

Fade-Out & Garment dye

Fade-Out washing aims to give the pieces an aged appearance due to color degradation.

It is an external aging process, so on the inside the garment, the color is more intense, although this difference diminishes near the edges.

The process can be applied to previously dyed pieces, however, the result may vary in tone after washing, for which we assume no responsibility.

The aging process is a delicate process and needs a careful study on the interaction between the dyeing, the finishing of the material and the process of corrosion, since several factors contribute to significant changes in shade.

Color fade is obtained from a chemical process with some characteristics, which are important to highlight:

- It is not possible to carry out samples in the laboratory, since it is not possible to reproduce, under laboratory conditions, the production conditions.
- For the same reasons as before, the result obtained in samples shows differences in relation to production. These differences are noticeable in terms of color (the color may have a different final shade), or in terms of uniformity.
- Long-sleeved items have a tendency to be accentuated with scratches, either on the opposite side of the seam, or random scratches along the sleeve. In the case of thin stitches, scratches may arise along the side seam. If there are pockets, they must be closed to avoid the accumulation of products inside them, giving rise to defects.
- The process has variations in intensity between pieces within the same match, so it is not possible to obtain a rigor of color and intensity between pieces. Scratches or spots may appear in certain areas of the parts, and it is not possible to control the derivative of the process itself. Therefore, it cannot be considered a defect.

It is advisable to carry out previous samples in all colors, materials and final models (namely printed and embroidered). The previous samples must be carried out in a sufficient quantity that allows their simulation in production, creating a SHADE BAND indispensable for production approval. Without the realization of the SHADE BAND, it is tacitly implied that all variations (of intensity, tone, risks or others) in production will be accepted.

All kinds of applications on the garment outside our company, are not our responsibility. It is not our responsibility for the print to get dirty or wear with this process.

The defect percentage is around 15%.

The process shows results of solidity in wet states that can vary between 2-3 (for very dark colors) and 3-4. The light solidity will depend on the color intensity, however, the process has a light solidity that varies between 2-3 and 3-4.

It is recommended to use special labels with the following indications:

- Wash at 30oC, separately
- Dry inside out

Do not expose for a long time and directly to bright lights or sunlight.

In terms of measurements, during fade-out/garment dye process the knitted/woven fabrics constrict and relax during the 4-5 following stages:

- Pre-wash
- Dyeing
- Stabilization

- Wash
- Specific rock wash (fade-out only)

We follow all Oeko-tex100 guidelines, and test previously all shrinking percentages of all fabrics and colors to confirm any variations and if the result is positive, we adapt all patterns with the respective percentages verified during the tests. However, a variation of up to 5% can be confirmed in some fabrics even after adjustments between sample and final production. Also, the same fabric can verify different variations on different colors up to 5% as well in the measurements.

Reactive Garment Dye

Garment dyeing answers fundamental questions for customer satisfaction and garment attractiveness.

The final desired aspect determines the process to be carried out, making it possible to obtain pieces with a "clean" appearance and excellent touch or pieces with vintage aspects, or even color combinations within the same piece (which in roll dyeing is only possible using print).

In order to obtain good quality final products, we recommend a set of good practices that are particularly important in dyeing the garment:

1. GOOD PRACTICES

The material must be previously prepared in order to obtain good hydrophilicity, dimensional stability and good sewing ability.

It is proven that substrates with different degrees of preparation (alkaline boiling, medium white, mercerization) and / or different batches with the same degree of preparation, do not have the same tinting capabilities.

➤ All components of the part must come from the same source - that is, all components of a part must belong to the same roll.

➤ All materials used to complete weight must have the same composition and type of prior preparation.

In addition to these circumstances, the following considerations should also be taken into account when dyeing parts:

All the materials (tapes, fabric applications, seams, ribs) included in the piece must be prepared together, or in case of impossibility, all components of the same dyeing game must have undergone the same preparation operation (alkaline boil, medium white, mercerization).

2. LAB-DIPS

The opening of color in the laboratory must always be carried out on the material to be used in production, that is, with the same texture and the same degree of preparation.

The opening of colors must always take into account:

Customer specifications

Process to be carried out (especially in the case of corrosion and / or fade-out processes)

Specific indication of the degree of preparation of the material to be used.

This data must be provided at the time of the color opening to avoid unexpected results and potential waste of time.

Whenever there is more than one material / composition in a piece, the color will be opened for the material in predominance, however, it is advisable that all materials are present at the time of opening colors so that the final result can be evaluated.

3. SAMPLES

Preliminary samples should be performed on all models.

The tests for the evaluation of dimensional stability and the evaluation of the behavior of components from different sources must be carried out under production conditions, even if it is not possible to perform them in the desired colors.

There are special processes for which it is essential to carry out a shade-band in order to assess possible variations in results.

4. PRODUCTION

In order to avoid wasting time and misinterpreting the order, it is very important that the production comes with the lab-dip code and the seal.

Samples performed and approved or shade-bands must always accompany the production.

Color differences between samples and production can range from 5 to 10%. This is due to the fact that they are made pieces, and therefore they cannot be too long in the dyeing process, running the risk of the piece being degraded.

All relevant recommendations should be included in the piece (such as, approximating the color for the approved labdip, pilling, etc.)

All metallic accessories should be avoided. In the event that it is absolutely impossible (case of zippers) they must be prepared to withstand the required dyeing and drying conditions. In the case of mesh pieces with metal fasteners, we recommend protecting the cursors to prevent them from being damaged.

All kinds of applications in the piece outside our company are not our responsibility.

Prints should be avoided before dyeing. However, there are some types of prints that support the dyeing conditions so we advise you to discuss in advance the most suitable technique.

In the event that the print was made on a panel before dyeing, we recommend that all components of the piece be subjected to the same conditions of thermosetting, thus avoiding differences in tone between the printed panel and the rest of the piece.

It is not our responsibility to have the print soiled or worn with the dyeing process.

The models must be studied in order to avoid loose ends:

Long sleeves should be sewn along the seams

Ribbons and belts must come in mesh bags (preferably in PES) Jackets and shirts must come closed

Flaps and pockets must be closed

Preferably the pieces should be dyed inside out, except for the specifics of the model or process.

The process has values for solidity to washing, water, friction and sweat that vary between 3 (for intense and dark) and 4 for medium and light colors. With regard to colors that contain special dyes in their composition, the value ranges tend to drop by one point. The light solidity test, according to our dye suppliers, assumes a value of 4, however this value is not controlled by our company. The test must be carried out by the customer.

The percentage of defects is 15%.

All measurements alterations are the same as indicated for fade-out process stated above.