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:
ISKÒ™ 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.

ISKÒ 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.

ISKÒ 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.

ISKÒ 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.

ISKÒ 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.
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™
Weave Description: Classic 3x1 denim construction, adapted to all kinds of treatment.

**Code: 56624**
Composition: 77.49% Organic Cotton
22.51% Recycled Cotton
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™
Technology: ISKO Recall™
Weight: Oz 11.25
Weave Description: Classic 3x1, adapted to all kinds of treatment.

**Code: 56640**
Composition: 89.20% Organic Cotton
8.35% Recycled Polyester
2.45% Lycra
Category: Stretch Fabric
Concept: ISKO Earth Fit™
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 long 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.

<table>
<thead>
<tr>
<th>Code</th>
<th>Composition</th>
<th>Category</th>
<th>Concept</th>
<th>Weave Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>61429</td>
<td>68% Lyocell 32% Viscose</td>
<td>Rigid Fabric</td>
<td>ISKO Cottonized™</td>
<td>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.</td>
</tr>
<tr>
<td>61440</td>
<td>70% Lyocell 30% Viscose</td>
<td>Rigid Fabric</td>
<td>ISKO Cottonized™</td>
<td>Average weight fabric with a soft slippery fabric, but a typical denim look.</td>
</tr>
<tr>
<td>48422</td>
<td>100% Lyocell</td>
<td>Rigid Fabric</td>
<td>ISKO Cottonized™, Luxure.</td>
<td>Very light fabric with a soft saggy feel, classic 3x1 denim pattern.</td>
</tr>
</tbody>
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### 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.

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<tbody>
<tr>
<td>61432</td>
<td>61437</td>
<td>48430</td>
<td>47986</td>
</tr>
<tr>
<td><strong>Composition:</strong></td>
<td>100% Linen – natural.</td>
<td>100% Cotton – classic shirt fabric.</td>
<td>89% Cotton 6% Polyester 5% Elastane</td>
</tr>
<tr>
<td><strong>Category:</strong></td>
<td>Rigid Fabric</td>
<td>Rigid Fabric</td>
<td>Bi-Stretch Fabric, weft or warp.</td>
</tr>
<tr>
<td><strong>Concept:</strong></td>
<td>Luxure</td>
<td>Lightweight</td>
<td>ISKO Blue Skin™</td>
</tr>
<tr>
<td><strong>Weight:</strong></td>
<td>Oz 6</td>
<td>Oz 7.75</td>
<td>Oz 14.5</td>
</tr>
<tr>
<td><strong>Weave Description:</strong></td>
<td>Light fabric with herringbone pattern. Typical dry linen feel.</td>
<td>Weave Description: Classic 2x1 denim shirt, which may also be used for other types of garments. Adapted to all kinds of treatment.</td>
<td>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.</td>
</tr>
</tbody>
</table>
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.