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Tile-Sleeve Insertion Technique

Experience with the prototype modules has led to the conclusion that the insertion of the tiles into sleeves does not require any special tools. The technique described below requires less that 30 seconds per tile which we considered a good match to the tile production rate and approximately equivalent to the time required for the other tile handling operations such as removing molding flash, storage and packing.

1. Tiles and sleeves should be laid out on a clean work surface in a standard way so that the tile can be inserted with the correct orientation in a repeatable manner.

2. Gloves are worn to avoid hand contact with the tiles. Thin Latex or rubber gloves provide a better grip than cloth gloves on the Tyvek sleeves.

3. Pick up a tile in one hand. Blunt the sharp corners on the end of the tile which will be fed into the sleeve by dragging these 4 corners lightly over a paper surface. See Figure, Step A.

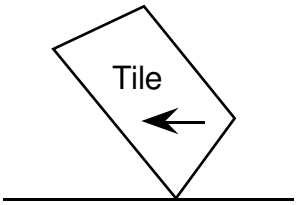
4. Pick up a sleeve in the other hand. Insert the corner at the short edge of the tile into the sleeve. Pull the sleeve against the tile to form a double creased opening in this edge of the sleeve. Figure, Step B.

5. Inserting the corner at the long edge of the tile. Form the opening at this edge of the sleeve. Figure, Step C.

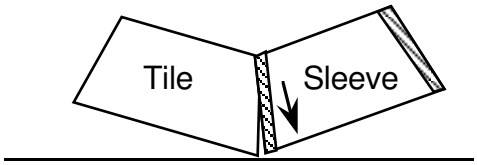
6. Rotate the sleeve while holding the sleeve against the long edge of the tile. The sleeve can be stretched slightly so that the corner at the short edge of the tile can be inserted into that corner of the sleeve. Figure, Step D.

7. Pull the sleeve over the tile. Figure, Step E.

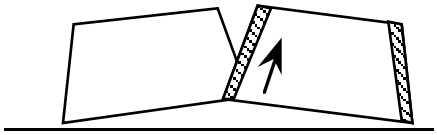
Tile Insertion into Sleeves



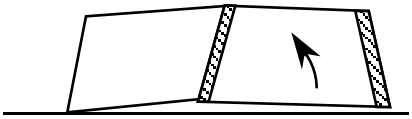
Step A



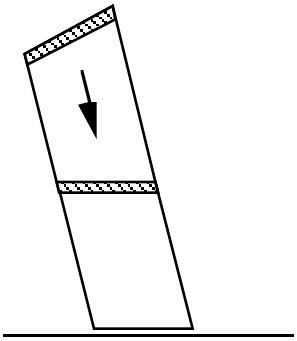
Step B



Step C



Step D



Step E