

**Dibella textiles are designed and optimized for processing in industrial laundries. To ensure that the maximum textile lifetime and productivity is achieved in the treatment process, the following recommendations should be followed:**

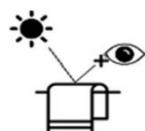
## New textiles



Pre-washing is recommended to remove potential residues from the textile production process – especially if you are operating with a low-water/low energy consumption program. The finishes are designed for easy removal with a conventional washing procedure. Preferably use a higher bath ratio for the first wash by loading at 70% of the capacity of the machine. Important: open larger articles properly and rinse thoroughly with fresh water (for tunnel washers minimum 6-8 l/kg fresh water and for washer extractors at least 3 rinses).



A special pre-wash program is generally not mandatory, but in special cases it may be necessary to adapt your washing process. You can add dedicated products to help remove the finishes or avoid re-setting. That might be necessary in cases where water is re-used intensively or if there are special limitations in the production process. Ask your detergent supplier for support if there are challenges in the pre-washing process. (Dibella desizes properly and is not using any PVA/PVAc!).



Most articles are treated with optical brighteners to minimize color change at the first wash. Optical brighteners are partially replaced during the washing process as every laundry has its own specific detergent formula. Please wash at least once before comparing colors and whiteness.

## Washing



Always use clear water that has good quality for washing and rinsing. This means hardness is below 2°D (<35 ppm CaCO<sub>3</sub>; HCO<sub>3</sub> < 200 ppm) and is free from metal ions (Fe, Mn, Cu should all be below 0,01 mg/l) to maintain color, prevent greying, ensure smooth ironing and limit textile damage.



Separate whites from colored in order to prevent dyestuffs from being transferred. Also be sure to separate cotton articles from those that contain man-made fibers and separate different square meter weights, in order to be able to process them accordingly.



Dibella textiles are suitable for industrial laundering, which means they can be washed at high temperatures and the majority of articles tolerate chlorine use. From both environmental perspective as well as the life expectancy of the textiles, it is recommended to refrain from both.



Always secure a suitable washing procedure from your chemical supplier to match your machine configuration and the specific material composition.



When using chlorine bleach, limit the concentration to 350 ppm with a pH around 10,5 and temperature not exceeding 60° C.

When using oxygen bleach: limit the concentration to 200 ppm with a pH around 11 and temperature not exceeding 80° C; For peracetic acid bleach a lower temperature and pH can be used.



Make sure the pH after rinsing is around 6 to prevent problems in the ironer/dryer or at the user. Final rinse temperature should not exceed 40° C to prevent excessive wrinkling and subsequent uncontrolled moisture evaporation.

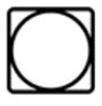


For fabrics with a higher thread count (300 and higher); make sure to adjust the pressure in the press and/or use a 2-step pressure build up to prevent possible air pockets from bursting.



## Finishing

For good finishing quality on ironers, no heat is normally required for cake-breaking. Make sure to have a high enough residual moisture level before ironing (guideline: 45 % for 100 % cotton, 40 % for 80/20 cotton/polyester and 35 % for 50/50 poly/cotton). If there is no possibility to iron the washed textiles immediately, cover the textiles while they are waiting to be finished, in order to prevent uncontrolled evaporation of moisture.



After drying the residual moisture should be around 7% for pure cotton, 5% for 80/20 cotton/polyester and 3% for 50/50 poly/cotton. Avoid overheating by using good controls on your dryers like infrared sensors. Dry only goods with same square weight together to enable homogenous drying. These guidelines will save resources (energy) and optimize whiteness, softness and life expectancy.



For articles that are mainly made of polyester, e.g. incontinence pads or bathrobes with a 100 % velour outer surface, we recommend setting the input temperature to 120° C. The exit temperature should be limited to 60° C. In addition, ensure a residual moisture content of at least 20 % - strong overdrying of polyester usually leads to non-reversible damage to the textile (polyester melt).



Adjust the ironing speed and pressure to suit the fabric, paying particular attention to the weight per square meter, the fineness and the blend ratio of the fabric being processed.