

ultrasuede®
Beautiful Possibilities

'TORAY'
Innovation by Chemistry

Sewing Manual



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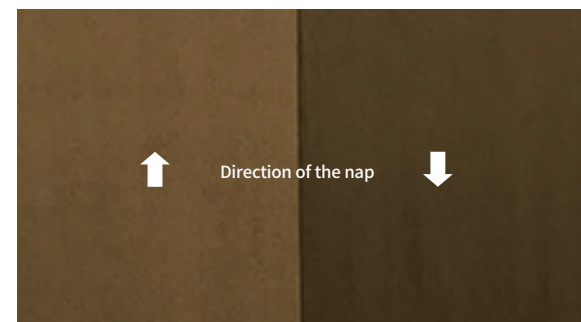
Handling of fabrics rolls

Ultrasuede® is a delicate material. Please store it in an environment with appropriate temperature, humidity and physical storage conditions.

- 1.** When storing fabrics rolls, keep in a cool, well-ventilated area out of direct sunlight. To prevent excessive load from being applied to the fabric rolls, store it on shelves rather than stacking it in large volumes.
- 2.** If the fabric gets stained during handling, remove the stains as soon as possible so as not to damage the fabric, and then brush the fabric lightly with a lint brush.
- 3.** If moire-like wrinkles appear on the inner roll (tube core) when the fabric is unfolded, they can be removed with gentle steaming.
- 4.** Wrap the remaining fabric rolls after cutting and store it as described as in "1" above.
- 5.** The surface of Ultrasuede® is made of brushed fibers with a lengthwise nap. When checking the color of the fabric, be sure that the length is configured along the lengthwise nap. The fabric hue will appear different based on the direction of the nap and the angle of incident light. Note that any observed differences will not be due to differences in the color of the fabric.



▲ Proper storage



▲ Differences in appearance due to differences in the direction of nap

Marking (stenciling)

Mark in one direction, paying attention to the direction of the nap.

- 1.** Marking (stenciling) should be done in one direction as the nap is directional.
*Do not rotate the stencil.
- 2.** The finish will be glossy in the direction of the nap, while it will have a deeper color against the nap.
- 3.** Please apply the stencil on a marking sheet.

Spreading

Spread the fabric in one direction, paying attention to the direction of the nap.

- 1.** The color and appearance of each part will differ when the fabric is folded or spread as the nap is directional.
- 2.** Place a sheet of paper below the bottom layer of fabric and lay the fabric on top. This will prevent misalignment and ensure accurate cutting of the layers in subsequent processes.
- 3.** The maximum fabric stack height should be 7 to 8 cm.

Cutting

Cut out the parts accurately to avoid problems in the subsequent sewing and finishing processes.

Single sheet cutting

1. Rotary cutter is recommended.
2. Place a sheet of paper below the bottom layer of fabric to prevent misalignment.

Overlapping cutting (vertical blade cutting machine, band knife cutting machine, CAM/automatic cutting machine, etc.)

1. The most accurate way to cut is with a CAM/automatic cutter, but it is also possible to make a rough cut with a vertical blade cutter then an accurate cut with a band knife (wavy blade).
2. The notch mark is preferred to be around 3mm.
3. There is no need to use a overlock sewing machine.

Interlining

Ultrasuede® is sensitive to heat. In order not to damage the surface quality and texture, please use the appropriate temperature, pressure and time when interlining fabric.

1. Type of interlining: Woven, knitted, and non-woven interlining can all be used. However, please note the following points.

- ⋮ (1) We recommend the use of interlining that can be bonded at low temperatures (120°C or lower) to obtain sufficient adhesive strength.
- ⋮ (2) Select an interlining that has adhesive strength, washing resistance and that does not affect shape retention.
- ⋮ (3) Make sure that there is no shrinkage or peeling when the interlining is worn or washed.
- ⋮

2. Adhesion press: Reliant (roller) type press, flat press, etc.

3. Adhesion conditions: The following are the reference setting conditions for low-temperature adhesive interlining.

- ⋮ (1) Bonding temperature: 120°C
- ⋮ (2) Pressure: Machine pressure 2–3 kg (actual pressure 150–300 g/cm²)
- ⋮ (3) Preheating time: 5–6 seconds
- ⋮ (4) Automatic pressurization time: 8–10 seconds
- ⋮ (5) Cooling time: 6–8 seconds

⋮ *The conditions may vary slightly depending on the model, interlining, etc.
⋮ Please make adjustments accordingly.
⋮

Sewing

Since Ultrasuede® does not slide across other layers easily when sewing, there is a tendency for misalignment to occur between the upper and lower fabrics. Please adjust the sewing machine appropriately and be

1. Sewing machine adjustment

The following are reference setting conditions for sewing machines.

- ⋮ (1) Needle plate: Use a Teflon-coated variety.
- ⋮ (2) Clamp: Use a Teflon clamp or ring clamp.
- ⋮ (3) Other measures: To decrease the friction of the needle plate, we recommend that you apply paper gummed tape, etc., that has a smooth and slippery surface (low adhesive type) to the needle plate and table area of the sewing machine.

Item	Stitch type				
	Ground stitch	Decorative stitch	Overlock stitch	Buttonhole stitch/ Eyelet stitch	Cinch stitch
Sewing machine model	Book stitch machine		Lock	Special sewing machine	
Sewing machine speed	2,500–3,000 revolutions per minute		No finishing required		
Sewing thread	No. 50	No. 30 - 50	No. 80 - 100	No. 50	
Sewing machine needle	#9-11				
Number of stitches (needle stroke)	13 stitches / 3cm				

*The conditions may vary slightly depending on the machine model, etc. Please make adjustments accordingly.

Sewing

Since Ultrasuede® does not slide across other layers easily when sewing, there is a tendency for misalignment to occur between the upper and lower fabrics. Please adjust the sewing machine appropriately and be careful during handling.

2. Sewing

- ⋮ (1) The needle holes are somewhat visible, so it is important to finish sewing in one sitting and avoid re-sewing.
- ⋮ (2) Note that since the fabric is stretch resistant and relatively inflexible, it is difficult to perform shirring and similar actions.
- ⋮ (3) In order to finish the sleeves neatly, use a running stitch, iron them into shape, and attach the sleeves.

Ironing and finishing press

Ultrasuede® is very sensitive to heat. In order not to damage the surface quality and texture, please use the appropriate temperature, pressure and time when ironing and finishing.

1. Ironing

- ⋮ (1) Ironing machine: Steam iron.
- ⋮ (2) Ironing cover: Teflon ironing covers are recommended.
- ⋮ (3) Ironing Board: Vacuum ironing boards are recommended.
- ⋮ (4) Temperature setting: 120°C or lower.
- ⋮ (5) Prevention of press marks and impressions: Use an ironing cover or cloth. Special fiber cloths are particularly effective in preventing press marks.

2. The following are the reference setting conditions for finishing press.

- ⋮ (1) Finishing press temperature: 100–105°C
- ⋮ (2) Steam pressure: 2–3 kg/cm²
- ⋮ (3) Pressing pressure: 50–150 g/cm²
- ⋮ (4) Time: 3–5 seconds for steaming, 5–7 seconds for vacuuming
- ⋮ (5) Press pad: soft and elastic
- ⋮ (6) Press cover: knitted fabric or raised fabric, such as towels, with no visible structure

*The conditions may vary slightly depending on the machine model, etc., so please adjust accordingly. Use a three-dimensional (body) press if possible.

Care label

- Machine-washable. Wash using cold water on delicate cycle with similar colors.
- Use mild laundry detergent. Do not use bleach.
- Ultrasuede® fabric must not be washed together with other items.
- Use a mesh laundry bag for washing Ultrasuede® items.
- color migration may occur when dark fabrics are washed together with white and light-colored fabrics.
- Set your washing machine to its Dry Course or Dry Program mode. (If these modes are not available on the washing machine, keep the spin-dry mode within 1 minute)
- Do not tumble-dry.
- Hang out to dry immediately after spin-drying (within 1 minute).
- Lightly wring dry if washed by hand.
- Line dry.
- Can be steam ironed on low setting using cloth to press down.
- Can be dry cleaned with conventional dry cleaning methods.
- Lightly brush after drying if Ultrasuede' s nap alignment causes concern.

*When handling Ultrasuede®, please give priority to the "Care Label" displayed on the product,as these relate to the secondary materials used.

