

(2)

2.

.

Quality

.

2.1

1)

2)

3)

Edge Mark

가

Take up Roll Edge Hole

Edge

.

4)

.

2.2

1)

2)

3)

Bar

4)

.

2.3

1)

2) Lot , ,

Space 가 Lot , .

3) Lot Order

.

4) 1~2 ,

Quality .

5)

가

3.

3.1 (Stitch Length, Loop Length)

(Stitch)

1 Feeder (Course Length)

Needle .

Needle .

Data

.

Feeder 가

.

3.2

3.2.1

Feeder

가 .

3.2.2

(1) Wale

Jersey : 50 Wale

Interlock, Pique : 51 Wale

Rib : 25 Wale

(2)

10Cmx10Cm 가

Loop가 . < 1-1>

Loop Loop Marking Wale

Marking < 1-2>

Marking Cm Wave

Stretch 가 20~30 Feeder

. < 1-3>

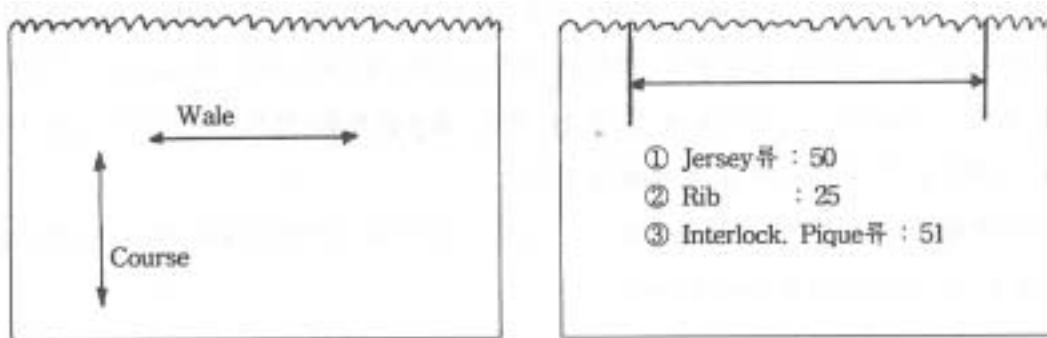
1 Check

Check .

가 Check Feeder

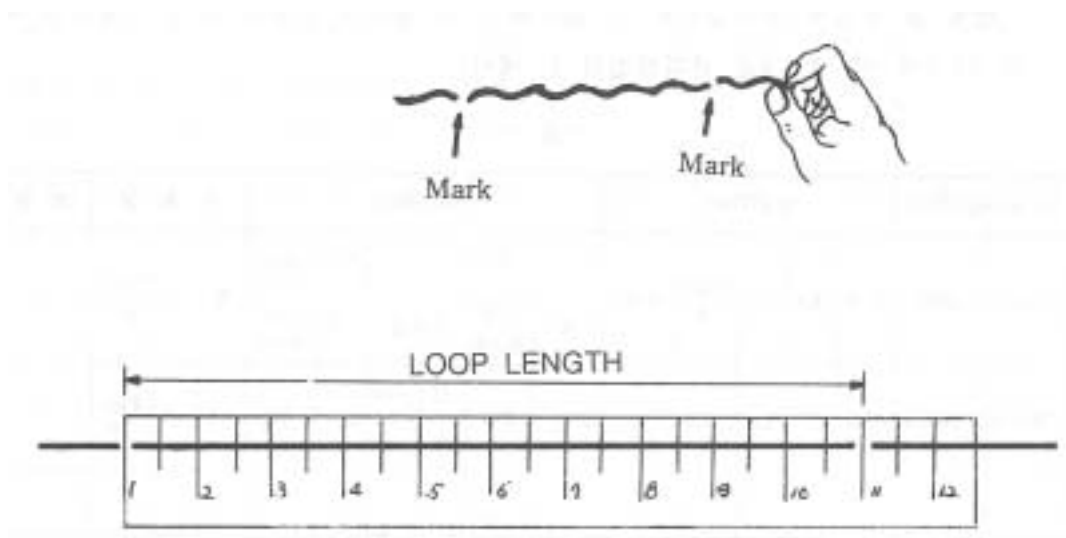
가

.



< 1-1>

< 1-2>



< 1-3>

(3)

1)

Trip Tape Wheel

Feeder

(Negative)

(Positive)

System

System

Feeder

가

가

,

System

가

.

2)

가

Item

.

Order

가

.

,

.

< 1>

Construction		Knitting					Finishing									
Yarn	Fabric		DIA	G/G	Loop		Dry			Finishing				Test		
								g/yd			g/yd					
CM20'S	F/PIQUE	1,520	22"	22	17.5	O O	58 1/2"	275		+10	62"	285	+3	+7	Flat	
										-3					1	

		MAKER	G/G	DIA		FEEDER	TRACK		
Jersey	O O	O O	28	30"	2,638	120	4	3	22G/G

4. 가

4.1 (SHRINKAGE)

4.1.1

Garment	Washing	line	Tumble	Screen
Spec				
CVS	CVC	Poly	Side	
100% Cotton		가		.
100% Cotton	Shrinkage		,	
				.

4.1.2 100% Cotton Shrinkage

(1)

Wave가 , Opening, Maxing, Combing, Drafting, Twisting
가 .
() 5%
가 8~12% 가
가 .

(2)

Miss : Yarn
Weight Down

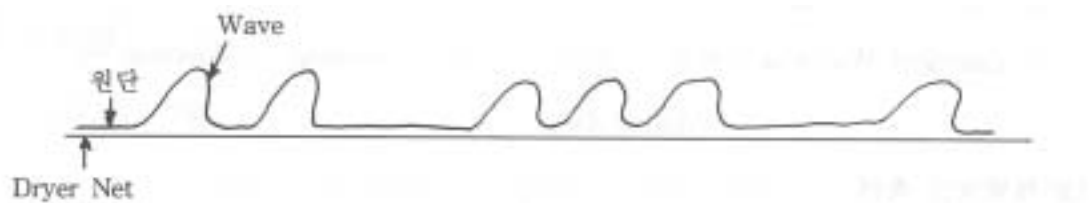
(3)

. Miss :
. , ,

(4)가

[illegible]

< Wave >



*

< Wave >



*

가

< 2>

4.1.3 Shrinkage

(1)

OPEN 가

Pin Tenter : Over Feeding Length Shrinkage

Width Shrinkage 가 .

가

Wet 가

가 .

Open Compact M/C : Course

Length Width Shrinkage .

(Shoe Type, Felt Type etc)

Tubular 가

Calender M/C 가 Dry Shrinkage가 Tube

Type Compact M/C Shrinkage .

(Shoe Type, Felt Type etc)

Loop

Weight up 가 .

(2)

Washing : Fabric, Garment

Fabric Washing : → → Washing → Tumble Dry → 가

Garment Washing : → → 가 → Sawing → Washing →
Tumble Dry

(3)

Softening : Soft 가

.

Resin Finishing : .

가 (WRINKLE – FREE.FINISHING) : Cotton or Cotton Blends

, Crease

가

4.1.4 Shrinkage

AATCC 가 Buyer가 Dry
Check .

(1) Shrinkage Test

Machine Wash Warm (cold) Tumble Dry : Tumble Dryer

Flat (Screen) Dry : Screen

Line Dry :

Drip Dry :

(2) 가 Test 가

Wet 1yd
(g/yd) Check 30cm x 30cm 40
10 Cotton Net Dry,
CVC or CVS Tumble Dry Length Width
Check 3mm 1% .
Test Checking
.

Order , 가

.

4.2 Twist

4.2.1 Twist

(, Z) 가
Fabric or Garment Washing , 가
가 .

4.2.2 Twist

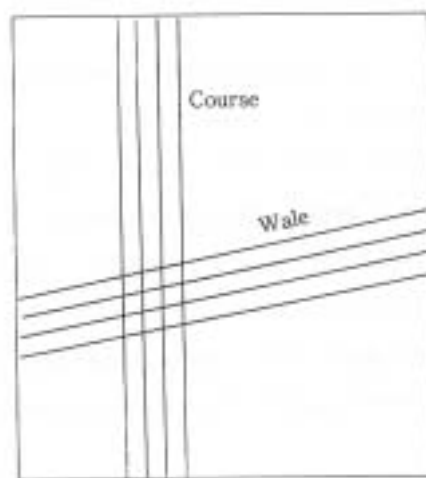
(1)

Utility 가 .
가 Feeder 가 .

(2)

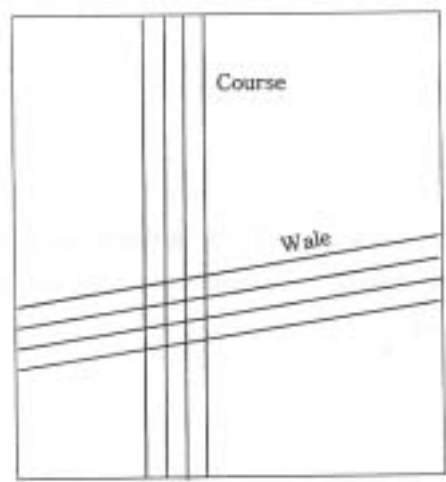
가 (Ply) .

(3) < 3>



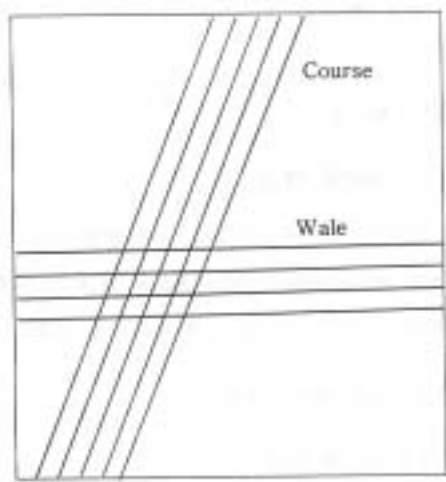
< 3>

Vertical



< 3-1>

Bias



< 3-2>

Verticak	:	Course	Tenter
Twist	. < 3-1>		
Bias	:	Wale	<

3-2>

(4) 가

Vertical

Vertical

Wale

가

(Straitener,

)

Twist

. ,

Twist가

가

. < 4-1>

Bias

가

Twist

Garment Washing

. < 4-2>

Twist

Twist

가

가

Check

.

Twist

Spec

가

7%~8%

(1.2~1.5 inch)

.

가 Twist

.

- : , ,

- Check < 5>

가

1yd

.

Wale Line

Wale Line

.

< 5> Washing Twist Check .
 Twist .

4.3

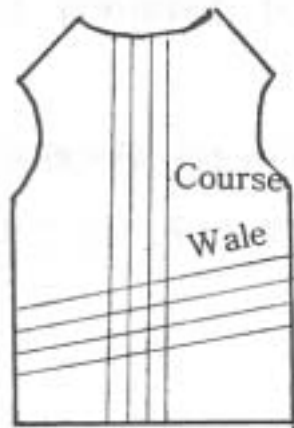
4.3.1

, 가

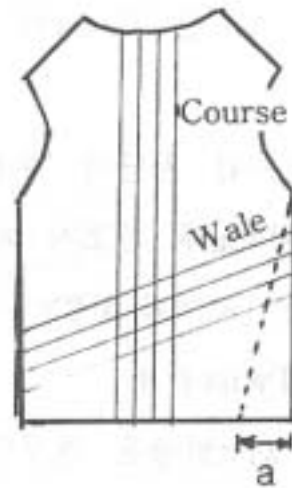
- (Shade Alteration) (Staining) .

- 1 가 5
 가 1 가 8
 가 .

a : Twist가

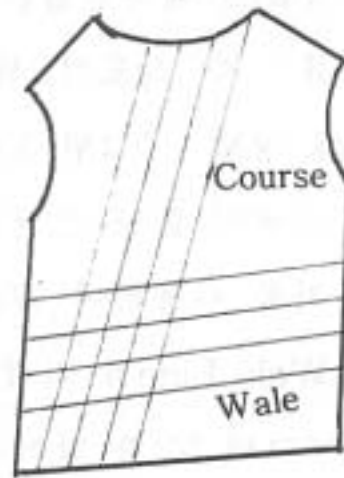
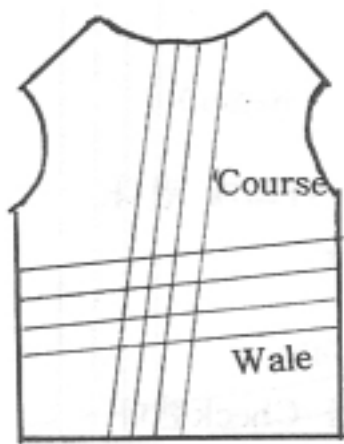


< >



<Washing >

< 4-1>

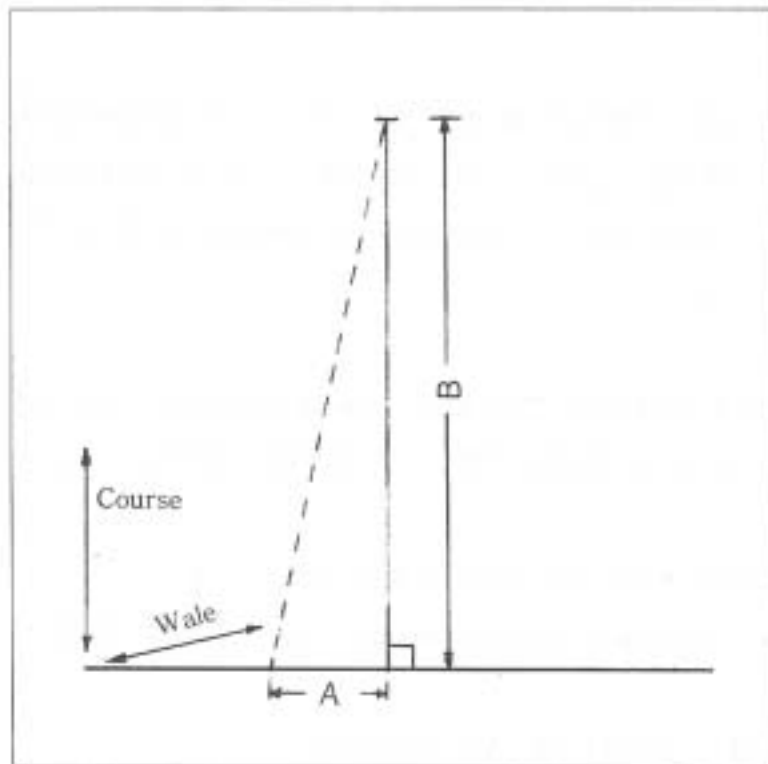


< >

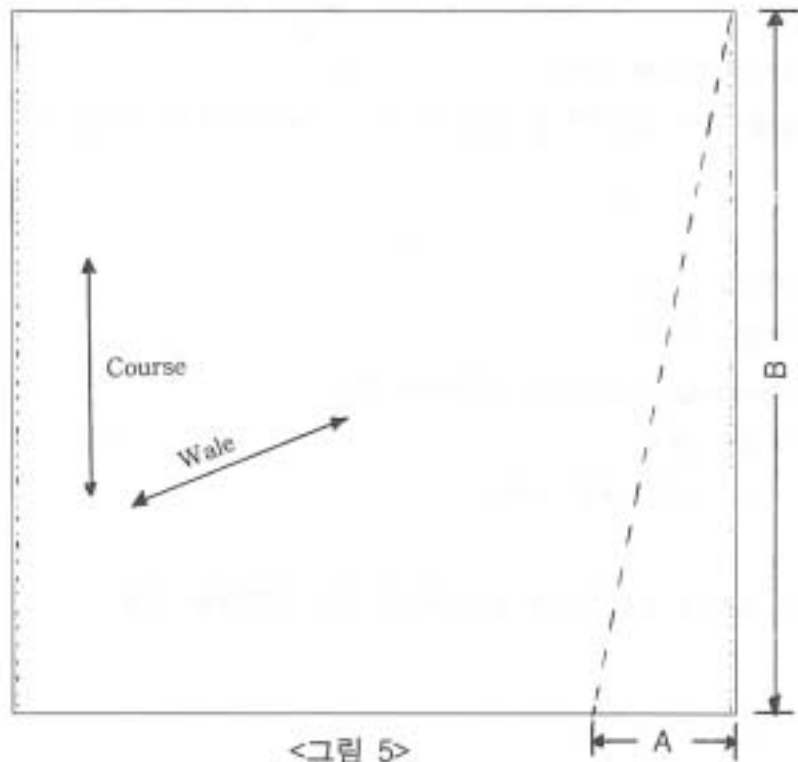
<Washing >

< 4-2>

1.



2. 가 (Tubular)



< 5>

<Twist >

$$\frac{A}{B} \times 100$$

A : Washing Twist

B : Garment SPEC

(40cm)

4.3.2

(1) Cotton P/C

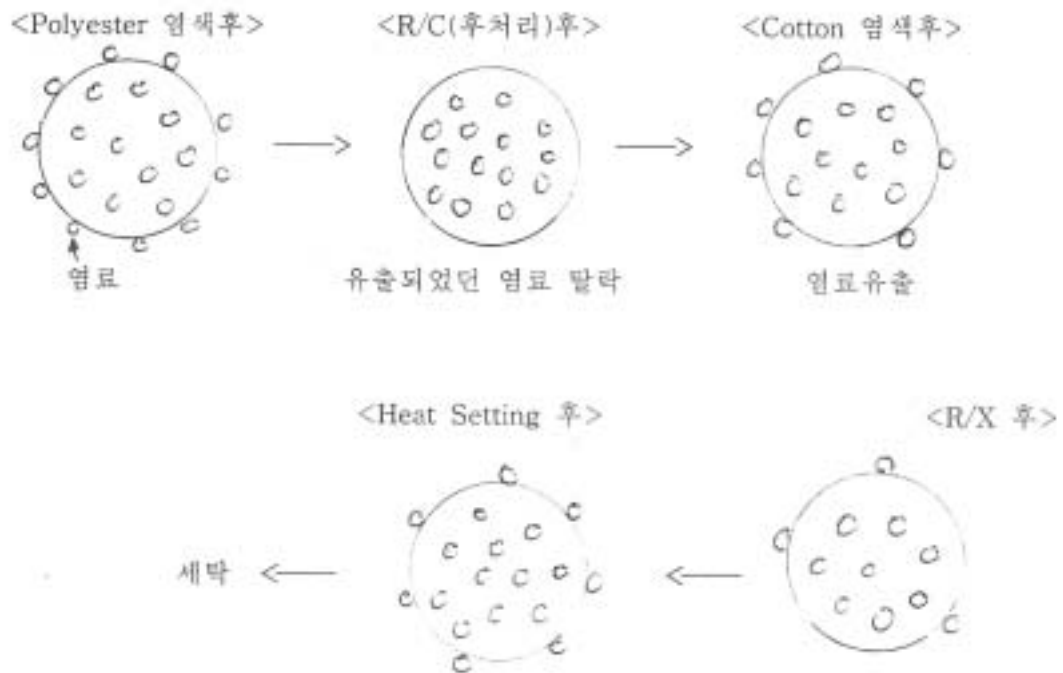
Cotton P/C

Polyester Side Reduction Cleaning
 Cotton Soaping Hot Rinse 가
 가 .
 100% PET P/C .
 Heat Set Thermo Migration
 가 . < 6>
 가 (Acetate, Cotton)
 DK color
 가 .
 가 .
 가 () 가
 .

Soaping Rinse가
 Fixing 가
 가 가 ()

Thermo Migration

가



*

가

Thermo

Migration

< 6> Thermo Migration → CVC & CVS

가

R/C, soaping

Rinse

:

Bleeding

. (

)

P/C 가

가 ,

Heat Set가

가

가

.

4.3.3

(1) 가 가 .

(2) 가

Garment, Solid

- 가 (150 ~155)

. , 가 가

Shrinkage 2% .

Garment, Cut & Sawing (Contrast)

- White or LT Color Combine

가

DK Color . Test Garment

White or LT Color Portion 1 : 1 Test

Color Portion

.

Pigment Print

Washing : 175~185 가

Fade Out .

Non Washing : 150~160 가

.