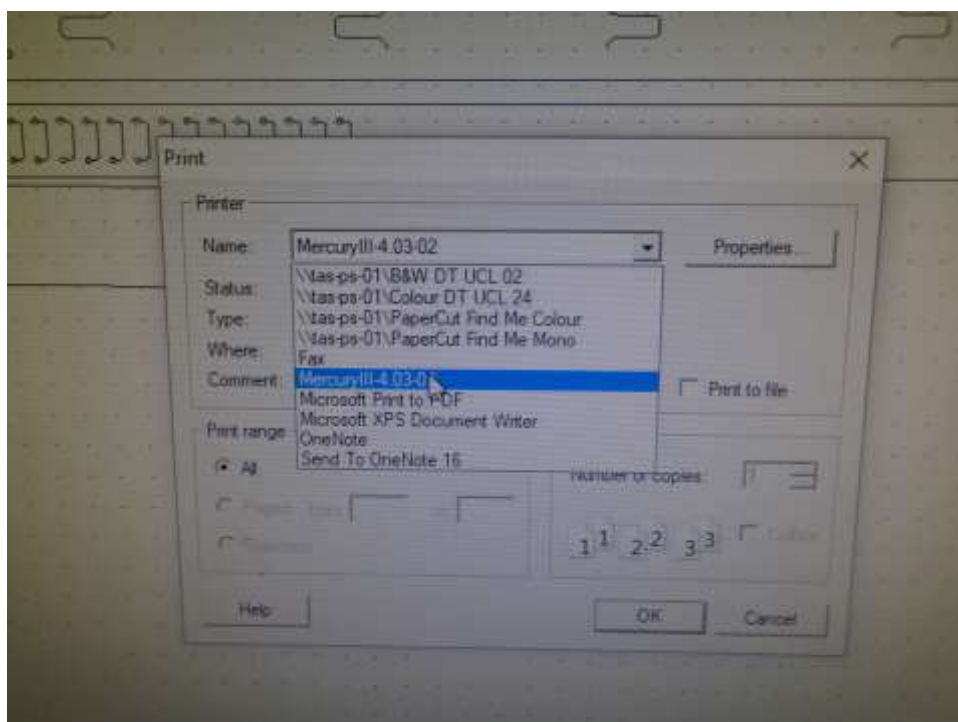
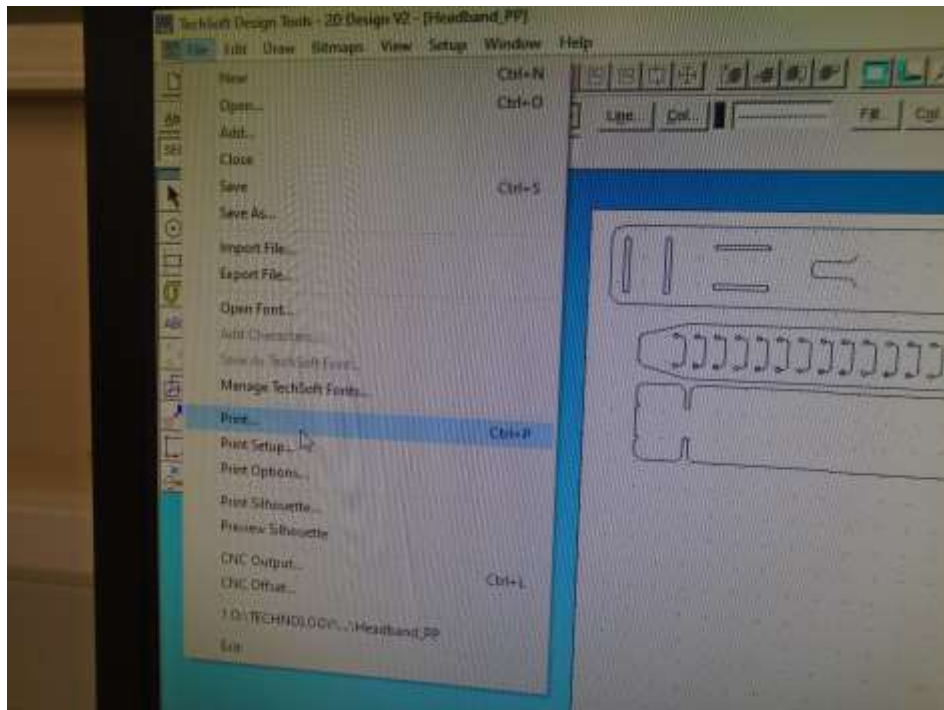
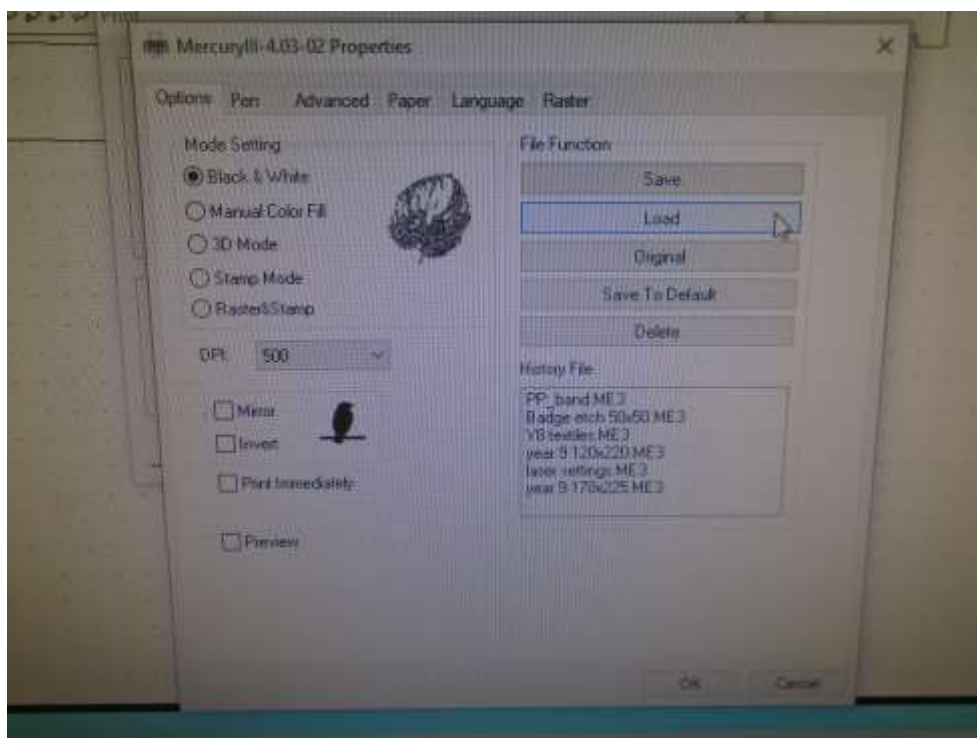
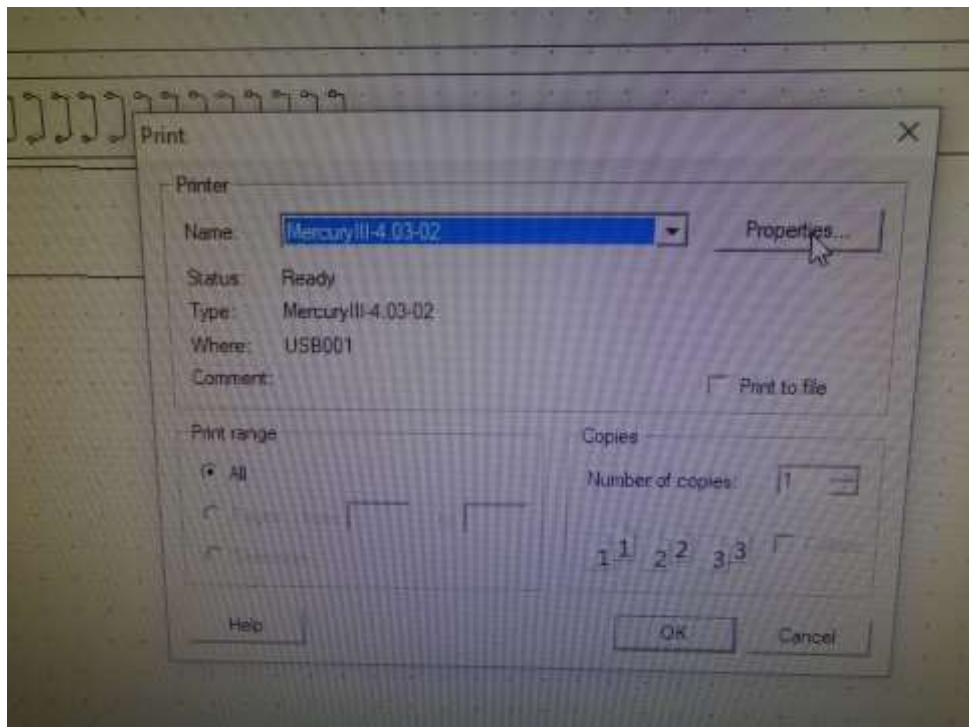


Feeds and speeds for 0.5mm Polypropylene sheet

NORMALLY JUST follow these instructions, but, feeds speed and paper sizes are included below.



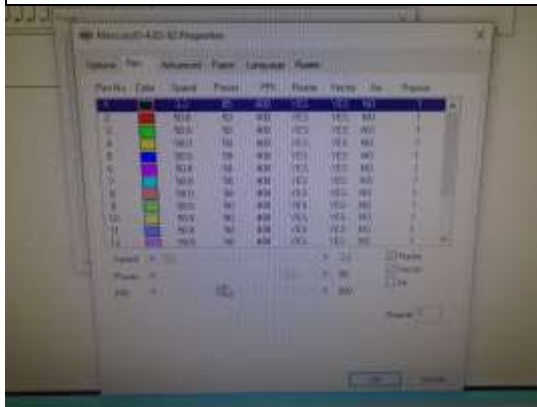


**load PP band V2.ME3 (found in
O:\TECHNOLOGY\COVID-
19_full_face_mask_2020\PP_band_V2.me3) and
pen/paper setting will automatically load. JUST
CHECK!**

If unable to load/locate file follow the below setup.

Pen settings

SPEED	2.4
POWER	96%
PPI	600



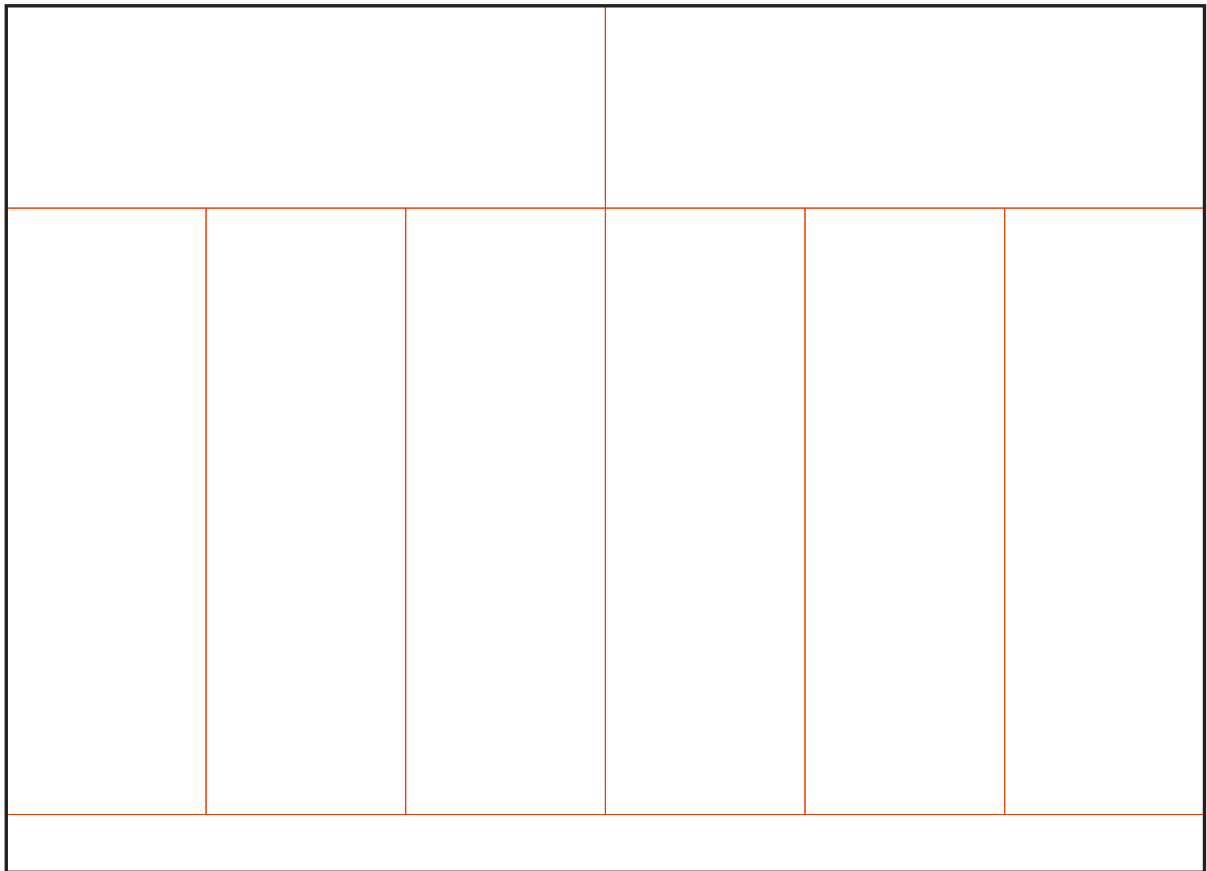
Paper size

X	420.00mm
Y	270.00mm
CLICK METRIC	



CUT OUT Polypropylene BLANKS to 525mm x 175mm

Lay out as shown on sheet
(1050x750mm)



One sheet makes **8 blanks.**

8 blanks make 2 headbands each.

Yield: 16 headbands in total per sheet.



use template to mark out 8 blanks.

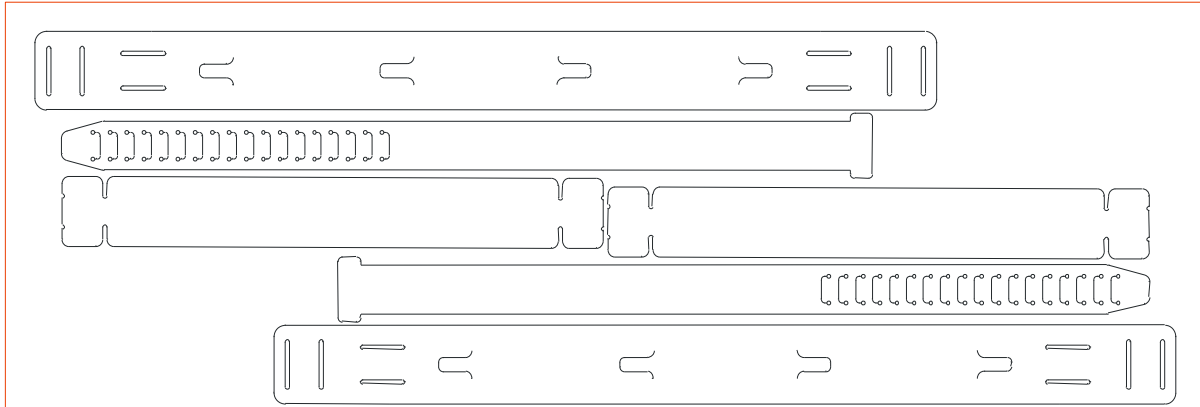


Cut in half with guillotine.



Start to chop up the other blank. Place in tray ready to laser cut.

LASER CUTTING BLANKS



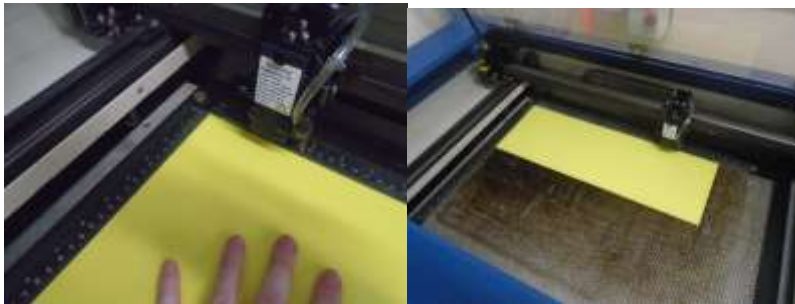
Make sure laser setting are set up.



ENSURE the extraction
is on and drawing air at
the back of the laser.

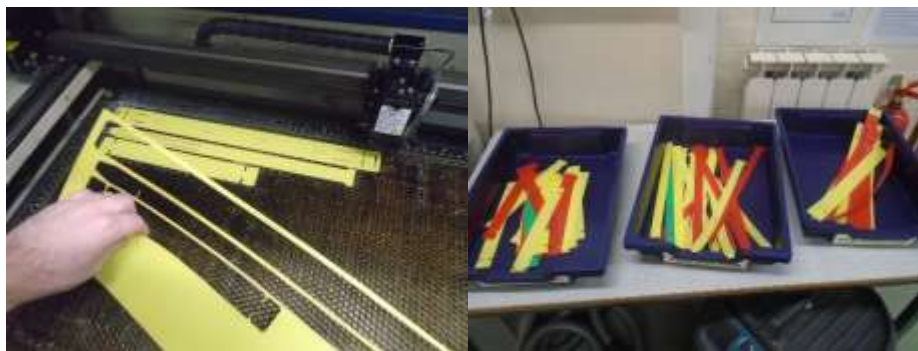


- 1) Align PP blank in the top left corner **LANDSCAPE** orientation.

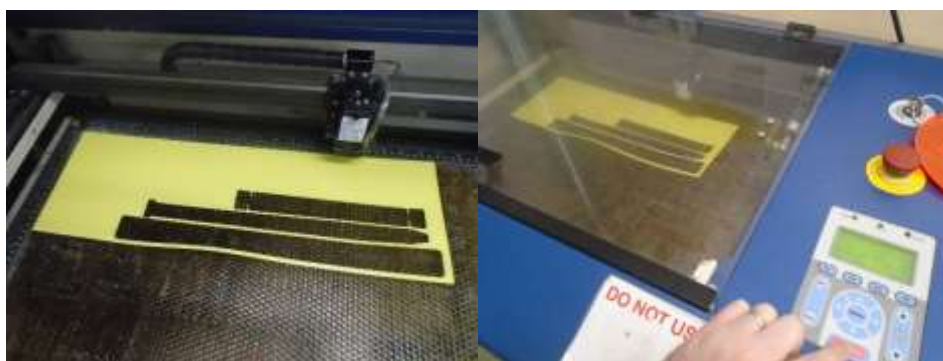


- 2) Close the lid, press start/stop once and the laser will start.

- 3) The laser will automatically stop after about 2.50 minutes. Remove waste, if it's all working properly the blank should lift freely away leaving the cut products. Store them in the trays provided.



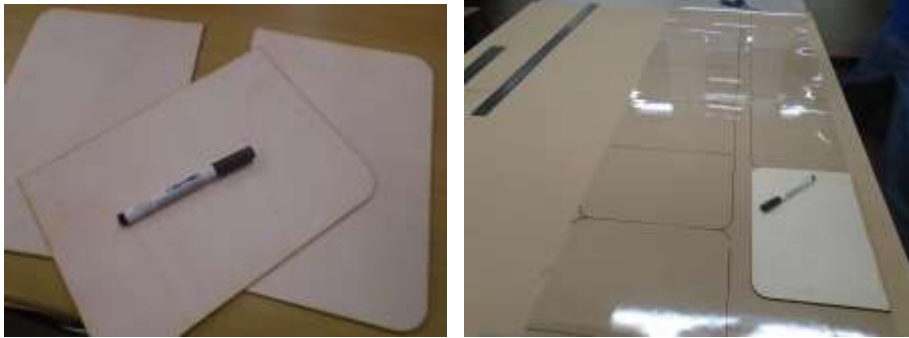
- 4) Flip the master 180° for the second cut. Press Start/stop again.



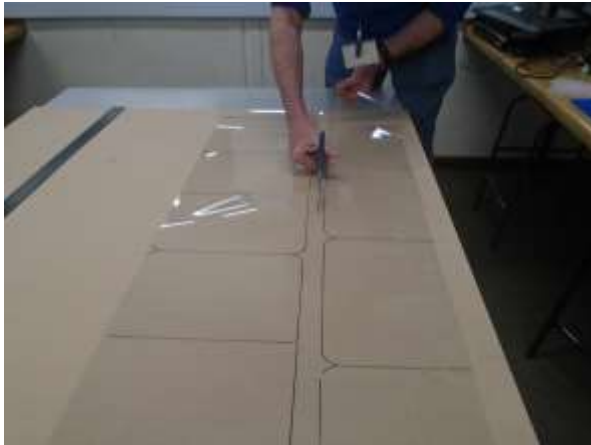
- 5) Repeat steps 1-4.

NOTE: you may need to vacuum out the laser bed if excess offcuts are building up.

SHIELD MANUFACTURE



Draw around templates with dry markers. Follow the arrangement indicated for minimum waste.



Rough cut down centre with scissors.



Use guillotine to cut straight edges.



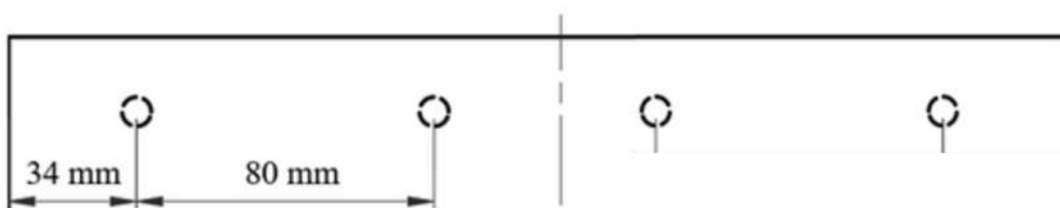
Use scissors to cut (round) the 2 corners.



Use a cloth to remove dry marker.



Hole punch the long, NON rounded side using the 4-hole punch. It's been set up. **DO NOT ADJUST**. If needed the dimensions are below.



ASSEMBLY



