

FABRIC SPECIFICATION SHEET

PREPARE FOR GARMENT WET PROCESSING

STYLE: _____ CONSTRUCTION (woven/knit): _____

FIBER CONTENT: _____

WIDTH: _____ WEIGHT: _____

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Property	Warp (wales)	Filling (courses)	Test Method
Tensile (lbs)	_____	_____	ASTM D-1682
Tear	_____	_____	ASTM D-1424
Mullen Burst	_____	_____	ASTM D-3786
Seam Slippage	_____	_____	ASTM D-434
Shrinkage	_____	_____	AARCC 135

Fabric Has Been Mercerized	Yes _____	No _____
Fabric Has Been Preshrunk	Yes _____	No _____
Fabric Has Been Resin Treated	Yes _____	No _____
Fabric Has Been Bleached/Dyed	Yes _____	No _____
Fabric Has Been Skewed	Yes _____	No _____

Dye Type _____

Color Name/Number _____

Notes:

- For best results entire garment should be cut from one piece of fabric.
- Fabric should be tested for desired appearance following wet processing procedure intended to be used.

COMMON PROBLEMS AND PROBABLE CAUSES

Problem

Probable Cause

- | | |
|---|---|
| 1. Inconsistent shade within the same garment | Mismatched fabric used in assembly |
| 2. Inconsistent shade from garment to garment within the same batch | Inconsistent fabric colorfastness |
| 3. Inconsistent shade from batch to batch | Change in wet processing procedures, chemicals, or fabric performance |
| 4. Blotchiness or uneven shading | Poor techniques, e.g., overloading, improper introduction of chemicals, improper liquor ratios. |
| 5. Unraveled stitches | Poor sewing techniques or improper thread selection |
| 6. Holes along stitch lines (needle cutting) | Improper sewing or fabric finishing techniques |
| 7. Color migration from fabric to other garment component or vice versa | Failure to pretest components under exact wet processing conditions |
| 8. Undesirable loss of or change in color of thread or other components | See: #7, e.g., fiber reactive, sulfur or direct dyes are often severely affected by wet processing chemicals such as hypochlorite bleaches. |
| 9. Inordinate or unexpected shrinkage | Failure to pretest fabric under exact wet processing conditions |
| 10. Severe seam puckering | Component incompatibility or poor manufacturing techniques, e.g., uneven feeding during sewing, improper sewing tensions. |

Do's and Don'ts

Manufacturing:

1. The entire garment should be cut from one piece of fabric.
2. Fabric shrinkage should be considered prior to manufacturing the garment. This can be accomplished by a procedure such as AATCC Test Method 135, or any other agreed upon procedure.
3. Variation in shrinkage and color wash-down can be reduced if fabrics are grouped by process lot.
4. Select thread and other components based upon their compatibility and performance parameters in the wet processing procedure you expect to use.
5. To monitor shade consistency, test wash a patchwork blanket made with swatches taken from each roll in a style, color or process lot, to include a swatch from the standard sample.

Wet Processing:

1. Pretest individual garment styles for desired wet processing results.
2. If you change wet processing procedure or chemicals, pretest again.
3. Rigorously maintain exact processing conditions from batch to batch to achieve continuity of results.

A Special AAMA Bulletin from the Apparel Quality Committee

The Garment Dyeing and Wet Processing Subcommittee of AAMA's Apparel Quality Committee offers the following as a communication guide between the garment manufacturer and the wet processor.

GARMENT WET PROCESSING

The principal purpose for garment wet processing is to achieve certain aesthetic merchandising effects, e.g., appearance, comfort.

To enjoy consistent success in this endeavor, preparation and planning must begin with the manufacture of the fabric and garment components, not at the time that the garment is assembled and ready for wet processing.

Unlike fabrics used in garment dyeing which are predominantly 100 percent cotton, virtually all fiber types and blends, dyed and natural, are being subjected to wet processing. Precise knowledge of the behavior of fabrics, trim and other findings under the conditions of wet processing to which they will be subjected is mandatory for having a successful program.

Communication between the fabric and findings producers, the garment manufacturer, and the garment processor is a key factor in avoiding pitfalls resulting in substandard garments.

The form on the back page of this bulletin entitled **Fabric Specification Sheet Prepare For Garment Wet Processing** is a good starter in communication between the various parties in understanding the fabric characteristics.