



## THE FABRIC: DENIM

This guide will help you get to know ISKO™ fabrics before even taking part in the Denim Seminar (reserved for finalists) where you'll be able to delve into the field and realize that denim is not only what you had always imagined! When you choose the fabric, remember that you'll have to justify your choice during the final evaluation. Besides the model and style, the fabric plays a very important role in the final look of the garment.

When you look at the fabrics on the label you'll find the code. On this document you can find any other information, which is more understandable and has more detail.

### COMPOSITION:

you'll find the percentage of fibers in every fabric.

### CATEGORY: RIGID, COMFORT, STRETCH.

- RIGID FABRIC  
firm fabric not majorly altered in weft and warp after it's washed
- COMFORT FABRIC  
fabric with a 10 to 25% stretch component which depending on a more or less strong wash shrinks
- STRETCH FABRIC  
over 25% stretch fabric, shrinking considerably

No fabrics of various categories can be mixed in the same garment.

It is important to choose the right fabric depending on the desired volume.

Example:

large and full volume → rigid fabric  
figure-hugging tight-fitting garment → stretch

### CONCEPT:

the concepts refer to the idea behind a certain fabric category, its aim and purpose.

### TECHNOLOGY:

ISKO™ is known for its patented technologies. This means that each fabric construction can have one or more technologies that will add a benefit to how the fabric can be used and hold a particular shape.

ISKO Recall™ is patent, meaning the fabric does not lose its elasticity over time. Tri-blend weft thread technology: Lycra core interlaced with polyester. Outside cotton cover.

Select ISKO Pop™ cotton with long fibers and mercerizing providing brightness and a consistently soft feel.

ISKO Blue Skin™ gives freedom of movement with 2.5 times more holding power in the warp than the weft. Gravity-defying lift and hold. Flexible premium 4-way stretch.

ISKO Xmen's™, a fabric designed with invisible superpower stretch technology to enhance wearability, style and fit. It maintains a truly rigid, purist look with distinct twill lines and yarn character.

ISKO Future Face™, the first woven fabric technology with a knitted look. The lining is similar to fleece.

### WEIGHT:

the weight of the denim is measured in ounces (Oz).

### WEAVE:

the classic pattern used for the denim is the 3x1 diagonal for every light fabric, if featuring a classic structure.

### THE CAST/COLOR:

The particular thing about the color blue comes from the warp yarn: an indigo-dyed white core. The indigo dye is superficial, and thus after it's washed the color "blends" in various shades. The default color, that is the color to dye the surface of the thread, gives the fabric its base shade: the CAST.

Denim is thus a particular fabric which must be washed after being made, before reaching the point of sale.

For every type of fabric, we have made 1 stone-washed fabric swatch with 3 possible nuances: raw, rinse and bleach fabric. The colors you see are the colors you get, you cannot get other variants. Indigo can be replaced by black, as in the examples you will find on the list.

## ISKO™ RESPONSIBLE INNOVATION FABRIC LIST

All fabrics are innovative and have been made implementing responsible measures during the production process. The technologies and concepts are an essential part of giving to the denim a sustainable element that adds value to the final consumer's experience.

### Fabric Group 1: CERTIFIED FABRICS

ISKO™ is the only denim mill in the world to have received the prestigious EU Ecolabel and Nordic Swan certifications.

One of the awards in the competition actually concerns CERTIFIED RESPONSIBLE INNOVATION.

If you choose to compete for this award we advise you to complete your ENTIRE outfit (whether Industry-Driven Garments or Denim Show Piece) with fabrics from this group.



#### Code: 56656

Composition:

95.45% Organic Cotton  
3.46% Recycled Polyester  
1.09% Elastane

Category:

Stretch Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Technology:

ISKO Recall™

Weight:

Oz 13,5

Weave Description:

Traditional denim pattern  
3x1, visible diagonal,  
open-hand look.

#### Code: 56631

Composition:

90.19% Organic Cotton  
8.55% Recycled Polyester  
1.26% Lycra

Category:

Stretch Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Technology:

ISKO Recall™

Weight:

Oz 14.25

Weave Description:

Ring-Ring Construction  
(shot fabric).

#### Code: 56636

Composition:

80.98% Organic Cotton  
10.70% Recycled Polyester  
6.75% Recycled Cotton  
1.3% Lycra

Category:

Stretch Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Technology:

ISKO Recall™

Weight:

Oz 12.75

Weave Description:

More compact 3x1  
construction, and cleaned  
with a less obvious  
diagonal.

#### Code: 56539

Composition:

50% Pre-Consumer  
Recycled Cotton  
50% Organic Cotton

Category:

Rigid Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan

Weight:

Oz 13.25

Weave Description:

Pattern is a classic 3x1  
diagonal. Classic denim  
fabric, rigid, with strong  
wash, and a noticeable  
crossage.

#### Code: 31290

Composition:

100% Organic Cotton

Category:

Rigid Fabric

Concept:

ISKO Earth Fit™, Selvedge.

Certification:

Nordic Swan + EU Ecolabel

Weight:

Oz 10

Weave Description:

Diagonal 2x1 pattern  
with Neps surface.  
Selvedge – particular fabric,  
typical of the first traditional  
denims. Average weight also  
fit for shirts and light jackets,  
ideal for the workwear world.

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 ISKO™ RESPONSIBLE INNOVATION FABRIC LIST

**Fabric Group 1: CERTIFIED FABRICS**

**Code: 56411**
Composition:

100% Organic Cotton

Category:

Rigid Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Weight:

Oz 4.75

Weave Description:

Light fabric with a soft saggy feel.

**Code: 56534**
Composition:

86% Organic Cotton  
7% Recycled Polyester  
6% Recycled Cotton  
1% Elastane

Category:

Comfort Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan

Technology:

ISKO Recall™

Weight:

Oz 14.25

Weave Description:

Typical diagonal 3x1, open-hand construction, adapted to all kinds of treatment.

**Code: 56624**
Composition:

77.49% Organic Cotton  
22.51% Recycled Cotton

Category:

Rigid Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Weight:

Oz 12.75

Weave Description:

Classic 3x1 denim construction, adapted to all kinds of treatment.

Color:

Washable black, with stone-wash giving it an “orange peel effect”, typical of 80s wash.

**Code: 56536**
Composition:

80.50% Organic Cotton  
11% Recycled Polyester  
7% Pre-Consumer Recycled Cotton  
1% Elastane

Category:

Stretch Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan

Technology:

ISKO Recall™

Weight:

Oz 11.25

Weave Description:

Classic 3x1, adapted to all kinds of treatment.

Color:

Washable black.

**Code: 56640**
Composition:

89.20% Organic Cotton  
8.35% Recycled Polyester  
2.45% Lycra

Category:

Stretch Fabric

Concept:

ISKO Earth Fit™

Certification:

Nordic Swan + EU Ecolabel

Technology:

ISKO Recall™

Weight:

Oz 10.50

Weave Description:

Classic 3x1

Color:

Its particular feature is the color, a blue overdyed black, so the nuances of the wash can be played with, from dark to light bleached, with very light and subtle flames.

## ISKO™ RESPONSIBLE INNOVATION FABRIC LIST

### Fabric Group 2: ALTERNATIVE FIBERS

Another way of looking at responsibility is by using man-made fibers, some produced by Lenzing.

Cotton has always been the principal fiber in denim fabric, but ISKO™ has continued to push the boundaries of denim construction, researching new and novel fibers for our fabric. ISKO Cottonized™ employs TENCEL®, rayon, and Lenzing Modal® to produce cotton-less denim fabric with a look, drape, and wash-down unlike any other denim.

These fabrics, constructed using regenerated cellulose, have a lower environmental impact compared to traditional cotton fabrics.



#### Code: 48422

Composition:

100% Lyocell

Category:

Rigid Fabric

Concept:

ISKO Cottonized™, Luxure.

Weight:

Oz 7.25

Weave Description:

Very light fabric with a soft saggy feel, classic 3x1 denim pattern.

#### Code: 61429

Composition:

68% Lyocell

32% Viscose

Category:

Rigid Fabric

Concept:

ISKO Cottonized™

Weight:

Oz 12

Weave Description:

Classic 3x1 denim pattern. Average weight fabric with a soft slippery fabric, but a typical denim look.

#### Code: 61440

Composition:

70% Lyocell

30% Viscose

Category:

Rigid Fabric

Concept:

ISKO Cottonized™

Weight:

Oz 16

Weave Description:

Typical denim fabric with a bulky look, but soft and pleasant to the touch. Adapted to all kinds of treatment. The color, coupled with the finish of the fabric and fibers, and the wash, all result in a natural marbled look.

ISKO™ RESPONSIBLE INNOVATION FABRIC LIST

**Fabric Group 3: RESPONSIBLE TECHNOLOGIES AND PROCESSES**

This group of fabrics also has a sustainable component in the processes that have been used, all ISKO™ products are made using responsible processes, and because some particular technologies bring sustainable values into the end consumer's lifestyle.

The finished garment doesn't have to be washed often and doesn't lose its fit and shape thanks to ISKO™ patented technologies, which helps the consumer save water and chemicals.



**Code: 61432**

Composition:

100% Linen – natural.

Category:

Rigid Fabric

Concept:

Luxure

Weight:

Oz 6

Weave Description:

Light fabric with herringbone pattern. Typical dry linen feel.

**Code: 61437**

Composition:

100% Cotton – classic shirt fabric.

Category:

Rigid Fabric

Concept:

Lightweight

Weight:

Oz 7.75

Weave Description:

Classic 2x1 denim shirt, which may also be used for other types of garments. Adapted to all kinds of treatment.

**Code: 48430**

Composition:

89% Cotton  
6% Polyester  
5% Elastane

Category:

Bi-Stretch Fabric, weft or warp.

Concept:

ISKO Blue Skin™

Technology:

ISKO Recall™

Weight:

Oz 14.5

Weave Description:

The particular feature in this fabric is it is stretched in both directions (weft and warp), while maintaining a typical denim look. Classic 3x1 pattern. Adapted to all kinds of treatment, except for breaks in elastic threads.

**Code: 47986**

Composition:

94.5% Cotton  
2.5% Elastane  
3% Polyester

Category:

Stretch Fabric

Concept:

ISKO Future Face™ Twill

Technology:

ISKO Recall™

Weight:

Oz 12.75

Weave Description:

Particular fabric with a denim look, but ISKO Future Face™ technology. It feels like a sweatshirt to the touch. Adapted to all kinds of treatment.

**Code: 980308**

Composition:

77% Cotton  
20% Polyester  
3% Elastane

Category:

Stretch Fabric

Concept:

ISKO Future Face™

Technology:

ISKO Recall™

Weight:

Oz 5

Weave Description:

Shuttle-woven fabric with a mixed texture resulting in the inside look of a light sweatshirt, which is what it also feels like. The possible treatments are more limited thanks to the lightness of the fabric.

## ISKO™ RESPONSIBLE INNOVATION FABRIC LIST

## Fabric Group 3: RESPONSIBLE TECHNOLOGIES AND PROCESSES

**Code: 48811**Composition:

88.5% Cotton  
3.5% Elastane  
8% Polyester

Category:

Stretch Fabric

Concept:

ISKO Pop™

Technology:

ISKO Recall™

Weight:

Oz 11

Weave Description:

Look reminiscent of satin fabric. It is extremely soft and doesn't lose its softness after being washed.

**Code: 61436**Composition:

58% Cotton  
42% Linen

Category:

Rigid Fabric

Concept:

Luxure

Weight:

Oz 10.5

Weave Description:

Average weight particular fabric with a dry, yet fluid feel, and a diagonal pattern with missed stitches and white dots – Neps.