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 repellant fabric, such as durable 55%/45% polyester/cotton blend or similar
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 3” apart - EVEN with the edge of the fabric (**tip: create a 3” 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
Each mask uses 4 cut pieces of fabric. For added durability, you can use zig-zag stitch and backstitching as deemed necessary.

1. If not yet assembled, pin two pieces together on side where pattern indicates First Seam line, pinning ends of elastic inside, between pieces where indicated by notches.

2. Following the First Seam line on pattern, sew seam using a 1/2 inch seam allowance for GREEN fabric (regular size mask) or 5/8 inch for BLUE fabric (small mask).

3. Turn two halves inside out so that the straps are exposed.

4. Line up and pin the center (nose) seam.

5. Sew both sides together through all 4 pieces of fabric approximately width indicated on pattern.


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.
Mask Cover Pattern
Cut 4

First seam, this side
Sew 2 pieces together, then next 2 together

1/2 inch seam for regular mask
GREEN FABRIC

5/8 inch seam for small mask
BLUE FABRIC

Second seam, this side

Elastic- put between 2 pieces

Sew elastic into seam at notches

Revised 3/26/2020