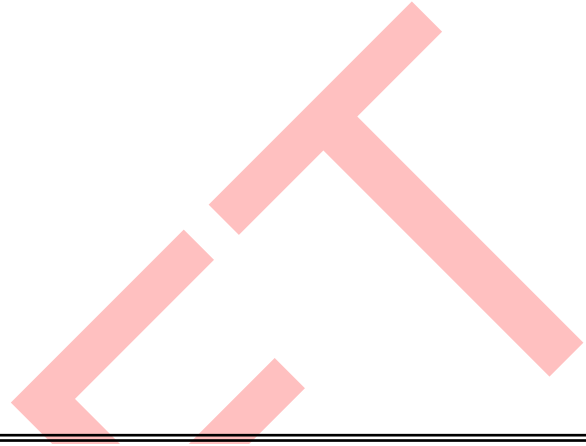




Guide lines for leather garment finishing

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Foreword

This Ethiopian Standard has been prepared under the direction of Technical Committee for Leather- and Leather products(TC 74) and published by the Ethiopian Standards Agency(ESA).

Draft of the standard has been presented by Ethiopian Leather Industry Development Institute.

Acknowledgment has been made for the organization for its concern to contribute to the effort of national standardization.

DRAFT

Guide lines for leather garment finishing

1. Scope

This standard provides guidelines for the various stages of garment finishing, ensuring final garment quality.

2. Normative References

The following standards contain provisions, which, through reference in this text, constitute provisions of the Ethiopian standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreement based on the Ethiopian standards are encouraged to investigate the possibility of applying the most recent editions of the Ethiopian standard indicated below. Registers of currently valid standards are maintained in the Ethiopian Standards Agency.

ES 3328 Standard Terminology Relating To Care Labeling For Apparel, Textile, Home Furnishing, and Leather Products

ES ISO 9001, Quality management system requirements

3. Terms and Definition

For the purpose of this standard, the definitions given in ES 3328 shall apply.

4. Leather garment finishing operations

4.1. Trimming

Trade trimmer is a cutting instrument used to cut out unwanted excess thread from the finished products. There are different kinds of trimmer instrument in garment manufacturing:

- a) Attached with sewing machine, to trim when you finished stitch formation
- b) Hand-operate, to trim when you finished stitch formation and unwanted thread
- c) Trimmer machine, to trim unwanted thread on the whole finished garment with trimmer machine

Thread trimming tool is a very important tool used to fuse excess thread after stitching.

Thread Trimmer is used to trim excess thread after stitching of the components or products in the sewing machine. It is also used in final finishing of the products to trim excess thread, left un-noticed.

In the finishing process of leather garment, excess threads have to be removed carefully in manufacturing units. The quality of the product is maintained by quality checkers, who are responsible for the work. Thread trimming tool is a very important tool used to fuse excess thread after stitching.

4.1.1. Precaution of Thread trimming Machine:

- a) Trimmer not cutting cleanly
- b) Tension release not working properly causing the thread to pull back out of the needle when the thread is trimmed
- c) Thread caught in trimmers
- d) Make sure the Thread trimmer is operating properly
- e) The trimming knives and sharp and trim the needle and bobbin thread cleanly.
- f) The tension release mechanism is working properly so a needle thread tail is left allowing it to be picked up at the beginning of the next stitching cycle.

4.1.2. Stitch Ripping

A seam ripper is a small tool used for unpicking stitches. The most common form consists of a handle, shaft and head. The head is usually forked with one side of the fork flattening out and becoming a blade and the other side forming a small point.

4.1.3. Stitch Repairing

Stitching repairing needle is a tempered steel needle. One end of it is flattened with a groove to pull the thread. The flattened head is made very sharp so that it can pierce into the fibrous leather components easily. It is generally known as cobbler's needle. It is used for stitching handles and also for joining component where machine stitching is not possible.

4.2. Cleaning

Cleaning brush is used to clean unwanted materials on the surface area of finished leather garment. The cleaning brush fibers must be soft because it would not damage the area of finished leather garment.

4.2.1. Cleaning excess materials (adhesives, thread, and others)

Leather is a difficult material to take care of. In the manufacturing of garment and goods we should carry out cleaning excess material after finishing the whole operation. In order to clean excess adhesive remove any wet or dry glue from your finished leather garment and goods with help of plastic wrapper.

4.2.2. Cleaning markings

Marks can be removed by rubbing gently with a suede cleaning block, a hard rubber eraser, or by touching up the surface with a fine emery paper. Spray new/clean items with a specialist leather protectant to help retain its color and appearance. Ensure you raise the nap before spraying by using a soft brush

4.3. POLISHING

Leather garment polishing brush is used to polish with appropriate wax on finished leather garment where it required.

Polishing is the process of smoothing and shining the surface of leather garment by rubbing. After cleaned adhesive and thread polishing leather part in appropriate wax with smother cloth or towel helps to enhance the look of the product and retain leathers natural characteristics. Polishes enhance the color and provide a protective layer from light rains and spills.

A polish conditions and helps retain leathers natural oils. It masks scuffs and marks, enhances the color and provides a protective layer from light rains and spills.

4.4. Ironing

Ironing is used to attach and remove wrinkles from leather. The piece at the bottom is called a sole plate. Special electrically heated hand irons which are thermostatically controlled are used for removing wrinkles. Sometimes the whole leather surface is ironed to improve the finished quality.



Figure 1 Electrically Heated Hand Irons

Ironing is the use of a machine, usually a heated tool (an iron), to remove wrinkles from the leather surface. Genuine leather outfits are always trendy. Leather is stylish, casual, and waterproof and does not crumple easily. However, as a result of improper storage, there are situations when wrinkles and crumples appear on the leather. Hence ironing removes those wrinkles from the surface of the leather products.

4.4.1. Types of Material and Features

In order to effectively smooth the folds on the leather clothes with an iron, you need to know what type of material you are dealing with. Leather clothing can be made of the following types of material:

- a) Genuine leather
- b) Artificial leather (pleather)
- c) Eco-leather

If you do not know what type of leather your product is made of, look at its underside. The reverse side of the natural material will be velvety and fleecy. Pleather and eco-leather, which is a kind of artificial leather, will have a woven underside. You can see the weaving of the threads on the reverse side of the product.

For all types of material, you can use the same methods of ironing, with just slight variations. A skirt or a dress made of genuine leather is better ironed from the front side through paper or cotton material. Artificial leather, with a woven base, can be ironed from the underside without the use of fabric layer.

In case a dress or a skirt has a lining that does not allow you to see the reverse side, you need to iron the outfit from the front side through a thin fabric. You can also use other ways to straighten folds at home.

4.4.2. Conditions when to iron the leather garment necessarily

- a) The presence of crumples and creases on the surface of the leather as a result of improper storage or other reasons
- b) The stretched areas appear on outfits made of genuine leather when wearing, for example, on elbows or backside. Outfits made of artificial material are not stretchable
- c) Deformation of the leather outfits occurred as a result of improper care or for other reasons
- d) To maintain the shape of the leather garment

If the outfit has changed its shape under the influence of moisture or heat, you cannot restore it to its original form by ironing. For example, a skirt made of genuine leather was completely soaked and then crumpled. Ironing is also useless if the outfit was put on a hot radiator and it has deformed. In other cases, when the leather clothes are wrinkled or stretched, they can be ironed out.

The quality of the leather also matters. The thinner and better the material used for making clothes, the easier and faster you will be able to iron and smooth it. Thin, genuine leather is easier to iron than hard artificial leather.

To iron crumpled leather clothes, place the piece on the ironing board and straighten it out. Cover it with paper or a dry cotton cloth. Turn the iron on minimum power and gently iron the leather on the edge. It's best to test the iron on a spare piece of the same leather your garment is made of. But if you don't have one, you will just have to be very careful.

Iron the crumpled area, placing the iron directly onto the crease. If you don't see any effect, slightly increase the temperature. After the crumpled area is smoothed out, wait until the garment has cooled and hang it up.

Straightening out the parts that stretched out is done in much the same way. Put the skirt on the ironing board with the back part facing up, smooth it with your hands and cover with a cloth. Place the iron on the

outstretched areas and hold it for a while. If you use the right temperature, the skirt should restore its original shape.

The creases on the dress or skirt can also be removed using the steam function. Hang up the leather garment; switch the iron into the steam mode. Steam the skirt at a short distance and on low power so as not to spoil the leather. Direct the steam stream onto the folds, while slightly pulling the material from the bottom.

Using water

Small creases on the garments can be removed in an easy way. Hang up the clothes in the bathroom. Sprinkle crumpled areas with water from the spray gun or wet with your hand. Water should be purified, so it doesn't leave stains.

Leave the leather outfit hanging for some time (several hours). During this time, it should recover its original shape.

Using steam

Hang the leather outfit up in the bathroom and smooth the surface with your hands. Open the hot water tap, and make sure that the steam does not touch the clothes. Close the door to the bathroom so the steam cannot come out.

To iron a leather outfit at home and not damage it, use the above recommendations. Choose the most effective way yourself. In order to avoid ironing in the future, store and care for leather clothes properly.

If hanging your jacket for long periods of time does not solve your wrinkle problem or is not an option follow these instructions:

- a) Adjust the iron to the lowest setting. Let the iron heat up and do not use steam.
- b) Place aluminum foil under the cloth that covers the ironing board. The aluminum foil will heat up and attack the wrinkles from the opposite side. It may not be necessary to iron both sides.
- c) Use a towel, brown paper bag, or thick newspaper between the jacket and iron. Gently and firmly press down on one spot at a time.

Notes

- ❖ Avoid a heat build in a small localized area, which may damage the finish of the leather, or shrink the leather upper. Have TEFLON CLOTH on the iron to prevent burning. Maximum temperature of the iron 70 – 75 degree Celsius and with the Teflon up to 96 degree Celsius.
- ❖ May apply water before ironing to prevent burning or anti crease wax if water cannot be used use.
- ❖ Patent and high gloss finishes are very easily or loose gloss in the heat. It is sometimes an advantage to apply a little Vaseline or anti creasing wax as a lubricant especially when ironing.
- ❖ Discoloration of pastel shades, white and aniline finishes, all have a tendency to discolor under heat. Check the effect on scrape before attempting the bulk.
- ❖ High grease content leather, the heat may bring the grease to the surface and prevent adhesion of later dressing or cause bloom to appear after boxing.

4.5. Final Checking

The whole product is cleaned both inside and outside with a clean piece of foam. Before the articles are sent for packing, strict quality control is observed for perfection in assembling, Stitching accuracy and smooth functioning of fittings. Start by removing any dirt or debris by wiping the bags with a foam/ cloth. Apply a small amount of cream and spread evenly in a circular motion over bags. You can use either Foam, cotton cloth or a polish application brush to apply. Polyurethane foam rubber sheets are used in a variety of leather goods where

cushioning of the products is necessary. 2m x 1m x 3mm and 2m x 1m x 6mm foam rubber sheets are normally used in leather goods reinforcement making and polishing with cream.

The following aspects of garments should be checked:

- a) Correct dimensions;
- b) Seam pucker, seam allowance and sewing,
- c) Garment symmetry;
- d) Pressing/fusing defects;
- e) Cleanliness;
- f) Loose threads;
- g) Correct matching of garment and trimmings;
- h) Correct fitting and alignment of closures; and
- i) Correct placing of labels.

A reference sample and complete specification of garment should be available at the inspection point which should have proper lighting conditions. As far as possible, all garments should be checked.

4.6. Labelling

The leather garments should be properly labelled. The size and details of labels should be as agreed to between the buyer and the seller and as far as possible, should indicate the following:

- a) Fibres content;
- b) After-care instructions;
- c) Size designation;
- d) Manufacturer's name, initials or trademark; and
- e) Country of origin.

4.7. Packaging

Garment packages should be so designed as to ensure that the garments reach the consumer in satisfactory condition. The details such as, method of garment folding, number of garments in each package, type of outer packing, etc., should be worked out.

Organization and Objectives

The Ethiopian Standards Agency (ESA) is the national standards body of Ethiopia established in 2010 based on regulation No. 193/2010. ESA is established due to the restructuring of Quality and Standards Authority of Ethiopia (QSAE) which was established in 1998.

ESA's objectives are:-

- ❖ Develop Ethiopian standards and establish a system that enable to check whether goods and services are in compliance with the required standards,
- ❖ Facilitate the country's technology transfer through the use of standards,
- ❖ Develop national standards for local products and services so as to make them competitive in the international market.

Ethiopian Standards

The Ethiopian Standards are developed by national technical committees which are composed of different stakeholders consisting of educational institutions, research institutes, government organizations, certification, inspection, and testing organizations, regulatory bodies, consumer association etc. The requirements and/or recommendations contained in Ethiopian Standards are consensus based that reflects the interest of the TC representatives and also of comments received from the public and other sources. Ethiopian Standards are approved by the National Standardization Council and are kept under continuous review after publication and updated regularly to take account of latest scientific and technological changes. Orders for all Ethiopian Standards, International Standard and ASTM standards, including electronic versions, should be addressed to the Documentation and Publication Team at the Head office and Branch (Liaisons) offices. A catalogue of Ethiopian Standards is also available freely and can be accessed in from our website.

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International Involvement

ESA, representing Ethiopia, is a member of the International Organization for Standardization (ISO), and Codex Alimentarius Commission (CODEX). It also maintains close working relations with the international Electro-technical Commission (IEC) and American Society for Testing and Materials (ASTM). It is a founding member of the African Regional Organization for standardization (ARSO).

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