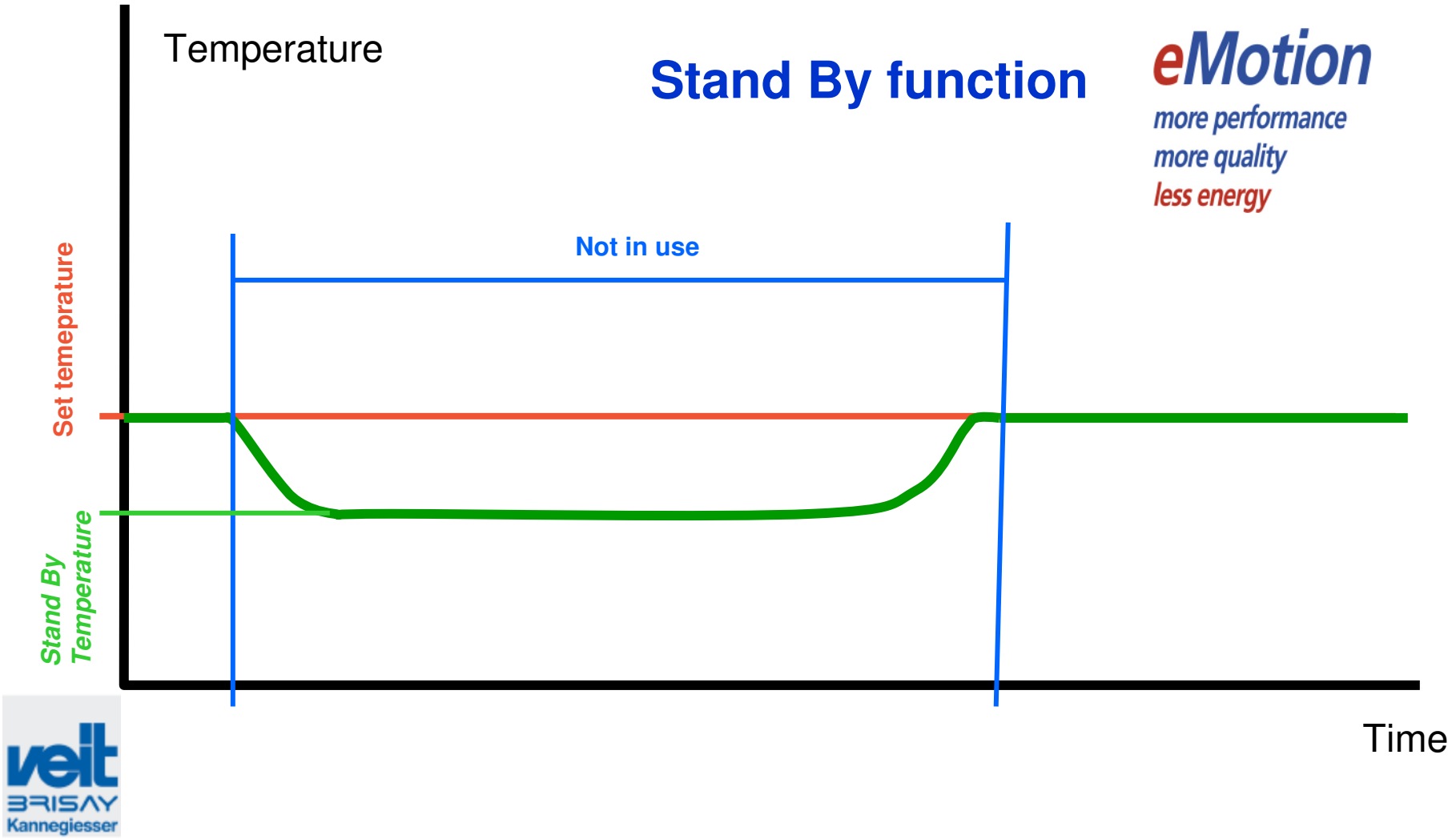
Fusing Machine, Management:

Stand By



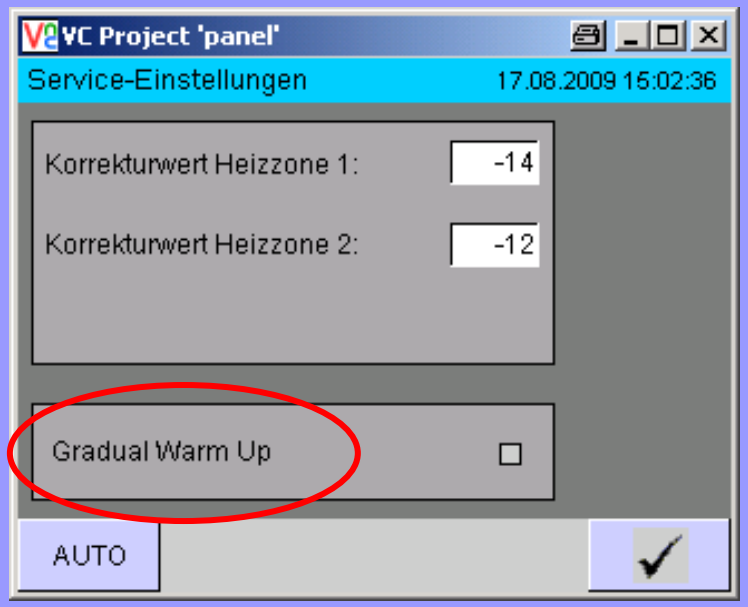
- Machine speed slows down to 1m/min
- Pressure released to 0
- Set temperature according to “Stand By” level

Fusing Machine, **Management:**



Fusing Machine, Management:

Gradual warm up



eMotion
more performance
more quality
less energy

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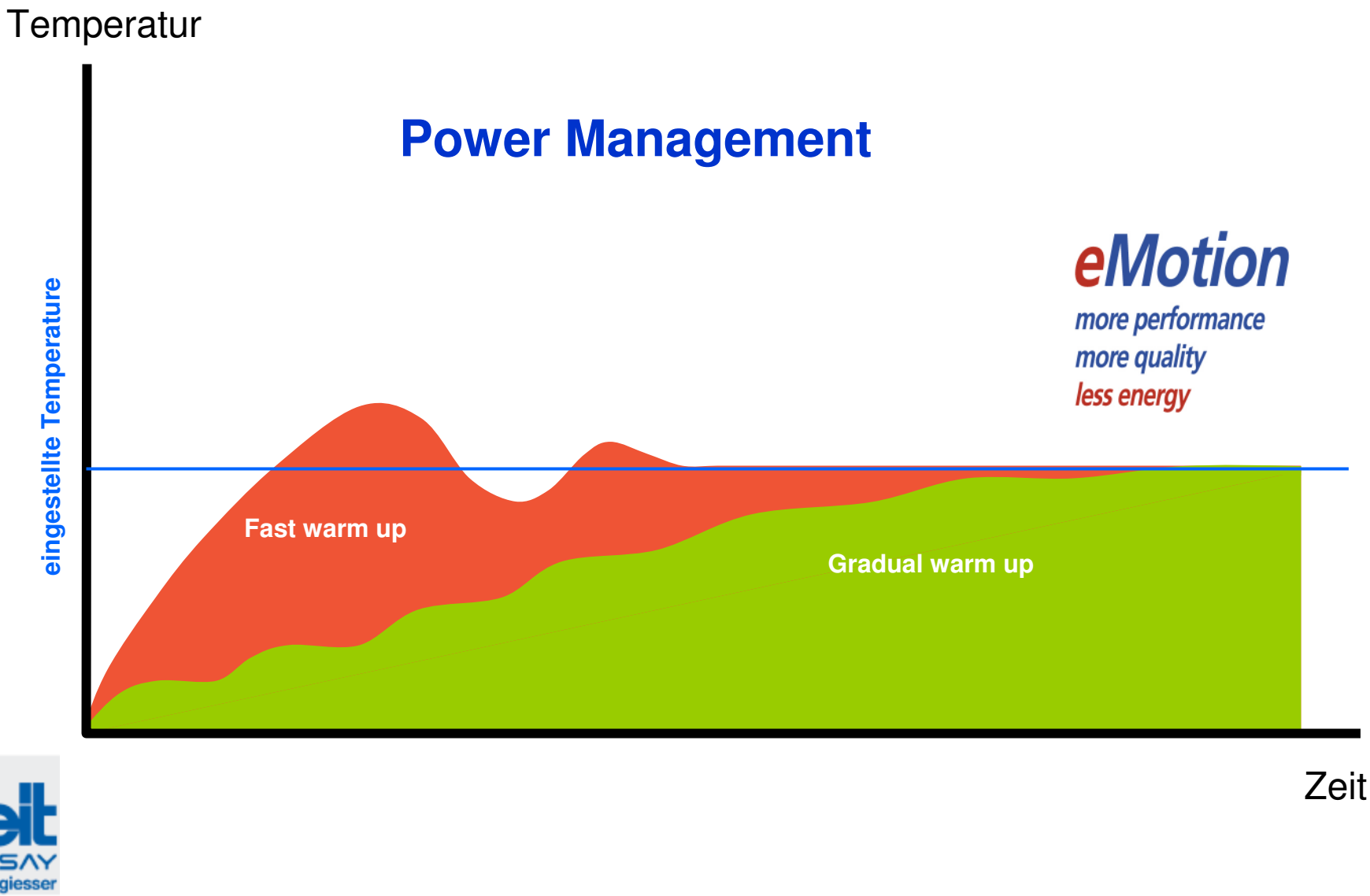
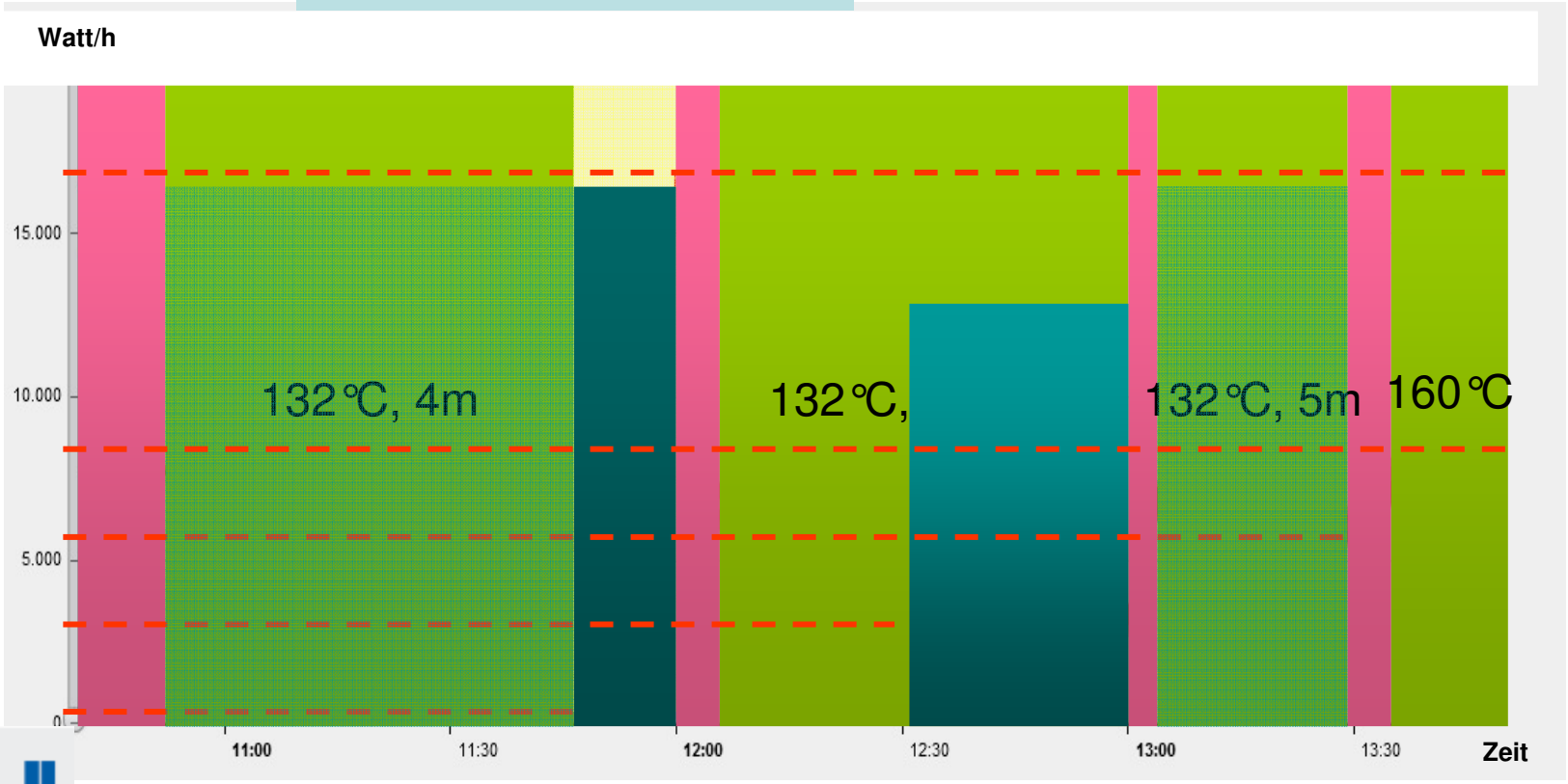
Fusing Machine, **Management:**



Fusing Machine, **Management:**

BX 1000 S
Connected load: 17,5 kW



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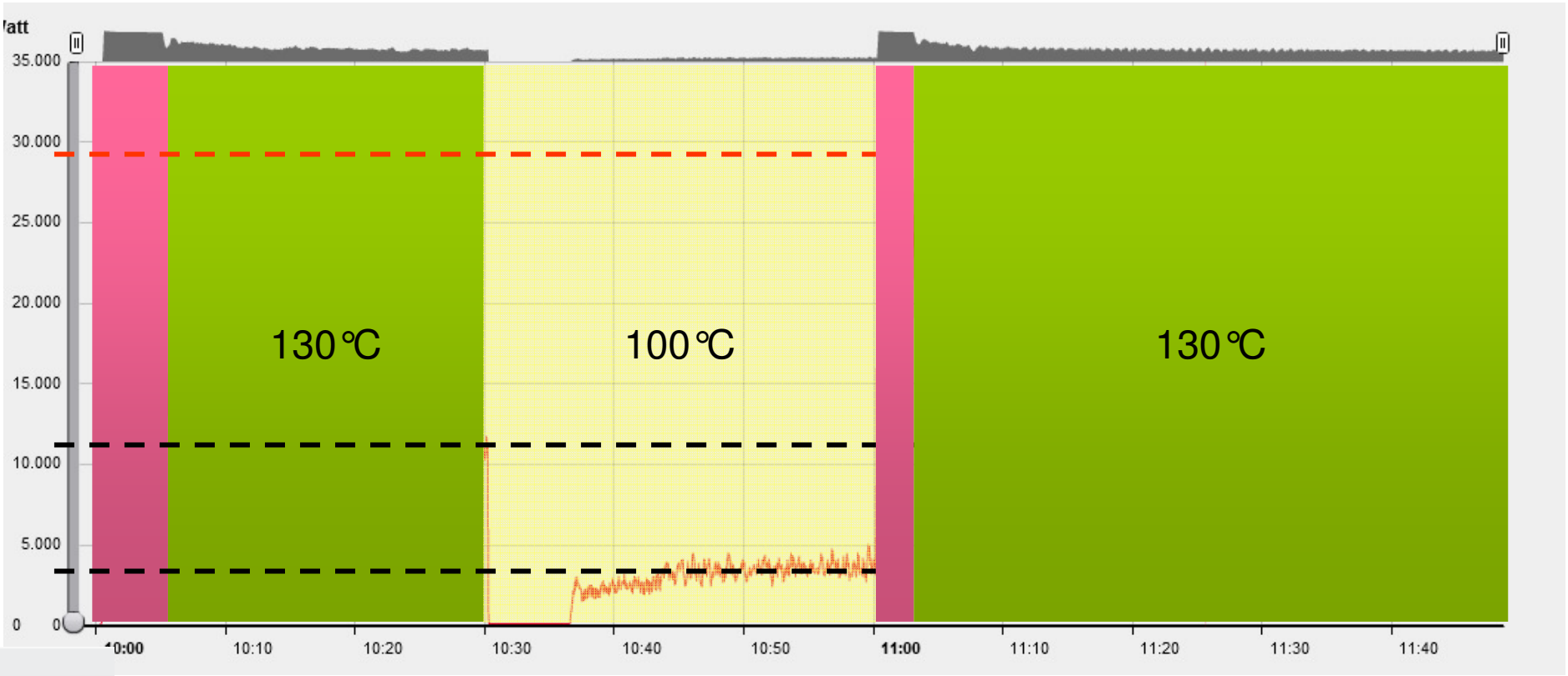
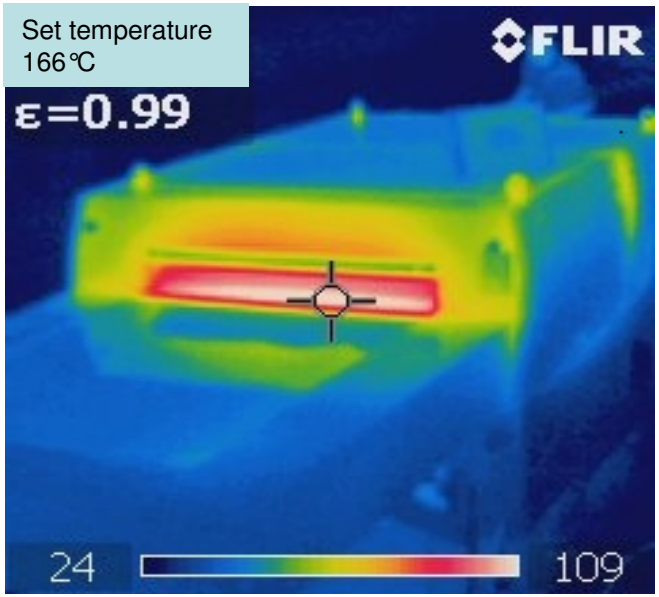
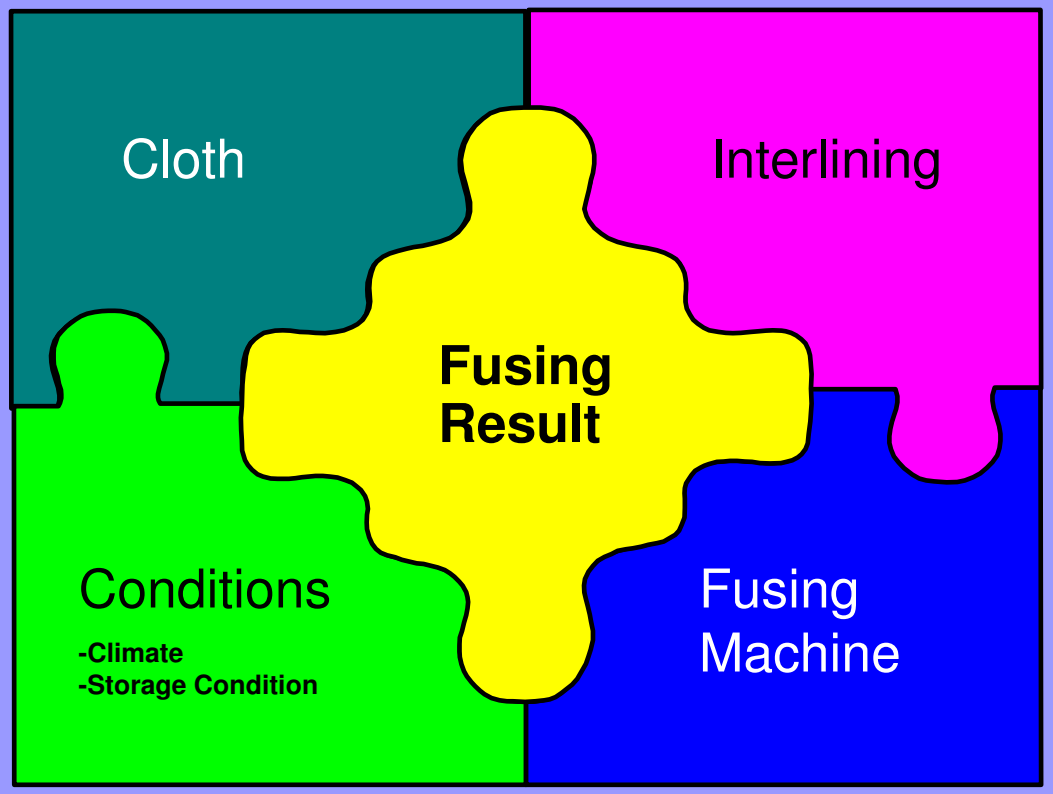
EX 1400 CU FE
Connected load: 30,5 kW



Fusing Machine, **Management:**

Effective machine insolating





Quality first:

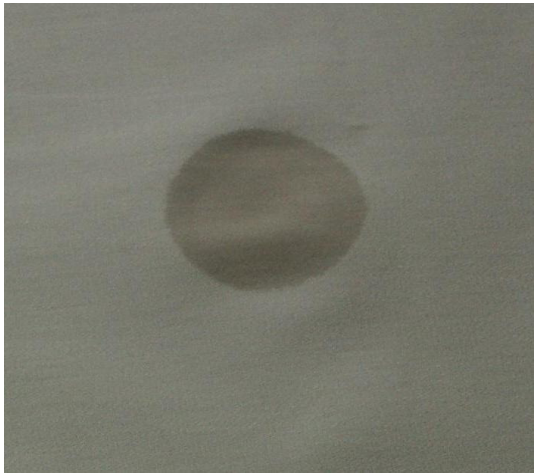
Recommended Fusing Tests

Fusing Tests, **Tools:**

- How old are the temperature stripes in use ?
- Where have they been stored ?
- Does the temperature level is matching ?
- Does the spring tester is calibrated?
- How does the bonding is displayed ? (N, Kg, Kp)

Fusing Tests, **Short Testing:**

Fusing Tests, **Short Testing:**



Fusing Tests, **Requirements:**

What has to be tested ?	Bonding, Shrinkage, etc.
How the bonding has to be tested ?	Bonding by 2,5 cm (1 inch) or 5 cm (2 inches), width
How often those attempts have to be made ?	Every cloth and /or colour/design, etc.
Fusing/Inviromental conditions ?	20℃ + 65% rel. moisture, relaxing time etc.
Testing Methods	Pictures and descriptions
Testing protocol	What should be the contains ?
Does the interlining specification and care label is matching ?	
Who has authority to change fusing parameter ?	QC, factory manager, boss
Does different interlinings are fused at the same time ?	Does they match ?

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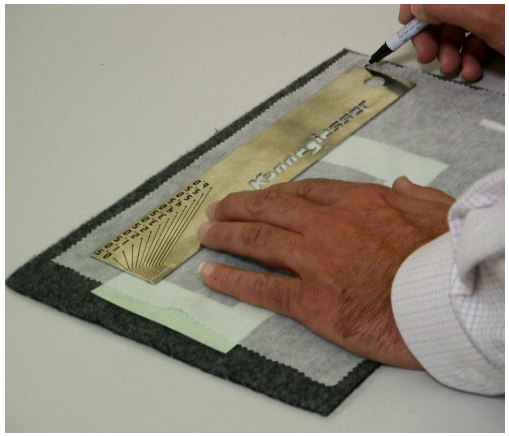
Fusing Tests, **Requirements:**

Measuring (No experience)

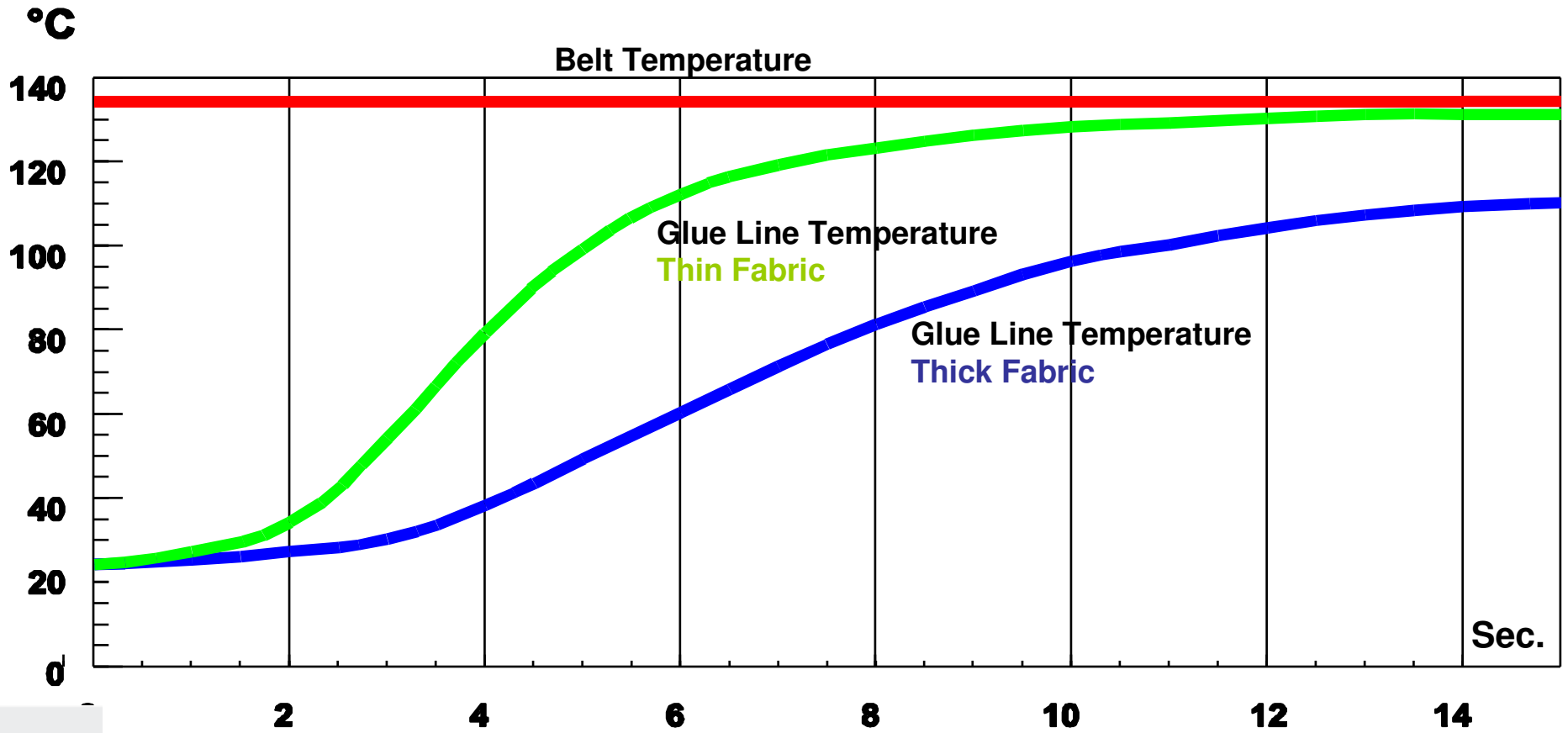
- Belt temperature
- Gue line temperature
- Bonding
- Shrinkage
- Belt speed

Judging (Experience)

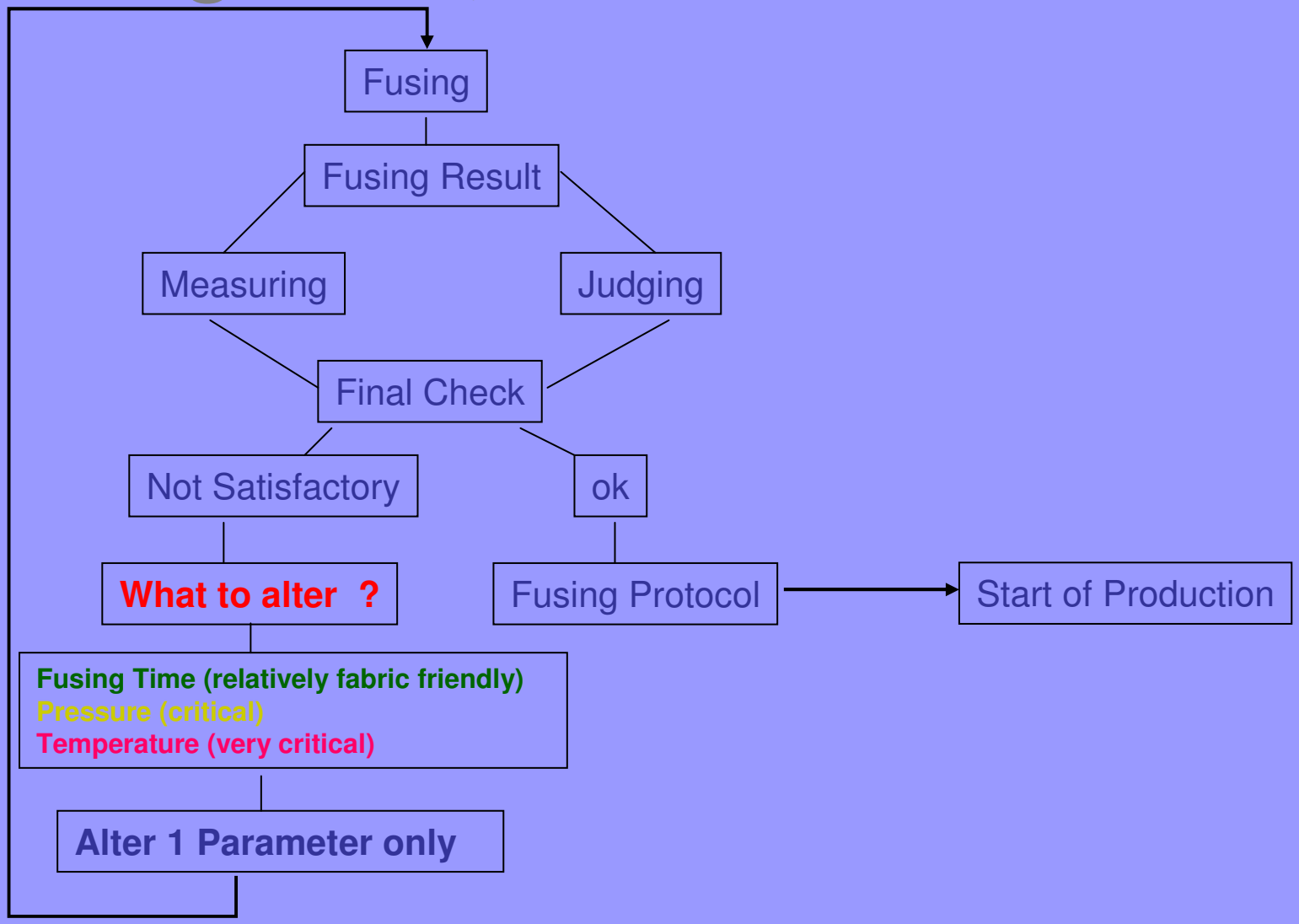
- Hand feel
- Strike through
- Strike back
- Colour shading
- Fabric surface



Fusing Tests, Requirements:



Fusing Tests, Work Flow:



VEIT-Kannegiesser Guidance for Fusing-Tests

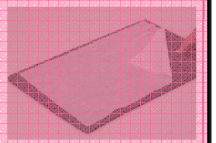
Pressing for Excellence

Today's fabric and interlining are very sensitive to heat and pressure.
It is essential that the fusing machine is in a good condition and fusing conditions are according to interlining specifications.

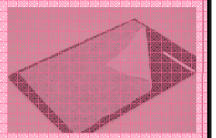
Fusing has always been a very delicate step in the garment manufacturing process.
As the pioneer in fusing technology, VEIT-Kannegiesser is pleased to offer the following guidelines to help eliminate the most likely problems.

Glue Line Temperature

Choose interlining and shell fabric to fuse. To prepare the sample for the bond test, place interlining with the glue face down.

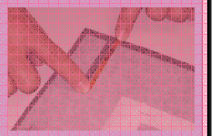


Place temperature strips face down between interlining and shell fabric.
Note: Adjust the temperatures on the machine display as indicated on the strips.



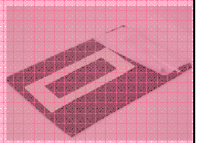
To check the glue line temperature, cut aside the temperature strip on one side.
Note: Never leave temperature strips in a hot place. Keep them cool and dry.

Read the glue line temperature above or below the black field. If a field is not black, but shows any grey colour, the temperature is somewhere in between two temperature indications.

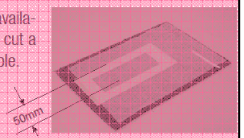


Bonding Test

Place the paper frame between the interlining and the shell fabric. Leave the top side of the paper frame out.

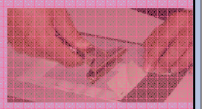


In case paper frames are not available, use the shrinkage roller to cut a 50 mm wide strip into the sample.



Cut paper frame and interlining on both sides.

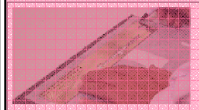
Put interlining and paper frame into the jaws of the bonding tester. Jaws and paper frame should be absolutely parallel. Watch your fingers.



Hold the shell fabric with one hand and pull gently and straight the bonding tester with the other hand. Make sure you don't pull too fast. Observe the scale and read the bond strength from the scale (Newton).

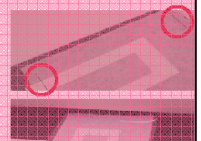
Note:
1 kg = 10 N = 1 kp

Shrinkage Test

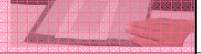


Use a small felt pen to mark both ends of the shrinkage ruler, or cut both ends of the ruler with a knife.

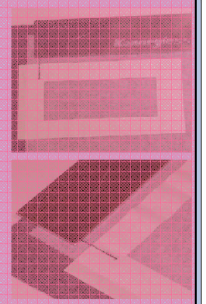
After preparation, a clear mark should be visible.



Put the sample into the machine.

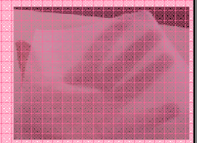


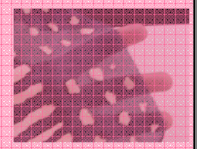
Place the shrinkage ruler on the fusing sample after fusing. Make sure the ruler matches the mark on one side, so that the shrinkage rate can be read on the other side.



Strike Through and Strike Back

Strike through and strike back appears usually when using thin fabric and/or interlining.
In those cases the glue easily gets squeezed and appears on the front side of the fabric or interlining, where it is visible and/or touchable.





It is very simple now to recognize strike through and strike back.
If the fabric sticks to the lower tissue paper, glue has permeated onto the fabric surface
→ **strike through**

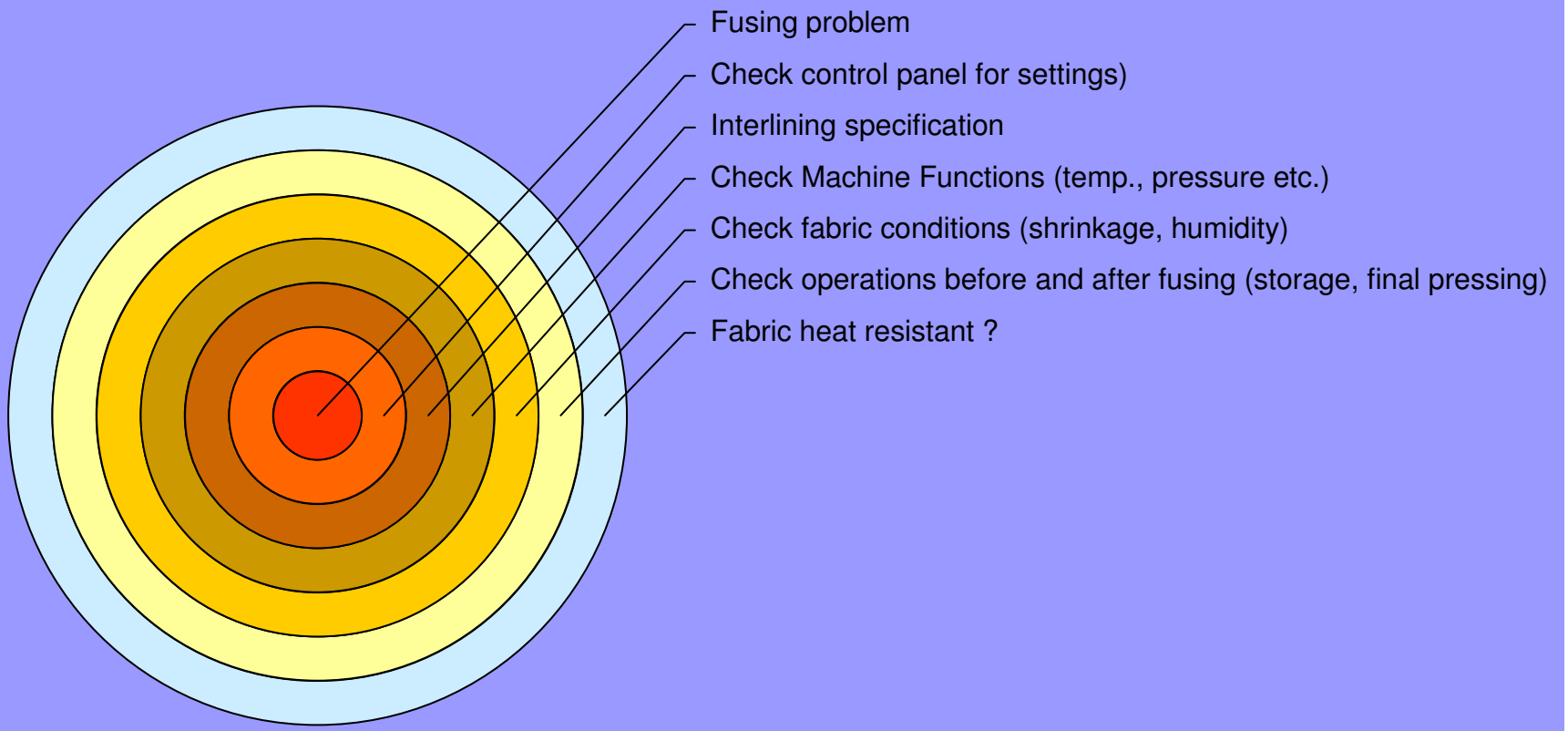
In this case it is likely that either:
- the lower temperature is too high or/and
- the pressure adjusted is too high

In case the interlining sticks to the upper tissue paper, the glue has gone back all the way towards the interlining
→ **strike back**

In this case it is likely that either:
- the top temperature is too high or/and
- the pressure adjusted is too high

Preparation | After fusing

Fusing, How to manage Problems ?



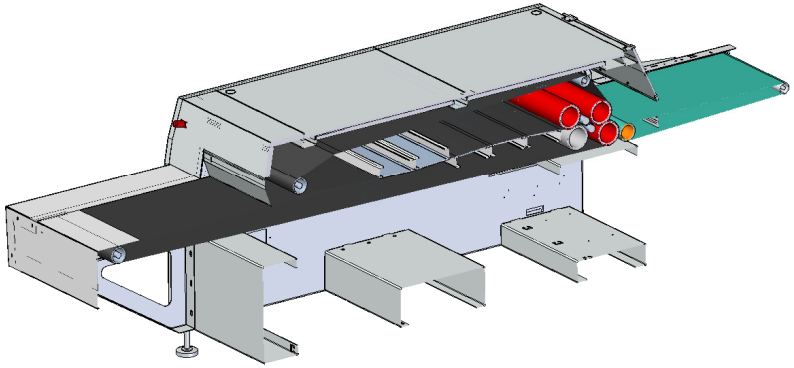
veit
BRISAY
Kannegiesser

Fusing, Check all relevant Operation

- Make a tour on the factories floor, in case the production plant is unknown to you.
- Check all operations which may have an impact on fusing
- Clear instructions for:
    - Proper storage of raw material
    - Preparation of fabric in case of high humidid
    - Proper fusing
    - Fusing tests
- Ability and competence of staff for quality checks
- Clear and accessible fusing instructions

Our Philosophy:

Dress Shirts

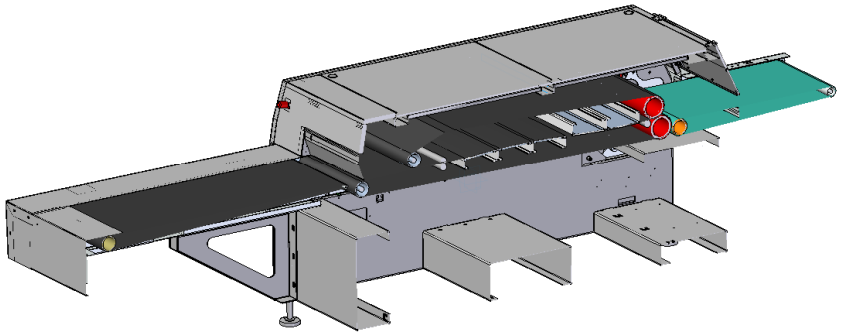


- Interlining as thick as fabric
- Feeding belt short or long
- First heat zone top

Pressure system medium

Single or double pressure system

Outerwear



Interlining thinner as fabric

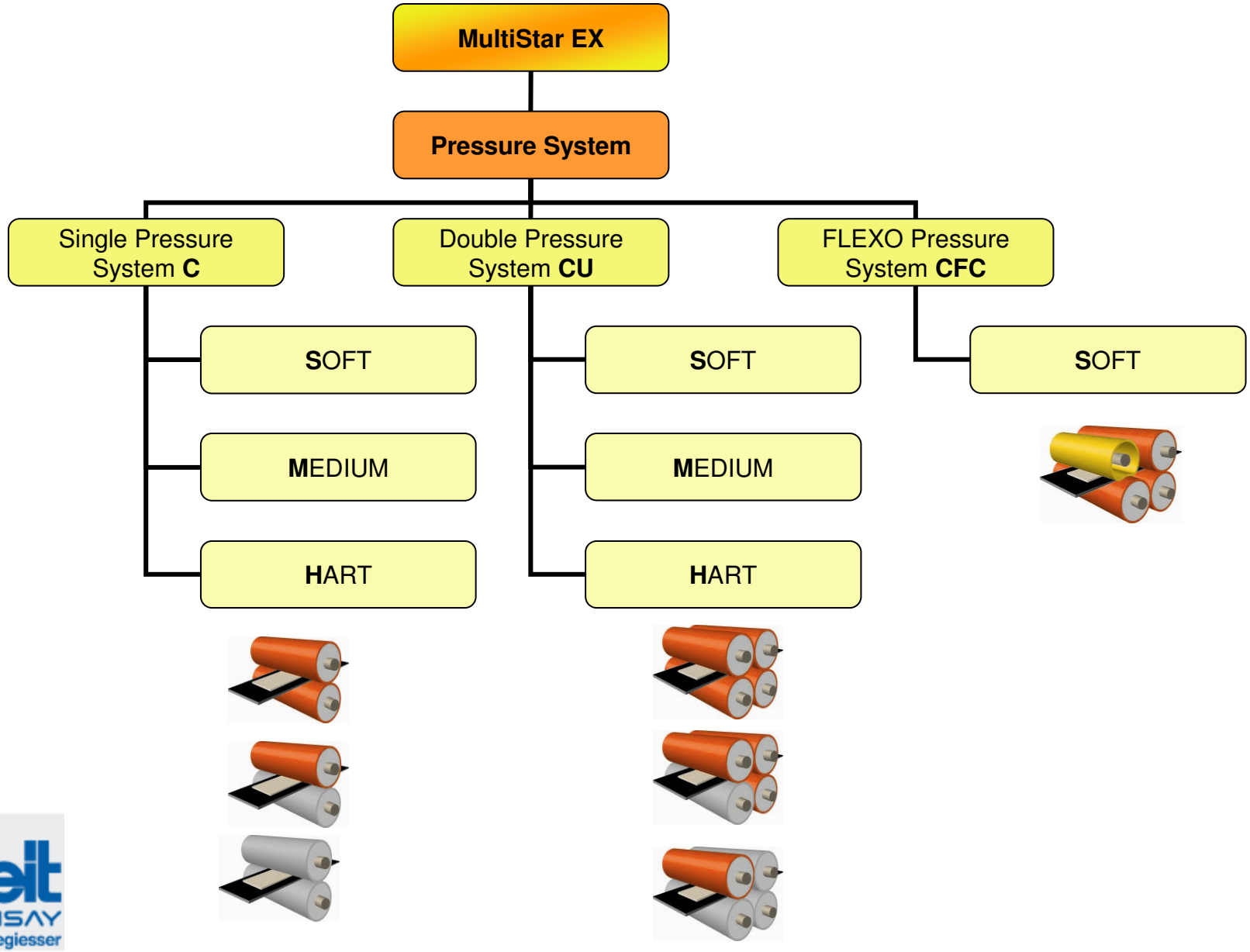
Feeding belt long, as mostly long parts have to be fused

First heat zone bottom

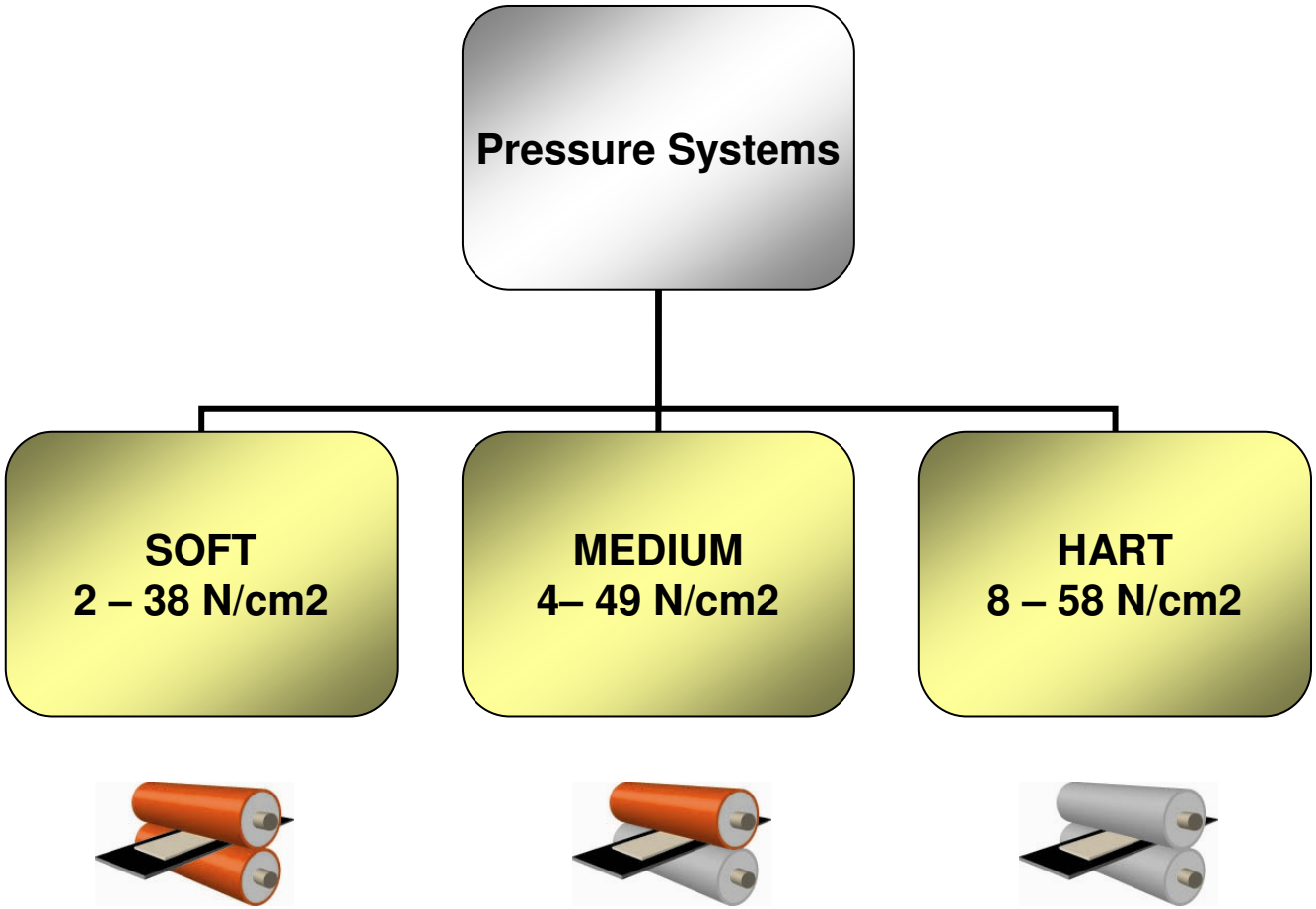
Pressure system soft

Single pressure system

Fusing Pressure System:



Fusing **Pressure System:**



Multi Star EX 1000

Pressing for Excellence

- Feeding System
  - Single Belt for Loading and Fusing SB
  - Separate Loading and Fusing Belt FE
  - Basic BA
  - Table TA
- Control Panel
  - Standard Control Panel EX
  - Touch Screen EXT
- Heat Zone Configuration
  - Top First Heat Zone Top
  - Bottom First Heat Zone Bottom
- Pressure System
  - Standard Pressure System C
    - Soft
    - Medium
    - Hard
  - Double Pressure System CU
    - Soft
    - Medium
    - Hard
  - Flexo Pressure System CFC
    - Soft
- Accessories

Feeding System

Single Belt SB

Feeding System FE

Basic BA

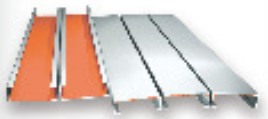
Table TA

Control Panel

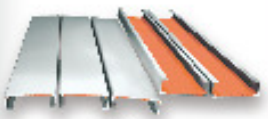
EX

EXT

Heat Zones

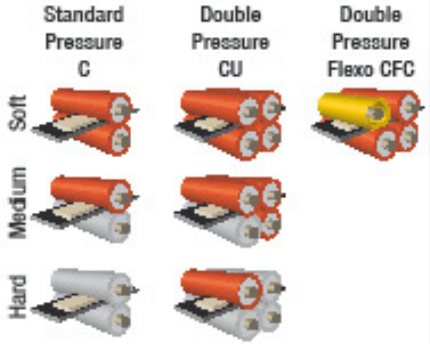


Top



Bottom

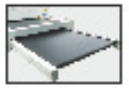
Pressure System



Accessories

ET

FE-L



Return Feed System

Tank you for your attention