

Mask Production 2020

May be worn alone or over an N95 for isolation precautions to extend N95 use when appropriate during a severe shortage of available PPE. Intended for reuse after laundering. If N95 is visibly soiled, it must be discarded.

Materials

OR linens or other breathable water repellent fabric

Pins

1/4" or 3/8" wide Elastic – white or black

Thimbles

Fabric Scissors

Heavy paper for patterns: 9" x 15" & attached mask pattern

Cardboard – optional (**tip: use a 9.5" piece of cardboard to loop around 10-15 times to cut all at once to produce 20-30, 9.5" pieces)

Sewing Machine

Thread

PREP – Estimated time 3 minutes per unit

Station 1: Cutting

Cut a rectangular 9" x 15" base paper pattern

Fold fabric in 4 layers

Lay 9" x 15" base pattern on top of 4-layer fabric

Cut around the base pattern

Station 2: Pinning

Take 2 cut sheets and fold in half to make 4 layers

Cut mask pattern per attached sample (8.19 x 5.4")

Pin mask pattern to cut 4-layer fabric using 4 pins around the outside

Station 3: Cutting

Cut the fabric for the mask pattern

Station 4: Finishing

Remove pins and paper pattern from cut fabric

Separate 4 fabric pieces into 2 sections of 2 layers of fabric each

Pin 2 piece sections around curved edge vertically, every 2"

Station 5: Elastic

Cut elastic into (2) 9.5" sections.

Insert (1) elastic into each 2-piece pinned section through the flatter open edge (opposite from the edge that is pinned)

Check to be sure elastic is not twisted inside the section. Once elastic strip is inserted into the opening and placed

flat in a U shape, center the new elastic ear loop and pin down each end of the elastic strip 2" apart - EVEN with the edge of the fabric (**tip: create a 2" line on your table as a guide**)

Use your completed 2-piece section as a guide for the other section to keep ear loops even

Place a single pin through middle of the 2 sections to make one unit, ready for sewing

Station 6: Quality Control

Examine product and correct any defects before advancing to sewing

Station 7: Distribution

Count and log mask units before issuing for sewing distribution. Record the name of the person picking up inventory. Ensure timely turnaround time of assigned masks, and do not over allocate to a single sewing resource.

SEWING – Estimated time 7 minutes per unit

Unpin the 2 sections pinned together

Place one 2 piece section on the machine and prepare to sew the edge with the elastic ends

Place machine on a zigzag stitch and sew along the entire edge

Line up second 2-piece section, place on the machine and sew the edge with elastic ends

Remove from the machine and take out the pins

Turn both sections inside out

For each section, sew a straight stitch on the same edge for extra stability for the elastic, ensuring the elastic is caught in the stitch

Place one section directly on top of the other section, line up directly on top of the other and prepare for sewing

Using a 5/8" seam for a regular size N95 and a 1/2" seam for a small N95, zigzag stitch down the section that will be over the nose part of the mask, making sure all pieces are getting caught in the stitch

Backstitch to finish and cut loose threads

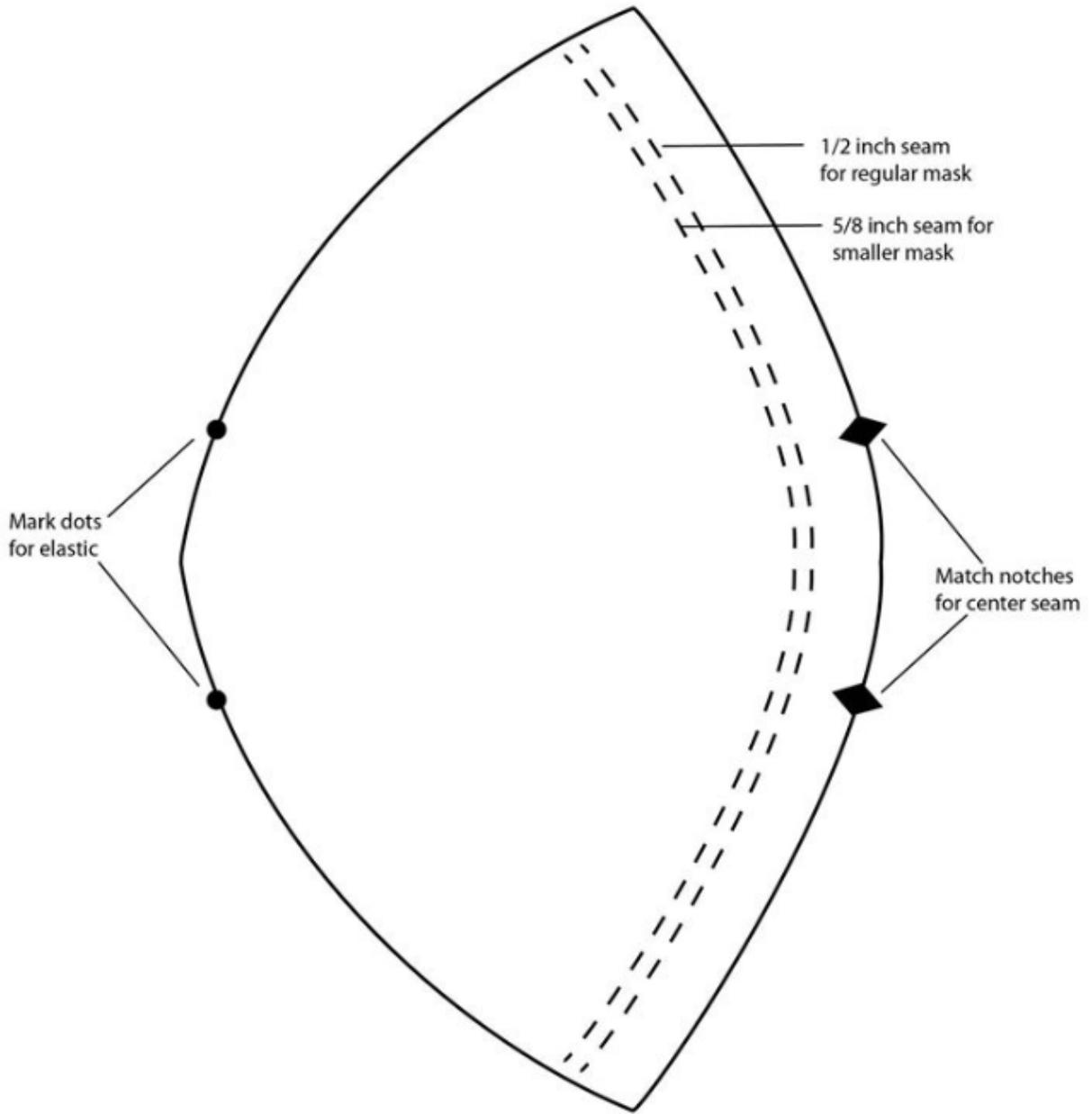
Open completed mask

Trim up any frays

Examine product and correct any defects

This information is provided for your independent evaluation. Neither the materials nor design of these masks has been reviewed or approved by the FDA or any other regulatory agency. Each institution must make its own independent determination as to whether the masks are suitable for any particular purpose.



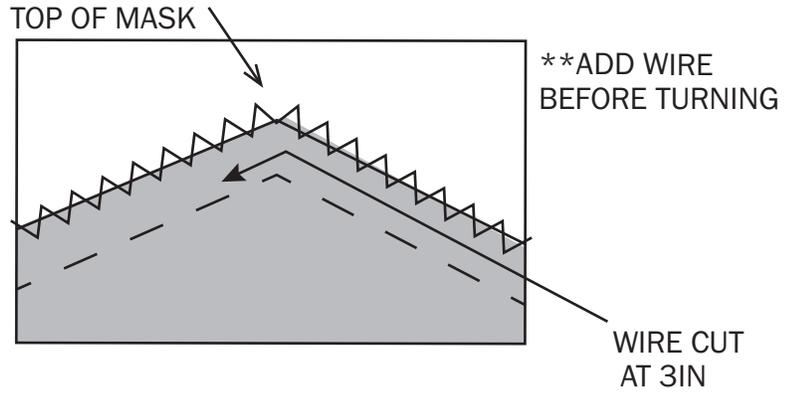






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ZIG-ZAG FABRIC LAYERS AT TOP OF MASK (FOR NOSE)



CLOTH SURGICAL FACE MASK PATTERN

SUPPLIES:

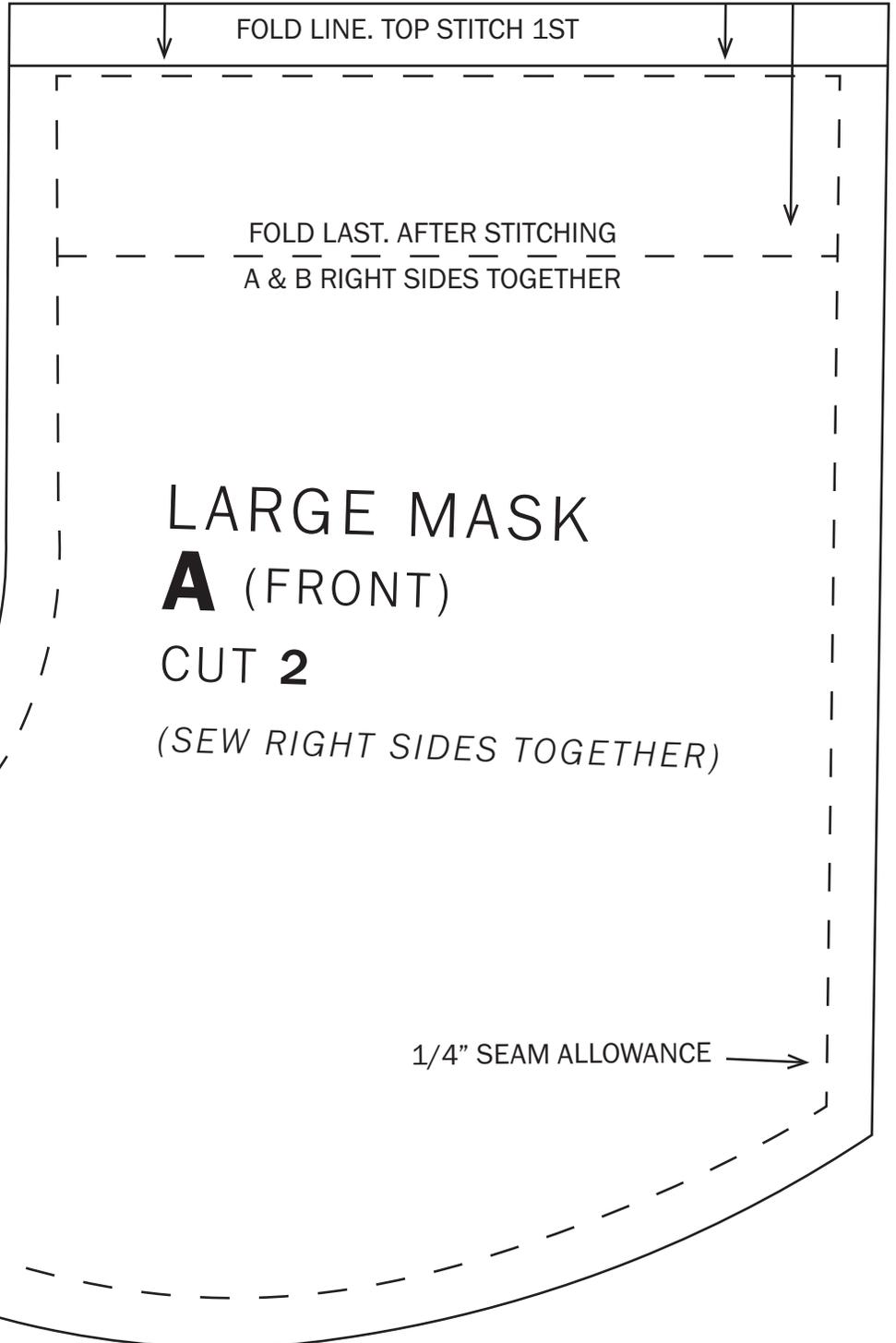
FABRIC SCRAPS (NEED 1 LIGHT AND 1 DARK COLOR FABRIC FOR VISIBLE CONTRAST)

SEWING MACHINE OR SERGER

13IN OF 1/4IN ELASTIC (ANY NARROW ELASTIC WORKS)

3IN WIRE (THINNER GAUGE ENOUGH TO BEND AND HOLD FOR NOSE PIECE. CAN EVEN USE PAPER CLIPS! MAKE SURE TO BEND ENDS IN SO THE WIRE DOES NOT POKE THROUGH FABRIC)

INSTRUCTIONS ON NEXT PAGE



CLOTH SURGICAL FACE MASK PATTERN INSTRUCTIONS



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Step 1: Cut 2 of pattern A fabric right sides together, cut 2 of pattern B fabric right sides together. Cut 2, 6.5in pieces of 1/4in elastic.

Step 2: Fold pattern A fabric 1/4in from end (as shown on pattern) top stitch down.

Step 3: Fold pattern B fabric 1/2in from end (as shown on pattern) top stitch down.

Step 4: With pattern A fabric right sides together, sew curved seam to create the center of mask with 1/4in seam allowance with a straight stitch. Clip curved seam to allow seam to lay flat.

Step 5: With pattern B fabric right sides together, sew curved seam to create the center of the mask with 1/4in seam allowance. Clip curved seam to allow seam to lay flat.

Step 6: Match pattern A and B at middle seam (nest seams) and stitch with 1/4in seam allowance both layers together at top and bottom (leaving ends open). Pattern A WILL BE LONGER THAN pattern B!

Step 7: Before turning right sides out, zig-zag stitch pattern A and B edges together at the nose of the mask (2in down from top point on both sides, 4in total).

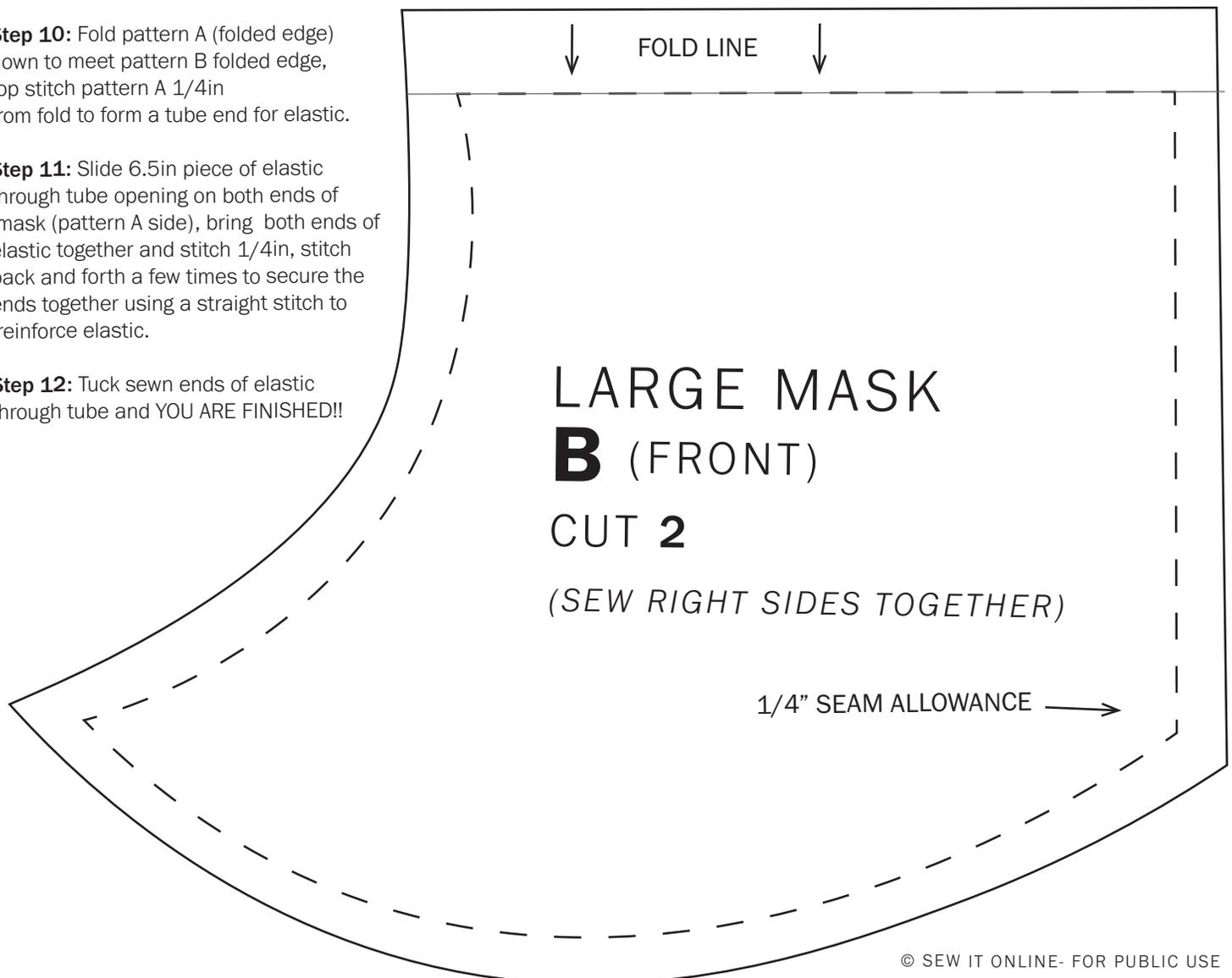
Step 8: Slide wire between 1/4in seam allowance and zig-zagged edge at nose point, bend slightly around the curve.

Step 9: Turn mask right side out using the side openings.

Step 10: Fold pattern A (folded edge) down to meet pattern B folded edge, top stitch pattern A 1/4in from fold to form a tube end for elastic.

Step 11: Slide 6.5in piece of elastic through tube opening on both ends of mask (pattern A side), bring both ends of elastic together and stitch 1/4in, stitch back and forth a few times to secure the ends together using a straight stitch to reinforce elastic.

Step 12: Tuck sewn ends of elastic through tube and YOU ARE FINISHED!!



CLOTH SURGICAL FACE MASK PATTERN

INSTRUCTIONS ONLY



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SUPPLIES:

Fabric scraps (*Need 1 light and 1 dark color fabric for visible contrast*)

Sewing machine or serger

13in of 1/4in elastic (*any narrow elastic works*)

3in wire (*thinner gauge enough to bend and hold for nose piece. Can even use paperclips! Make sure to bend ends in so the wire does not poke through fabric*)

STEP 1: Cut 2 of pattern A fabric right sides together, cut 2 of pattern B fabric right sides together. Cut 2, 6.5in pieces of 1/4in elastic.

STEP 2: Fold pattern A fabric 1/4in from end (as shown on pattern) top stitch down.

STEP 3: Fold pattern B fabric 1/2in from end (as shown on pattern) top stitch down.

STEP 4: With pattern A fabric right sides together, sew curved seam to create the center of mask with 1/4in seam allowance with a straight stitch. Clip curved seam to allow seam to lay flat.

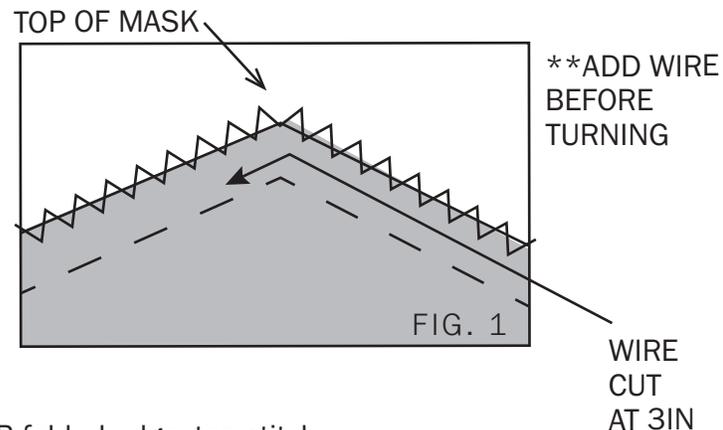
STEP 5: With pattern B fabric right sides together, sew curved seam to create the center of the mask with 1/4in seam allowance. Clip curved seam to allow seam to lay flat.

STEP 6: Match pattern A and B at middle seam (nest seams) and stitch with 1/4in seam allowance both layers together at top and bottom (leaving ends open). Pattern A WILL BE LONGER THAN pattern B!

STEP 7: Before turning right sides out, zig-zag stitch pattern A and B edges together at the nose of the mask (2in down from top point on both sides, 4in total). (See FIG. 1)

STEP 8: Slide wire between 1/4in seam allowance and zig-zagged edge at nose point, bend slightly around the curve.

ZIG-ZAG FABRIC LAYERS AT TOP OF MASK (FOR NOSE)



STEP 9: Turn mask right side out using the side openings.

STEP 10: Fold pattern A (folded edge) down to meet pattern B folded edge, top stitch pattern A 1/4in from fold to form a tube end for elastic.

STEP 11: Slide 6.5in piece of elastic through tube opening on both ends of mask (pattern A side), bring both ends of elastic together and stitch 1/4in, stitch back and forth a few times to secure the ends together using a straight stitch to reinforce elastic.

STEP 12: Tuck sewn ends of elastic through tube and YOU ARE FINISHED!!

How to make a Face Mask

What you will need

- Cotton fabric, a pretty print is best.
- Rope Elastic, beading cord elastic will work (you may also use 1/8" flat elastic)
- Cut the elastic 7" long and tie a knot at each end (DO NOT knot the ends of the flat)

You can make two sizes: Adult or Child

1. Put right sides of cotton fabric together
 - o Cut 9x6 (Adult) or 7.5 x 5 (Child)
2. Starting at the center of the bottom edge, sew to the first corner, stop. Sew the elastic with the edge out into the corner. A few stitches forward and back will hold this.
3. Sew to the next corner, stop, and bring the other end of the same elastic to the corner and sew a few stitches forward and back.
4. Now sew across that top of the mask to the next corner. Again put an elastic with the edge out.
5. Sew to the next corner and sew in the other end of the same elastic.
6. Sew across the bottom leaving about 1.5" to 2" open. Stop, cut the thread. Turn inside out.
7. Pin 3 tucks on each side of the mask. Make sure the tucks are the same direction
8. Sew around the edge of the mask twice.

It is so easy to make this.

Be sure any fabric design is placed horizontally.

