
Guide lines for leather goods finishing

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Foreword

This Ethiopian Standard has been prepared under the direction of Technical Committee for Leather- and Leather products(TC 74) and published by the Ethiopian Standards Agency(ESA).

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DRAFT

Guide lines for leather goods finishing

1. Scope

This standard provides guidelines for the various stages of leather goods finishing, to ensure final leather good product quality.

2. Normative References

The following standards contain provisions, which, through reference in this text, constitute provisions of the Ethiopian standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreement based on the Ethiopian standards are encouraged to investigate the possibility of applying the most recent editions of the Ethiopian standard indicated below. Registers of currently valid standards are maintained in the Ethiopian Standards Agency.

ES 3328, Standard Terminology Relating To Care Labeling For Apparel, Textile, Home Furnishing, and Leather Products

ES ISO 9001, Quality management system requirement

3. Terminology

For the purpose of this standard, the definitions given in ES 3328 shall apply.

4. Leather goods finishing operations

4.1. Trimming

In the finishing process of leather goods and garment excess threads has to be removed carefully in manufacturing units. The quality of the product is maintained by quality checkers, who are responsible for the work. Thread trimming tool is a very important tool used to remove excess thread after stitching. Since leather goods are stitched with synthetic threads, it is necessary to use thread burning tool to remove the excess thread after stitching. This enhances stitch appearance on the products. In garment and goods manufacturing after finished the whole product formation it must be trim unwanted thread and leather. For this formation hand operating and machine trimmer tools are important.

Thread trimmer is a cutting instrument used to cut out unwanted excess thread from the finished products.



Figure 1 Thread Trimmer

In leather goods production, thread trimmer is used to trim excess thread after stitching of the components or products in the sewing machine. It is also used in final finishing of the products to trim excess thread, left unnoticed. Thread trimming tool is a very important tool used to fuse excess thread after stitching.

Thread Burner

A thread burner is a tool used in beadwork to cut and melt the end of gel-spun (fishing line-type) and nylon beading threads. It allows for the very precise application of heat and replaces the use of a lighter to trim and seal ends.

Push and hold the button of the Thread Burner. The element tip will begin to heat up. Touch the element tip of the Thread Burner to the end of the thread. Burn, or melt, the end of your thread until the end is no longer visible.

Stitch Ripper (Stitch Remover) and Stitch Repair

A **seam ripper** is a small tool used for unpicking stitches. The most common form consists of a handle, shaft and head. The head is usually forked with one side of the fork flattening out and becoming a blade and the other side forming a small point.

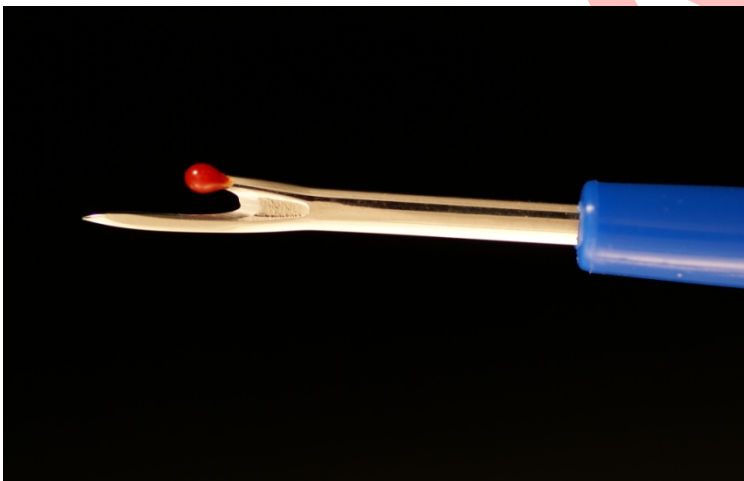


Figure 2 Seam Ripper

Stitch Repairing

Stitching repairing needle is a tempered steel needle. One end of it is flattened with a groove to pull the thread. The flattened head is made very sharp so that it can pierce into the fibrous leather components easily. It is generally known as cobbler's needle. It is used in leather goods making for stitching handles and also for joining component where machine stitching is not possible.



Figure 3 Stitch Repairing

4.2. Leather Goods Cleaning

4.2.1. Cleaning Excess Materials

Leather is a difficult material to take care of. In the manufacturing of leather goods, we should carry out cleaning excess material after finishing the whole operation. Excess material cleaning involves adhesives, excess threads, and others.

4.2.2. Cleaning Markings

Marks can be removed by rubbing gently with a suede cleaning block, a hard rubber eraser, or by touching up the surface with a fine emery paper. Spray new/clean items with a specialist leather protectant to help retain its color and appearance. Ensure you raise the nap before spraying by using a soft brush.

4.2.3. Cleaning of Adhesives from leather goods

In order to clean excess adhesive remove any wet or dry glue from your finished leather goods with help of plastic wrapper.



Figure 4 Plastic Wrapper

Figure 5 Soft brass wire brush

Soft brass wire brush is used to remove dust and loose foreign substances from suede and nubuck leather. Suede brush cleans and brushes up the nap in the suede. If the suede is shiny use a little piece of 120 grit sand paper they bring up the nap even more. In this way we use shoe brush 100% horse hair they provides the high gloss shine in suede leather. Similarly use leather shine cloth, after polishing, it provides extra- bright high gloss shine. The bars remove shiny marks and stains. The brush brings the nap of the leather to its original appearance.

4.2.4. Suede and nubuck cleaners

These cleaners clean, condition and soften suede and nubuck leathers. Removes dust and dirt from bags, shoes, boots, belts, clothing and more. The cleaners built in bristle top makes application and cleaning easy and mess free.



Figure 6 Suede and Nubuck Cleaners

Crepe rubber

Crepe Rubber is used to clean the surface of the leather goods wherever glue or adhesive has been be stuck. It is a natural product produced by coagulation of the latex from the rubber tree. Latex is formed into thin sheets, and then laminating and pressing a good number of sheets together to give a specific thickness. Chemically it is a polymer made from "Isoprene" monomer units which has sufficient strength not to need vulcanizing. The crepe which is harder and lighter in color provides better wear comfort.

4.3. Leather goods polishing

Leather goods polish is a waxy paste cream, or liquid used to polish in order to provide shine, water proof and restore the appearance of leather goods, bags etc. and extending the leather life.

4.3.1. Polishing Leather Goods

Polishing is the process of smoothing and shining the surface of leather garment and goods by rubbing. After cleaning of excess adhesives and threads, polishing leather part in appropriate wax with smoother cloth or towel helps to enhance the look of the product and retain leathers natural characteristics. Polishes enhance the color and provide a protective layer from light rains and spills.

Polish usually contains several kinds of synthetic waxes, paraffin waxes, resin, solvents, auxiliary agent and water. As well as the requirements of the consumer, cost of the components is an important factor in the formulations. In all types of color and design the polishes are needed with every type of leather goods.

A polish conditions and helps retain leathers natural oils. It masks scuffs and marks, enhances the color and provides a protective layer from light, rain and spills.

4.3.2. Polishing instruction

Polishing should take no more than a few minutes

- I. Start by removing any dirt or debris by wiping the bag with a damp cloth.
- II. Apply a small amount of cream and spread evenly in a circular motion over bag. You can use either cotton cloth or a polish application brush to apply.
- III. Take a minute to allow the cream time to dry on bags.
- IV. Once dry, buff off with a polishing cloth or polishing pad for high shine.

4.3.3. Tips and tricks for polishing

- I. Try and match the polish as close as you can to the color of your bags.
- II. If you choose the color neutral, use this on light colored bags only as it tends to leave a white film on dark colored bag over time.
- III. Always remove bags accessories before polishing to good clean and ensures that do not get stained by the polish.
- IV. If the bag has stains or greasy oil marks on them, use "SPOT Stain Remover" Before Polishing.

4.4. Leather goods ironing

Ironing is used to attach and remove wrinkles from leather. The piece at the bottom is called a sole plate. Special electrically heated hand irons which are thermostatically controlled are used for removing wrinkles. Sometimes the whole leather surface is ironed to improve the finished quality.

Ironing is the use of a machine, usually a heated tool (an iron), to remove wrinkles from the leather surface. Genuine leather outfits are always trendy. Leather is stylish, casual, and waterproof and does not crumple easily.

However, as a result of improper storage, there are situations when wrinkles and crumples appear on the leather. Hence ironing removes those wrinkles from the surface of the leather products.

4.5. Final inspection process

The whole product is cleaned both inside and outside with a clean piece of foam. Before the articles are sent for packing, strict quality control is observed for perfection in assembling, Stitching accuracy and smooth functioning of fittings. Start by removing any dirt or debris by wiping the bags with a foam/ cloth. Apply a small amount of cream and spread evenly in a circular motion over bags. You can use either Foam, cotton cloth or a polish application brush to apply. Polyurethane foam rubber sheets are used in a variety of leather goods where cushioning of the products is necessary. 2m x 1m x 3mm and 2m x 1m x 6mm foam rubber sheets are normally used in leather goods reinforcement making and polishing with cream.

The following aspects of garments should be checked:

- a) Correct dimensions;
- b) Seam pucker, seam allowance and sewing,
- c) Garment symmetry;
- d) Pressing/fusing defects;
- e) Cleanliness;
- f) Loose threads;
- g) Correct matching of garment and trimmings;
- h) Correct fitting and alignment of closures; and
- i) Correct placing of labels.

A reference sample and complete specification of garment should be available at the inspection point which should have proper lighting conditions. As far as possible, all garments should be checked.

5. Labelling

The leather garments should be properly labelled. The size and details of labels should be as agreed to between the buyer and the seller and as far as possible, should indicate the following:

- a) After-care instructions;
- b) Size designation;
- c) Manufacturer's name, initials or trademark; and
- d) Country of origin.

6. Packaging

Packages should be designed as to ensure that the leather goods reach the consumer in satisfactory condition. The details such as, packaging material, number of leather good product etc. should be mentioned.

Organization and Objectives

The Ethiopian Standards Agency (ESA) is the national standards body of Ethiopia established in 2010 based on regulation No. 193/2010. ESA is established due to the restructuring of Quality and Standards Authority of Ethiopia (QSAE) which was established in 1998.

ESA's objectives are:-

- ❖ Develop Ethiopian standards and establish a system that enable to check whether goods and services are in compliance with the required standards,
- ❖ Facilitate the country's technology transfer through the use of standards,
- ❖ Develop national standards for local products and services so as to make them competitive in the international market.

Ethiopian Standards

The Ethiopian Standards are developed by national technical committees which are composed of different stakeholders consisting of educational institutions, research institutes, government organizations, certification, inspection, and testing organizations, regulatory bodies, consumer association etc. The requirements and/or recommendations contained in Ethiopian Standards are consensus based that reflects the interest of the TC representatives and also of comments received from the public and other sources. Ethiopian Standards are approved by the National Standardization Council and are kept under continuous review after publication and updated regularly to take account of latest scientific and technological changes. Orders for all Ethiopian Standards, International Standard and ASTM standards, including electronic versions, should be addressed to the Documentation and Publication Team at the Head office and Branch (Liaisons) offices. A catalogue of Ethiopian Standards is also available freely and can be accessed in from our website.

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