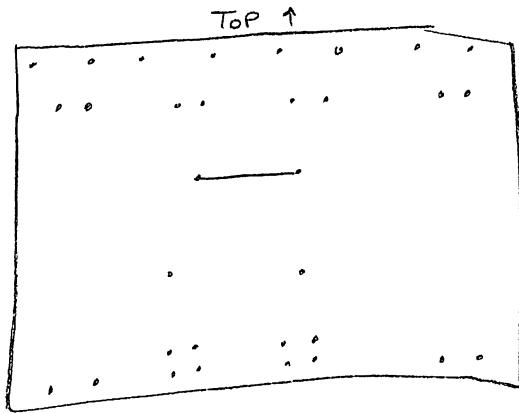


HAUL BAG

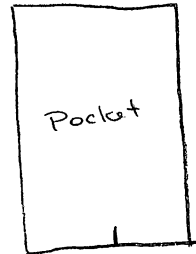
INSTRUCTION SHEET

Pieces

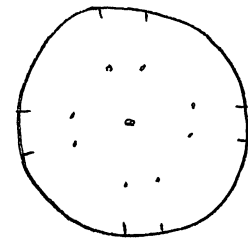
Vinyl



1 - piece



1 - piece



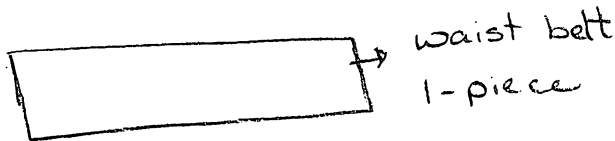
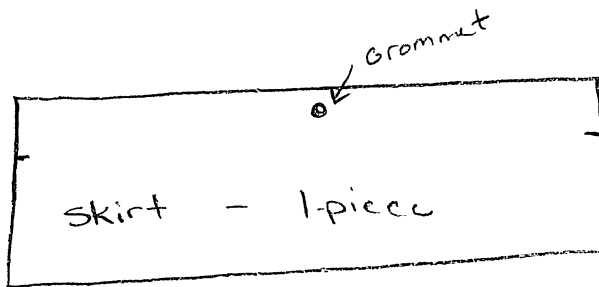
Bottom
w/ grommet
- 1 piece

waist
belt holder



1 - piece

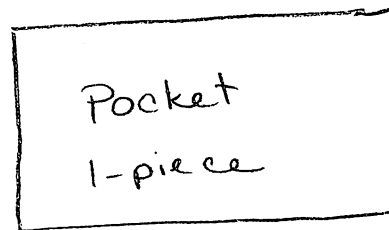
Packcloth



waist belt
1-piece



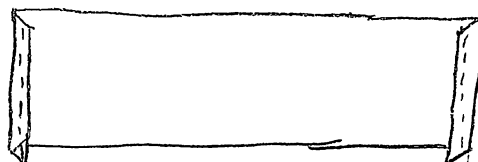
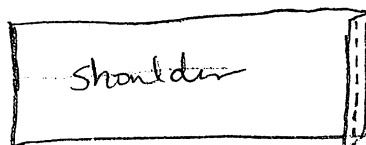
→ shoulder
strap
2 - pieces



1st step

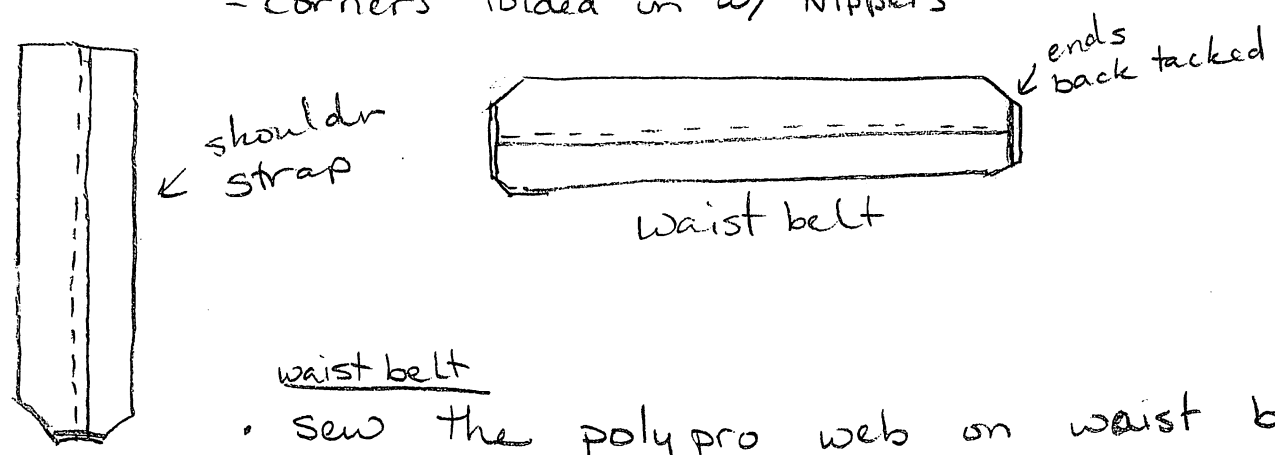
• sew $\frac{1}{4}$ " seam - folded once over on one end
of shoulder straps - both ends of waist belt

ie. →



2nd step

- Put foam inside shoulder straps & waist belt
- The Christmas package step
 - corners folded in w/ Nippers



waist belt

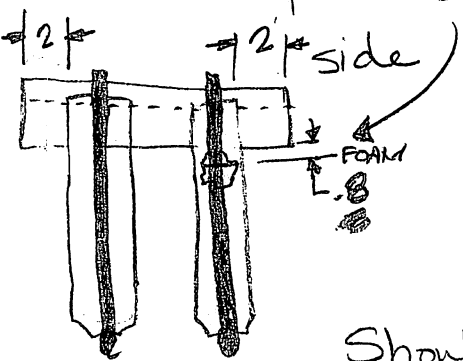
- Sew the polypro web on waist belt back tack ends & sew down each side
- put on buckle



shoulder straps

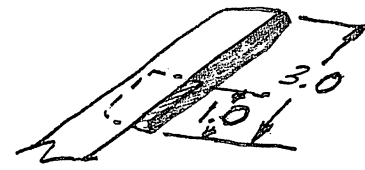
- Sew on the 1" flat web w/ the 1" tension lock two tacks to start then every 2" (approx) and bar tack - 4 times

- Sew shoulder straps on to the 14.5" piece of 2" seat belt - aprox 2" in on each



Shoulder Strap Attachments

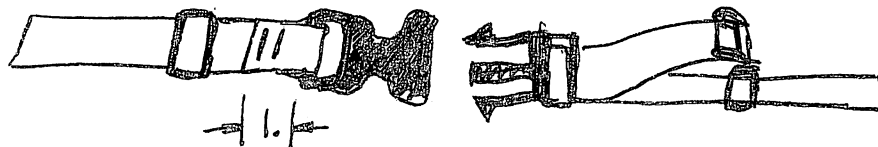
- 2-pieces of 32" flat web
 - ↓ sew all 3 down 3-tacks



Sternum Strap

- Female side

12" piece - 2 tacks



- Male side

- 2 sliplocks

18" piece - tack end

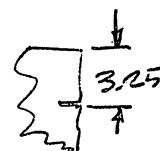
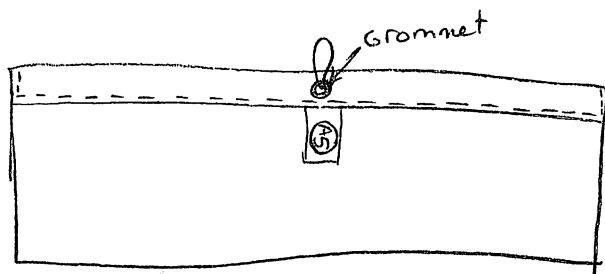
Skirt

- fold top edge at approx $\frac{1}{4}$ " - then fold over to cut mark

- Put in the lace

- Sew the length

- Put in the label



- Fold in half - take $\frac{1}{2}$ " seam

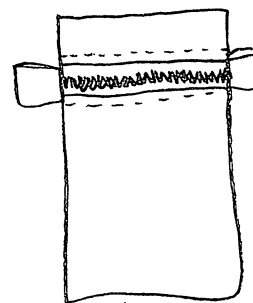
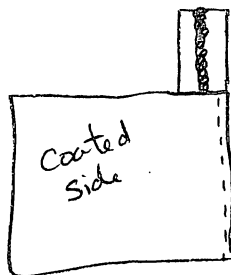
- Open ^{at seam} sew on top just over the folded part - back tack

Pocket

- #7 zipper -

lay zipper down & with packcloth coated side up
sew to zipper

- fold over &
stitch



Finished Pocket

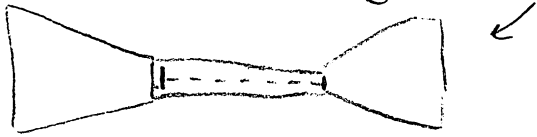
- Do the same to the other side

- Put on the sliders - one per pocket

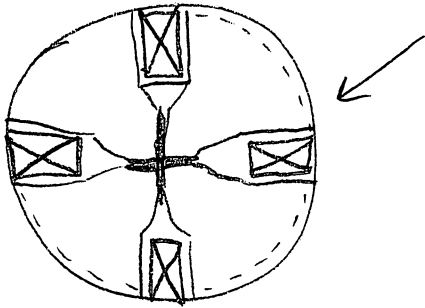
- With the pocket inside out sew together with the 4" piece of seam tape - back tack

Bottom

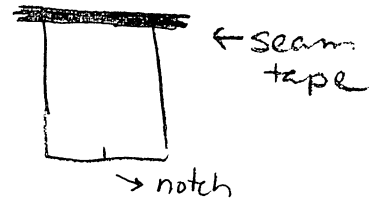
- Sew super tape into the 2" seat belt web the candy wrapper step



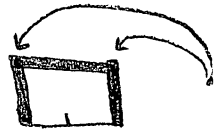
- Put the handles onto the bottom w/ box X

Vinyl Pocket

- seam tape top of Vinyl Pocket

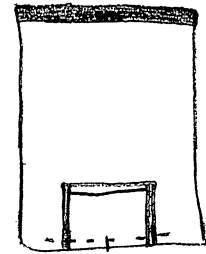


- seam tape 3 sides of small Vinyl piece



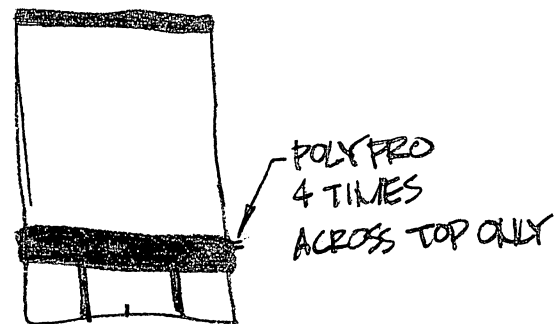
single edges w/ hot cutter

- Sew small piece to larger at notches

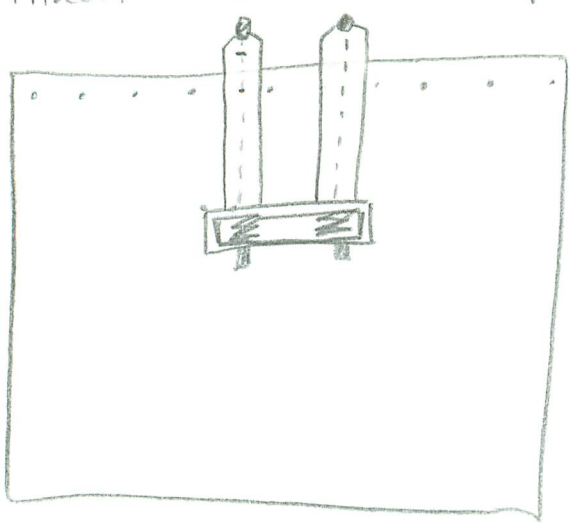


- once across bottom
- four times in seam tape at top

- Sew poly-pro scuff on top of small piece pass across 4 times

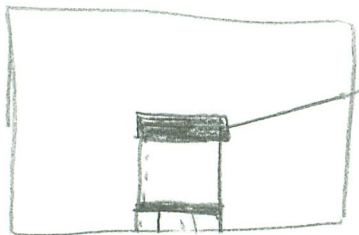


- Attach Shoulder straps to haul bag body



- First sew box
- Second time around
Sew Zig-zag's across
shoulder straps

- Attach Vinyl Pocket to body



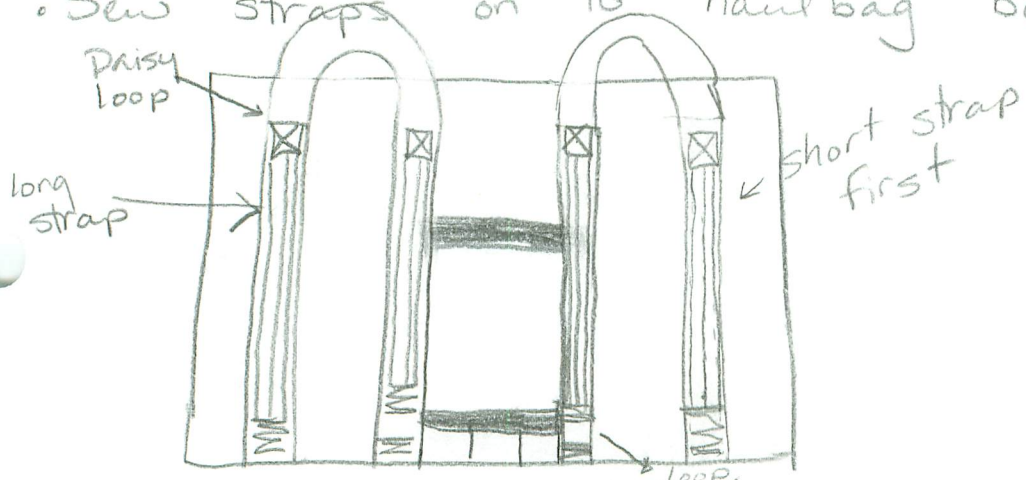
2" scuff
15" 5 BAR

- sew across bottom
- Sew up (hold poly-pro scuff)
- remember top scuff
- Sew across
- Back up (3 times in all)
- Sew again
- Sew down

← CHANGE TO 92 Thread →

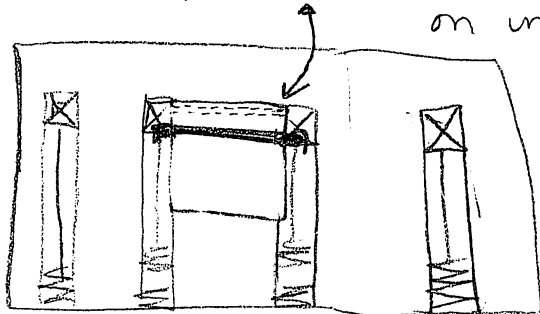
- Sew $\frac{9}{16}$ " super tape into haul straps
- keep track of short & long ones

- Sew straps on to haul bag body



Don't forget
Daisy loop
under long
strap

- Sew pocket on inside
2 parallel stitches
on inside



Sew haul bag together

- 2 stitches - 1st one at $\frac{1}{2}$ " - 2nd one inside that
- Seam tape

Scuff guard

- line up with bottom
- sew starting at middle of vinyl pocket
- 4 times around

Bottom

- sew it on - wrestle with it ≠ WIN!
- 4 times around

Top

- Sew skirt & the "cute" little loops to the top
- Sew on top scuff ^{TAPE} 3 times around

→ turn

GRADE VI HAULBAG (batches of 4)

5 BAR SEATBELT WEBBING

- (4) 1 @ 119" (59.5 x 2) long haul strap
- (4) 1 @ 110" (55 x 2) short haul strap
- (8) 2 @ 21" bottom strap
- (8) 2 @ 15" shoulder straps scuff

4 BAR SEATBELT WEBBING

- (4) 1 @ 58" top stiffener

2" Flat 1 @ 52" waist belt

1.5" FLAT WEBBING

- (4) 1 @ 58" bottom scuff
- (4) ~~1 @ 52" waist belt~~
- (4) 1 @ 14.5" scuff above waist belt

1" FLAT WEBBING

- (8) 2 @ 32" **CUT AT ANGLE** shoulder strap bottom attachment
- (8) 2 @ 23" shoulder strap top
- (4) 1 @ 18" **CUT AT ANGLE** sternum (male side)
- (4) 1 @ 12" **CUT AT ANGLE** sternum (female side)

3/4" TUBULAR WEBBING

- (4) 1 @ 10" scuff side daisy loop

9/16" TUBULAR WEBBING

- (40) 10 @ 4" top pull loops
- (4) 1 @ 69" draw cord for pull loops

9/16" SUPERTAPE WEBBING

- (8) 2 @ 6" inside of bottom handles
- (8) 2 @ 10" inside of top handles

LACE

- (4) 1 @ 69" draw cord for packcloth skirt

3/8" FOAM:

- (4) 1 waist belt
- (8) 2 shoulder straps

PACKCLOTH:

- (4) 1 waistbelt
- (8) 2 shoulder straps (same color)
- (4) 1 pocket
- (4) 1 skirt **grommet (webbing reinforcement/noncoated side)**

VINYL:

- (4) 1 waistbelt patch **1 cut** (smallest piece)
- (4) 1 bottom **8 marks, 8 cuts, 1 grommet (reinforcement/rough side)**
- (4) 1 back piece **1 cut**
- (4) 1 main body **9 cuts, 31 marks (includes line)**

DELUXE HAUL BAG (batches of)

Jan '96

2" 5 BAR SEATBELT WEBBING:

- () ~~1 @ 23"~~ ~~1 @ 14"~~ handle
- () 1 @ 114"
- () 2 @ 21"
- () 2 @ 15"

2" 4 BAR SEATBELT WEBBING:

- () ~~2 @ 58"~~

2" FLAT WEBBING:

- () 1 @ 52"
- () 1 @ 4 1/2"

1 1/2 " FLAT WEBBING:

- () ~~1 @ 38"~~ D
- () 1 @ 14.5"

1" FLAT WEBBING:

- () 2 @ 32" **cut at angle** shoulder strap bottom attachment
- () 2 @ 24" shoulder strap top
- () 1 @ 18" **cut at angle** sternum--male side
- () 1 @ 12" **cut at angle** sternum--female side
- () 1 @ 48"
- () ~~2 @ 20"~~ D
- () ~~2 @ 6"~~ D

1" FLAT--COLORED--WEBBING:

- () 1 @ ~~34"~~ 34"
- () 1 @ 27"

3/4" TUBULAR WEBBING:

- () 1 @ ~~12"~~ 12"

9/16" TUBULAR WEBBING:

- () 10 @ 4"
- () 1 @ 69"

11/16" SUPERTAPE WEBBING:

- () 2 @ 6" inside of handles
- () 2 @ 10" inside of handles

1/4" FOAM:

- () 2 ~~shoulder straps~~ (same size as 3/8")
- () 1 ~~waist belt~~ " " "

1/2" FOAM:

- () 2 shoulder straps (same size as 1/4")
- () 1 waist belt " " "

PVC VINYL (blue):

- () 1 ~~scuff~~ 5x56 1/2

(OVER)
FLIP PAGE

URETHANE VINYL (yellow):

- () 1 main body **31 marks (includes line), 9 cuts**
- () 1 bottom ** cuts, marks, one gromm. sm. webb. reinf./inside**
- () 1 back piece ** **
- () 1 waistbelt patch ** cut**

BALLISTICS CLOTH:

- () 1 skirt ** cuts, ~~one grommet sm. webb. reinf./inside**~~

CORDURA CLOTH:

- () 2 shoulder straps
- () 1 waist belt

PACKCLOTH:

- () ~~2 shoulder straps~~
- () ~~1 waist belt~~
- () 1 pocket

Haul bag & Pack Revisions-

- ~~Haul bag~~

- Grade VII body -

- Grade VII Ballistics skirt.

✓ - Add $1\frac{1}{2}$ " each side of ~~waist~~ waist belt.

✓ - Add $\frac{3}{4}$ " width of shoulder & waist
Pattern -

✓ - 5 bar bottom scuff ✓

✓ - handle

Haul Pack -

- Pocket from Alpine -

- Skirt

- 5 bar Bottom Scuff

VINYL ~~EVI~~

- SHOULDER STRAPS $\frac{1}{4}$ " UNDER ONE END
- HIP BELTS " " BOTH "
- FOAM - FOLD END IN $\checkmark$ ON SHOULDER STRAP
- SEAM DOWN CENTER OF FOAM
- WAIST BELT FOLD BOTH ENDS SEAM DOWN CENTER
- WEBBING 1" w/ 1" TENSION LOCK 23", TACK EVERY 2" FOR SHOULDERS
- 1.5" POLYPRO FOR HIP BELT 152" + 1.5" DUCKLE
- 32" of 1" FOR LOWER SHOULDER CONNECT
MAKE LOOP
- STERNUM STRAP 12" + 18" of 1", 1" BUCKLE &
2 ~~SLIP~~ SLIP COCKS - 12" to female END
2 TACKS
- SKIRT FOLD UNDER $\frac{1}{4}$ " MATCH TO NOTCH STITCH
DRAWSTRING INTO SEAM STITCH TO GROMMET
PUT IN LABEL STITCH STRING INTO SEAM
AT OTHER END. STITCH COATED SIDE DOWN
- POCKETS, #7 zipper DON'T FORGET
SLIDERS
~~SEAM STRAP~~
- SHOULDER STRAPS TO 2" SEAT BELT 14.5"
- SEAM TAPE SMALL VINYL SQUARES ALL SIDES
EXCEPT NOTCHED
- SEAM TAPE RECTANGLES SHORT UNNOTCHED
SIDE
- BOTTOMS 21" SEAT BELT @ 2 6" SUP. TAPE @ 2
MAKE CANDIES STITCH TO BOTTOM & NOTCHES
AND DOTS
- STITCH WAIST BELT PEICE TO RECTANGLES
4 ROWS AT TOP
- WAIST BELT SCUFF 4 SEAMS $\frac{1}{4}$ " ABOVE POCKET
- SHOULDER STRAPS TO BODY - SEW AROUND
twice - ZIG ZAG SECOND TIME

VINYL VI (2)

- STRAP POCKET OVER SH. STRAPS - SCUFF AT TOP 3 SEAMS $\frac{1}{4}$ " ABOVE POCKET
- HAUL STRAPS - DAISY LOOP ON LONG OUTSIDE
- POCKETS TO BODY
- CLOSE UP BODY - 2 SEAMS AND SEAMTAPE
- SCUFF GUARD ON BOTTOM 58" POLYPRO 4 SEAMS
- BOTTOM - 4 SEAMS
- SKIRT ON TOP DON'T FORGET 4" LOOPS AT EVERY DOT - Giant seam tape
- THREAD $\frac{9}{16}$ " THRU WEBBING
- STERNUM STRAP
- SHOULDER STRAPS
- HIP BELT

1

2

1
9
v

15
v

v

1

VINYL

IV.

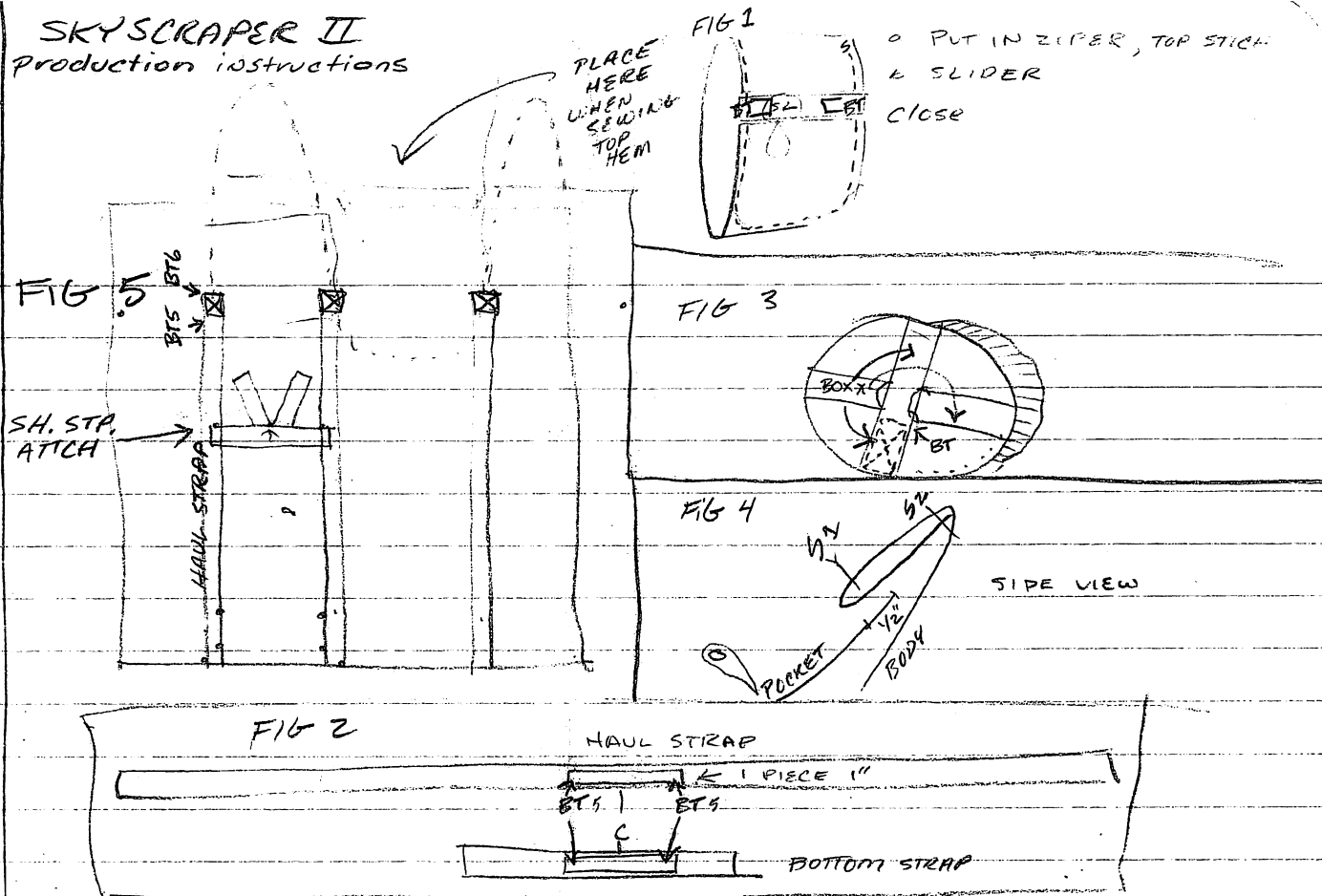
1

1

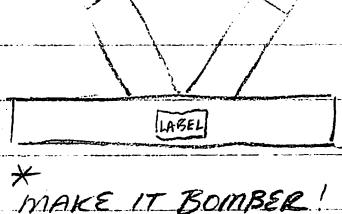
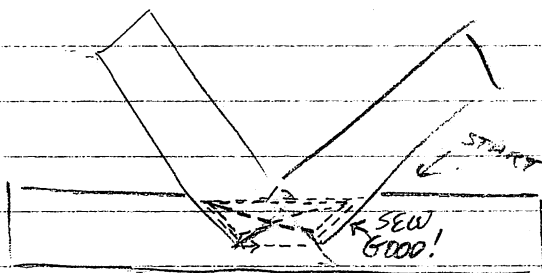
Hip belts $\frac{1}{4}$ " each end wrap foam
Shoulders $\frac{1}{4}$ " one end
Webbing to straps 23" x 1" + 1 tension
lock each
Two locks at base
tack every 2"
Straight steam at end
Poly pro to belts 52"

SKYSCRAPER II

Production instructions



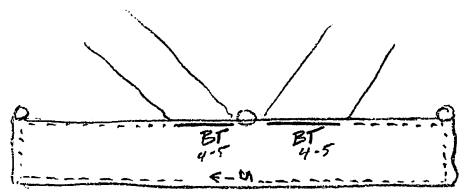
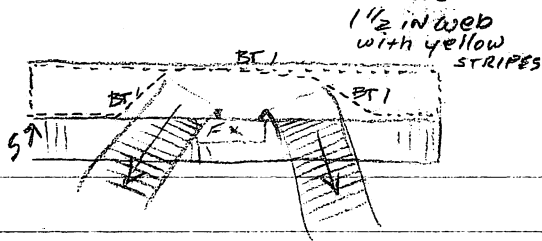
- 1.) SEW POCKET FIG 1 (PACKCLOTH #7 ZIP, ZIP TARS 4",)
1" TUBE to 2" SEAT BELT WEB
- 2.) SEW HAUL STRAP / BOTTOM STRAP REINFORCEMENT FIG 2
- 3.) SEW BOTTOM TO DBL. BOTTOM - once around (BALLISTICS)
SEW STRAP TO BOTTOM FIG 3 4 box X with Backtacks
at center 5 to 6 tacks.
- 4.) TAKE MAIN BODY AND ROLL TOP FOR GROMMETS 2 (BALLISTICS 2 sizes)
PLACE POCKET IN POSITION AND
SEW INTO THE ROLL. FIG 4 BACK TACK AT BOTH ENDS
OF THE POCKET
PLACE GROMMETS ON MARKS, #2 GROMMET
- 5.) MAKE WAIST STRAP TUBE (*)
(BALLISTICS, 2 sizes)
- 6.) MAKE CROSS STRAP (SHOULDER
2" SB. WEB)
STRAP ATTACHMENT. SEW ON LABEL (FX)
- 7.) SEW SHOULDER STRAP ATTCH. TO BODY* FIG 5



ONE GOOD HOLD
TACK TO HOLD
IT TOGETHER
UNTILL YOU SEW
IT TO BODY.

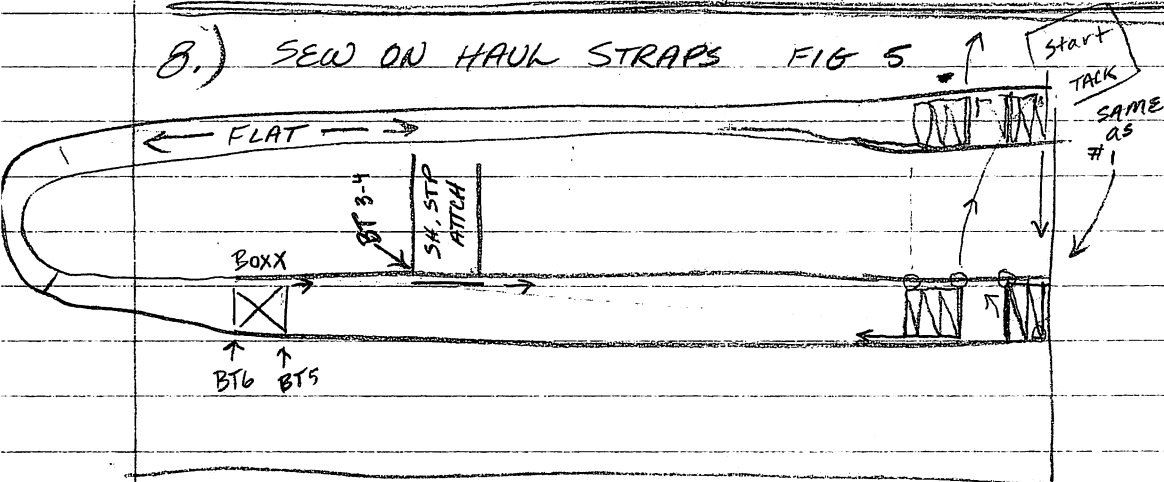
7 cont...

SEWING ON SH. STR. COVER



SEWING ON SHOULDER STRAP ATTACHMENT

8.) SEW ON HAUL STRAPS FIG 5

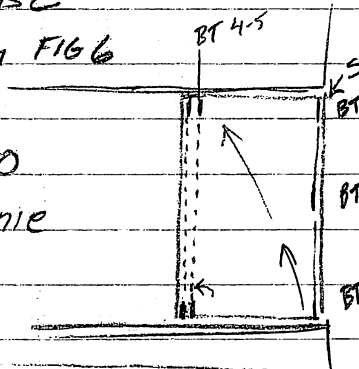


9.) SEW ON WAIST TUBE

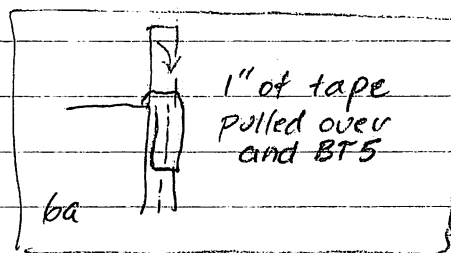
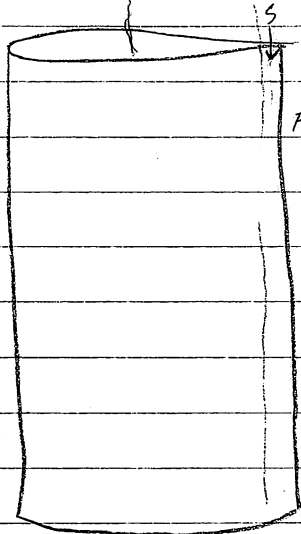
10.) CLOSE BODY 1/2 in seam FIG 6

11.) TAPE FIG 6a

12.) SEW 4th HAUL STRAP TO INSIDE (right side) same as 3rd strap.



3 BTs on the whole thing 3 times



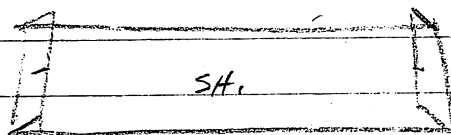
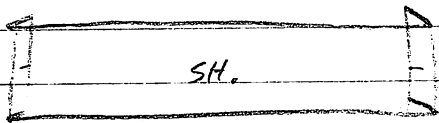
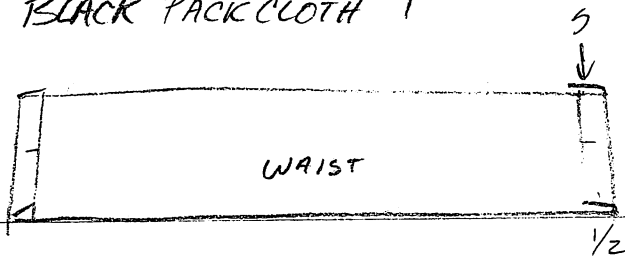
13.) SEW ON BOTTOM EDGE REINFORCEMENT 1 1/2 poly pro

14.) Sew in bottom, same as old 2-3 times

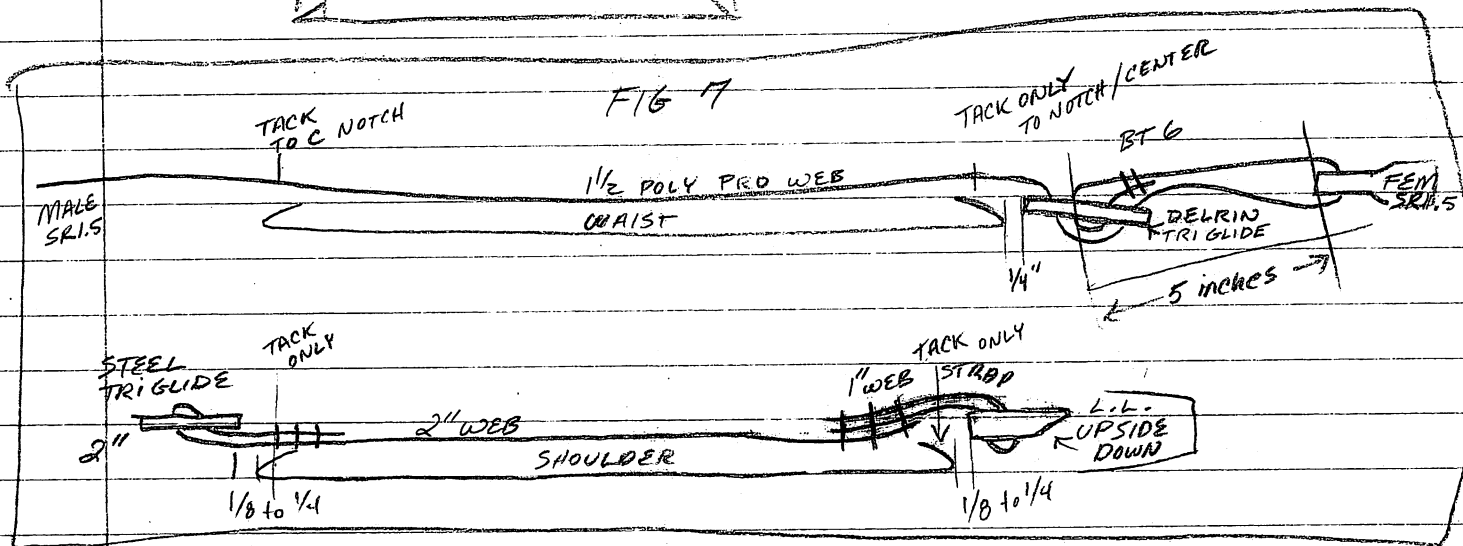
15.) TAPE

16.) SHOULDER STRAPS and waist belt

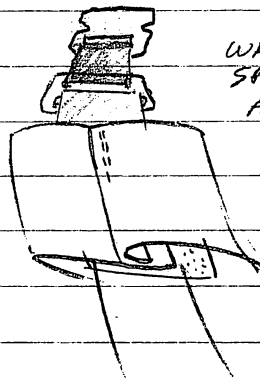
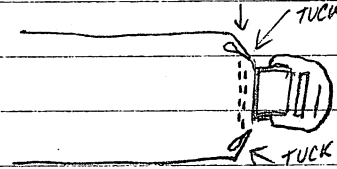
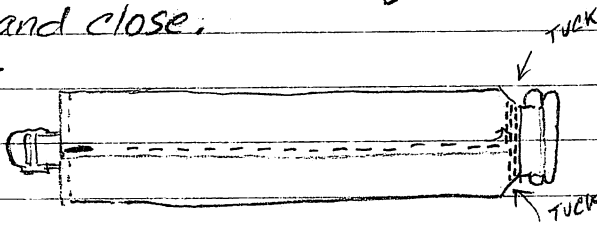
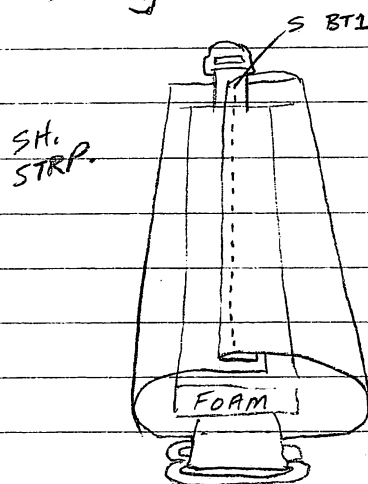
BLACK PACK CLOTH 1



- 1.) FOLD OVER $\frac{1}{2}$ in
and sew it down
 $\frac{1}{4}$ " from edge
(NOT A ROLL!)



- 2.) Sew buckles to web as in Fig # 7
- 3.) Lay in Foam and close.



WAIST BELT
SAME STEPS
AS SHOULDER
STRAP.