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
- 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 – 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 small size N95 and a 1/2” seam for a regular 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.
Mark dots for elastic

1/2 inch seam for regular mask

5/8 inch seam for smaller mask

Match notches for center seam