

PROCEDURE OF OUR BALLS

Please see our procedure of balls manufacturing as below.

1. CHOSE OF COVERING MATERIAL:

Covering material has been choosing accordingly customers specification. Cut to according standard size of 39 cm of pasting as covering material size is 54 cm

OBJECTIVE:

- 1) To cover customers demands.
- 2) Cut down by 54 to 39 cm help in easy pasting.
- 3) Help in accurate pasting
- 4) Help in equal distribution of fabrication implement on covering material.

2. INSPECTION OF COVERING MATERIAL:

Before lamination all covering material supposed to check accordingly as:

- 1) Equal distribution of colors.
- 2) No spot on covering material.
- 3) These above inspection used by special chemical in testing like rubbing the butyl on surface of covering material.
- 4) Equal desire gauge.

OBJECTIVE:

- 1) To avoid discoloration in covering material.
- 2) To avoid the chance of snuffing of printing after printing as some time spot on covering material do cause that problem.
- 3) Avoid the ball by unbalancing if it has two color combinations.

3. LAMINATION: (The Most Important Processes in Manufacturing of Balls)

In lamination process we used pure latex for reinforcing of

- PC Polyester + Cotton Mix**
- P Polyester**
- PV Poly Viscose**
- C Cotton**
- N Nylon**
- A Air mattress Sheet (To get Extra jump in ball)**

We make combination of above texture material according to the choice of customer and depending on prices as well as Quality of ball.

For instance: The match ball, we mostly used **PC + PV** and some time if customer give us good prices for match ball then we used **N + Pc + PV**, for training ball we mostly used combination of **P + PC** and some time **P + C** and for promotion Ball we used **C**.

OBJECTIVE:

- 1) Pure lamination give ball strengthens.
- 2) Better jump.
- 3) Decrease the chance of fungus.
- 4) Increase the life of balls

4. DYING:

However by seen it simple process but can effect the quality if it not done properly.

We used to dry the material by hanging them in shelves in sun shine so air and sun can pass through to them to make them dry, here we need to be very careful to not give them over heat or extra dry.

OBJECTIVE:

- 1) Proper dry provide us
- 2) Better shape of ball
- 3) Good jump to ball.

- 4) Avoid the fungus in ball.
- 5) Provide better absorption of ink during printing process

5. CUTTING: (Also the Most Important Processes in Manufacturing of Balls)

After checking the drying process we cut the ball according to panels and sizes, here we do care the ball which are going to cut, we separate each panels according to their weight

OBJECTIVE:

- 1) Accurate weight of ball panels provide proper roundness
- 2) Better jump.

Put those cutting panels on wooden plates and transfer them to printing department by written weight of each wooden plate so ball can not mix.

6. PRINTING: (One of Key Process, which helps to sell Balls fast in Markets)

All sketches briefing to printer given before start of work every day work either on paper or verbally.

We used different printing process of ink for promotional ball we used normal ink and for training ball we used HMK ink which help to remain in ball for certain time period like 1-3 months. then we used butyl proof ink which help to remain on ball for 3-5 months for match ball we also used butyl proof ink and for very expensive ball we used fulminated COATED film printing so design do not get off easily and remain on ball for longer time but these kinds of ink only used for brands because its very expensive ink,

OBJECTIVE:

- 1) Leave the printing ball for next 24 hours to let to dry properly so inks don't get off easily.
- 2) To provide proper time of drying of printing colors help to avoid the fungus in ball as well durability of printing.

7. BLADDER:

This is one of the most important materials in ball which can destroy even quality ball to zero, when bladder entered in our factory we filled the air and leave it for one day for checking their shape and linkage. Latex bladder has better quality to control swing as compare to Butyl bladder, Bladder is been weight with printed ball before go to stitching.

OBJECTIVE:

Good bladder improves the Shape and Jump of the ball.

8. STITCHING:

This is that kind of process which makes ball beauty or make ball ugly to look.

We used 100% polyester thread for promotional ball and for training and high quality ball we used polyester + nylon thread with wax which closed the seam of ball to prevent the water to not go in the ball

OBJECTIVE:

- 1) To get perfect seemed sewn of balls.
- 2) To get accurate jump of ball by nice stitching.
- 3) Close the seem to prevent the water do not go inside.

9. WASH / CLEAN:

After stitching completed ball come into cleaning purpose where ball been cleaned with Surf & Oil and then leave it for one day to get them dry.

OBJECTIVE:

- 1) Double checking of bladder if everything is ok then balls go to packing section.
- 2) Proper dry give us proper shine cleaned ball.

10. PACKING:

Customer sketch been given to packer with proper packing list.

OBJECTIVE:

- 1) Double check of customer designs by providing customer sketches of balls during packing.
- 2) Accurate packing numbers of boxes for desire customer demands.