

This document applies to ORALITE® industrial wash glass bead tapes (garment trims) for sewing application. These instructions do not apply to ORALITE® industrial wash glass bead tapes for heat application. Products covered in this document:

- ORALITE® GP 050
- ORALITE® GP 090
- ORALITE® GP 090P
- ORALITE® GP 095
- ORALITE® GP 095P
- ORALITE® GP 100

## 1.0 General Information

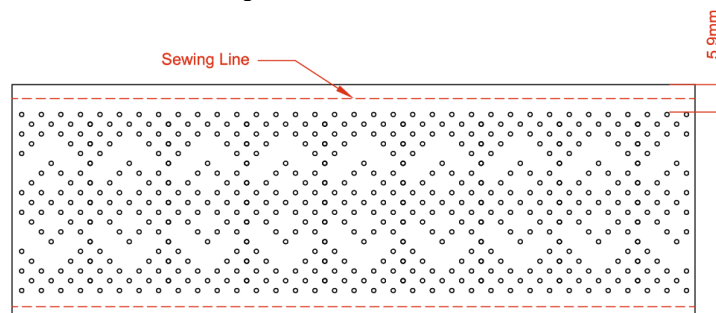
ORALITE® industrial wash glass bead tapes for sewing application are flexible, weather-resistant tapes designed for use on high visibility garments. They are to be sewn to suitable background fabrics and they exceed the photometric requirements of EN ISO 20471:2013. For more information on the retroreflectivity of ORALITE® industrial wash glass bead tapes for sewing application, please reference the relevant technical product bulletin. These are available from your ORAFOL representative or they can be downloaded at [www.orafol.com](http://www.orafol.com).

We suggest the following measures are taken to achieve the optimum performance from the tapes.





### 1.1 Application - Sewing to Garment Background Fabric

ORALITE® industrial wash glass bead tapes for sewing application should be sewn onto high visibility garments.





















1. **Sewing Machine Settings** – Recommended stitches per inch is 8 (eight). Reduce pressure on the machine foot. A Teflon coated pressure foot can also help with sewing.
2. **Background fabric** – Whilst ORAFOL has carried out compatibility checks to most of the readily available background fabrics, we cannot give an open guarantee that the chosen background fabric is fully compatible. Please check with the manufacturer of the fabric before use. The thread must be able to withstand the same wash and wear conditions as the material it is being applied to.
3. **General** – Do not stretch the tape as it is being applied. At the cut ends of the tape we recommend that the tape is turned under itself and sewn through the doubled over edge. Where possible within the design of the garment, the cut ends should be inside the seams of the garment.
4. **Sewing border** –  
ORALITE® GP 050/090/095  
There is no defined sewing border on these tapes but we recommend sewing at 2 – 3 mm from the edge of the tape.  
ORALITE® GP 090P/095P  
Please sew inside the centre of the sewing border as shown:



## 2.0 Care Instructions – General Information Symbols explained

	Tumble dry, normal, medium heat		Iron, low		Dry clean, any solvent except trichloroethylene		Industrial wash
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**Table 1: Overview of Care Instructions**

PRODUCT	RECOMMENDED CARE SYMBOLS	WASH TEMPERATURE	APPROVAL
ORALITE® GP 050	    	100 cycles at 60° C  **25 wash cycles at 75° C + tumble drying at 90° C	ISO 15797:2017 Method 1.2 & 4.2
ORALITE® GP 100	    	**50 wash cycles at 75° C + tumble drying at 90° C 50 wash cycles at 75° C + tunnel drying at 155° C	ISO 15797:2017 Method 1.2 & 4.2
ORALITE® GP 090/ GP 090P	    	100 cycles at 60° C  **50 wash cycles at 75° C + tumble drying at 90° C 50 wash cycles at 75° C + tunnel drying at 155° C	ISO 15797:2017 Method 1.2 & 4.2
ORALITE® GP 095/ GP 095P	    	50 cycles at 60° C  **50 wash cycles at 75° C + tumble drying at 90° C / 50 wash cycles at 75° C + tunnel drying at 155° C	ISO 15797:2017 Method 1.2 & 4.2

\*\*) as per ISO 15797:2017,

ORALITE® industrial wash glass bead tapes for sewing application wash as well at lower temperatures as they do at higher temperatures. Therefore select the lowest washing temperature that will ensure adequate cleaning of the fabric. This will allow environmentally friendly washing and will extend the life of the garment.

Variations in environmental conditions as well as chosen care process may affect the life of your garment. Regular inspection of the garment performance against the requirements of EN ISO 20471:2013 is recommended. Information included in the care label should be verified to ensure that the reflective material maintains compliance with EN ISO 20471:2013.

## Hand Washing

Hand washing can be done with a sponge, a soft fabric cloth or a soft brush with lukewarm water and a mild detergent. After washing, the tape must be rinsed with clean water. Stubborn stains such as grease or tar may be spot cleaned with petrol, alcohol, naphtha or turpentine. After spot cleaning the tape must be hand washed as above and rinsed with water.

## Industrial Washing

Washing Machine	Standard front-loading industrial washing machine. Tunnel washing is not recommended.
Temperature	Maximum wash temperature certified is 75° C. The tape will handle higher temperatures but that will reduce the life of the tape/garment.
Detergent	Low- to medium- alkaline, high-surfactant detergents. The detergent should not contain free sodium hydroxide or potassium hydroxide.
Detergent pH	Aggressive detergents with high pH values (>11) and high dosage will reduce product performance over the lifetime of the application. Please check the detergent Material Safety Data Sheet (MSDS) for the pH value and choose detergents with pH values less than 10.5 in order to increase the product lifetime. Please contact ORAFOL Technical Support for additional information.

### Caution!

- Do not pre-soak
- Do not use high alkaline products (such as heavy duty products or stain removal products)
- Do not use solvenated detergents or micro-emulsions
- Do not use additional bleaches
- Rinse thoroughly in order to completely remove all detergent residues.

Tape longevity can be improved by:

- Using lower temperatures
- Limiting abrasion in the wash process
- Not pre-soaking with detergent
- Lower pH detergents (more towards neutral)
- Using acid letdown/rinse

### Note!

ORALITE® industrial wash glass bead tapes for sewing application are certified to ISO15797 Method 1.2 & Method 4.2 as detailed above. Washing process, drying process and detergent selection changes can significantly change the wash durability of the reflective tape. It is important that these parameters are evaluated for each application, and it remains the responsibility of the user to test their specific conditions to assess durability.

## Household Washing

Washing Machine	Standard household washing machine
Temperature	Maximum wash temperature certified is 75° C. The tape will handle higher temperatures but those will reduce the life of the tape/garment.
Detergent	Standard household detergent, which contains oxygen bleach to reduce staining with Hi-Vis garments.
Setting	“Coloured clothing without pre-wash”

Maximum washing time on highest temperature should not exceed 12 minutes.  
Maximum total washing time should not exceed 50 minutes.

If ORALITE® industrial wash glass bead tapes for sewing application are used on fabrics that outbleed (run) easily; we recommend conducting the first two washes at 40° C. This can prevent colour staining.

## Bleaching

Only use non-chlorine bleach when needed.

## Drying

### Tumble dry

Maximum temperature shall not exceed 90° C.

Dry to "slightly humid". Do not over dry.

For extended life, the garment should be turned inside out before drying.

### Tunnel dry

Maximum inlet temperature shall not exceed 155° C.

The drying time should not exceed 6 minutes.

Limited abrasion tunnel dry is recommended.

## Chemical cleaning / dry cleaning

Do not dry clean.

## Ironing

Do not use steam.

Use a cool or warm temperature setting.

Avoid direct contact of the tape when ironing, use a press cloth.

## IMPORTANT NOTICE

All ORALITE® products are subject to careful quality control throughout the manufacturing process and are warranted to be of merchantable quality and free from manufacturing defects. Published information concerning ORALITE® products is based upon research which the Company believes to be reliable although such information does not constitute a warranty. Because of the variety of uses of ORALITE® products and the continuing development of new applications, the purchaser should carefully consider the suitability and performance of the product for each intended use, and the purchaser shall assume all risks regarding such use. All specifications are subject to change without prior notice.

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