



**CONE DENIM®  
VINTAGE SELVAGE DENIM  
PURCHASE GUIDE**

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**TO OUR VALUED CUSTOMER:** PLEASE REVIEW THIS DOCUMENT AS ACKNOWLEDGMENT OF YOUR UNDERSTANDING OF THE NATURE OF THE CONE DENIM VINTAGE SELVAGE FABRIC SAMPLED/PURCHASED. THANK YOU.

## EXPECTATIONS FOR CONE DENIM VINTAGE SELVAGE WOVEN DENIMS

CONE SELVAGE DENIM IS WOVEN ON LOOMS BASED ON VINTAGE TECHNOLOGY THAT ALLOWS FOR PRODUCTION TO HAVE THE APPEARANCE AND CHARACTERISTICS OF VINTAGE SELVAGE DENIM. THE SLOW PRODUCTION RATE AND LACK OF MODERN MICROPROCESSOR CONTROLS, AS WELL AS THE WOVEN SELVAGE, GIVES THE FABRIC WOVEN ON THESE LOOMS A UNIQUE CHARACTER THAT CANNOT BE DUPLICATED ON A MODERN WEAVING MACHINE. THESE SAME FACTORS BRING SOME INHERENT VARIABLES TO THE FABRICS THAT ARE AS MUCH A PART OF THE DENIM AS THE WOVEN SELVAGE.

BASED ON THE VARIETY AND CUSTOMER EXPECTATIONS FOR THE FABRIC DESIGNS MADE ON THESE LOOMS, MANY STYLES ARE PRODUCED USING REDUCED DYE SET LENGTHS. THE OLD WEAVING TECHNOLOGY COMBINED WITH THE LACK OF MODERN TENSION AND MICROPROCESSOR CONTROLS CAN RESULT IN SIGNIFICANT VARIATION IN THE AMOUNT OF FIRST QUALITY YARDAGE PRODUCED FROM EACH DYE RUN. DUE TO THIS VARIABILITY, CUSTOMERS WOULD BE EXPECTED TO PURCHASE ALL FIRST QUALITY FABRIC ON CUSTOM STYLES AND/OR CUSTOM ID SELVAGE RUNS; SHORTAGES ARE NOT MADE UP.

THE AVERAGE WIDTH OF VINTAGE FABRIC IS LESS THAN HALF THAT OF DENIMS WOVEN ON MODERN LOOMS. BECAUSE OF THE LIMITED NUMBER OF LOOMS, AND THE FACT THAT WE ARE DYEING THE EQUIVALENT OF TWICE THE LINEAR YARDS OF FABRIC PER DYE RUN, WE HAVE TO UTILIZE SHORTER DYE RUNS TO MAINTAIN FLEXIBILITY. THE SHORTER RUNS MEAN THAT THE PERCENTAGE OF WARP YARN THAT IS PART OF A START UP IS HIGHER THAN IT IS FOR WIDE LOOMS. START UP YARDAGE TENDS TO BE A BIT MORE VARIABLE, AND THEREFORE LEADS TO A WIDER SHADE RANGE FOR THE PRODUCTION.

THE SHADE IS ALSO INFLUENCED BY THE LOWER WARP TENSION AND THE INABILITY TO SET THESE SELVAGE MACHINES WITH THE SAME PRECISION AS A MODERN LOOM. THIS CAUSES MORE VARIABILITY IN THE "WARP COVER" OF THE FABRIC, WHICH MAKES THE FABRIC APPEAR LIGHTER OR DARKER AS THE COVER VARIES.

THE WOVEN SELVAGE ALSO PROVIDES A CHALLENGE WHEN SHADE SORTING THE FABRIC FOR SHIPMENT. WIDTH VARIATION ABOVE THE MINIMUM WIDTH DOES NOT CREATE A PROBLEM IN GARMENT CONSTRUCTION WHEN FABRIC IS WOVEN ON A WIDE LOOM. THE SPREAD IS LINED UP USING ONE SELVAGE, WITH THE OPPOSITE SIDE SHOWING ANY VARIATION IN FABRIC WIDTH. PATTERNS BASED ON THE MINIMUM FABRIC WIDTH ALLOW FOR PROPER CUTTING OF GARMENT PANELS, AND EXCESS WIDTH OVER MINIMUM BECOMES SCRAP. WITH VINTAGE FABRIC, THE WOVEN SELVAGES ARE INCORPORATED INTO THE CONSTRUCTION OF THE GARMENT. THIS REQUIREMENT CAN GIVE US SMALL GROUPS WITHIN A SINGLE SHIPMENT. AS MOST SHIPMENTS OF VINTAGE FABRIC ARE SMALL, THE GROUPS THEMSELVES MAY ALSO BE QUITE SMALL.

THESE FABRICS REFLECT PRODUCTION FROM A TIME WHEN LEG TWIST IN TWILL WEAVES COULD NOT BE CONTROLLED. EVEN WITH MODERN FINISHING EQUIPMENT, THE NARROW WIDTH OF SELVAGE FABRICS DOES NOT ALLOW US THE SAME DEGREE OF CONTROL THAT CAN BE ACHIEVED WITH MODERN WIDE FABRICS. SOME DEGREE OF LEG TWIST IS NORMAL WITH THESE FABRICS, AND IS INDICATIVE OF THE TRUE VINTAGE NATURE OF THESE PRODUCTS.

CONE DENIM VINTAGE FABRICS HAVE THEIR OWN UNIQUE GRADING REQUIREMENTS. EVEN TAKING INTO ACCOUNT THE VARIABILITY OF VINTAGE WOVEN FABRIC, THE FALL OUT THAT IS ABSORBED BY CONE DENIM IS MUCH HIGHER THAN WOULD BE ACCEPTABLE IN PRODUCTION FROM MODERN WEAVING MACHINES. BECAUSE OF THIS HIGH LEVEL OF OFF QUALITY, THE MINIMUM ROLL LENGTH ON SELVAGE FABRIC IS 20 YARDS. THIS VARIABILITY IS PART OF THE UNIQUE CHARACTER OF VINTAGE WOVEN FABRICS.

THE FABRIC IS 100% INSPECTED COUNTING/MARKING MAJOR DEFECTS AND COUNTING MINOR DEFECTS. THE ALLOWABLE POINT COUNT FOR THIS FABRIC IS 20 POINTS PER HUNDRED SQUARE YARDS BASED ON MAJOR AND MINOR DEFECTS. IN ADDITION, SOME "DEFECTS" ARE INTENTIONALLY LEFT IN THE PRODUCT TO ENHANCE THE VINTAGE APPEARANCE OF THE FABRIC AND THE GARMENTS PRODUCED FROM IT. AN EXAMPLE OF THIS TYPE OF DEFECT IS LIGHT STARTMARKS OR LOOM STOPS. THE SPECIAL NATURE OF THIS FABRIC AND THE GRADING METHOD USED SHOULD BE CONSIDERED WHEN ESTABLISHING THE EXPECTATIONS FOR GARMENTS PRODUCED FROM CONE DENIM VINTAGE DENIMS.



## SPREADING AND CUTTING CONE DENIM VINTAGE SELVAGE DENIMS

THE INFORMATION CONTAINED HEREIN IS PROVIDED FOR CUSTOMERS NOT FAMILIAR WITH SPREADING AND CUTTING NARROW WIDTH SELVAGE FABRICS. WHILE MANY SPREADING AND CUTTING TECHNIQUES CAN BE UTILIZED FOR SPREADING AND CUTTING NARROW WIDTH SELVAGE FABRICS, THERE ARE A FEW TECHNIQUES THAT HAVE BEEN DEVELOPED THAT MAY PROVE HELPFUL.

### FACE UP SINGLE PLY SPREADING

TRADITIONALLY, NARROW WIDTH SELVAGE FABRICS HAVE BEEN SPREAD USING THE FACE-UP TECHNIQUE IN WHICH COMPLETE GARMENTS ARE CUT FROM A SINGLE PLY IN VERY CLOSE PROXIMITY TO ONE ANOTHER. WHILE THIS TECHNIQUE IS STILL IN WIDE USE TODAY IT MAY NOT PROVIDE THE BEST UTILIZATION OF FABRIC. FABRIC IS SPREAD THE LENGTH OF THE MARKER FACE UP AND CUT-OFF AT THE END OF THE DESIRED SPREAD LENGTH. THE SPREADING CARRIAGE IS RETURNED TO THE STARTING POSITION AND A SECOND PLY IS SPREAD AGAIN FACE UP. THIS METHOD IS REPEATED UNTIL THE DESIRED NUMBER OF PLIES IS ACHIEVED. THE NARROW WIDTH FABRIC MUST BE CHECKED DURING SPREADING TO ASSURE THAT THE SELVAGES ARE EVEN AND MATCHED ON BOTH SIDES. THE PAPER PATTERN MARKER IS SPREAD ONTO THE TOP OF THE FABRIC PLIES. THE MARKER EDGE IS CHECKED FOR ALIGNMENT WITH THE SELVAGE, AS THE SELVAGE IS PART OF THE GARMENT PANEL, ON THE LEAD SIDE AND THEN THE OPPOSITE SIDE. IF THE ALIGNMENT OF THE EDGE OF THE MARKER AND THE FABRIC SPREAD ARE NOT IN AGREEMENT AN ADJUSTMENT FOR FABRIC WIDTH MUST BE MADE AT THIS TIME. ADJUSTING THE WIDTH OF THE PAPER PATTERN IS A SIMPLE PROCESS WHEREBY THE PAPER IS SPLIT DOWN THE MIDDLE BETWEEN THE PANELS THE LENGTH OF THE PAPER (SEE BLUE LINE) ON THE ATTACHED ILLUSTRATIONS. AFTER SPLITTING THE PAPER PATTERN AND MATCHING THE OUT SEAM SIDED TO THE SELVAGE THE PAPER PATTERN MAY BE SECURED TO THE TOP PLY OF THE SPREAD. THE FABRIC PANELS ARE THEN CUT BY NORMAL MEANS.

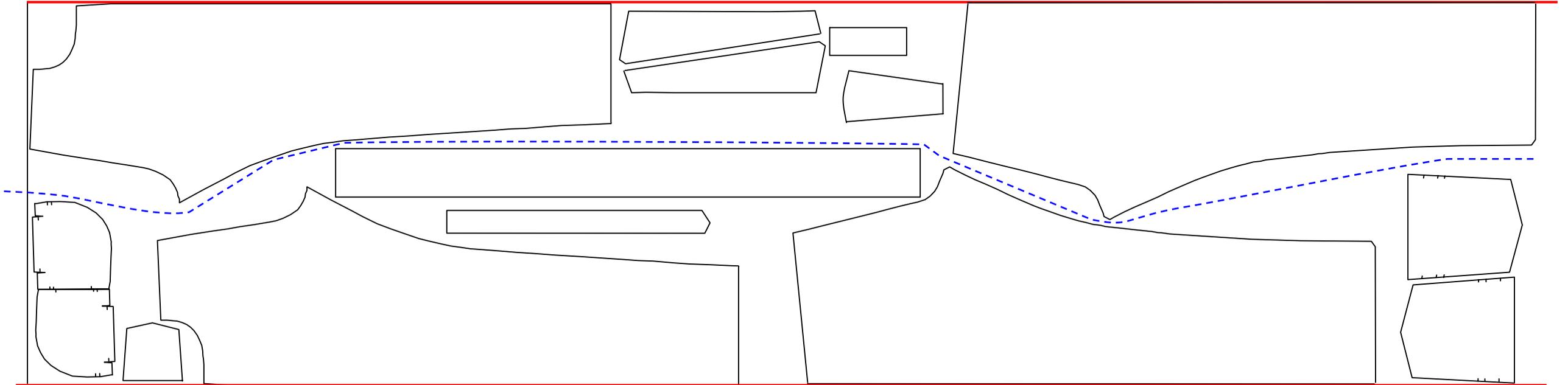
### PAIR BACK SPREADING

PAIR BACK OR FACE TO FACE SPREADING IS MORE COMMON PLACE DUE TO THE GREATER EFFICIENCY OF THIS METHOD. THE COMMON SPREADING OF THIS METHOD INVOLVES UTILIZING A ROLL OF FABRIC SPREAD BACK AND FORTH WITHOUT CUTTING THE FABRIC ALONG THE LENGTH OF THE MARKER UNTIL THE ROLL LENGTH IS USED UP. ANOTHER ROLL IS STARTED AT THE NEAREST SECTION COMPLETED WITH THE OVERLAPPING FABRIC CUT AWAY TO BE USED FOR RE-CUTS OR BELT HANGERS, HOWEVER WITH NARROW WIDTH SELVAGE IT IS SLIGHTLY DIFFERENT. GENERALLY, A SINGLE ROLL OR PARTIAL ROLL WILL BE USED FOR COMPLETING A SPREAD, AS THE SPREADS OF NARROW WIDTH SELVAGE TEND TO BE MUCH SHORTER THAN CONVENTIONAL SPREADING DUE TO SMALLER NUMBERS OF GARMENTS AND REDUCED AMOUNT OF WIDTH VARIATION REQUIRING ADJUSTMENT. FABRIC IS SPREAD INSURING THE SELVAGES ARE EVEN AND MATCH ON BOTH SIDES UNTIL FULL COMPLETED PAIR SECTION ARE SPREAD. THE PAPER PATTERN IS ALIGNED ON THE LEAD SELVAGE SIDE AND THE OPPOSITE SIDE CHECKED FOR ALIGNMENT. WIDTH ADJUSTMENT IS MADE IN THE SAME MANNER AS WITH FACE UP SINGLE PLY SPREADING BY SPLITTING THE PAPER PATTERN AND ALIGNING THE EDGE TO THE SELVAGES. SOME ADJUSTMENTS TO PATTERN PIECES MAY BE NECESSARY AND BENEFICIAL TO UTILIZATION WHEN USING THE PAIR BACK SPREADING METHOD. WHEN 2 OR MORE SIZES ARE IN THE SAME SECTION SOME SINGLE PARTS MAY BE STACKED FOR BETTER UTILIZATION. SUCH PARTS MAY INCLUDE WAISTBANDS AND FLY FRONTS. SOME EXAMPLES ARE SHOWN IN THE ATTACHED ILLUSTRATIONS. FOR ANY ADDITIONAL INFORMATION CONCERNING CONE VINTAGE SELVAGE FABRICS CONTACT YOUR CONE DENIM REPRESENTATIVE.



## SHORT SECTION 30.25" NARROW-WIDTH FABRIC

### FACE UP SINGLE PLY-SPREADING

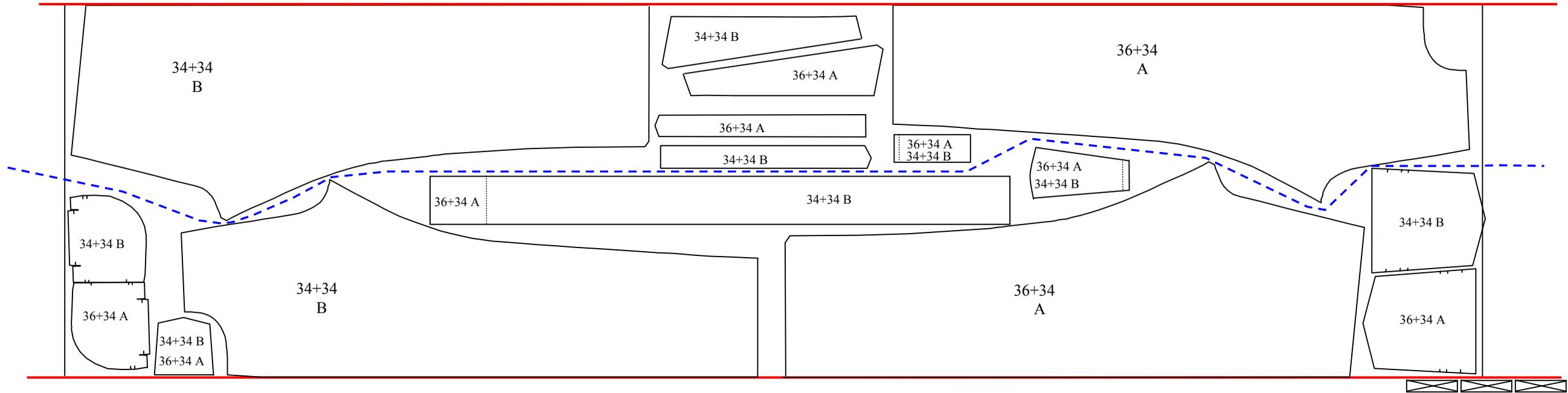


Single Ply face-up spreading techniques can be utilized to spread and cut narrow width fabrics using the selvage as indicated above. Common panels can be utilized for multiple sizes as shown in the Pair back spreading method such as: Waist bands, Watch Pocket and Fly, depending on design.

As previously indicated the paper pattern may be cut down the center (Blue) line in order to adjust for differences in width from one spread to another. Differences in width must be adjusted to maintain the outseams on the selvage edge.

# SHORT SECTION 30.25" NARROW-WIDTH FABRIC

## PAIR BACK SPREADING



The illustration above represents a 2 pair short section, which makes use of stacked multiple sized waistbands and other parts to maximize utilization and efficiency on narrow width fabrics with pair back spreading. This marker method will also work on larger sections to increase utilization and yield.

The paper pattern may be cut down the center (Blue) line in order to adjust for differences in width from one spread to another. Differences in width must be adjusted to maintain the outseams on the selvage edge.