



# **Integrating Companies in a Sustainable Apprenticeship System**

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## **Intellectual Output 3A**

# **Learning-teaching activities - Pre-stitching -**

Authors: TUIASI Gheorghe Asachi Technical University of Iasi and ICSAS-Team

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## 1. Work-Based Pre-Stitching Training

### 1.1. What to prepare


In order to start the work-based training, there is a list of things to prepare:

- Pieces from cutting department in order to be processed
- Skiving machine, splitting machine, punching machine, templates for marking, folding machine, workplace

## 1.2. Activities


### Skiving

- Perform skiving operations. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of skived pieces for one model.

Piece to be skived	Type and scope of skiving	Possible defects
<p>Counter</p> 	<p><b>1,2</b> Type: Raw edge Scope: Closed seams</p> <p><b>3</b> Type: Lapped skive Scope: Overlapping</p>	<ul style="list-style-type: none"> <li>• the strength of the material is affected by skiving</li> <li>• skived edge is missing or corrugateds</li> </ul>


### Splitting

- Perform splitting operation on pieces. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of splitted pieces for one model.

Piece to be splitted	Possible defects
<p>Collar</p> 	<ul style="list-style-type: none"> <li>• the thickness is not uniform or does not meet the technological specifications</li> </ul>

### Punching/ gimping

- Perform punching and gimping operation on pieces. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of punched/gimped pieces for one model.


Piece to be punched/gimped	Type of punches/gimping	Possible defects
<p style="text-align: center;">Toe cap</p> 	<p>Punches 1- 2 mm Punches 2- 1 mm</p>	<ul style="list-style-type: none"> <li>• incomplete, deviated or doubled perforations</li> </ul>

### Marking

- Perform marking operation using templates. Prepare and attach a set of marked pieces for one model.


### Dyeing

- Perform dyeing operation on pieces. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of painted pieces for one model.

Piece to be painted	Possible defects
<p style="text-align: center;">Counter</p> 	<ul style="list-style-type: none"> <li>• Very high hue differences between the part and its section where the paint was applied;</li> <li>• Paint dries hard or leaves traces of touch</li> </ul>

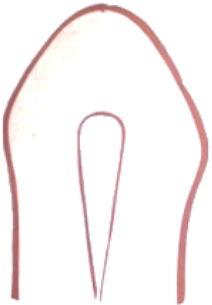

### Folding

- Perform mechanical folding operation. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of folded pieces for one model.

Piece to be folded	Possible defects
<p style="text-align: center;">Counter</p> 	<ul style="list-style-type: none"> <li>• the width after bending is uneven</li> <li>• the folded edge does not have a continuous line or uniform appearance</li> </ul>

### Reinforcement

- Apply reinforcements on pieces. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of reinforced pieces for one model.

Piece to be reinforced	Position of the reinforcement	Possible defects
<p style="text-align: center;">Vamp</p> 		<ul style="list-style-type: none"> <li>• upper and linings have not been centred</li> <li>• the edges of the reinforcement are visible on the upper</li> </ul>