



Journal of the **TEXTILE Association**

VOL. 86

NO.6

MARCH-APRIL, 2026



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Printed at : **S S Enterprises, Mumbai**

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Chemical Abstracts - USA | World Textile Abstracts-UK
Science Abstracts - India | Elsevier, Scopus-Netherland

THE TEXTILE ASSOCIATION (INDIA)

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Threads of Resilience Amidst Global Conflict

Dear Readers,
Greetings!!

As we move through the second quarter of 2026, the global textile landscape is being reshaped by a "new phase" of geopolitical instability. While the industry has historically shown remarkable adaptability, the current conflict has introduced systemic pressures that demand a strategic shift from mere cost efficiency to deep-rooted resilience. The most immediate impact of this situation has been a dramatic disruption of maritime trade routes. Container shipping costs have surged by nearly 50% since the recent escalation. For textile hubs in India and South Asia, the diversion of vessels away from the Red Sea and through the Cape of Good Hope has not only doubled transit times but also significantly increased "landed costs".

For an industry that operates on razor-thin margins, these logistical hurdles are no longer peripheral; they are central to survival.

Beyond logistics, the war has ignited a multi-layered cost crisis. With oil prices volatile, the cost of synthetic fibres (e.g. polyester, nylon) has skyrocketed by an estimated 35 to 40%. High energy and coal prices have raised manufacturing overheads by 10 to 15% globally. While raw material costs for yarns have also jumped, selling prices have lagged, leaving approximately 40% of manufacturing units struggling to remain operational.

As a Path Forward, the message is clear: the industry cannot simply wait for a ceasefire. Success in 2026 requires shifting from single-route dependence to dual-route logistics and nearshoring. Using technological tools to manage inventory and respond to shifting consumer sentiment in the US and Europe. Utilising digital tools to streamline product creation and minimise the waste of high-value inventory.

From the textile association, The Journal remains committed to providing the technical insights necessary to navigate these turbulent times. As the "backbone of trade information," we urge our readers to view these disruptions not just as temporary obstacles, but as a catalyst for a more robust and regionalised global textile value chain.

With best wishes,

Dr. Aadhar Mandot
Hon. Editor
Journal of the Textile Association



R. K. VIJ, President

The Crisis of Inverted Duty in the MMF Sector

The Textiles & Apparel (T&A) industry was having long-pending (first under sales tax then, under VAT and finally under GST regime) demand for removal of inverted tax structure on manmade fibre (MMF) value chain. The GST on MMF, MMF Yarn and MMF Fabrics were 18%, 12% and 5% respectively. The taxation of inputs at higher rates than finished products created a build-up of credits and cascading costs. It further led to the accumulation of taxes at various stages of the MMF value chain and the blockage of crucial working capital for the industry.

Govt. corrected the long-standing inverted duty structure in the Man-Made Fibre (MMF) sector to boost domestic production and exports.

Key Aspects of the MMF Inverted Duty Crisis & Resolution:

- **The Crisis:** Previously, MMF raw materials (fiber/yarn) were taxed at higher rates (12%-18%) than finished products (fabrics at 5%), leading to an accumulation of Input Tax Credit (ITC) and blocked working capital.
- **The Correction (September 2025):** The GST Council slashed rates on MMF from 18% to 5% and MMF yarn from 12% to 5% to harmonize the entire textile chain at 5%.
- **Impact:** This shift resolves the inverted structure for the chain, allowing manufacturers to claim refunds on accumulated ITC, thus improving competitiveness and reducing compliance costs.
- **Ongoing Concerns:** Despite the changes, some stakeholders noted that key inputs like Purified Terephthalic Acid (PTA) and Mono Ethylene Glycol (MEG) remained at higher rates, necessitating further adjustments to fully alleviate the tax burden.
- **Objective:** The move aims to boost India's share in global textiles, which is heavily shifted towards MMF rather than cotton.

Man-Made Fiber (MMF) manufacturers across all categories POY, DTY, FDY, and PSF are facing a severe working capital crunch. Because the tax rate on raw materials is much higher than the tax rate on finished products, massive amounts of capital are being locked up in government refund cycles.

1. The Step-by-Step Financials

The industry suffers an Inverted Duty Inversion of ₹14.26 per kg across the board. Here is how it works out using a standard industry example:

Stage	Product / Material	Base Price Per Kg.	GST Rate	GST Per Kg.
Input (Purchase)	Primary Raw Materials (PTA & MEG)	₹ 111.22	18%	₹20.01 (paid)
Output (Sale Example)	Fine Denier POY (or PSF, DTY, FDY)	₹ 115.00	5%	₹5.75 (Collected)
The Deficit	Net Capital Blocked per KG	-	-	₹14.26 (Blocked)

2. Illustration: The Working Capital Chokehold

The flowchart below illustrates how every single segment of the MMF downstream chain is forced to deposit this deficit before chasing refunds.

STEP 1: RAW MATERIAL PURCHASE

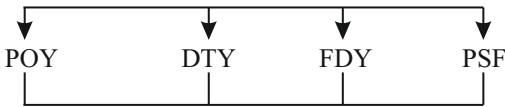
Manufacturers buy PTA & MEG (Paid: 18% GST / ₹20.01)



STEP 2: THE MANUFACTURING PROCESS

Affects ALL Segments across the MMF Value Chain:

Affects ALL Segments across the MMF Value Chain:



STEP 3: SALES TO CUSTOMERS

Finished goods sold at a lower tax rate
(Collected: 5% GST / ₹5.75)



STEP 4: THE FINANCIAL CRUNCH

Manufacturers must **FIRST DEPOSIT** the difference
of ₹14.26 / kg to the Government.



STEP 5: THE REFUND BOTTLE-NECK

Apply for GST refunds on the excess input tax.
Cash is **BLOCKED** for 2 to 3 MONTHS
Huge interest losses incurred all year long.

3. Impact on the MMF Ecosystem

- **Forced Capital Blockage:** Manufacturers of POY, PSF, DTY, and FDY are collectively forced to act as interest-free lenders to the system, waiting months to recover their own money.
- **Compounded Interest Loss:** The 2-to-3-month delay in refund processing creates a continuous cycle of interest losses that drains yearly profitability.
- **Growth Stagnation:** Money that should be used for business scaling, tech upgrades, and daily operations is trapped.

4. The Industry's Unified Appeal

Last year, the government took a monumental step toward Ease of Doing Business by consolidating the downstream MMF value chain (fiber, filament, yarn, fabric, and garments) from fragmented rates (18%, 12%, and 5%) into one uniform GST rate of 5%.

To finish the job and unlock the full potential of Indian Textiles, we request the government with folded hands:

The Final Request

To bring the primary raw materials PTA and MEG down from 18% to the same 5% GST rate.

Unifying the tax rates from raw material to finished garment will completely eliminate the refund bottleneck, boost domestic growth, aggressively promote Indian exports, and heavily reduce our dependence on textile imports.

R. K. VIJ

National President
The Textile Association (India)

Strategic HRM Practices for Enhancing Employee Retention in MSMEs

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Abstract:

The growth and sustainability of Micro, Small, and Medium Enterprises (MSMEs) heavily rely on their human resource base, making employee retention a critical component of strategic management. High attrition rates in MSMEs are often attributed to limited career progression, inadequate compensation, and lack of structured HR practices. This study explores the role of Strategic Human Resource Management (SHRM) practices in fostering employee retention within MSMEs, emphasizing performance-based reward systems, learning and development opportunities, leadership engagement, and workplace culture enhancement. By integrating theoretical frameworks with empirical insights, the research underscores how HR strategies, when aligned with business goals, improve organizational commitment and reduce turnover. Using qualitative methodology supported by structured questionnaires and real-life case analysis from Indian MSMEs, the study reveals that companies deploying proactive HRM strategies outperform others in retaining skilled talent. The paper also identifies critical limitations, such as resource constraints and lack of professional HR expertise, which hinder HR effectiveness in MSMEs. Furthermore, the research adds new dimensions by linking SHRM practices with employee well-being, organizational branding, and psychological contract fulfilment factors often overlooked in small businesses. The findings serve as a blueprint for HR transformation within this vital sector of the economy, offering practical and scalable interventions.

The study further emphasizes the cost implications of high attrition on productivity and operational continuity, particularly in high-skill sectors. It explores how digital HR tools like cloud-based appraisal systems and AI-driven engagement platforms can support SHRM in resource-limited environments. Employee voice mechanisms, when institutionalized through feedback loops, significantly enhance retention rates. By comparing MSMEs with and without SHRM practices, the research establishes quantifiable retention benefits. Ultimately, the paper positions SHRM not only as a retention strategy but as a catalyst for cultural change and long-term business resilience in the MSME landscape.

Keywords: *Employee Retention, Human Capital, Strategic HRM, MSMEs, Performance Appraisal, Talent Management*

Citation: S. Vijayalakshmi, "Strategic HRM Practices for Enhancing Employee Retention in MSMEs", *Journal of the Textile Association*, **86/6** (March-April, 2026), 593-597, <https://doi.org/10.5281/zenodo.20552485>

Article History : Received : 25-02-2026, Revised: 28-02-2026, Accepted: 03-03-2026

1. Introduction

Employee retention has emerged as one of the most pressing challenges in Micro, Small, and Medium Enterprises (MSMEs), where the competition for skilled labor is intense and financial constraints limit incentive offerings. In India, MSMEs contribute approximately 30% to the GDP and employ over 110 million individuals. However, according to a report by the Ministry of MSME (2023), the sector experiences an annual attrition rate of over 35%, with younger professionals seeking better remuneration and structured growth trajectories. Unlike larger corporations, MSMEs often lack formalized HR systems, resulting in ad hoc decision-making that fails to meet employee expectations. This disorganized approach leads to inconsistent communication, fragmented training programs, and a lack of clarity in performance evaluation, all of which contribute to dissatisfaction and premature exits.

Strategic Human Resource Management (SHRM) offers a

transformative approach by aligning HR functions with long-term organizational goals. It emphasizes talent acquisition, retention strategies, and performance management, not as isolated functions but as integral components of business strategy. The goal is not just to manage employees but to invest in them strategically for sustainable organizational growth. Moreover, SHRM creates an ecosystem of mutual respect, accountability, and ownership, which is especially crucial for small businesses trying to maintain consistent service delivery and productivity. It facilitates the development of customized policies that reflect employee expectations while staying within the enterprise's resource limitations. SHRM also helps in forecasting workforce needs, mapping competencies, and aligning employee development with business expansion plans.

The importance of retention in MSMEs is also reflected in operational stability and brand reputation. High turnover not only disrupts continuity but also increases the cost of rehiring and retraining, particularly in skill-based or client-facing roles. Additionally, the absence of strong HR practices leads to lower employee engagement and decreased morale.

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SHRM, when implemented correctly, becomes a mechanism for organizational learning and a driver of long-term innovation. It promotes a culture of performance, adaptability, and internal mobility, ensuring that employees envision a clear trajectory within the organization. Hence, the need for structured and strategic HR initiatives in MSMEs is not just desirable it is imperative for their sustained success in competitive environments. As globalization and digital transformation reshape workforce expectations, MSMEs must view SHRM as a cornerstone for attracting and retaining top talent in an evolving business landscape.

2. Data Analysis (Theoretical Overview)

The theoretical analysis of strategic HRM and its influence on employee retention begins with the Resource-Based View (RBV) of the firm, which identifies human capital as a key differentiator in achieving competitive advantage. In the MSME context, employees are not just labor inputs but carriers of tacit knowledge and innovation potential. Firms that implement structured retention strategies such as performance-linked incentives, clear career pathways, and inclusive decision-making tend to preserve their human capital more effectively. Moreover, the RBV underlines that sustainable competitive advantage is achieved when firms possess resources that are valuable, rare, inimitable, and non-substitutable (VRIN), and high-performing employees meet all four criteria.

Herzberg's Two-Factor Theory also provides valuable insights into MSME dynamics. Hygiene factors such as salary, job security, and working conditions are often neglected due to budgetary constraints, while motivators like recognition, responsibility, and growth opportunities remain underutilized. This leads to disengagement and increased turnover. SHRM practices, when integrated into MSMEs, help convert hygiene factors into strengths while reinforcing motivational elements through tailored interventions. For instance, even small-scale recognition programs, mentorships, or public appreciation at meetings can significantly boost morale and loyalty, particularly where financial raises may be infeasible.

Social Exchange Theory (SET) supports the idea that employees are more likely to stay when there is a perceived balance between their contributions and the rewards they receive. SHRM enables MSMEs to institutionalize this reciprocity through structured feedback mechanisms, fair appraisal systems, and transparent communication. Moreover, psychological contract theory suggests that unmet expectations significantly contribute to attrition. Strategic HRM plays a vital role in managing expectations by offering consistent performance reviews, professional development plans, and participatory management. These initiatives cultivate trust, which serves as the bedrock of enduring employment relationships.

Additionally, the Theory of Planned Behavior implies that intentions to stay within an organization are influenced by

subjective norms and perceived behavioral control, which are strengthened by positive HR practices. When HR policies promote skill development and allow employees to take ownership of their work, their psychological commitment deepens. Empirical studies from India's SME sector demonstrate that retention is closely linked to the sense of empowerment and autonomy employees experience. Furthermore, research from the International Labour Organization (2022) indicates that autonomy in work design correlates with 40% higher employee retention in SMEs.

Finally, data from global surveys (e.g., SHRM Global Report 2023) affirm that MSMEs that prioritize HR digitization and strategy report 28% higher retention than their peers. This includes the adoption of tools such as performance dashboards, e-learning platforms, and self-service HR portals. The integration of analytics into HR functions also enables better prediction of attrition trends, allowing timely managerial intervention. These findings reinforce that SHRM is not a luxury but a necessity in the evolving employment ecosystem of small enterprises, especially in an era marked by digital disruption and rapidly shifting workforce expectations.

3. Methodology

The research adopts a qualitative and exploratory approach, suitable for understanding the strategic nuances of HRM practices in small-scale enterprises. Primary data were collected through structured interviews and questionnaires administered to 50 MSMEs across sectors including textiles, manufacturing, IT services, and food processing in India. Each enterprise employed between 20 to 150 workers, making them ideal representatives of the MSME sector. The interviews were conducted both in-person and virtually, depending on the availability and preferences of participants, ensuring flexibility and higher response rates. Respondents included founders, HR managers, team leads, and employees, providing a multi-stakeholder perspective.

The secondary data sources include policy reports from the Ministry of MSME, World Bank working papers on small businesses, SHRM India insights, and relevant academic journals. The data were thematically analysed using NVivo software to identify recurring themes related to retention practices. Care was taken to ensure diverse geographical representation across North, South, and Western India. The literature review phase further enriched the contextual understanding of employee retention and allowed for benchmarking with global best practices.

The inclusion criteria for enterprises focused on operational longevity (minimum five years), employment of formal HR personnel or consultants, and demonstrated concern over attrition rates. The study aimed to assess whether strategic HRM frameworks were adopted, the extent of their implementation, and their perceived impact on employee retention. Additionally, the study evaluated whether MSMEs integrated digital HR solutions such as payroll software, feedback platforms, and e-learning tools. These

technological enablers were assessed for their usability, cost-effectiveness, and acceptance among both management and employees.

This mixed-methods strategy ensures triangulation and enhances the validity of findings by juxtaposing organizational narratives with statistical patterns from employee responses. The cross-sectoral sample also aids in uncovering both industry-specific and universal HR retention trends. In-depth interviews with HR managers, supported by observation of internal policy documents and training calendars, helped enrich the interpretive layer of the research findings. Pilot testing of the questionnaire was conducted prior to final rollout to ensure clarity, relevance, and contextual appropriateness of all items included.

4. Questionnaire

To support the empirical foundation, a structured questionnaire was designed to assess the implementation of SHRM practices and their influence on employee retention. The questions were administered to both HR heads and employees in participating MSMEs. The design focused on capturing both perceptions and measurable practices related to employee development, feedback, and managerial responsiveness.

Table 1: HR Manager Responses (N=50)

Practice Area	Strongly Implemented (%)	Moderately Implemented (%)	Not Implemented (%)
Performance-Based Appraisal	44	36	20
Training & Development	38	42	20
Flexible Work Policies	30	26	44
Employee Feedback System	40	40	20
Career Progression Plans	28	40	32

Table 2: Employee Feedback Summary (N=200)

Indicator	Agree (%)	Neutral (%)	Disagree (%)
I see long-term growth here	35	40	25
I feel recognized for my work	48	30	22
HR responds to my concerns	42	38	20
I am satisfied with my training	41	35	24
My pay reflects my contribution	32	28	40

Sample Questions

1. What HR initiatives has your organization introduced to reduce attrition in the last two years?
2. Do you believe that your performance is evaluated fairly and transparently?
3. How satisfied are you with the career advancement opportunities offered?
4. What is your perception of the management's engagement with employee well-being?
5. Would you recommend your workplace to a colleague based on HR support?

The questionnaire also included open-ended responses for employees to share qualitative views about training programs, exit interviews, or informal feedback mechanisms. This approach enabled a nuanced understanding of the relational dynamics within MSMEs that go beyond numbers.

5. Case Study

One notable case is that of BrightTech Solutions, an MSME based in Pune specializing in SaaS products. With a workforce of 85 employees, the firm faced a staggering 48% turnover rate in 2021, threatening its operational continuity and client service reliability. The attrition, mostly among junior developers and marketing associates, was attributed to a lack of growth opportunities, inconsistent appraisal systems, and minimal HR engagement. Post consultation with an HR strategist, the company implemented a range of SHRM practices including a quarterly performance review system, leadership training workshops, and a structured mentorship program. These efforts were aligned with the broader organizational vision of becoming a talent-centric innovation hub where every employee feels both valued and accountable.

Within one year, attrition reduced to 22%, and internal promotion rates rose by 35%. Employee satisfaction scores, as captured by internal pulse surveys, improved by 43%. The firm also adopted cloud-based HR analytics to track absenteeism, overtime trends, engagement metrics, and productivity fluctuations, allowing for proactive interventions. These tools helped the HR team detect early signs of disengagement and respond with personalized communication, coaching, or rotation in responsibilities. Additionally, job descriptions were standardized and career ladders were published, enabling greater transparency around advancement.

The CEO acknowledged that treating HR not just as an administrative function but as a strategic pillar yielded tangible organizational resilience and talent stability. He personally engaged in one-on-one conversations with team leads and participated in “town hall” style meetings to gather anonymous feedback. The shift in leadership behavior had a cascading effect, empowering middle management to act as people leaders and not just task supervisors. This culture of open dialogue reduced friction and built mutual trust.

The company also introduced employee wellness programs, including stress management webinars, on-demand counselling services, and flexible work arrangements. These initiatives were especially welcomed by younger professionals, who cited improved work-life balance, mental health support, and accessible leadership as reasons for staying. Employee turnover among female professionals, which was earlier 55%, dropped significantly due to enhanced maternity policies and hybrid work options. This further established the link between inclusive SHRM practices and retention outcomes.

The case further illustrates that even with modest financial resources, MSMEs can make measurable strides in retention by prioritizing strategic HR decisions over reactive responses. BrightTech also leveraged peer recognition platforms, allowing employees to appreciate one another for collaboration and achievements, creating an ecosystem of shared ownership and positivity. The HR team regularly reviewed exit interview data and refined on-boarding experiences based on feedback, thereby closing the feedback-action loop.

BrightTech's journey also shows the importance of leadership buy-in. Without the CEO's active involvement, the HR changes would have remained superficial and disconnected from day-to-day realities. By participating in feedback sessions and sharing personal experiences of vulnerability and growth, top leadership helped normalize transparency and fostered a culture of inclusion. Their case reinforces the idea that strategic HRM is most successful when embedded across organizational layers, not confined to HR departments alone. It also proves that when MSMEs treat human capital as a long-term investment rather than a cost centre, the returns are transformative manifested in improved productivity, morale, and brand equity.

6. Conclusion

Strategic Human Resource Management is no longer a luxury but a necessity for MSMEs seeking to retain talent and remain competitive in a volatile employment landscape. The evidence suggests that companies that approach HR with a long-term strategic mind-set prioritizing employee development, fair appraisals, and transparent policies benefit from reduced turnover and increased productivity. In contrast, those clinging to traditional or reactive HR practices risk losing valuable human capital and incurring replacement costs. As the business environment becomes increasingly knowledge-driven, the capacity to retain experienced personnel becomes a critical determinant of operational stability and innovation potential.

The study clearly shows that SHRM enables organizations to institutionalize value-based relationships with employees, where performance, commitment, and trust are mutually reinforced. MSMEs that invest in leadership development, digital HR tools, and inclusive decision-making emerge stronger in both employee engagement and operational continuity. These businesses also report better customer

satisfaction, since stable and motivated teams directly influence service quality and innovation. Furthermore, the alignment of HRM with strategic goals supports adaptability during economic disruptions, allowing enterprises to respond to change without compromising workforce integrity.

Moreover, the analysis underlines the role of strategic communication, timely feedback, and recognition as non-monetary tools that significantly contribute to employee loyalty. By fostering a culture where individuals feel valued and heard, MSMEs can elevate themselves into employers of choice despite financial limitations. SHRM also builds internal talent pipelines, reducing over-reliance on external recruitment and promoting a sense of upward mobility among existing employees. The study thus recommends integrating retention indicators within key performance metrics at the organizational level.

The shift from reactive HR practices to proactive talent strategies is essential in today's dynamic economic environment. MSMEs that recognize HRM as a dynamic and data-driven discipline are more likely to attract, nurture, and retain top-tier talent in the long run. Hence, MSMEs should no longer view HRM as merely administrative, but rather as a strategic instrument that ensures organizational sustainability. With rising competition for skilled talent and changing workforce aspirations, employee retention must be embedded in the very DNA of business strategy. This research highlights how MSMEs can adopt simple yet impactful HRM frameworks that build resilient, future-ready teams, positioning themselves for sustained growth in a competitive global economy.

7. Limitations and Future Research Directions

The study is limited by its reliance on self-reported data, which may carry inherent biases related to social desirability or selective recall. While participant perspectives offer rich qualitative insights, they may not always align with objective metrics, particularly in the absence of verifiable documentation. Additionally, the research primarily focuses on Indian MSMEs, which, though valuable for localized understanding, limits the generalizability of findings to broader international contexts where cultural, regulatory, and economic variables differ significantly. The relatively small sample size of 50 MSMEs may not fully capture the heterogeneity of the sector in terms of industry verticals, ownership models, or regional socio-economic differences.

Another important limitation is the absence of longitudinal data. Although the study captures present perceptions and practices effectively, it does not track retention patterns over time, which could have provided a more dynamic understanding of the actual impact of Strategic HRM initiatives. Moreover, during data collection, some MSMEs were hesitant to disclose internal HR documents or personnel data due to privacy concerns, which restricted the granularity of analysis, particularly in evaluating the authenticity of policy implementation. This lack of transparency in some

cases made it difficult to differentiate between formalized HR systems and informal, undocumented practices driven by intuition or managerial discretion.

Furthermore, the study does not distinguish between family-owned businesses and professionally managed MSMEs, which can have significantly different organizational cultures, governance styles, and employee engagement mechanisms. This absence of segmentation restricts the ability to analyse how ownership structures influence the adoption and outcomes of SHRM. The research also did not incorporate generational segmentation of employees, a potentially crucial dimension given the rising dominance of millennial and Gen Z workers in the modern workforce. Their distinct expectations regarding purpose-driven work, flexibility, and continuous feedback might necessitate different retention strategies than those effective for older cohorts.

Future research could examine the role of artificial intelligence, machine learning, and cloud-based platforms in automating and enhancing HR functions in MSMEs. Such studies should assess the feasibility, affordability, and effectiveness of digital HR solutions tailored for small enterprises. Cross-country comparisons between developing and developed economies may reveal contextual enablers or constraints in SHRM implementation, adding to the global knowledge base. Another area of interest is the effect of

leadership style transactional vs. transformational on the success of strategic HR initiatives in small firms. A gendered analysis of employee retention could also shed light on whether current HR practices are inclusive and equitable across different demographic groups.

Additionally, research into the impact of remote work, hybrid models, and gig-based staffing on MSME retention strategies would be timely in the post-pandemic context. These emerging work formats are reshaping employee expectations and operational models, requiring MSMEs to rethink traditional notions of engagement and loyalty. Expanding this study through longitudinal case studies or action-research models would enrich understanding of what works sustainably over time. Researchers may also consider collaborating with HR technology providers to co-design tools that are MSME-specific and grounded in empirical findings. Finally, policymakers and industry associations should be encouraged to create strategic HR toolkits, training modules, and policy frameworks aimed specifically at capacity building in MSMEs. These initiatives could include government-led incentives for HR digitization, certification programs for HR professionals working in small firms, and knowledge-sharing platforms that disseminate best practices. Building HR capabilities in MSMEs is not merely a managerial challenge it is a developmental imperative with implications for national employment and productivity.

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Optimization of Thermal Conductivity of Handloom Woven Silk–Cotton Union Fabrics using Response Surface Methodology

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Abstract:

Thermal conductivity is a key determinant of thermos-physiological comfort in apparel textiles, governing the rate of heat transfer between the human body and the external environment. Although pure silk (silk-by-silk) fabrics are widely appreciated for their lusture, drape, and smooth handle, previous studies report relatively higher thermal conductivity due to the compact filament structure and reduced air entrapment, which may limit insulation performance under variable climatic conditions. Earlier investigations have concentrated on mechanized woven systems or single-fiber constructions, with limited systematic optimization of handloom-woven silk–cotton union fabrics using statistical design approaches. Addressing this research gap, the present study employed Response Surface Methodology based on a Box–Behnken Design to optimize thermal conductivity by varying weft yarn count (20–40 Ne), twist per inch (10–20 TPI), and picks per inch (55–65 PPI), while maintaining constant silk warp parameters. Thermal conductivity ranged from 0.0014 to 0.0020 W/m·K, with pick density showing the most significant influence; the minimum value (≈ 0.0014 W/m·K) was achieved at moderate yarn fineness, controlled twist, and higher pick density. Compared with silk-by-silk fabrics, the optimized union fabrics exhibited lower thermal conductivity due to enhanced air entrapment from cotton weft yarns. The study demonstrates the potential of statistically engineered handloom fabrics for sustainable, climate-responsive apparel, with future prospects in smart textile integration and performance-oriented garment design.

Keywords : Box–Behnken Design, Handloom fabrics, Response Surface Methodology, Silk–Cotton union fabrics, Thermal conductivity, Weft yarn count

Citation: Mahesh Pratap Dubey, Anupam Kumar, Ashutosh Pandey, “Optimization of Thermal Conductivity of Handloom Woven Silk–Cotton Union Fabrics using Response Surface Methodology”, *Journal of the Textile Association*, **86/6** (March–April,2026), 598–604, <https://doi.org/10.5281/zenodo.20554776>

Article History : Received : 08-04-2026, Revised: 29-04-2026, Accepted:30-04-2026

1. Introduction

Thermal comfort is a critical performance requirement in apparel textiles, as it directly influences heat regulation, wearer satisfaction, and physiological balance. Among thermo-physical properties, thermal conductivity (W/m·K) is a key parameter that governs the rate of heat transfer through textile materials. It determines whether a fabric allows rapid heat dissipation, creating a cooling sensation in warm climates, or restricts heat flow, providing insulation under cooler conditions [1, 2]. Because textiles are porous assemblies of fibers and entrapped air, their effective thermal conductivity depends not only on the intrinsic conductivity of fibers but also on structural parameters such as yarn count, yarn twist, fabric density, thickness, and porosity. Since still air has a very low thermal conductivity (~ 0.024 W/m·K), the amount and distribution of air within the fabric structure significantly influence overall heat transfer behavior [3].

Previous research has demonstrated that fabric geometry plays a decisive role in thermal performance [2] reported that increased fabric thickness enhances thermal resistance due to greater air entrapment, thereby lowering effective heat conduction. Similarly, [4] investigated knitted cotton fabrics

and observed thermal conductivity values in the range of 0.072–0.082 W/m·K, confirming that structural compactness and fabric density significantly influence conductive heat transfer [5] further demonstrated that structural modifications that increase air pockets within fabric assemblies improve insulation by reducing effective thermal conductivity. These findings collectively highlight that thermal conductivity is not merely fiber-dependent but strongly governed by structural engineering and yarn configuration [6].

Natural fibers such as silk and cotton exhibit distinct thermal behaviors due to differences in their morphology and molecular structure. Cotton, a cellulosic staple fiber, possesses moderate intrinsic thermal conductivity and a bulky yarn structure that promotes air entrapment within woven assemblies [7]. In contrast, silk is a continuous filament protein fiber characterized by a smooth surface, compact structure, and high tensile strength (up to 500 MPa) [8, 9]. Pure silk (silk-by-silk) fabrics typically exhibit more compact filament alignment, which can influence heat transfer pathways differently compared to staple fiber-based fabrics. Silk–cotton union fabrics combine the complementary characteristics of these two natural fibers within a single woven structure. In such constructions, silk warp yarns provide dimensional stability, strength, and

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aesthetic luster, while cotton weft yarns introduce bulkiness and structural openness. The interaction between silk's relatively compact filament arrangement and cotton's air-trapping staple yarn structure may significantly affect the overall thermal conductivity of the fabric. However, despite the functional importance of such hybrid textiles, limited research has focused on systematically optimizing the thermal conductivity of handloom-woven silk-cotton union fabrics [10-13].

Handloom weaving represents a sustainable and culturally significant segment of the textile industry, particularly in developing economies. Compared to mechanized weaving, handloom production consumes less energy and allows precise control over yarn insertion, tension, and pick density [14, 15]. These controllable parameters such as weft yarn count, twist per inch (TPI), and picks per inch (PPI), which directly influence fabric compactness, porosity, and thickness, and therefore play a vital role in determining thermal conductivity. However, the absence of systematic scientific optimization has limited the performance enhancement and standardization of handloom union fabrics [10-13]. To address this research gap, advanced statistical tools such as Response Surface Methodology (RSM) have been effectively applied in textile engineering for modeling and optimizing multi-variable systems [16-19]. The Box-Behnken Design (BBD), a class of RSM, enables efficient evaluation of three independent variables and their interaction effects with a reduced number of experimental runs [20, 18]. This approach facilitates the development of predictive mathematical models and identification of optimal structural configurations for desired thermal performance.

Therefore, the present study aims to optimize the thermal conductivity of handloom-woven silk-cotton union fabrics using Response Surface Methodology. By systematically varying cotton weft yarn count, twist per inch, and picks per

inch while maintaining constant silk warp parameters, this research seeks to develop a statistically validated predictive model and determine the optimal structural combination that minimizes thermal conductivity. The novelty of this work lies in integrating traditional handloom craftsmanship with modern statistical optimization techniques to engineer thermally efficient, sustainable hybrid fabrics suitable for diverse climatic applications.

2. Materials and Methods

2.1 Materials Used

In the present study, yarn materials and structural parameters were systematically selected to investigate the effect of fabric construction on the thermal conductivity of handloom-woven silk-cotton Union fabrics using Response Surface Methodology based on the Box-Behnken Design. Three independent variables were considered for optimization: cotton weft yarn linear density (A), twist per inch of the weft yarn (B), and picks per inch (C). These parameters were selected because they directly govern yarn packing density, fabric compactness, thickness, porosity, and the volume of entrapped air within the fabric structure, which collectively control conductive heat transfer in woven textiles [10-13].

Fabric samples were prepared on a traditional handloom under controlled conditions to ensure uniformity. A constant warp of 253 Ne silk was maintained at 96 ends per inch for all samples. The weft consisted of 100% cotton yarns with linear densities of 20, 30, and 40 Ne, further the fabric construction parameters and twist per inch were varied systematically by adjusting picks per inch 55, 60, & 65 and TPI 10, 15 & 20 respectively, as presented in Table 1. All samples were woven in plain weave structure to maintain consistency, enabling a systematic assessment of the influence of weft variables on the resulting fabric properties.

Table 1 - Structural Parameters and Estimated Physical Properties of Handloom Woven Silk-Cotton Union Fabrics

Sample Id	Weft Yarn Linear Density (Ne)	Ends per Inch (EPI)	Picks per Inch (PPI)	Twist per Inch (TPI)	Fabric Mass (GSM) (g/m ²)	Thickness (mm)	Air Permeability (cm ³ /cm ² /s)
S1	20	96	55	15	121	0.36	162.32
S2	40	96	55	15	95	0.28	176.38
S3	20	96	65	15	132	0.39	120.83
S4	40	96	65	15	104	0.31	152.86
S5	20	96	60	10	123	0.35	138.81
S6	40	96	60	10	99	0.29	159.84
S7	20	96	60	20	125	0.37	143.26
S8	40	96	60	20	101	0.30	165.39
S9	30	96	55	10	105	0.31	164.89
S10	30	96	65	10	114	0.33	133.66
S11	30	96	55	20	107	0.32	168.64
S12	30	96	65	20	116	0.34	130.91
S13	30	96	60	15	112	0.33	158.98
S14	30	96	60	15	112	0.33	157.72
S15	30	96	60	15	112	0.33	151.85

2.2 Fabric Construction Process

All fabric samples were produced on a traditional handloom to maintain low yarn tension and precise control of structural parameters. Handloom weaving is also considered an energy-efficient and environmentally sustainable method compared to mechanized systems. A plain weave structure was used for all samples to ensure uniform yarn interlacement and minimize the influence of weave geometry, enabling evaluation of yarn count, twist per inch, and pick density on thermal conductivity. Warp preparation was carried out using a peg warping system. Fabrics were woven following a three-factor, three-level Box–Behnken design, producing 15 samples (S1–S15). After scouring and air drying, samples were conditioned at 20 ± 2 °C and 65 ± 2 % RH for 24 h before testing.

2.3 Experimental Design Using Box–Behnken Design

To systematically investigate the influence of yarn and fabric structural parameters on the thermal conductivity of silk–cotton Union fabrics, a three-factor, three-level Box–Behnken Design was employed within the Response Surface Methodology framework. The Box–Behnken Design was selected because it efficiently estimates second-order polynomial models and interaction effects using a reduced number of experimental runs, thereby minimizing material consumption and experimental effort while maintaining adequate statistical reliability, as widely reported in optimization studies on textile materials [17, 18 & 20]. In comparison to Central Composite Design, which requires a larger number of experiments and axial points, the Box–Behnken Design provides comparable predictive capability with fewer experimental combinations, making it particularly suitable for optimization studies involving handloom-woven fabrics where large-scale experimentation is constrained [21, 22].

In the present study, three independent variables were selected based on their direct influence on fabric compactness, thickness, and internal air entrapment, which govern conductive heat transfer in woven textiles. These variables were weft yarn count (Ne, factor A), twist per inch of the weft yarn (TPI, factor B), and picks per inch (PPI, factor C). Each variable was studied at three coded levels (-1, 0, and +1), corresponding to low, medium, and high values, respectively, as summarized in Table 2. The experimental design generated fifteen fabric combinations (S1–S15), forming a balanced and nearly rotatable design suitable for modeling and optimization of thermal conductivity. Experimental data were analyzed using quadratic polynomial regression, and Design-Expert software. The general regression model is expressed as:

$$Y = B_0 + \sum B_i X_i + \sum B_{ii} X_i^2 + \sum \sum B_{ij} X_i X_j \quad (1)$$

Where Y represents thermal conductivity (W/m·K), B_0 is the intercept, B_i denotes linear coefficients, B_{ii} represents quadratic coefficients, and B_{ij} indicates interaction effects of the coded variables A, B, and C.

Table 2 - Coded and actual levels of independent variables

Factor	Symbol	Level -1	Level 0	Level +1
Weft Yarn Count (Ne)	A	20	30	40
Twist per Inch (TPI)	B	10	15	20
Picks per Inch (PPI)	C	55	60	65

The actual and predicted values of thermal conductivity obtained from the 15 experimental runs are presented in Table 3. The close agreement between experimental and predicted values confirms the suitability of the quadratic model for capturing the influence of yarn fineness, twist, and pick density on the thermal behavior of the fabric. Thermal conductivity values ranged from 0.0014 to 0.002 W/m·K across different sample combinations, demonstrating the sensitivity of heat transfer characteristics to structural variations in the fabric.

Table 3 - Experimental and predicted responses of silk–cotton union fabrics

Sample Id	Independent variables			Thermal conductivity Watt/ m. K	
	Ne (A)	PPI (B)	TPI (C)	Actual Value	Predicted Value
S1	20	65	15	0.0015	0.0015
S2	30	65	20	0.0016	0.0016
S3	20	55	15	0.0018	0.0018
S4	30	60	15	0.0014	0.0015
S5	40	65	15	0.0016	0.0016
S6	30	65	10	0.0014	0.0015
S7	40	60	20	0.0018	0.0018
S8	30	55	20	0.0019	0.0019
S9	40	60	10	0.0016	0.0016
S10	20	60	10	0.0016	0.0015
S11	40	55	15	0.002	0.002
S12	20	60	20	0.0015	0.0016
S13	30	55	10	0.0018	0.0018
S14	30	60	15	0.0015	0.0015
S15	30	60	15	0.0016	0.0015

3. Measurement of Fabric Properties

3.1 Thermal Conductivity

Thermal conductivity of the handloom-woven silk–cotton union fabric samples was measured using the Lee's Disc Method in accordance with ASTM D1518. Prior to testing, the instrument was calibrated to ensure accurate steady-state heat transfer measurements. Fabric specimens of 10 cm × 10 cm were conditioned under standard atmospheric conditions and placed between the heated and lower disc assemblies.

After attaining thermal equilibrium, the temperature difference was recorded and thermal conductivity (W/m·K) was calculated using Fourier's law of heat conduction. Thermal conductivity indicates the ability of a fabric to transfer heat. Lower values correspond to better insulation performance, while moderate values promote controlled heat dissipation, contributing to balanced thermal comfort [1].

4. Results and Discussion

4.1 Analysis of Variance

Thermal conductivity (TC) of the developed silk–cotton union fabrics was analyzed using Response Surface Methodology (RSM) based on a Box–Behnken Design comprising seventeen experimental runs. The effects of weft yarn count (A), picks per inch (B), and twist per inch (C) were evaluated using ANOVA (Table 4) to develop a quadratic regression model. The statistical model was found to be significant (F = 11.20, p = 0.008), with a coefficient of determination (R²) of 0.9527 and adjusted R² of 0.8676, indicating that over 95% of the variation in thermal conductivity is explained by the selected parameters. The lack-of-fit was not significant, confirming the adequacy of the model.

Among the linear factors, picks per inch (B) showed the most significant negative influence (−0.0002), indicating that fabric density strongly governs thermal behavior. The quadratic term B² was also statistically significant (F = 20.42, p = 0.0063), demonstrating a non-linear relationship between fabric density and heat transfer. The interaction terms (AB, AC, and BC) were statistically insignificant within the studied range.

The developed second-order polynomial equation for thermal conductivity is:

$$TC = 0.0015 + 0.0001A - 0.0002B + 0.0001C - 0.0000AB + 0.0001AC + 0.0000BC + 0.0001A^2 + 0.0002B^2 + 0.0000C^2 \dots \dots \dots (2)$$

Overall, the results indicate that picks per inch is the dominant factor influencing thermal conductivity, with a significant quadratic effect highlighting non-linear heat transfer behavior. The high R² value confirms the robustness of the model for predicting and optimizing thermal conductivity in handloom silk–cotton union fabrics as shown in Fig.2.

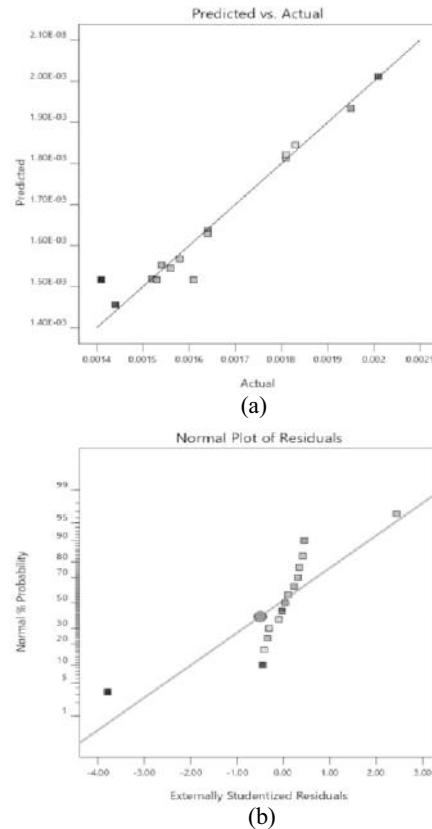


Figure 1 - Plot of predicted versus actual values (a) and Normal Probability Plot versus Externally Studentized residuals (b) of Thermal Conductivity (TC, in W/m·K)

Table 4 - ANOVA for Thermal Conductivity (TC, in W/m·K)

Source	Sum of Squares	df	Mean Square	F-value	p-value	
Model	4.401E-07	9	4.890E-08	11.20	0.0080	significant
A-Weft Count	4.961E-08	1	4.961E-08	11.36	0.0199	
B-Picks Per Inch	2.245E-07	1	2.245E-07	51.38	0.0008	
C-Twist Per Inch	4.061E-08	1	4.061E-08	9.30	0.0285	
AB	1.600E-09	1	1.600E-09	0.3663	0.5715	
AC	1.823E-08	1	1.823E-08	4.17	0.0966	
BC	9.000E-10	1	9.000E-10	0.2060	0.6689	
A ²	1.963E-08	1	1.963E-08	4.49	0.0875	
B ²	8.919E-08	1	8.919E-08	20.42	0.0063	
C ²	5.308E-09	1	5.308E-09	1.22	0.3205	
Residual	2.184E-08	5	4.368E-09			
Lack of Fit	1.575E-09	3	5.250E-10	0.0518	0.9806	not significant
Pure Error	2.027E-08	2	1.013E-08			
Cor Total	4.620E-07	14				
Std. Dev.	0.0001	R²			0.9527	
Mean	0.0017	Adjusted R²			0.8676	
C.V. %	3.98	Predicted R²			0.8467	

4.2 Impact of Weft Count (A), Picks per Inch (B), and Twist per Inch (C) on Thermal Conductivity (TC)

The combined influence of weft count (Ne), picks per inch (PPI), and twist per inch (TPI) on thermal conductivity (TC, W/m·K) is illustrated in Fig. 2. The response surface and contour plots demonstrate the interaction between two variables at a time while keeping the third parameter constant, thereby clarifying the structural factors governing conductive heat transfer in the woven silk–cotton union fabrics.

As shown in Fig. 2a and 2b, the interaction between PPI and weft count reveals a gradual increase in TC from approximately 0.00145 W/m·K at lower Ne (~20) and PPI (~55) to nearly 0.0020 W/m·K at higher Ne (~40) and PPI (~65). Coarser yarns combined with lower pick density create a more porous structure with higher air entrapment, resulting in lower effective thermal conductivity. In contrast, finer yarns and increased pick density reduce porosity and enhance fiber contact, thereby facilitating conductive heat transfer.

The interaction between TPI and weft count is presented in Fig. 2c and 2d. A non-linear relationship is observed, with minimum TC (~0.0015 W/m·K) occurring at intermediate weft counts (~30–35 Ne) and moderate twist levels (~14–16 TPI). At lower twist levels, yarns may exhibit higher internal porosity, while excessive twist increases compactness and restricts effective inter-yarn heat pathways. Moderate twist therefore appears to optimize fiber packing and alignment, resulting in balanced heat transfer. The influence of yarn twist on thermal behavior through structural compactness has been widely documented.

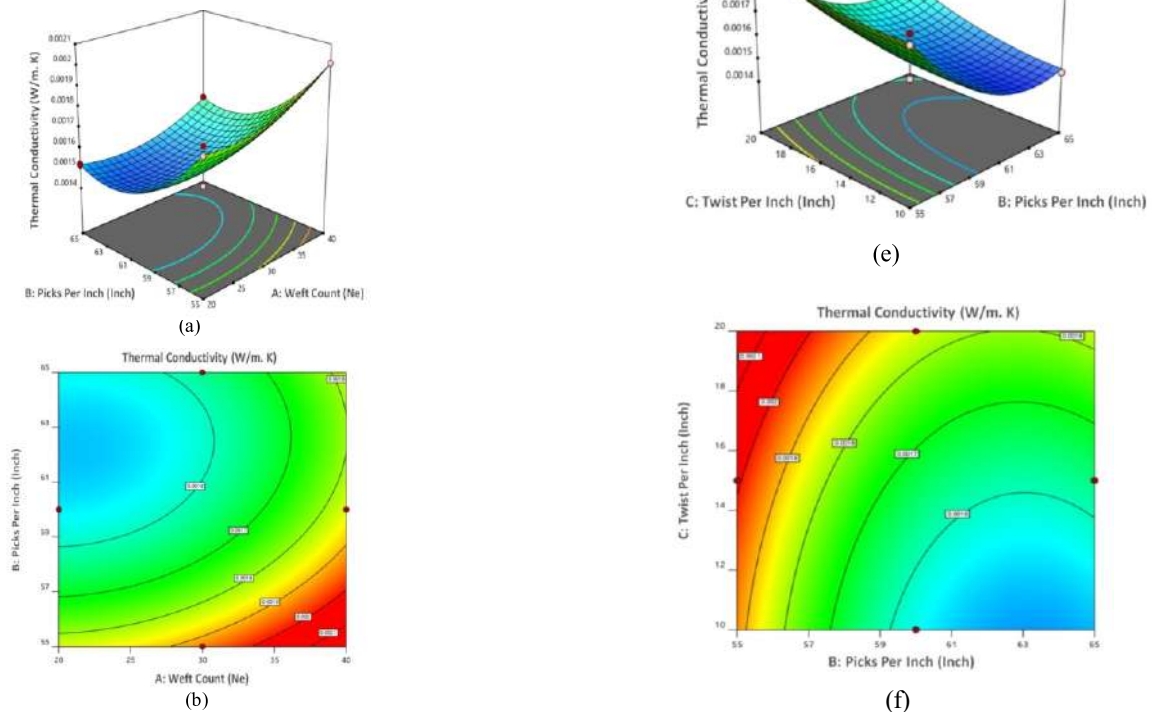


Figure 2 - Interaction between PPI and weft count: (a) surface plot and (b) contour plot; the interaction between TPI and weft count: (c) surface plot and (d) contour plot; and the interaction between TPI and PPI: (e) surface plot and (f) contour plot

The interaction between TPI and PPI is shown in Fig. 2e and 2f. Thermal conductivity decreases with increasing PPI at lower twist levels, reaching minimum values (~0.0014 W/m·K) in relatively dense fabrics formed with low-to-moderate twist yarns. However, at higher TPI (~20), TC remains comparatively elevated despite increased pick density, suggesting that excessive yarn compactness limits effective inter-yarn thermal pathways. The contour plot confirms that maximum TC occurs at low PPI combined with high TPI, while minimum TC is achieved at higher PPI and moderate TPI. This highlights the dominant role of structural density and inter-yarn connectivity in governing heat conduction. Overall, the results presented in Fig. 2a to 2f demonstrate that thermal conductivity is controlled by the coupled and non-linear interactions of yarn fineness, fabric density, and yarn twist. Higher TC is associated with finer yarns, increased pick density, and higher twist, whereas lower TC is achieved with coarser yarns, moderate density, and controlled twist. These findings provide a scientific basis for optimizing weaving parameters to tailor thermal performance in handloom-woven silk–cotton union fabrics.

5. Conclusion

This study successfully optimized the thermal conductivity of handloom-woven silk–cotton union fabrics using Response Surface Methodology based on a Box–Behnken

Design, developing a statistically significant quadratic regression model ($F = 11.20$, $p = 0.008$) with high predictive accuracy ($R^2 = 0.9527$; adjusted $R^2 = 0.8676$). The results identified picks per inch (PPI) as the most influential parameter, showing a significant negative linear and quadratic effect on thermal conductivity, confirming the non-linear relationship between fabric density and heat transfer. Thermal conductivity ranged from approximately 0.0014 to 0.0020 W/m·K, with lower values achieved at moderate twist (~15 TPI), optimized PPI, and relatively coarser weft yarns, which enhanced air entrapment and reduced conductive pathways. Compared to silk-by-silk fabrics, which typically exhibit compact filament alignment and more continuous heat conduction, the silk–cotton union structure demonstrated improved thermal regulation due to the bulkier cotton weft modifying structural porosity and heat transfer mechanisms. This highlights the advantage of union fabrics in achieving balanced thermal comfort while retaining silk's strength and aesthetic appeal. The developed model provides a reliable predictive tool for engineering thermally efficient handloom fabrics, supporting performance enhancement, product standardization, and sustainable value addition in the traditional textile sector, with future scope for multi-response optimization and advanced eco-friendly finishing applications.

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Common Effluent Treatment Plants in Textile Industry: Technologies, Performance Evaluation and Sustainability Challenges – A Review

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Abstract :

The textile industry is one of the largest consumers of freshwater and simultaneously one of the major contributors to industrial water pollution worldwide. Textile manufacturing processes such as sizing, desizing, scouring, bleaching, mercerizing, dyeing, printing, and finishing generate substantial volumes of wastewater containing complex pollutants. These effluents are characterized by intense colour, high chemical oxygen demand (COD), biological oxygen demand (BOD), total dissolved solids (TDS), suspended solids, heavy metals, surfactants, and recalcitrant organic compounds including reactive and azo dyes. The presence of high salinity and non-biodegradable organics makes treatment particularly challenging using conventional biological systems alone. For small and medium enterprises (SMEs), which constitute a significant portion of textile clusters in developing countries, installation and operation of individual effluent treatment plants (ETPs) are often economically and technically unfeasible. To address this issue, Common Effluent Treatment Plants (CETPs) were developed as centralized treatment facilities serving multiple industrial units. CETPs enable cost-sharing, regulatory compliance, and improved monitoring of wastewater discharge. This review discusses CETP configurations, treatment stages and technologies, performance efficiencies, Zero Liquid Discharge (ZLD) systems, sludge management strategies, and emerging sustainability challenges in textile wastewater management.

Keywords: *Advanced oxidation, CETP, Membrane treatment, Sustainability, Textile wastewater, Zero Liquid Discharge*

Citation: Mahesh B. Chougule, "Common Effluent Treatment Plants in Textile Industry: Technologies, Performance Evaluation and Sustainability Challenges – A Review", *Journal of the Textile Association*, **86/6** (March-April, 2026), 605-613, <https://doi.org/10.5281/zenodo.20554686>

Article History : Received :18-02-2026, Revised: 19-3-2026, Accepted:23-03-2026

1. Introduction

The textile industry significantly contributes to industrial water pollution. Textile effluents are characterized by high color intensity, chemical oxygen demand (COD), biological oxygen demand (BOD), total dissolved solids (TDS), heavy metals and complex dye molecules.

An early comprehensive analysis on dye removal from textile effluents presented a systematic evaluation of physical, chemical, and biological treatment methods for the remediation of synthetic dyes in wastewater. The study emphasized that textile dyes, particularly azo dyes, are highly resistant to biodegradation because of their complex aromatic structures and stable chromophoric groups. These structural characteristics make them persistent in aquatic environments and contribute to serious ecological and toxicological concerns. The review compared the treatment efficiencies of adsorption, coagulation–flocculation, oxidation processes, and biological degradation methods. It was observed that adsorption techniques offer high color removal efficiency but involve challenges related to adsorbent regeneration and disposal. Coagulation–flocculation was found to be effective for

partial color removal, though it generates significant sludge requiring further management. Oxidation processes demonstrated strong decolorization potential but were often associated with higher operational costs. Biological treatments, including conventional activated sludge systems, were identified as environmentally compatible but limited in their ability to completely remove color from textile effluents. The study ultimately highlighted the need for integrated and advanced treatment technologies, which later became essential components of Common Effluent Treatment Plants [1].

A comprehensive review examined the characteristics of textile dye wastewater and recent advancements in treatment technologies. The study compiled quantitative data on important physicochemical parameters such as COD, BOD, total dissolved solids (TDS), salinity, and heavy metals commonly present in textile effluents. It highlighted the complex and variable nature of textile wastewater generated from different processing operations. Modern treatment methods, including membrane filtration, advanced oxidation processes, adsorption techniques, and hybrid systems, were critically evaluated for their efficiency and operational feasibility. Membrane technologies were recognized for their high removal efficiency and suitability for water reclamation, while advanced oxidation processes were noted

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for their ability to degrade recalcitrant dye compounds. The review also emphasized sustainability considerations, particularly water reuse potential and the implementation of zero liquid discharge (ZLD) strategies. These aspects were identified as essential for improving environmental performance and regulatory compliance in textile industries. Overall, the study provides valuable contemporary insight into environmental risks and technological innovations in textile wastewater management. [2].

A comprehensive review analyzed textile wastewater treatment methods by categorizing them into physical, chemical, biological, and integrated treatment systems. The study critically assessed the performance of various processes with respect to COD, BOD, and color removal efficiencies. Physical and chemical methods were evaluated for their rapid treatment capabilities, while biological systems were examined for their cost-effectiveness and environmental compatibility. Emerging technologies such as electrocoagulation, Fenton oxidation, photocatalysis, and membrane-based processes were discussed for their enhanced efficiency in treating recalcitrant dye compounds. The review also addressed key operational challenges, including excessive sludge generation, formation of toxic

intermediates during oxidation, and the adverse impact of high salinity on biological treatment processes. Limitations associated with individual treatment methods highlighted the need for combined or hybrid approaches. The study emphasized the importance of integrating multiple technologies to achieve effective and sustainable treatment. Overall, it provides a strong technical foundation for designing and optimizing treatment systems in Common Effluent Treatment Plants [3]. The main pollutants discharged from each step of textile wet processing are shown in Figure 1.

A detailed study examined the environmental hazards associated with textile dyeing industries, focusing on the ecological and health risks posed by untreated effluents. It highlighted the toxicological impacts of textile wastewater on aquatic ecosystems, particularly due to the presence of heavy metals, carcinogenic dye intermediates, and persistent organic pollutants. The analysis explained how these contaminants reduce dissolved oxygen levels, hinder photosynthetic activity, and disrupt aquatic food chains. Special attention was given to the long-term bioaccumulation and mutagenic effects of certain dye compounds and metal ions. The study also discussed the

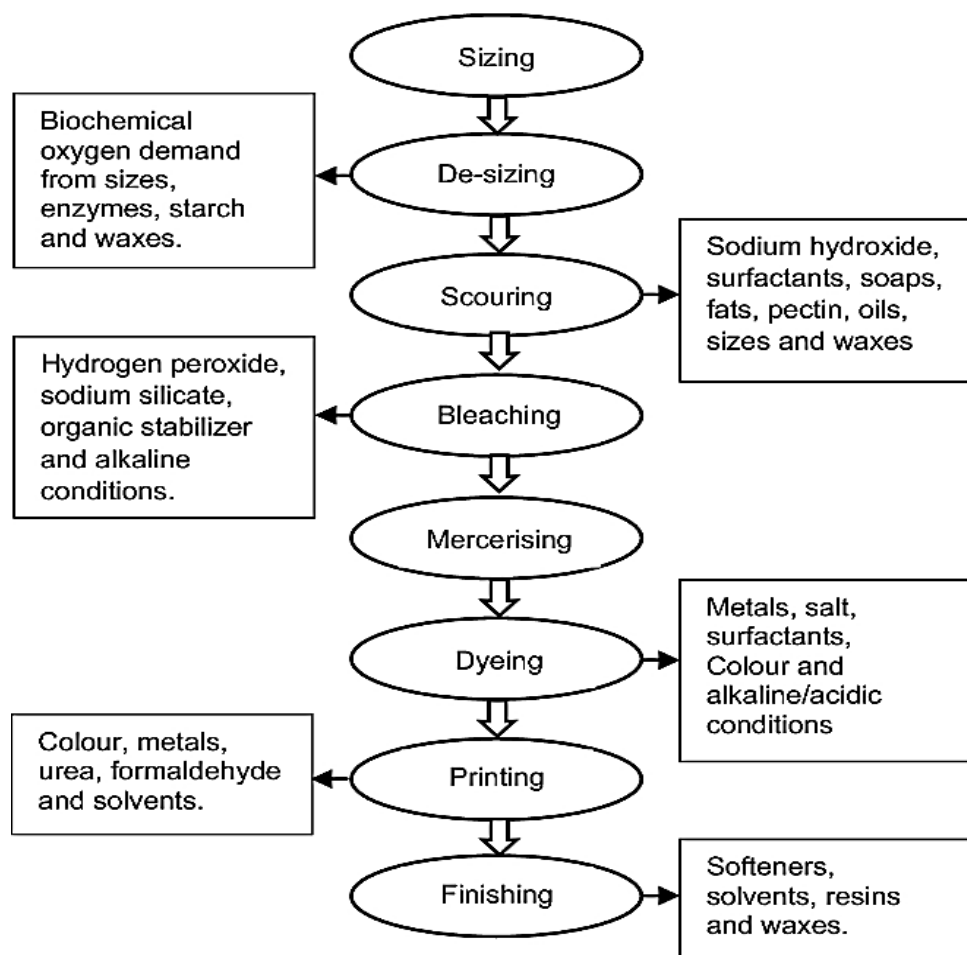


Figure 1 - The main pollutants discharged from each step of textile wet processing [3]

regulatory requirements governing textile effluent discharge and the compliance challenges commonly faced by industries, especially in developing countries. Issues such as inadequate infrastructure, high treatment costs, and weak enforcement mechanisms were identified as major constraints. The findings emphasized the necessity of centralized treatment facilities to collectively manage pollution loads. Overall, the work underscored the critical role of Common Effluent Treatment Plants (CETPs) in achieving effective pollution control and promoting sustainable industrial growth. [4]. To address wastewater from clustered textile industries, Common Effluent Treatment Plants (CETPs) were introduced as centralized systems.

A detailed performance assessment of a Common Effluent Treatment Plant (CETP) in Maharashtra revealed significant underperformance primarily due to hydraulic and organic overloading. The study reported that inlet concentrations of BOD and COD exceeded the plant's design capacities by as much as 96%, severely stressing the treatment units. Reliability analysis indicated that high variability in effluent quality substantially reduced overall plant reliability, necessitating much lower mean effluent concentrations to consistently achieve 95% compliance with regulatory discharge standards. Technical evaluation showed that excessive loading adversely affected the efficiency of primary clari-flocculators and secondary clarifiers, while high organic loads in aeration tanks created anoxic conditions leading to sludge bulking. The investigation further observed that oil and grease removal showed a relatively strong correlation with preliminary treatment performance, whereas parameters such as BOD and TSS exhibited significant fluctuations and lower reliability across treatment stages. These findings highlighted operational instability within biological treatment units under overload conditions. To address these issues, the study recommended strict adherence to prescribed inlet standards by member industries and optimization of dissolved oxygen levels and settling efficiency in secondary treatment systems. Additionally, it established that the coefficient of

determination derived from the relationship between removal efficiency and reliability can serve as an important indicator for evaluating the operational health of individual treatment units [5]. Fig. 1 shows the layout of the treatment processes involved in a typical CETP.

A technical evaluation of Common Effluent Treatment Plants (CETPs) operating in textile industrial clusters assessed their performance with respect to pollutant removal efficiency and regulatory compliance. The study analyzed key parameters such as COD, BOD, total suspended solids (TSS), color, and heavy metals by comparing influent and effluent characteristics to determine overall treatment effectiveness. The findings indicated that CETPs are generally effective in significantly reducing organic load and suspended solids. However, persistent challenges such as high total dissolved solids (TDS), incomplete color removal, and safe sludge disposal were identified as major operational concerns. The assessment also highlighted bottlenecks including shock loading from member industries, inadequate pre-treatment at individual units, and the absence of advanced tertiary treatment systems. Variability in influent quality was found to adversely affect biological treatment performance and compliance consistency. The study emphasized the importance of integrating advanced treatment technologies and strengthening operational control measures. Overall, it provides practical insight into the real-world functioning of textile CETPs and underscores the need for technological upgradation and improved management practices [6].

2. Characteristics of Textile Wastewater

Textile wastewater composition depends on raw materials and processing methods. Major pollutants include reactive dyes, azo dyes, salts, surfactants and heavy metals. The high salinity and recalcitrant organics make biological treatment challenging.

A critical review examined various textile wastewater treatment methods with particular focus on the complex composition of textile effluents. The study explained that different processing operations such as dyeing, bleaching, washing, and finishing introduce a diverse range of contaminants, including reactive dyes, azo dyes, dissolved salts, surfactants, and auxiliary chemicals. It highlighted that the combined presence of these pollutants makes textile wastewater highly variable and challenging to treat effectively. Special emphasis was placed on the high concentrations of dissolved salts and synthetic dyes, which significantly reduce the efficiency of conventional biological treatment systems. The analysis noted that elevated salinity levels inhibit microbial growth and suppress enzymatic activity, thereby limiting biodegradation potential. The presence of recalcitrant dye molecules further complicates biological oxidation processes. The review concluded that standalone biological treatments are often insufficient for achieving complete pollutant removal. Overall, the study reinforces the need for integrated and advanced treatment approaches to manage the complex nature of textile wastewater [7].

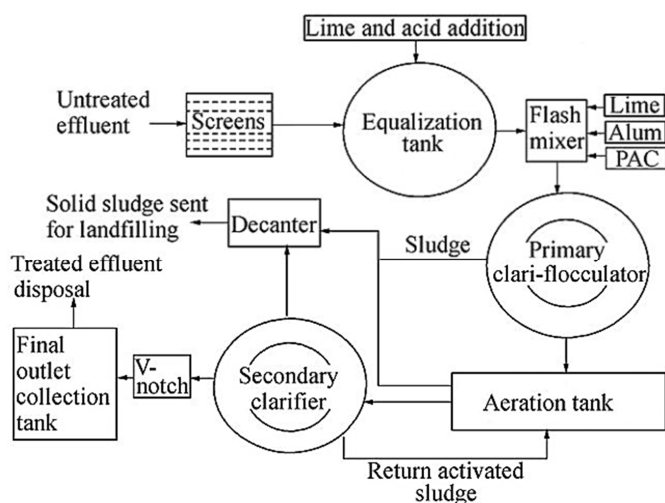


Figure 1 - Typical layout of CETP for textile industries [5]

A focused study examined the removal of synthetic dyes from industrial wastewater, emphasizing the chemical stability and persistence of azo dyes in aquatic environments. It explained that many azo dyes possess complex aromatic ring structures and nitrogen–nitrogen ($-N=N-$) bonds, which render them highly resistant to microbial degradation. These structural features contribute to their recalcitrant behavior and long-term environmental persistence. The review highlighted that conventional biological treatment systems often fail to achieve complete decolorization due to the stability of these dye molecules. Various physical and chemical treatment techniques, including adsorption, membrane filtration, and oxidation processes, were evaluated as effective alternatives or supplementary methods. The study demonstrated that such approaches can achieve significant color removal, although operational and cost considerations must be addressed. It also emphasized that synthetic dyes are major contributors to color pollution and toxicity in receiving water bodies. Overall, the work reinforces the significant treatment challenges posed by reactive and azo dyes in textile effluents and underscores the need for advanced remediation strategies [8].

A detailed investigation explored biological approaches for the treatment of textile dyes, with particular emphasis on the limitations of microbial degradation under high salinity conditions. The study demonstrated that certain bacterial and fungal strains possess the ability to degrade azo dyes effectively under controlled conditions. However, their degradation efficiency was found to decline significantly in saline wastewater typically generated by textile industries. Elevated salt concentrations were shown to inhibit microbial growth and metabolic activity, thereby reducing enzymatic breakdown of dye molecules. Additionally, the formation of toxic dye intermediates and fluctuations in pH were identified as factors that further suppress biological performance. The findings indicated that saline and chemically complex textile effluents create an unfavorable environment for stable biological treatment. As a result, complete degradation of recalcitrant organic compounds through standalone biological processes was considered difficult to achieve. The study therefore recommended the adoption of integrated or hybrid treatment systems to enhance overall efficiency and reliability [9].

3. Treatment Technologies in Textile CETPs

CETPs generally include preliminary, primary, secondary and tertiary treatment stages. Preliminary treatment includes screening and equalization. Primary treatment uses coagulation–flocculation for color removal. Secondary treatment commonly involves activated sludge processes, SBR and MBBR systems. Tertiary treatments include activated carbon adsorption, advanced oxidation processes and membrane systems such as UF, NF and RO.

A detailed investigation evaluated the effectiveness of chemical coagulation–flocculation processes for treating textile wastewater, with particular focus on the removal of

color and suspended solids. The study examined the performance of various coagulants, including alum, ferric chloride, and polymeric flocculants, in reducing turbidity, COD, and color intensity. Results indicated that coagulation–flocculation is highly efficient as a primary treatment step, especially for eliminating non-biodegradable dye particles and colloidal matter prior to biological treatment. The process was found to significantly improve wastewater quality by decreasing the pollutant load entering secondary treatment units. The analysis further highlighted that treatment efficiency strongly depends on proper optimization of pH and coagulant dosage. Inadequate dosing or improper pH conditions were shown to reduce floc formation and settling efficiency. The study emphasized that this method enhances the overall performance and stability of subsequent biological processes. Overall, the findings provide a strong technical foundation for incorporating coagulation–flocculation as a primary treatment stage in textile Common Effluent Treatment Plants (CETPs) [10].

A detailed investigation examined the biodegradation of azo dyes in textile wastewater, focusing on the performance of activated sludge systems under varying operational conditions. The study reported that conventional activated sludge processes are effective in substantially reducing BOD and can partially degrade certain dye compounds when operated under controlled parameters. However, the presence of toxic dye constituents and elevated salinity levels was found to inhibit microbial activity and reduce overall treatment efficiency. The research highlighted that shock loading and fluctuations in influent characteristics further affect biological stability. To overcome these limitations, the study proposed process modifications such as optimizing hydraulic retention time and maintaining adequate dissolved oxygen levels. It also recommended the integration of anaerobic–aerobic treatment systems to enhance dye degradation and improve overall performance. The combined approach was shown to facilitate better breakdown of azo bonds and subsequent mineralization of intermediates. Overall, the findings support the role of activated sludge processes as a widely adopted secondary treatment method in Common Effluent Treatment Plants (CETPs), while emphasizing the need for operational optimization and system integration. [11].

A comprehensive review examined biological treatment techniques for textile effluents, including activated sludge systems, sequencing batch reactors (SBR), and biofilm-based processes such as moving bed biofilm reactors (MBBR). The study discussed the underlying mechanisms of dye biodegradation, emphasizing microbial adaptation, enzymatic reduction of azo bonds, and the role of acclimatized microbial consortia. It highlighted those operational challenges such as shock loading, fluctuating influent characteristics, and the formation of toxic intermediates can adversely affect system stability. The analysis showed that biological processes are highly effective in reducing organic load, particularly BOD, under optimized conditions. However, complete color removal was

often found to be insufficient when relying solely on biological treatment. The need for supplementary physical or chemical treatment methods to achieve satisfactory decolorization was therefore emphasized. The review also noted that biofilm-based systems offer improved resilience and biomass retention compared to conventional suspended growth systems. Overall, the findings validate the widespread application of SBR and MBBR systems in textile Common Effluent Treatment Plants (CETPs), while supporting the integration of additional treatment stages for enhanced performance [12].

A detailed study evaluated the application of Fenton's reagent as an advanced oxidation process (AOP) for the treatment of textile wastewater. The research demonstrated high efficiency in decolorization and significant COD reduction due to the generation of highly reactive hydroxyl radicals. These radicals were shown to effectively break down complex and recalcitrant dye molecules that are otherwise resistant to biological degradation. The study emphasized that advanced oxidation processes can degrade aromatic structures and improve overall biodegradability of treated effluent. Operational parameters such as pH, hydrogen peroxide dosage, and ferrous ion concentration were identified as critical factors influencing treatment efficiency. The process was found to be particularly effective in removing residual color and persistent organic compounds after secondary treatment. Based on performance evaluation, Fenton oxidation was recommended as a suitable tertiary polishing step in textile wastewater treatment plants. Overall, the findings support the integration of advanced oxidation processes into Common Effluent Treatment Plants (CETPs) to achieve enhanced and reliable treatment performance. [13].

A detailed investigation evaluated the application of ozonation as a tertiary treatment method for textile effluents. The study demonstrated that ozone effectively attacks and degrades chromophoric groups present in dye molecules, resulting in significant color removal and partial mineralization of organic pollutants. The oxidation process was shown to enhance effluent quality by reducing residual COD and improving overall clarity prior to discharge or reuse. It was highlighted that ozonation can transform complex dye structures into smaller, more biodegradable compounds. The study also emphasized that integrating ozonation with membrane-based systems enhances overall treatment efficiency and reliability. Membrane processes such as ultrafiltration (UF), nanofiltration (NF), and reverse osmosis (RO) were identified as suitable complementary technologies for achieving high-quality effluent standards. The combined approach was found to be particularly effective for advanced textile wastewater treatment and water reclamation. Overall, the findings provide strong technical justification for incorporating ozonation and membrane-based systems in modern textile Common Effluent Treatment Plants (CETPs) [14].

4. Zero Liquid Discharge (ZLD) Systems

ZLD systems integrate reverse osmosis, multiple effect evaporators and crystallizers to achieve complete wastewater reuse. Though effective, ZLD increases energy demand and operational costs.

A detailed analysis examined the performance and limitations of reverse osmosis (RO) systems in treating high-salinity industrial wastewater. The study identified membrane fouling, inorganic scaling, and elevated osmotic pressure as major operational challenges when processing effluents with high total dissolved solids (TDS), such as those generated by textile industries. It explained that increasing salinity raises osmotic pressure, thereby reducing permeate flux and increasing energy consumption. Membrane fouling caused by organic matter and colloids was also shown to significantly impair system efficiency and lifespan. Despite these limitations, RO was demonstrated to achieve high levels of water recovery and effective salt rejection under optimized conditions. The study emphasized that performance declines at very high salinity levels, making standalone RO systems less viable in such cases. As a result, integration with thermal processes such as evaporation or crystallization was recommended for achieving complete zero liquid discharge (ZLD). Overall, the findings provide strong scientific justification for incorporating RO as a major component of ZLD systems, while clearly acknowledging its technical and operational constraints [15].

A comprehensive review examined the implementation of Zero Liquid Discharge (ZLD) systems in textile industries, particularly in water-scarce regions where water conservation is critical. The study described the integration of reverse osmosis (RO), multiple effect evaporators (MEE), and crystallizers to achieve near-complete recovery of water and dissolved salts from textile effluents. It demonstrated that ZLD systems can substantially reduce freshwater consumption and effectively eliminate liquid effluent discharge into the environment. The recovered water was found to be suitable for reuse in industrial processes, thereby enhancing resource efficiency and environmental compliance. The analysis highlighted that such systems significantly minimize pollution loads and support sustainable industrial operations. However, the study also emphasized that ZLD implementation involves high capital investment and considerable operational and maintenance costs. Intensive energy requirements and the need for skilled technical management were identified as major constraints. Overall, the findings support the view that while ZLD enhances environmental sustainability, it simultaneously increases operational complexity and financial burden for textile industries [16].

A detailed techno-economic evaluation assessed Zero Liquid Discharge (ZLD) systems implemented in textile industrial clusters and compared them with conventional Common Effluent Treatment Plant (CETP) configurations. The study analyzed key factors such as energy consumption,

operational expenditure, capital investment, and sludge or salt management requirements. It was observed that ZLD systems provide superior regulatory compliance and enhanced environmental protection by eliminating liquid effluent discharge. However, the analysis revealed a substantial increase in energy demand, primarily due to evaporation and crystallization processes involved in water and salt recovery. Higher operational and maintenance costs were also identified as significant challenges for large-scale implementation. The study emphasized the importance of optimizing system design to reduce energy intensity and improve cost-effectiveness. It further highlighted the potential role of energy-efficient evaporators and integration of renewable energy sources to enhance long-term sustainability. Overall, the findings reinforce the trade-off between environmental benefits and economic feasibility in ZLD-based textile CETPs [17].

5. Performance Evaluation

Reported performance efficiencies include COD removal (70–95%), BOD removal (>85%) and color removal (80–98%). Efficiency depends on influent variability, shock loads and process control.

A comprehensive evaluation analyzed textile wastewater treatment performance across various configurations, including physical, chemical, and biological systems. The study reported that properly designed and well-operated treatment plants can achieve COD removal efficiencies ranging from 70% to 95%, while BOD removal efficiencies often exceed 85%. It emphasized that biological processes such as activated sludge systems and sequencing batch reactors play a major role in reducing organic load. Chemical treatment methods were identified as particularly effective for enhancing color removal and improving overall effluent quality. The findings indicated that integrated treatment approaches generally provide more stable and higher removal efficiencies compared to standalone systems. The study also highlighted that operational parameter such as hydraulic retention time, aeration rate, sludge age, and influent pollutant concentration strongly influence overall performance. Variations in these parameters were shown to directly affect system stability and compliance with discharge standards. Overall, the work provides quantitative support for the commonly reported COD and BOD removal efficiencies achieved in textile Common Effluent Treatment Plants (CETPs) [18].

A comprehensive review examined various color removal technologies for textile wastewater and reported that integrated treatment systems combining coagulation, biological processes, and advanced oxidation methods can achieve color removal efficiencies ranging from 80% to 98%. The study highlighted that the synergistic effect of multiple treatment stages enhances overall decolorization and pollutant reduction compared to standalone processes. However, it was noted that treatment performance is highly sensitive to influent variability, including fluctuations in

organic load, dye concentration, and salinity. Shock organic loading and the presence of toxic dye intermediates were identified as key factors that can disrupt biological activity and reduce efficiency. High salinity levels were also found to inhibit microbial processes and destabilize system performance. The review emphasized the importance of equalization tanks to buffer influent variations and maintain steady operating conditions. Proper process control, optimized operational parameters, and continuous monitoring were considered essential to achieving consistent removal efficiency. Overall, the study substantiates that the performance of Common Effluent Treatment Plants (CETPs) is strongly influenced by influent fluctuations and effective operational management practices [19].

6. Sludge Management

CETPs generate chemical and biological sludge containing dyes and heavy metals. Sustainable disposal options include solidification, co-processing in cement kilns and resource recovery approaches.

A detailed investigation examined the characteristics and management practices of sludge generated from textile wastewater treatment plants, particularly those employing chemical coagulation and biological processes. The study reported that sludge from Common Effluent Treatment Plants (CETPs) often contains residual dyes, heavy metals, coagulant precipitates, and microbial biomass, rendering it potentially hazardous if not properly handled. Comprehensive physicochemical analyses were conducted to determine metal concentrations, leachability potential, moisture content, and overall stability of the sludge. The findings indicated that improper disposal may lead to secondary environmental contamination through soil and groundwater pollution. Various sustainable disposal and management strategies were evaluated to mitigate these risks. Solidification–stabilization techniques were highlighted as effective methods for immobilizing heavy metals and reducing leachability. The study also discussed co-processing in cement kilns as a viable energy recovery option and explored emerging resource recovery approaches such as salt extraction and reuse of treated sludge in construction materials. Overall, the paper emphasized that sustainable sludge management is critical for ensuring the long-term environmental and operational viability of textile CETPs [20].

7. Sustainability and Future Research

Future CETPs should focus on hybrid treatment systems, AI-based monitoring, brine recovery, energy optimization and circular economy approaches.

A recent study explored the development of hybrid wastewater treatment systems that integrate biological, chemical, and membrane-based technologies to enhance overall treatment performance. The research emphasized that combining biological processes with advanced oxidation or membrane filtration significantly improves the

removal of recalcitrant organic compounds and dissolved salts. It was demonstrated that such multi-stage configurations offer synergistic effects, where each treatment unit compensates for the limitations of others. Biological treatment was identified as effective for bulk organic load reduction, while advanced oxidation processes target persistent dye molecules and toxic intermediates. Membrane technologies were highlighted for their ability to remove dissolved solids and achieve high-quality effluent suitable for reuse. The study pointed out that complex industrial effluents, particularly from textile industries, often cannot be adequately treated using single-stage systems. Operational stability and improved compliance with discharge standards were noted as key advantages of hybrid approaches. Overall, the work strongly supports the adoption of integrated and multi-barrier treatment strategies in next-generation Common Effluent Treatment Plants (CETPs) [21].

A recent investigation examined the application of artificial intelligence (AI) and machine learning techniques in the monitoring and control of wastewater treatment plants. The study demonstrated that AI-based predictive models can analyze real-time operational data to optimize critical parameters such as aeration control, chemical dosing, and sludge management. By utilizing historical performance trends and sensor data, these models were able to predict system behavior and prevent process instability. The findings indicated that intelligent control strategies significantly improve treatment consistency and reduce the risk of non-compliance with discharge standards. Energy consumption was also reduced through optimized aeration and chemical usage, contributing to cost savings. The study highlighted the role of data-driven decision-making in enhancing plant reliability and performance. It further emphasized that automated monitoring systems enable rapid response to influent fluctuations and shock loading conditions. Overall, the work reinforces the importance of AI-based monitoring and smart control systems in improving the operational efficiency and sustainability of future Common Effluent Treatment Plants (CETPs) [22].

A detailed evaluation examined brine management strategies in Zero Liquid Discharge (ZLD) systems, with particular focus on salt recovery and reuse in textile processing operations. The study described how brine concentration and crystallization units can effectively recover usable salts from concentrated reject streams generated during membrane treatment. This approach was shown to significantly reduce waste generation while simultaneously lowering the demand for fresh raw materials. The recovered salts were found to be suitable for reuse in dyeing and other textile processes, thereby supporting circular resource utilization. The analysis emphasized that improper brine disposal can create environmental risks, making recovery-based management strategies essential. Operational considerations such as purity of recovered salts and energy consumption of crystallization units were also discussed. The study highlighted resource recovery as a crucial component of

sustainable textile wastewater management. Overall, the findings support the integration of brine recovery and salt reuse units within advanced Common Effluent Treatment Plants (CETPs) to enhance both environmental and economic sustainability [23].

A recent study analyzed energy consumption patterns in textile Common Effluent Treatment Plants (CETPs) and identified major areas contributing to high operational costs. The investigation revealed that energy expenses constitute a substantial portion of total operational expenditure, particularly in Zero Liquid Discharge (ZLD)-based systems where evaporation and crystallization processes are energy-intensive. The study evaluated optimization strategies such as the installation of high-efficiency aerators to reduce power demand in biological treatment units. It also proposed the use of heat recovery systems to utilize waste heat from evaporators and other thermal processes. Integration of renewable energy sources, including solar thermal support for evaporators, was highlighted as a sustainable approach to lowering dependency on conventional energy. The analysis demonstrated that process automation and real-time monitoring can further enhance energy efficiency by optimizing aeration and pumping operations. Regular energy audits were recommended to identify inefficiencies and implement corrective measures. Overall, the findings strengthen the case for systematic energy optimization to improve the economic and environmental sustainability of future textile CETPs [24].

A seminal study introduced the concept of the circular economy and explored its application within industrial systems as a pathway toward sustainable development. The work emphasized core principles such as resource efficiency, waste minimization, recycling, and material recovery to reduce environmental impact. It argued that traditional linear “take–make–dispose” production models are environmentally unsustainable and should be replaced with closed-loop systems that retain materials and energy within the production cycle. The framework highlighted the importance of designing processes that enable reuse, regeneration, and recovery of resources. Although not limited to textile wastewater treatment, the concepts are highly applicable to industrial effluent management systems. In the context of textile Common Effluent Treatment Plants (CETPs), the circular economy approach supports treated water reuse, salt recovery from brine streams, sludge valorization, and energy-efficient operations. The study also underscored the economic and environmental benefits of integrating sustainability into industrial infrastructure planning. Overall, it provides a strong theoretical foundation for incorporating circular economy principles into the future design and management of CETPs [25].

8. Identified Research Gaps in Textile CETP Technologies and Sustainability

Despite extensive research on textile wastewater treatment technologies and CETP configurations, significant gaps

remain in long-term performance benchmarking, reliability-based evaluation under variable influent conditions, and real-time operational optimization. Most studies report short-term removal efficiencies without addressing seasonal variability, shock loading, and compliance probability. There is limited practical implementation of AI-based monitoring and predictive control for aeration, chemical dosing, and membrane fouling management. Furthermore, textile-specific membrane fouling mechanisms in high-salinity ZLD systems are inadequately studied, and comprehensive life cycle assessment (LCA) or carbon footprint analyses of CETPs are scarce. Sludge valorization, brine recovery optimization, and techno-economic models for circular economy integration also remain underexplored, particularly in Indian textile clusters. Addressing these gaps through integrated techno-economic, environmental, and governance-based research frameworks is essential for advancing the sustainability and resilience of textile CETPs.

9. Conclusion

The textile industry remains one of the most significant contributors to industrial water pollution due to the discharge of highly colored, saline, and chemically complex effluents. The presence of reactive and azo dyes, high COD and BOD levels, dissolved salts, heavy metals, and recalcitrant organic compounds makes textile wastewater treatment technically challenging. This review highlights that standalone conventional biological treatment systems are often insufficient to achieve stringent discharge standards, particularly in textile clusters with highly variable influent characteristics.

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Common Effluent Treatment Plants (CETPs) have emerged as an effective and economically viable solution for clusters of small and medium textile industries. By centralizing treatment infrastructure, CETPs enable cost-sharing, regulatory compliance, and improved environmental monitoring. A typical CETP integrates preliminary, primary, secondary, and tertiary treatment stages, including coagulation–flocculation, activated sludge/SBR/MBBR systems, advanced oxidation processes, and membrane technologies. Performance evaluations indicate that well-operated CETPs can achieve COD removal efficiencies of 70–95%, BOD removal exceeding 85%, and color removal up to 98%, although efficiency depends heavily on influent variability and operational control.

Zero Liquid Discharge (ZLD) systems further enhance environmental sustainability through water reuse and salt recovery, but they significantly increase energy demand and operational costs. Sludge management remains a critical challenge due to the presence of heavy metals and residual dyes. Sustainable approaches such as solidification, co-processing, and resource recovery are essential for long-term viability.

Future CETPs should focus on hybrid treatment configurations, AI-based process optimization, brine recovery, energy-efficient operations, and circular economy principles. Integrating advanced technologies with sound policy, monitoring, and management practices will be crucial to achieving sustainable textile wastewater management and environmental protection.

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An Overview on Effect of Atmospheric Pressure and Low Pressure Plasma Treatment on Cellulosic Textiles

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Abstract :

The removal of lignin, gum, and other contaminants that negatively impact the softness and dyeability of banana fibres is the main challenge to be overcome during chemical processing. To remove impurities, enhance softness, dyeability, etc., textiles can undergo a variety of chemical treatments, such as alkali treatment and silicone finishing. However, the amount of water and chemicals needed for these chemical treatments end up harming the ecosystem. Other surface treatments, such as the application of plasma to the textile to eliminate impurities and improve softness, are available to address this issue. These treatments don't need water, use less energy, and are environmentally friendly. The use of plasma in textile modification offers a huge opportunity for advancing from a more traditional, energy-intensive, slow and environmentally damaging treatment techniques. Utilising plasma in textile chemical processing is an environmentally safe option and lowers production costs because it uses less energy and processes more quickly. Plasma treatment also provides the opportunity to obtain textile surface finishes without altering the essential bulk characteristics. The current review aims to provide a comprehensive overview of atmospheric pressure and low pressure plasma treatment on cellulosic textile materials for improvement of various characteristics.

Keywords: Cellulosic textile, Dyeability, Impurity, Plasma treatment, Softness, Surface finish

Citation: Sushanta Naik, V. R. Sampath, "An Overview on Effect of Atmospheric Pressure and Low Pressure Plasma Treatment on Cellulosic Textiles", *Journal of the Textile Association*, **86/6** (March-April,2026), 614-617, <https://doi.org/10.5281/zenodo.20552730>

Article History : Received :07-02-2025, Revised: 14-04-2026, Accepted:18-04-2026

1. Introduction

Chemical treatment of textile is important to remove the natural surface impurities and also to impart different value-added finishing [1]. A large amount of energy and water is used in such treatment due to sequence of multi-step water based processes and drying of wet textile. With the increasing environmental concern in the recent years along with eco-friendly process/products, and the government legislation on effluent discharge in many countries, sustainable processing is one of the major challenges in textile sector [1]. Various groups of researchers are involved in sustainable processing/finishing of textile using biomolecules, aromatic and medicinal plant extracts, nano materials, and water-free irradiation techniques. Surface modification of fiber and fabric has been found to be effective for some specific applications. Chemical treatment like chlorination, alkali treatment, synthetic polymer coating, etc. have also been developed for modification of textile surface. These processes are often found to be harsh, non-ecofriendly, modifying the bulk properties of materials and generating effluent [1]. Cold plasma in low pressure to atmospheric pressure conditions in the presence of non-polymerizing to polymerizing precursors has been used to improve/introduce a new or existing property of a textile substrate. The UV excimer irradiation has used to impart smart attributes in woolen and silk fabrics, having hydrophobic property in one surface and hydrophilic property on other surface. Likewise,

different laser sources were reported for treatment of denim fabric. Water-free electron beam technology has also been used for treatment of textile effluent [2, 3]. The paper highlights the applications of atmospheric pressure and low pressure plasma treatment in cellulosic textiles which is an emerging irradiation technique.

2. Introduction to Plasma

Plasmas are composed of ionized gases [4]. Typically, a gas acts as an electrical insulator. However, if a gap containing a gas or gas mixture is exposed to a sufficiently high voltage, the gas or gas mixture will disintegrate and conduct electricity. The electrically neutral atoms or molecules of the gas are ionised, or divided into positively charged ions and negatively charged electrons. The resulting ionised gas is called as a discharge or plasma. The specific physical and chemical characteristics of the plasma environment are produced by the interactions of the electrically charged particles with one another, with the neutral gas, and with contact surfaces. Plasmas are sometimes referred to as the fourth state of matter because of the environment they exist in, which is different from that found in solids, liquids, or gases [5].

3. Plasma's significance in textile applications

Although on a scientific level, the textile industry is progressively catching on to the benefits and interest that plasma processing has generated in the creation of microelectronics, the automotive industry, biomedical applications, and the modification of polymers [6].

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The plasma treatment of textiles has several practical, economic, and environmental advantages. The ability to modify many types of fibres (natural protein and cellulose, synthetic), textile forms, and product functional design using a single system is a reflection of plasma processing's versatility [8]. In order to deliver intrinsic effects on textiles, the right choice of gas (O₂, N₂, H₂, air, Ar, He, NH₃, hydrocarbons, fluorocarbons) and management of the plasma operating conditions (treatment time, power, pressure, gas flow rate) are necessary. Since the fibre surface is primarily responsible for the bulk of the end-use qualities of textile products, the alteration of the fibre surface is an important step in many processes and applications [7]. Additionally, the confinement of plasma treatment to the fibre surface, which preserves the bulk properties, seems to make it particularly convenient [8].

4. The importance of low temperature plasmas in the treatment of textiles

There are two different forms of plasma that can be applied to textiles: atmospheric pressure and vacuum pressure. Low-pressure treatment provides superior stability, control, and reproducibility [7]. The majority of low-temperature plasma (LTP) or cold plasma is created by glow discharges in gaseous environments. A crucial characteristic of this kind of plasma is that the temperature of the electrons and the energy of the unionized gas particles are not in equilibrium. This makes it possible to create situations where the plasma gas's temperature stays near to that of the surrounding air while the electrons' energy is adequate to break covalent and intermolecular bonds. LTP has the ability to initiate modifications in polymers that are not heat-resistant, which includes nearly all fibre-forming polymers [7]. Extremely high gas temperatures (Thermal Plasma) can only support extremely high plasma densities (more than 10¹³ electrons cm⁻³). Because the energy of the plasma will burn practically any material, this exceptionally high degree of plasma density is inappropriate for treating textiles. Thus, the plasma must operate at room temperature to process textiles, giving rise to the term "cold plasma." Cold plasma also has the advantage of chemically treating fabrics and other substrates without harming them with high temperatures [9].

5. Influence of plasma treatment on various types of natural cellulosic fabrics

Influence of plasma treatment on cotton fabrics
Poly Vinyl Alcohol sizing substance has been taken out of cotton garments using atmospheric plasma. It has been reported that plasma treated cotton could entirely remove PVA sizing material with a single cold water wash, in contrast to conventional treatment, which requires hot water for effective removal of size. Under low pressure, O₂ plasma treatment has been proven to enhance the scouring and dyeing behaviour. [10, 11] studied the impact of low pressure plasma treatment on cotton fabric dyeing. They discovered that attachment of surface polar groups makes cotton more wettable, which enhances dye absorption and scouring. Better treatment follows from better adsorption.

According to SEM analysis of the cotton fibres, the plasma-treated cloth features pores on the surface that act as entry points for dye molecules, improving dyeing rates. The plasma's ablation effect, which is characterized by holes, may have increased the surface area of the fibre. This, together with the improved wetting brought on by the attachment of surface polar groups, may have resulted to an increase in dyeing rates.

Investigations into the effects of DC air plasma and cellulase enzyme treatments on the hydrophilicity of cotton fabric samples revealed that these treatments were successful in enhancing the hydrophilicity of cotton fabrics. The physico-chemical changes brought on by plasma and enzyme are what are responsible for this rise in hydrophilicity [12, 13] investigated the impact of argon/oxygen atmospheric dielectric barrier discharge (DBD) treatment on desizing and scouring of cotton fabric for removal of polyvinyl alcohol (PVA). The capillary heights of fabrics treated with plasma grew dramatically as the plasma treatment time increased, according to wick-ability analysis, [14] studied on the hydrophilic enhancement of grey cotton fabric by low pressure DC glow discharge air plasma and came to the conclusion that the development of polar groups on the fabric's surface was what caused the rise in hydrophilicity. Plasma treatment can be used to make cotton fabrics water repellent by adjusting the application gases. Hexamethyl disiloxane gas treatment of cotton fabric can be used to smooth the surface of the fibres and can increase the contact angle on the fibre up to 130°. Similar to this, fluorine groups can be added to the surface of the fibres using hexafluoroethane plasma to provide a potent water repellency effect. Neither of these techniques lessens cotton's capacity to transmit water vapour [7]. It was also claimed that cotton fabrics might produce the lotus effect with plasma treatment. The basic idea is to etch the fibre to produce nanoscale peaks, which are subsequently covered with a hydrophobic coating using a suitable gas, like hexafluoroethane. The impacts of air and argon atmospheric plasma treatments on different physical properties of bleached cotton fabrics, including pilling propensity, friction coefficient, thermal comfort, water vapour permeability, and surface properties, were examined [15]. CF₄ and C₃F₆ were applied to cotton denim fabrics by McCord's research team at North Carolina State University using a low-pressure, low-temperature plasma system to boost the water repellency characteristics of surface [16]. Samanta et al. have applied atmospheric pressure cold plasma in the presence of helium as well as helium oxygen mixture and cotton fabric sample was treated for 30 secs to 120 secs. [17]. The plasma treated fabric was found to be more hydrophilic in nature. This was validated by its wicking property due to generation of more hydrophilic functional groups resulting better water transport. This treatment also increased the crystallinity index of cotton. The colour strength of the dyed fabric was increased in case of helium/oxygen plasma treated cotton fabric. Another study was conducted by Samanta et al. in

which cotton fabric was treated with atmospheric pressure cold plasma in the presence of helium fluorocarbon gases for making the cotton fabric hydrophobic [18]. After treatment, it was found that the cotton fabric becomes water repellent and water droplet of 37 μl was not absorbed by cotton even after 60 min. The applied water repellent finish was also found to be durable to repeated washing. FTIR analysis validated the presence of various C-F molecules in the plasma treated sample and from EDX analysis it was found that 4.2% fluorine atom was deposited on cotton surface. SEM analysis and SIMS images have proved that no blockage of inter fiber spacing occurred in fabric structure and this is a nano scale surface modification of cotton. So, although the cotton fabric became water repellent due to the plasma treatment, it does not decrease cotton's capacity to transmit air and water vapour. So, this treatment does not degrade the comfort property of cotton. Malik et al. have applied cold glow discharge oxygen plasma and nitrogen plasma on cotton fabric [19]. They found that the treated cotton fabric has better wettability, better crease recovery and lower stiffness as compared to untreated cotton. They found that the tensile strength of treated cotton fabric was decreased as compared to untreated cotton. So, when cotton or other cellulosic textiles are treated with plasma in the presence of hydrogen, oxygen, nitrogen, helium or their mixture, then hydrophilicity improves and when they are treated with plasma in the presence of fluorocarbon or hexamethylene disiloxane, the water repellency of cotton increases.

6. Influence of plasma treatment on flax and hemp fabrics:

The observed increase in water retention and wetting rate of flax is explained by the fiber's improved receptivity to water molecules as a result of plasma etching and plasma oxidation which result in the production of new carboxyl groups [20]. The effect of low-temperature plasma (LTP) of hemp has been investigated [21]. Radetic et al. examined how hemp's dyeing abilities were affected by low-temperature air plasma and enzymatic treatment [22]. In addition to determining dyeing kinetics, colour yield, and colour fastness, measurements of weight loss, water retention, and degree of whiteness were made, along with SEM analyses of samples that had been subjected to various treatments. Hemp cloth was subjected to low-temperature plasma treatment, which increased the dyeing rate, total dye exhaustion, and colour yield of dyed samples. Plasma etching and oxidation effects on the surface of the hemp fibre were used to explain the beneficial effects of the treatment. According to the findings, samples that had been treated with enzymes and low-temperature plasma had even lower final exhaustion and dyeing rates than all other samples. This might be explained by a more pronounced digestion of the fiber's amorphous regions, which after plasma etching were much more easily accessible to enzymes. Plasma etching probably improved fibre porosity and brought about minute topographical modifications that made hemp fibre more permeable to dye

and water molecules. Increased dye exhaustion is not solely due to the easier dye penetration into the fibre brought on by plasma treatment; it is also significantly impacted by the structure, molecular weight, and state of the dye in the dyeing bath [23].

7. Influence of plasma treatment on banana fiber

Now a day's natural fibers are utilised to produce fiber reinforced composites. The plasma treatment of natural fibre produces better interfacial bonding and greater mechanical strength in fiber-reinforced composites [24]. Gupta et al have evaluated the plasma treatment conditions that affected the mechanical properties of banana fibre reinforced composites and looked into the tensile and surface features [25]. Using argon gas and two separate sets of conditions - 80 W and 120 W - plasma treatment was carried out on banana fibres for 30 minutes. With a plasma intensity of 80 W for 30 minutes, improvements in banana fiber's tensile strength, modulus of elasticity, strain, and percentage of elongation were seen. The influence of oxidation on the fundamental components of banana fibre during surface modification results in the production of hydrophobic nature, which is particularly highlighted by FTIR. By removing some of the amorphous components of the banana fibre and rearranging the crystalline zones, plasma treatment with argon gas increased crystallite size and improved crystallinity, according to the results of X-ray diffraction. Gupta et al have also conducted research on application of cold glow discharge nitrogen plasma on banana fiber to improve interfacial bonding of fiber matrix. They have treated at two different condition of plasma treatment i.e. 80 W for 30 min and 120 W for 30 min. [26]. They found that banana fiber was treated with cold glow discharge nitrogen plasma at 80 W for 30 min shows better flexural strength, better interlaminar shear strength and higher tensile strength in banana fiber reinforced composite as compared to the treatment with cold glow discharge nitrogen plasma at 120 W for 30 min.

8. Conclusion

Even though plasma treatment is an environmentally favourable method, it has become a minor component in many industrial processes. From plasma treatment, several advantages such as water less process, low chemical requirement as compared to conventional processing, improved chemical exhaustion from the bath, low BOD/COD in effluents, lower temperature requirement, and saving of energy, time and money. The main drawback of plasma treating textiles is that it requires high initial investment and it cannot completely replace wet procedures, but it can be a good pretreatment with plenty of economic and environmental advantages. The textile sector should thus think about making larger initial investments in equipment that will pay off rapidly in terms of savings for the environment and the revenue from the sale of high-value items.

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Comparative Analysis of Yarns Spun from Textile Waste

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Abstract:

The rapid growth of the textile and apparel sector has led to a substantial increase in pre-consumer textile cutting waste, highlighting the need for efficient recycling strategies to promote sustainable material utilisation. In the present study, mixed textile cutting waste generated during garment manufacturing was mechanically recycled and blended with virgin viscose fibres to enhance fibre processability. Recycled fibres were converted into slivers through carding and subsequently spun into yarns using both ring and rotor spinning systems. Produced yarns were evaluated in terms of linear density, tensile strength, and elongation behaviour. Woven fabrics were further prepared using recycled yarns in the weft direction with cotton warp yarns, and their structural properties, such as thickness and fabric density, were analysed.

Results indicated that recycled fibre slivers showed hank values close to those of virgin viscose slivers, suggesting satisfactory blending compatibility. Ring-spun yarns obtained from recycled fibres exhibited coarse structure with higher extensibility but comparatively lower tenacity. In contrast, the rotor-spun yarns—integrated with a 25% virgin viscose blend—achieved a significantly finer linear density and superior tensile performance, as the added viscose fibers facilitated better fiber consolidation and stress distribution within the yarn structure. Fabric evaluation revealed that rotor-spun yarns produced comparatively thinner and more compact fabrics, whereas ring-spun recycled yarns generated bulkier fabric structures. Furthermore, fabrics woven with sateen weave demonstrated higher warp density compared to plain weave due to the presence of longer yarn floats and fewer interlacements. Findings confirm that mechanically recycled mixed textile cutting waste can be effectively transformed into functional yarns and woven fabrics, demonstrating the potential of such recycling strategies for sustainable textile manufacturing.

Keywords: Mechanical recycling, Pre-consumer garment waste, Recycled yarn production, Ring and rotor spinning, Sustainable woven fabrics, Textile waste recycling

Citation: Hiren Jaiswal, Sanjay Parmar, Aadhar Mandot, Sanjay B. Bambhaniya, “Comparative Analysis of Yarns Spun from Textile Waste”, *Journal of the Textile Association*, **86/6** (March-April, 2026), 618-621, <https://doi.org/10.5281/zenodo.20552634>

Article History : Received : 24-03-2026, Revised: 07-04-2026, Accepted: 11-04-2026

1. Introduction

The textile industry is one of the largest generators of solid waste, with a significant proportion arising from pre-consumer cutting waste produced during garment manufacturing. This type of waste, although relatively clean and uniform compared to post-consumer textiles, is often underutilised and disposed of through landfilling or incineration, leading to environmental and economic concerns. In the context of increasing emphasis on circular economy and sustainable material utilisation, mechanical recycling of textile cutting waste into value-added yarns and fabrics has gained considerable attention [1].

Mechanical recycling offers an attractive route for textile waste valorisation due to its low chemical and energy requirements. However, fibres recovered through mechanical processes typically suffer from reduced length, higher irregularity, and poor cohesion, which adversely affect spinnability and final product performance [2]. To overcome these limitations, blending recycled fibres with virgin fibres has been widely explored as a practical approach to enhance fibre processability and yarn quality. Among various virgin fibres, viscose is particularly suitable due to its cellulosic nature, good fibre uniformity, and compatibility with recycled textile fibres [3].

Spinning technology also plays a critical role in determining the performance of recycled yarns. Conventional ring spinning provides good yarn strength and extensibility, but is sensitive to fibre quality, while rotor spinning is more tolerant of shorter and heterogeneous fibres, making it suitable for recycled fibre processing. A comparative evaluation of these spinning systems is therefore essential to understand their suitability for recycled fibre-based yarn production [4]. Furthermore, the translation of recycled yarn characteristics into fabric properties depends not only on yarn structure but also on fabric construction parameters, such as weave type and yarn float length [2].

In this study, mixed textile cutting waste containing different textile fabrics and their blends was mechanically recycled and blended with virgin viscose fibres to improve fibre processability. Recycled fibre slivers were spun using both ring and rotor spinning systems, and the resulting yarns were characterised for their linear density and tensile properties. The yarns were subsequently woven into fabrics using plain and satin weave structures to evaluate the influence of yarn type and floated yarn length on fabric thickness and structural parameters. The study aims to assess the feasibility of converting mixed textile cutting waste without segregation into usable yarns and fabrics and to identify suitable spinning and fabric construction routes for recycled textile materials.

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2. Materials and Methods

2.1 Materials

Mixed textile cutting waste was collected from garment industries and tailor shops. This cutting waste was not segregated according to the type of material, but it was used as it is, irrespective of material type, i.e., cotton, polyester, viscose, etc. The pre-consumer mixed textile waste was selected due to its minimal contamination and suitability for mechanical recycling. Virgin viscose fibres were obtained from Birla Cellulose Ltd., Kosamba, and were used to improve fibre processability and yarn formation.

2.2 Mechanical Recycling and Fibre Preparation

The collected cutting waste was manually cut into small pieces and processed on a miniature flat carding machine to open, clean, and convert the fabric waste into fibrous form. The prepared carded web was further processed through a second carding stage using a trumpet (10 mm bore size) to produce slivers of approximately 0.21 hank. To enhance the structural integrity and eventual durability of the fabric, 25 wt% virgin viscose fibres were incorporated during the second carding passage; this addition stabilized the recycled fibre matrix and ensured more uniform fibre distribution throughout the yarn.

2.3 Yarn Spinning

The recycled fibre slivers were spun using both ring and rotor spinning systems to evaluate their processability. For ring spinning, the sliver was directly processed on a miniature ring frame to produce yarns through the drafting and twisting processes and was labelled as Y1, i.e., Ring-spun yarn from mixed waste (Figure 1a).



Figure 1 - Prepared Yarn Samples a) Rotot-Spun Yarn b) Ring-Spun Yarn

For rotor spinning, two slivers were fed simultaneously: one recycled fibre sliver (0.21 hank) and one virgin viscose fibre sliver (0.18 hank). The rotor speed was maintained at 30,000 rpm, and the opening roller speed was set at 8,000 rpm. The produced yarn was subsequently wound onto a package and labelled as Y2, i.e., Rotor-spun yarn with viscose + mixed waste (Figure 1b).

2.4 Fabric Formation

Woven fabric samples were produced on a handloom using the recycled yarns as weft and 100% cotton yarns as warp. Four fabric samples were prepared based on the spinning method and weave type, i.e., plain and satin fabrics woven with ring-spun and rotor-spun recycled yarns. Photographs of prepared samples are shown in Figure 2, and their coding was used as follows:

- Y1 in weft, plain weave
- Y2 in weft, plain weave
- Y1 in weft, satin weave
- Y2 in weft, satin weave

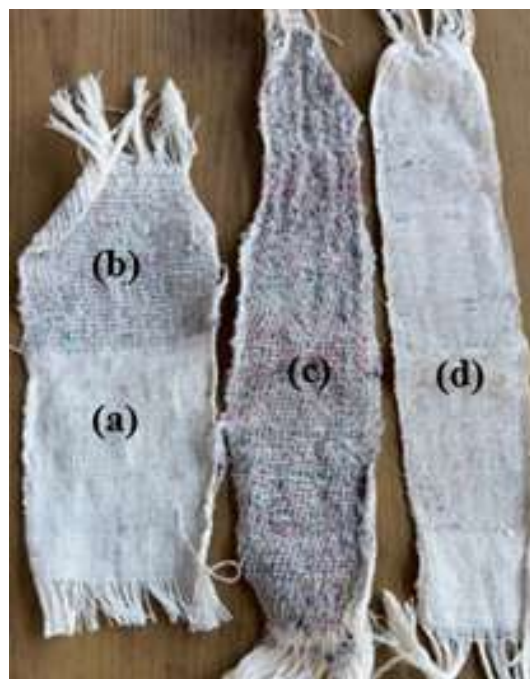


Figure 2 - Samples Prepared on A Handloom, a) Y1 In Weft, Plain Weave, b) Y2 In Weft, Plain Weave, c) Y1 In Weft, Satin Weave, d) Y2 In Weft, Satin Weave

3. Results and Discussion

The increasing demand for sustainable textile materials has accelerated interest in recycled fibres as alternatives to virgin fibres. In this study, the processability and performance of non-segregated mechanically recycled fibres were evaluated through sliver hank, yarn properties (denier, strength, elongation, tenacity), and fabric characteristics (thickness, EPI, and PPI).

3.1 Sliver Hank

The sliver hank obtained from virgin viscose fibres was 0.18, while the sliver produced from recycled fibres derived from mixed textile waste exhibited a slightly higher hank value of 0.21. This could be due to non-segregation of fibres, which consist of fibres of varying densities, which may have led to a change in hank value. The close similarity between these sliver hank values (0.18 for viscose and 0.21 for recycled) confirms excellent compatibility during blending, which is essential for ensuring the long-term structural integrity and

durability of the resulting fabric. This compatibility allowed the recycled fiber sliver to be processed seamlessly on standard machinery, facilitating a stable spinning process that directly contributes to the consistency of the final textile product.

3.2 Yarn Denier and Tensile Properties

The denier and tensile properties of the produced yarns are summarised in Table 1. It can be seen that the ring-spun recycled yarn (Y1) exhibited a very high denier (9000), which can be attributed to the use of carded sliver as an input and the limited drafting capability of the miniature ring frame used in this study[5]. As a result, the yarn structure remained coarse and bulky. Apart from this, Y1 showed a high maximum load-bearing capacity; however, its tenacity was relatively low due to its coarse structure. This may be due to poor fibre alignment and a higher proportion of short and recycled fibres[6]. Analysis also showed that ring-spun yarn has relatively high extension, which may be attributed to the nature of ring-spun yarn having a good twisted configuration, which allows fibre migration, leading to high stretch[7].

Table 1 - Yarn Properties

Type of Yarn	Denier	Max Load (gf)	Elongation (%)	Tenacity (gpd)
Ring-spun Recycled only (Y1)	9000	2135.41	19.76	0.24
Rotor: Viscose + Recycled (Y2)	945	561.61	9.11	0.59

In contrast, the rotor-spun yarn blended with viscose and recycled fibres (Y2) displayed a significantly lower denier (945) along with improved tensile properties. The higher tenacity of Y2 indicates better fibre consolidation and stress distribution within the yarn structure. These characteristics make rotor-spun blended yarns more suitable for short staple fibres, particularly where uniformity and strength are required.

3.3 Fabric Properties

Fabric samples woven using different recycled yarns in the weft direction were analysed for thickness, ends per inch (EPI), and picks per inch (PPI), and the results are presented in Table 2. Fabrics produced with ring-spun recycled yarn (Y1) exhibited substantially higher thickness values in both plain and sateen weaves. This increase in thickness is primarily attributed to the coarser ring-spun recycled yarn. Conversely, fabrics woven with rotor-spun viscose-recycled yarn (Y2) showed lower thickness due to the finer yarn count and improved fibre packing.

Table 2 - Fabric Properties

Weft Yarn Type	Weave	Thickness (mm)	EPI	PPI
Y2 (Rotor Viscose Mix)	Sateen	0.852	46	22
Y1 (Ring Recycled)	Sateen	1.833	50	10
Y2 (Rotor Viscose Mix)	Plain	0.841	40	16
Y1 (Ring Recycled)	Plain	2.061	40	10

It can also be observed that fabric woven with sateen weave showed higher EPI values compared to plain weave. This can be due to the longer weft floats with sateen weave, which allows greater weft thread shrinkage due to reduced interlacement points, that groups more warp threads per unit length [8]. Also, EPI values were relatively higher for ring-spun yarn than rotor-spun yarn in sateen weave-based woven fabric[6]. This may be due to less PPI, which results in higher shrinkage of warp threads per unit length [8, 9]. This behaviour was not observed with plain weave, where frequent interlacements limit yarn mobility and negate the influence of yarn structure on warp density [8, 9]. Apart from this, variations in PPI were mainly influenced by irregular beat-up force on the handloom and different yarn count.

4. Conclusion

This study investigated the mechanical recycling of mixed textile cutting waste and its subsequent processing into yarns and woven fabrics without segregating it as per type of material. The incorporation of virgin viscose fibres during carding enabled stable sliver formation and improved processability of recycled fibres without major machine adjustments. Comparative spinning trials demonstrated that rotor spinning was more effective than ring spinning for producing finer and stronger yarns from recycled fibre blends, whereas ring-spun recycled yarns exhibited higher bulk and elongation but lower tenacity.

Fabric analysis showed that yarn structure and spinning method significantly influenced fabric thickness and density, with rotor-spun viscose-recycled yarns yielding thinner and more compact fabrics. Additionally, weave structure played an important role in determining fabric parameters, as sateen weave fabrics exhibited higher warp density than plain weave due to increased yarn float length and reduced interlacements. The results confirm that mixed textile cutting waste can be successfully recycled into functional yarns and fabrics using appropriate blending, spinning, and fabric construction strategies, thereby supporting sustainable material utilisation in textile manufacturing.

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Green Rheology Modifiers: Enhancing Dye Printing Efficiency using Acrylated Flaxseed-Based Thickeners

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Abstract:

Thickeners control pastes rheology, dye transfer, and fixing efficiency, making them essential in textile printing. The stability, color compatibility, and reproducibility of conventional natural and modified polysaccharide thickeners are limited, while synthetic versions pose toxicological and environmental issues. In order to improve performance in Direct, Reactive, and Disperse dye printing, this study examines flaxseed gel as an environmentally acceptable thickener and assesses derivatives modified by acrylation. The findings show that acrylated modified thickeners provide better color strength and washing fastness than gum indalca, ZnO and TiO₂ modified thickeners. Notably, a 40.27% increase in color strength is achieved in Reactive dye printing, with consistently high performance observed across all dye classes. These findings highlight the strong potential of acrylated flaxseed-based thickeners as sustainable, high-efficiency rheology modifiers, contributing to advancements in green and performance-driven textile printing technology.

Keywords: Color strength, Flaxseed, Printing, Sustainable, Thickeners

Citation: Y. M. Indi, Swapnil Deshmukh, S. R. Kamat, "Green Rheology Modifiers: Enhancing Dye Printing Efficiency using Acrylated Flaxseed-Based Thickeners", *Journal of the Textile Association*, **86/6** (March-April, 2026), 622-626, <https://doi.org/10.5281/zenodo.20556645>

Article History : Received : 12-12-2025, Revised: 15-04-2026, Accepted: 19-04-2026

1. Introduction

A thickener is a substance that can increase the viscosity of a liquid without significantly altering its other properties. Commonly used in the food industry, thickeners help to thicken sauces, soups, and puddings without changing their taste. They are also used in textiles, paints, inks, explosives, and cosmetics. Thickening agents can be classified into two categories: polysaccharides and proteins. Thickeners may also improve the suspension of other ingredients or emulsions, thereby increasing the stability of the product. Some thickening agents are also gelling agents (gellants), which form a gel by dissolving in the liquid phase as a colloid mixture, creating a weakly cohesive internal structure [1-3].

Thickeners play a crucial role in textile printing by providing the appropriate viscosity to the print paste, holding dye particles in place to prevent spreading, and extracting sufficient condensed water during steaming to ensure dye transfer and fixation onto the fabric. Essential requirements for thickeners include good stability, specific physical and chemical properties such as viscosity and flow, and compatibility with other ingredients in the printing paste like oxidizing agents, acids, alkalis, and solvents. The thickener film must dry properly to avoid capillary spreading of color and allow effective water extraction during steaming, ensuring dye movement towards the fabric. Thickeners should not have an affinity for the dye, must control free water pick-up to prevent dye bleeding, and should be easily removable during washing. Additionally, they should be cost-effective and readily available [4-5].

Natural thickeners [6], derived from cereals (e.g., maize, wheat, rice), plant exudates (e.g., gum tragacanth, gum arabic, gum karaya), roots and seeds (e.g., guar gum, locust bean gum), and seaweeds (e.g., sodium alginate), offer the advantages of being cheap, easily available, and providing good viscosity at low concentrations. They are also suitable for printing with direct dyes. However, they have limitations, such as poor keeping properties, a harsh feel due to higher solid content, unsuitability for reactive dyes (except sodium alginate), and pigment printing. Natural modified thickeners, such as starch derivatives (e.g., British gum, carboxymethyl starch), gum derivatives (e.g., Meypro gum, gum indalca), and cellulose derivatives (e.g., CMC, HEC), improve keeping properties through modifications like etherification and esterification, making them suitable for most dyes except reactive ones [7-9]. Despite their benefits, they are costlier, have limited availability due to food regulations, and face production uncertainties from natural disasters [10]. Synthetic thickeners, such as acrylic (e.g., polyacrylic acid) and vinyl (e.g., polyvinyl alcohol), provide good viscosity at low concentrations without harshness, making them suitable for pigment printing and disperse dyes. Their main drawbacks are sensitivity to electrolytes and limited compatibility with other ingredients. Emulsion thickeners, including oil in water and water in oil types, are ideal for pigment printing due to minimal solid content and a soft fabric feel. They eliminate the need for washing, as oil and water evaporate during polymerization, fixing the prints. However, they are costly, pose fire hazards, and emit harmful vapors, posing health risks to workers [11].

In this study, an attempt has been made to explore the possibility of flaxseed gel [12] as a thickener in printing

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offers a sustainable and eco-friendly alternative to synthetic thickeners, which are known to have negative environmental impacts, cause skin irritations, allergies, and are generally toxic and non-biocompatible. Flaxseed gel, a water-based thickener, shares similarities with cellulose derivatives and other natural thickeners, making it compatible with various dyes while being environmentally friendly. Research highlights the significant influence of thickeners on print performance, affecting rheology, adhesion, viscosity, and keeping properties. The concentration of the thickener and its interaction with additives play a crucial role in these properties. Recent advancements in nanotechnology have introduced nanoscale thickeners, which enhance viscosity control, fastness properties, and keeping properties. The literature emphasizes the importance of thickeners in optimizing printing processes, ensuring consistency across different fabrics and dyes, and fostering innovation in printing technology. Flaxseed gel's advantages include biocompatibility, non-toxicity, environmental friendliness, safety for human skin, non-polluting nature, and sustainability, making it a promising alternative in the printing industry.

2. Materials and Methods

2.1 Materials

The 60X59 plain woven scoured and bleached fabric 100% cotton cambric fabric (164 g/m²) was used for study. Both warp and weft yarns were of 20s count.

For disperse dye printing the 73x66 plain woven scoured and bleached 100% polyester fabric (169 g/m²) was used for the study. Both warp and weft yarns were of 30 deniers.

The chemicals, namely sodium alginate, gum indalca, urea, trisodium phosphate, resist salt, sodium bicarbonate, sodium chlorate, and tartaric acid of LR grade, manufactured by Merck (I) Ltd., were used for the preparation of the printing paste. Reactive and disperse dyes used were Coractive Red P4B and Coralene Dark Red 2B from Colourtex, respectively, and the direct dye Direct Red 111 from Prima Chemicals, Gujarat.

2.2 Methods

Flaxseed Gel Extraction

To prepare the flaxseed gel at concentrations of 12%, 14%, 16%, 18%, and 20%, begin by weighing the whole flaxseeds and water according to the required concentration. Start boiling the mixture and continue boiling for 10-15 minutes until it turns into a gel-like solution. Use a nylon mesh to strain the mixture, separating the seeds from the gel. Allow the gel to cool before using it for further processing. Viscosity was checked on LABMAN digital viscometer model LMDV-200.

Modification of Extracted Gel and Metal oxide Addition
Incorporating acrylation into flaxseed gel offers several

enhancements, notably improved stability under varying conditions such as temperature, pH, and exposure to light and air. These modifications provide structural reinforcement and prevent degradation, ensuring the gel's integrity. Additionally, metal oxides impart new functionalities like UV protection, antimicrobial activity, and moisture retention. They also enhance the gel's texture and rheological properties, improving viscosity, elasticity, and spread ability, which enhances user experience and application methods. Furthermore, the antimicrobial properties of metal oxides and acrylation extend the shelf life of flaxseed gel by inhibiting microbial growth, making it more suitable for long-term storage.

The extraction of flaxseed gel begins by boiling flaxseeds in water, which releases mucilage that forms a gel-like substance. This gel is separated from the seeds through filtration or centrifugation. The preparation of an acrylation solution involves dissolving acrylic monomers, such as acrylic acid, in a solvent. These monomers, containing reactive double bonds (C=C), can undergo addition reactions with functional groups in the flaxseed gel. During the acrylation reaction, the flaxseed gel is mixed or immersed in the acrylation solution. Under appropriate conditions, such as elevated temperature and the presence of a catalyst or initiator like potassium persulfate, the acrylic monomer reacts with functional groups (e.g., hydroxyl groups) in the gel, resulting in the covalent attachment of acrylic groups to the polymer backbone. After the acrylation reaction, the acrylated flaxseed gel is purified to remove unreacted monomers, catalysts, and byproducts through methods like washing, filtration, or precipitation. The purified acrylated flaxseed gel is then isolated for further characterization and use.

Printing Trials

Printing was carried out on cotton using direct and reactive dyes, and on polyester fabric using disperse dye. This was done by using a conventional thickener (Gum Indalca/Sodium Alginate), unmodified flaxseed thickener, and modified flaxseed thickener. The printing recipe ingredients are shown in Table 1, Table 2, and Table 3 for direct dye, reactive dye, and disperse dye, respectively.

Table 1 - Direct dye print paste formulation

Ingredients	Quantity in parts			
	Conventional	Unmodified	Formulated	Modified
Direct Red 111	1	1	1	1
Urea	2	2	2	2
Trisodium Phosphate	3	3	3	3
Water	5	5	5	5
Gum Indalca	89	-	-	-
Flaxseed gel Thickener	-	89	85	-
TiO ₂	-	-	4	-
Flaxseed gel Thickener (Acrylated)	-	-	-	89
Total	100	100	100	100

All samples were printed with print paste under neutral conditions. Then, it was dried after printing at temperatures below 80°C. Next, the fabric was steamed at 102°C for 1 hour. After steaming, the fabric was treated with 3 g/L cationic dye fixing agent at room temperature for 20 minutes. This was followed by a cold wash, and finally, the fabric was dried.

Table 2 - Reactive dye print paste formulation

Ingredients	Quantity in Parts			
	Conventional	Unmodified	Formulated	Modified
Coractive Red P4B	1	1	1	1
Urea	2	2	2	2
Resist Salt	1	1	1	1
Sodium Bicarbonate	3	3	3	3
Water	5	5	5	5
Sodium Alginate	88	-	-	-
Flaxseed gel Thickener	-	88	84	-
TiO ₂	-	-	4	-
Flaxseed gel Thickener (Acrylated)	-	-	-	88
Total	100	100	100	100

All samples were printed with print paste under neutral conditions. After drying, the fabric was steamed at 105°C for 1 hour. After steaming, the fabric was washed with hot water, then treated with 2 g/L soap at boiling temperature for 20 minutes. This was followed by a hot wash and a cold wash. Finally, the fabric was dried.

Table 3 - Disperse dye print paste formulation

Ingredients	Quantity in Parts			
	Conventional	Unmodified	Formulated	Modified
Coralene Dark Red 2B	1	1	1	1
Sodium Chlorate	1	1	1	1
Tartaric Acid	1	1	1	1
Water	5	5	5	5
Sodium Alginate	92	-	-	-
Flaxseed gel Thickener	-	92	88	-
TiO ₂	-	-	4	-
Flaxseed gel Thickener (Acrylated)	-	-	-	92
Total	100	100	100	100

All samples were printed with print paste under neutral conditions. After drying, the fabric was steamed at 130°C for 20 minutes. After steaming, the fabric was washed with hot water, then treated with 2 g/L caustic and 2 g/L Sodium

dithionite at 60°C temperature for 20 minutes. This was followed by a hot wash and a cold wash. Finally, the fabric was dried.

2.3 Testing and Analysis

The viscosity of the extracted gel at different concentrations was checked, and the viscosity of modified acrylated thickeners was also checked using a LABMAN digital viscometer, model LMDV-200. The keeping property of unmodified and modified thickening agents is also checked by change in viscosity.

Washing fastness of cotton and polyester fabric printed by using modified and unmodified thickening agent was determined by IS 13036 (1991).

The color strength difference of cotton and polyester fabrics printed using modified and unmodified thickening agents was determined on X-Rite color matching system CI42 UV spectrophotometer, employing the CIE formula, with a D65 light source and a 10° observer.

3. Result and Discussion

A shown in Fig.1a line graph is plotted and viscosity is measure on digital viscometer (Fig.1b) to understand the viscosity behavior of flax-seed gel against its concentration. The study also examines whether the viscosity of the gel decreases after stirring compared to before stirring.

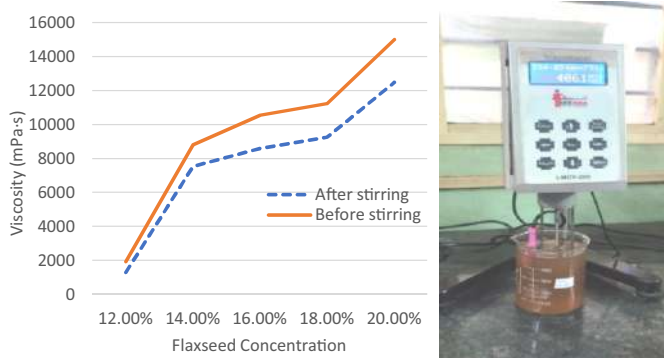


Figure 1 - a) Effect of concentration of flex seed on viscosity b) Digital viscometer

The viscosity increases as the concentration of flaxseed gel increases. It is observed that the viscosity drops to some extent after stirring the flaxseed gel. An 18% concentration of thickener is used for all trials, as it is deemed suitable for the printing paste.

Table 4 - Colour strength Direct, Reactive and Disperse printed samples by using various thickener

Thickener	Strength in %		
	Direct	Reactive	Disperse
Gum indalca	100	-	100
Sodium Alginate	-	100	-
Unmodified flaxseed	62.74	80.09	97.12
ZnO modified	70.87	89.50	155.66
TiO ₂ Modified	61.04	55.20	147.02
Acrylated Modified	140.76	140.27	249.92

Table 5 - Washing fastness rating of Direct, Reactive and Disperse printed samples by using various thickener

Thickener	Direct			Reactive			Disperse		
	1 st Adjacent Fabric	2 nd Adjacent Fabric	Colour Difference	1 st Adjacent Fabric	2 nd Adjacent Fabric	Colour Difference	1 st Adjacent Fabric	2 nd Adjacent Fabric	Colour Difference
Gum indalca	5	5	4-5	-	-	-	5	5	4-5
Sodium Alginate	-	-	-	5	5	4-5	-	-	-
Unmodified flaxseed	4	4	4-5	4	4	3-4	4	4	3-4
ZnO Modified	4	4	5	4	4	3	4	4	4-5
TiO2 Modified	4	4	5	4	4	4-5	4	4	3-4
Acrylation Modified	5	5	3-4	5	5	4	5	5	4

Experiments were conducted using 1% Direct dye, 1% Reactive dye, and 1% Disperse dye, following the procedures and recipes mentioned in Tables 1, 2, and 3. When comparing the results to the standard thickeners for direct dye, Gum Indalca and Sodium alginate, both set at 100% as shown in Table 4 and Fig.2-4, it was observed that the acrylation modification yielded superior results across all dye types. Specifically, acrylation showed a 40.76% increase in color strength for Direct dye, a 40.27% increase for Reactive dye, and a 49.22% increase for Disperse dye. This improvement is likely due to the acrylation process producing a homogeneous mixture, which enhances dye dissolution and provides more stability to the flaxseed gel. The ZnO/TiO2 modification also gave good results, with approximately a 50% increase in color strength for Disperse dye. However, the TiO2 modification resulted in significantly poorer performance for both Direct and Reactive dyes, with decreases in color strength of 38.96% and 44.8% respectively, likely due to the fine particle size of ZnO and TiO2 clogging the screen. Additionally, the unmodified flaxseed thickener performed 2.88% worse than the standard for Disperse dye and showed a 10% decrease in color strength for Reactive dye, likely because it does not form a homogeneous mixture, hindering its ability to pass through the screen properly. The other modifications fell between the results of the acrylation and TiO2 modifications.

As shown in Table 5, the color fastness to washing was evaluated by ISO 105 test method and experiments for direct dye, reactive dye, and disperse dye printed samples involved

using adjacent fabrics: Cotton and Wool for direct and reactive dyes, and Polyester and Cotton for disperse dye. Ratings were conducted using the grey scale, assessing color difference for the original samples and color staining for adjacent fabrics. For direct dyes, both Cotton and Wool adjacent fabrics exhibited excellent color staining ratings with Gum Indalca and acrylation modifications, attributed to enhanced viscosity and stability of the printing paste. The unmodified flaxseed, ZnO, and TiO2 modifications showed good color staining ratings. Additionally, the color difference of printed Cotton received excellent ratings for ZnO and TiO2 modifications, and good to excellent ratings for Gum Indalca and acrylation modifications, indicating improved paste homogeneity. For reactive dyes, Cotton and Wool fabrics similarly showed excellent color staining with sodium alginate and acrylation modifications, while unmodified flaxseed exhibited good ratings. The ZnO and TiO2 modifications also showed good performance. The color difference ratings for Cotton were good to excellent with sodium alginate and TiO2, and average to good with acrylation and unmodified flaxseed. In disperse dyes, Polyester and Cotton fabrics displayed excellent color staining ratings with Gum Indalca and acrylation modifications, and good ratings with unmodified flaxseed, ZnO, and TiO2 modifications. The color difference ratings for printed Disperse dye were good to excellent with Gum Indalca and ZnO modifications, good with acrylation, and average to good with unmodified flaxseed and TiO2 modifications.

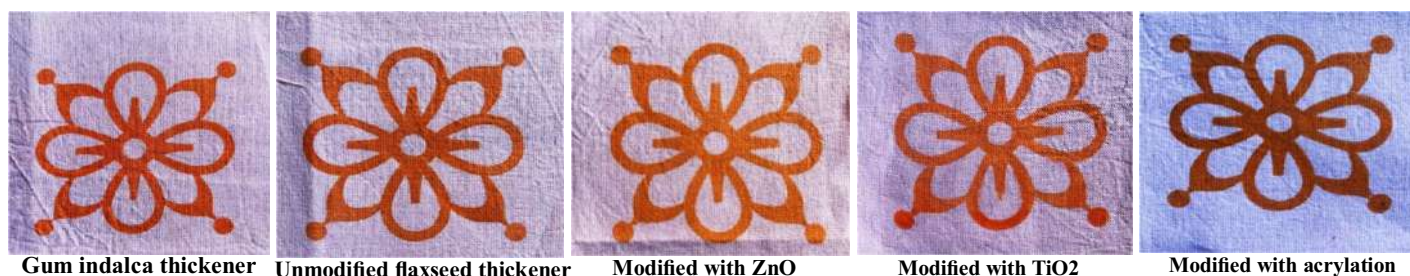
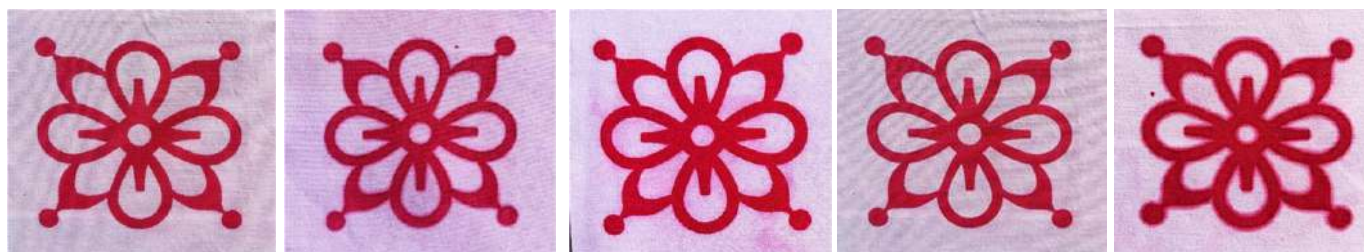


Figure 2 - Printed Samples of Direct Red111



Sodium alginate Thickener Unmodified flaxseed thickener Modified with ZnO Modified with acrylation Modified with TiO2

Figure 3 - Printed Samples of Coractive Red P4B



Gum indalca thickener Unmodified flaxseed thickener Modified with ZnO Modified with TiO2 Modified with Acrylation

Figure 4 - Printed Samples of Coralene Dark Red 2B

4. Conclusions

Based on the findings from Direct, Reactive, and Disperse dye printing processes, acrylated modified thickeners consistently demonstrate superior performance in terms of color strength and color fastness to washing compared to their counterparts such as ZnO and TiO₂ modified thickeners, as well as gum indalca thickeners. Specifically,

acrylated modified thickeners show remarkable results with a 140.27% increase in color strength in Reactive dye printing and excellent performance across all dye types. These findings underscore the potential of acrylation-modified thickeners as a versatile and sustainable choice for enhancing dyeing processes, promising significant advancements in textile printing technology.

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Indian Silk Industry Overview: Identifying Consumer Concerns

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Abstract:

Background: *The Indian silk industry has been booming worldwide, creating a mark for itself. India is home to some of the most exotic and wide-ranging silks globally. It occupies a distinctive position in the textile industry of India as it plays a significant role by contributing almost 15% of the world's total raw silk production and is also a dominant contributor to the textile exports from India. The silk industry also plays a significant role in elevating the rural economy of India. India happens to be the largest consumer of silk goods, mainly influenced by traditional clothing practices.*

Methods: *The present paper studies in depth the silk demographics of India. It keenly tracks the silk industry production, imports and exports and its future projections. In an attempt to understand the current consumer behaviour in relation to silk textiles, a survey has been conducted on 200 women aged between 20-60 years.*

Results and Discussion: *The results have been discussed to bring to light the critical consumer concern areas that the stakeholders in the silk industry need to focus on to strengthen their foothold further. The results of the survey highlight that many consumers do not use silk due to the expensive maintenance it requires such as drycleaning. Various other consumer patterns and concerns have come to light through the survey. The Indian silk industry is passing through a crucial phase of reorientation and adjustment necessitated by the market forces. The use of silk is becoming increasingly prevalent in the upcoming sectors such as home textiles and other technical textiles.*

Keywords: *consumer, export, import, India, silk*

Citation: Ruchira Agarwal, Deepali Rastogi, "Indian Silk Industry Overview: Identifying Consumer Concerns", *Journal of the Textile Association*, **86/6** (March-April, 2026), 627-633, <https://doi.org/10.5281/zenodo.20556507>

Article History : Received :08-03-2025, Revised: 30-04-2026, Accepted: 05-05-2026

1. Introduction

Silk holds an unchallenged position as a mark of beauty and luxury, and is aptly known as the "Queen of Textiles". Its pleasing lustre, excellent drapability and comfort make it a sought-after fibre. To add to this are its properties of strength, flexibility, softness, and absorbency along with high wearer comfort. Silk is breathable and its isothermal properties make it cool in summers and warm in winters. Silk fibre's outstanding properties rival the most advanced synthetic polymers [1]. Thus, it can be said that silk is a remarkable material that has played a significant role in human history and continues to be valued for its many qualities today [2]. Silk has been known for its use in clothing for a long time, but more recently, it has become a contender for use in non-apparel products as well. This is partly because of its remarkable mechanical properties, as well as its ability to be both biocompatible and biodegradable.

Even though silk makes up a small percentage of the global textile market, i.e. less than 0.2%, its production base is spread over 60 countries in the world, the major producers being in Asia (95% of mulberry production and almost 100% of non-mulberry silk). The major silk-producing countries in the world are; China, India, Uzbekistan, Brazil, Japan,

Republic of Korea, Thailand, Vietnam, DPR Korea, Iran, etc. A few other countries are also engaged in the production of cocoons and raw silk in negligible quantities; Kenya, Botswana, Nigeria, Zambia, Zimbabwe, Bangladesh, Colombia, Egypt, Japan, Nepal, Bulgaria, Turkey, Uganda, Malaysia, Romania, Bolivia, etc. [5].

The European Union (EU) and the United States are the biggest consumers of silk outside the silk-producing countries of Asia. USA imports the largest quantities of silk textile and clothes. Japan is the country with the highest consumption of silk per capita. France, Germany, Italy, Switzerland and the United Kingdom are also leading silk consumers. Italy is the world's largest importer of waste silk which is spun into yarn for the production of knitwear [2].

1.1 Indian Silk Industry

The Indian silk industry has been successful worldwide in creating a mark for itself. It occupies a distinctive position in the textile industry of India as it plays a significant role by contributing almost 15% of the world's total raw silk production and also is a dominant contributor to the textile exports from India (Yaseen, 2013.) The added advantage is that sericulture is a labour-intensive, agriculture-based industry and thus, it plays a significant role in elevating the rural economy of India. Statistics reveal that India is the 2nd largest producer of raw silk in the world and produces raw

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silk to the tune of over 32,000 metric tonnes out of the global 1,75,000 metric tonne production (approximate values), next only to China which produces an enormous 80% share of the world production.

India also happens to be the largest consumer of silk goods, mainly influenced by the traditional clothing practices. This has also driven India to a position where the gap between the demand and supply of silk is filled by a large quantum of exports, majorly from China [3].

The current shift in the Indian population demographic structure, which leans towards professionally engaged women and a marked influence of the Western world on fashion choices, has resulted in a decrease in the use of silk clothing by Indians. The Indian silk industry is experiencing a critical phase of reorientation and adjustment necessitated by the market forces. The use of silk is becoming increasingly prevalent in the upcoming sectors such as home textiles and medical textiles (Technical textiles).

1.2 History

Silk has been produced in India from pre-Vedic times. India was strategically situated on the famous Silk Route, which stretched across Asia from China to the Mediterranean. Indian caravans laden with luxury goods like spices and indigo traded for silk from China. The Chinese have been known to keep the practice of sericulture a very closely guarded secret. It is popularly believed that a Buddhist monk smuggled the eggs of the silkworm into India, from where sericulture was established in India [4].

Fascinated by the elegance, princely rulers like Tipu Sultan of Mysore propagated and encouraged the cultivation of silk in India. Mughal emperors were also very fond of silk clothes and patronised the industry in Bengal and Kashmir. The British administration in India accorded top priority to silk cultivation in India, especially the Bengal region for the manufacture of parachutes. The first silk textile mill, on modern lines, was started by the East India Company at Haora in 1832. Later on, new factories also started in Karnataka (in 1845) and Kashmir (1892). The industry suffered a setback between 1875 and 1915 due to the occurrence of the perinea disease and the loss of the raw silk crop. However, it got boosted after tariff protection was granted in 1934. In the post-independent era, the Government of India identified the silk industry as an employment-oriented industry, suitable for the development of rural India. After independence, there has been a significant increase in the production of silk textiles in the country [4].

2. Methods and Materials

Extensive research was required to understand the Indian silk industry and its consumers to comprehend the silk industry's current situation. Phase one of the study involved conducting a thorough review of the industry's current status through accessible secondary sources. The second phase was to understand consumer behaviour towards the consumption of

silk textiles and their concerns with using silk. A thorough literature study was done in phase one. The data was tallied, sorted, and structured before being presented in the results and discussion section. To better understand consumer behaviour and patterns, a survey of 200 women aged between 20-60 years, residing in the Urban NCR region and belonging to middle and high-income groups was undertaken in phase two. A convenience sampling plan was employed and a google form was used for online data collection. The following section discusses the same study's findings.

3. Results and discussion

Silk is an integral part of Indian cultural clothing. Its use is not restricted to the fashion-conscious but is also deeply integrated into India's traditional clothing practices. Various parts of the country are centres of silk production, practising silkworm rearing, yarn production, fabric weaving and fabric finishing, including dyeing. Reports suggest that over sixty lakh people are directly involved in sericulture activities. The employment potential of this industry is immense, with a large section dedicated to rural employment. Statistical data reveals that sericulture generates substantial employment amounting to 11 man-days per kg of raw silk produced almost every year. Of the total revenue generated, 57 percent flows back to the cocoon growers in the rural areas; thus, a large share of income goes back to the villages from the cities. Hence, sericulture can also be seen as a tool for redevelopment reconstruction of rural areas.

3.1 Indian Silk Demographics

India is known for some of the most exquisite and wide-ranging varieties of silks in the world. It is the only country in the world to produce all five varieties of silk i.e. Mulberry, Tassar, Muga, and Eri. In fact, India holds a position of being the only country producing the non-mulberry, wild varieties of silk. The Indian silk market has a strong cultural holding and is to a large extent bound by traditions. Silk has been intermingled with the life and culture of the Indians. The below figure (Figure 1) depicts the relative production quantities of Mulberry, Tassar, Eri and Muga silks in India I between 2015-2021 (The figures for the past three years remain unavailable). From the Central silk board data for 2020-21. It is evident from the Central silk board data for 2020-21 that Mulberry silk makes up over 70% of the total silk produced in 2020-21. Of the remaining, 20% is Eri silk, 8% is tussar and a minimal quantity of muga silk. [4].

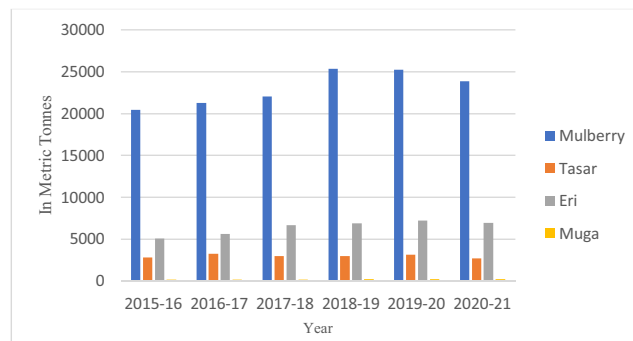


Figure 1: Domestic Raw Silk Production in India over Six Years

High fashion fabrics from classic dupion and taffeta silk to fine fabrics such as organza, crepe, georgette, chiffon have not only high domestic demand but also are sought after by international fashion designers across the globe. The Indian silk industry is very adaptable to the colours, weave patterns, prints, embroideries and appliqué work. It can be conveniently tailor-made to the designers' specifications, allowing the exporter to supply small quantities and endless varieties.

Silk production spans across the entire Indian subcontinent. Certain parts of the country undertake sericulture and also yarn and fabric production, whereas other centres are not involved in silk fibre production but are established centres for silk processing and weaving. Each silk producing centre is known for its uniqueness in patterns and designs. Traditional methods and modern techniques of production co-exist, resulting in a vast array of silk fabrics that find a unique place in the world. The varieties of fabrics produced by the silk handloom sector have a distinct character and individuality. There are various identified silk production centres. The map below (Figure 2) indicates the silk centres of India.

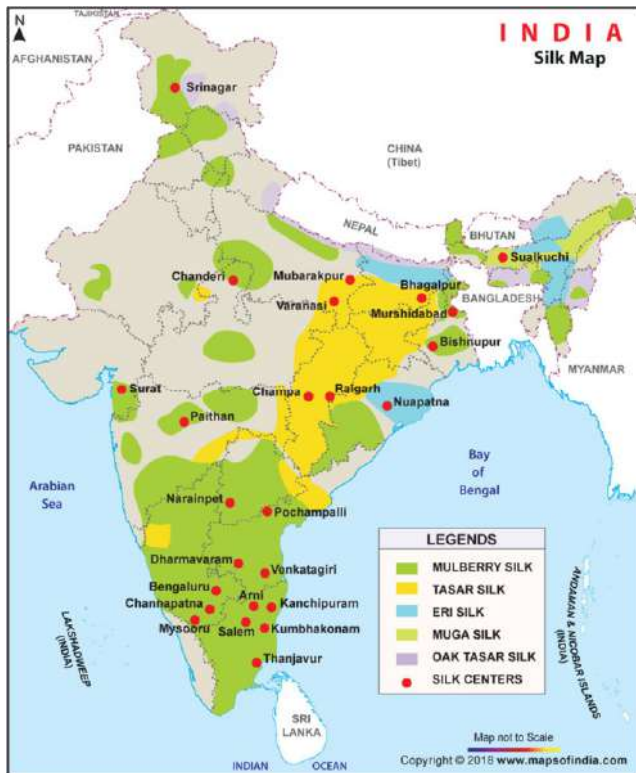


Figure 2 : Silk Centres in India

The above map indicates that mulberry silk is primarily produced in Karnataka, Andhra Pradesh, Tamil Nadu, Jammu & Kashmir and West Bengal. The non-mulberry silks are produced in Jharkhand, Chattisgarh, Orissa and the north-eastern states. Karnataka contributes about 85% of the country's production by rearing multivoltine hybrids of a silkworm. This activity results in five to six crops a year. Due to their suitable climate, Jammu and Kashmir produce silk by

rearing univoltine silkworms. Other states, namely, Andhra Pradesh, Assam, Tamil Nadu, Uttar Pradesh, Himachal Pradesh and Punjab, contribute roughly 1.8% to the total production of mulberry silk in India.

The tribes of Madhya Pradesh, Bihar, and Orissa traditionally rear tussar silkworms. These three states mainly contribute to the production of tussar silk in the country. The recent rearing of *Antherea royeli* & *Antherea pernyi* has enabled the country to produce the oak tussar silk in the sub-Himalayan belt and Manipur. Muga silk is grown exclusively in Assam, producing 90% of Muga silk in the country [1].

The state wise distribution of raw silk production as per the latest available statistics in the Central Silk Board 38th annual report 2020-21 is depicted in the following graph (Figure 3) [3].

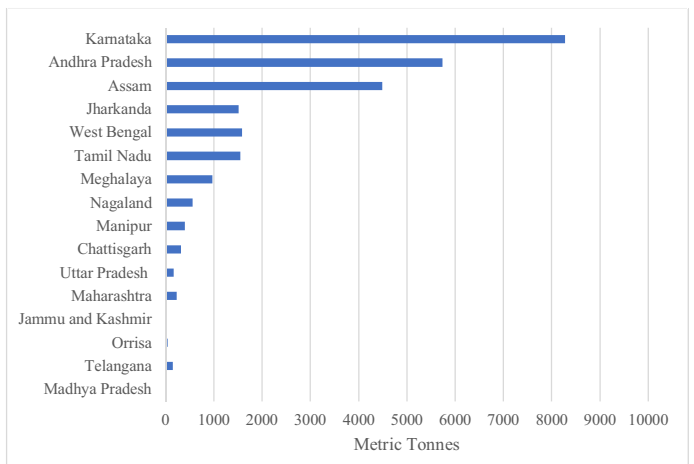


Figure 3: State wise raw silk production

Figure 4 below depicts the volume of raw silk produced in India in metric tonnes and demonstrates the gradual increase in production [5].

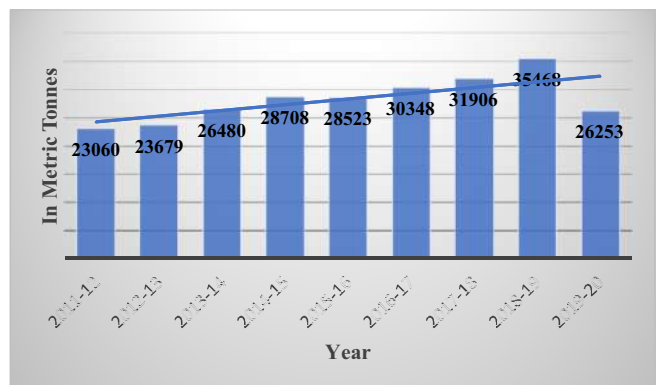


Figure 4 : Raw Silk Production in India

3.2 Indian Silk Exports and Imports

The silk exports from India are under the categories of raw silk, silk yarn, silk fabric, silk made-ups (including furnishing materials like curtains, bedspreads, cushion covers, shawls, scarves, carpets, etc.), readymade silk garments, silk waste, silk carpets and silk handloom

products. The market share of silk exports from India in the global silk industry is estimated at around 3-3.5%, as reported by The Indian Silk Export Promotion Council (as per the latest available data as of 2020); this figure is not too significant considering India is the second-largest producer of raw silk. This may be attributed to India itself being a large domestic market for silk goods, and about 85% of silk goods produced are sold in the domestic market. However, India exports approximately 15% of its output of all types of silk goods (including value-added items). [6].

The export of silk and silk products from India are depicted Figure 5. The figure depicts an declining trend in the exports of silk [7].

As per the latest available data of 2020-21, top 10 importing countries and the value of their imports from India have been tabulated in Table 1 [8].

Table 1 : Top 10 countries importing silk from India

Sr. No.	Country	Value (in million USD)
1.	USA	76.87
2.	UAE	26.56
3.	China	20.18
4.	UK	10.92
5.	Australia	10.25
6.	Germany	8.92
7.	France	7.86
8.	Italy	6.38
9.	Spain	4.75
10.	Malaysia	4.37

Reports suggest that readymade silk garments are the largest segment generating around 35% of silk export earnings in 2020-21. Handloom silk products also contributed a substantial 27.7 %, and natural silk yarn, fabrics, and made-ups comprised 21 % of silk export earnings. Silk waste silk carpet comprised 7.6 per cent and 8.8 per cent, respectively.

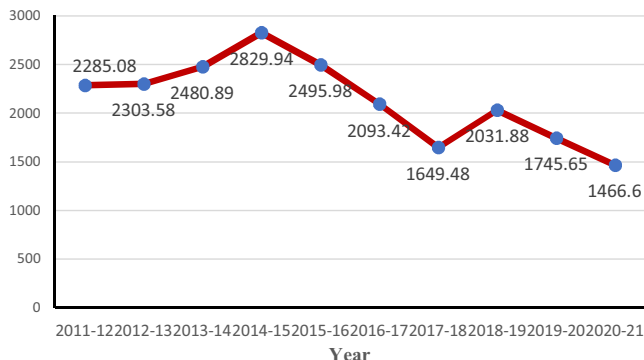


Figure 5 : Export of Silk and Silk goods [9]

A significant value of silk is also imported by India, majorly from China, though this figure has been on the decline in the recent past. The import data is depicted in Figure 6 [9]

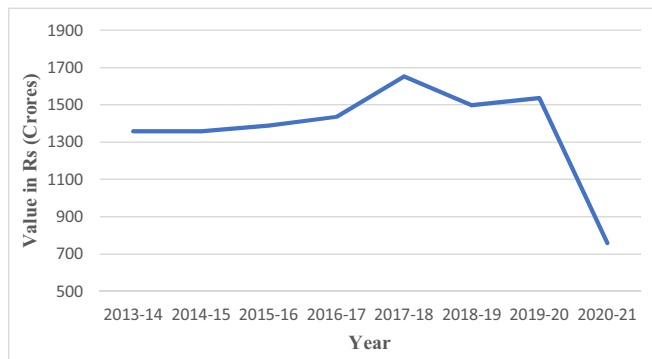


Figure 6 : Import of Silk and Silk Goods [6]

3.3 Consumer Perception and Concerns towards Silk Products

Phase two was conducted to understand the experiences and perceptions of Indian women consumers regarding the usage, care and maintenance of silk products. A survey was conducted on 200 women in the urban NCR region to understand consumer behaviour concerning silk textiles. This survey was carried out to determine the current prevalence of silk-made articles in an urban Indian household and identify the areas of concern for the care and maintenance of silk. This survey was conducted via a questionnaire comprising open-ended and closed-ended questions administered remotely via an online platform. The obtained responses were tabulated and analysed and have been graphically presented. The respondents were in the age bracket of 20-60 years. For analysis, the respondents were categorised into the following age brackets; 20-40 years and 41-60 years. The salient findings for the analysis of the responses were as follows: 54% of the respondents were from the age group of 20-40 years, while 46% belonged to the 41-60 years category.

As per Figure 7, out of the total respondents, most consumers used silk for women's apparel such as sarees, blouses, kurtas and dupattas. 92% of respondents in the age bracket of 41-60 years use silk sarees, and a lower but significant number (75%) of women in the 20-40 years bracket also used silk sarees. The use of silk in the Indian traditional garment, i.e. a saree, has been a major contributor to the success of the silk industry in India. Along with the saree, the saree blouse is also seen to be widely used by consumers. Like the saree, its use in the older age category is more prominent. 57% of women of the younger age group were seen to be using silk blouses, whereas this figure is 79% for the women in the age bracket of 41-60 years. Women's kurtas in silk are almost as popular as the saree. 82% (20-40 years) - 90% (41-60 years) of respondents wear kurtas made with silk. The use of silk dupattas is also seen to be very prevalent in both age groups. Women's lower garments like the salwar and churidar are not as popular as the upper garments like the kurta or the saree and the blouse. Their use is seen to be low in both age categories. Only around 35% of women in the 20-40 years bracket and 49% in the 41-60 years reported using churidars or salwars made of silk. Women respondents were also

asked about the purchase and use of silk kurta-pyjama by male members of their families. A larger section (43%) of women in the older age group and 26% of the younger age bracket reported the use of silk men's kurta-pyjama. This is seen as a considerable section of men consumers who are contributing to the consumption of silk. Home furnishing is also seen as a promising sector for the consumption of silk. A sizeable section of women consumers, 46% in the 41-60 age group and 36% in the age group of 20-40 years, are seen to be using home furnishings made with silk. The responses suggest that silk is still integral to the Indian wardrobe. Its use is more prominent in traditional clothing such as saree, kurtas, dupattas etc., and its use in non-traditional dress such as women's tops, shirts and trousers is also prevalent. Home furnishings are also seen as a relevant and upcoming category of silk textiles.

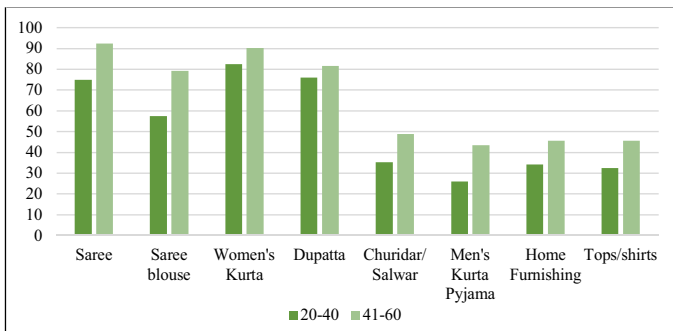


Figure 7 : Percentage of Women Respondents in Different Age Groups Using Various Categories of Silk Articles

It was established that silk finds a place in the modern Indian wardrobe, but the extent of its use by consumers is of concern as that determines the industry size. It was considered relevant to find out whether silk was a fabric for everyday use or only reserved for occasional use. As depicted in Figure 8, as many as 70% of consumers in the age bracket of 41-60 years and 74% in the 20-40 years bracket did not use silk for everyday apparel and home textiles and reserved it for only occasional or festive wear. It may also be noted that consumers of both age groups were almost equally disinclined to use silk as everyday articles

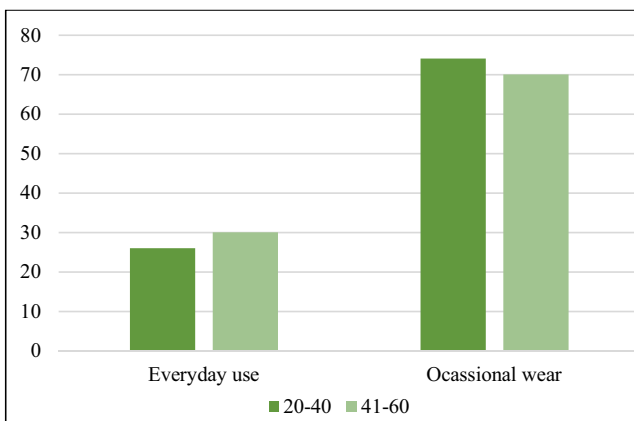


Figure 8 : Percentage of Women Respondents in Different Age Groups Using Silk for Everyday Use or Occasional Wear

The responses to the reasons consumers did not use silk for everyday and casual use are depicted in Figure 9.

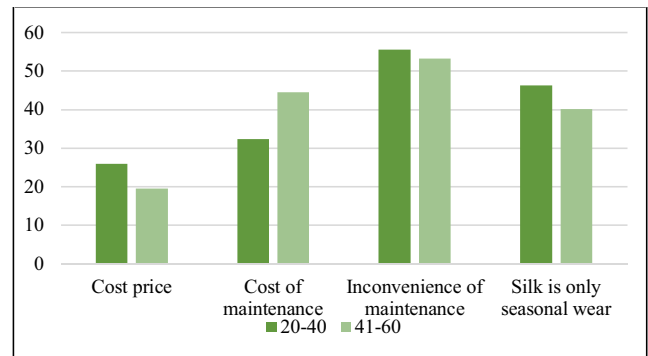


Figure 9 : Percentage of Women Respondents in Different Age Groups Citing Various Factors as Deterrents to Everyday Use of Silk

The most highlighted reason cited for limited preference for silk in everyday use was that maintenance of silk was inconvenient, followed by the seasonal usability of silk. 45% of respondents in the age category of 41-60 years and 32% of the 21-40 mentioned the cost of maintenance as the deterrent to using silk articles more frequently. The inconvenience, coupled with the cost of maintenance, are seen to be major limitations in the use of silk textiles. This, along with the fact that silk is considered seasonal wear, greatly impacts the extent of the use of silk by consumers. Though it is considerably more expensive than the other common-use fibres, only 20% (41-60 years) and 26% (20-40 years) of respondents reported that as the reason for limited usage. The response to this question revealed that the primary reason for the lesser adoption of silk textiles is the inconvenience and recurring cost of their care and maintenance. If the care and maintenance of silk fabrics could be made more convenient for consumers in these terms, their usage may probably be enhanced.

The respondents were also asked about the preferred practices of cleaning and maintenance of silk articles. Figure 10 graphically represents the responses obtained.

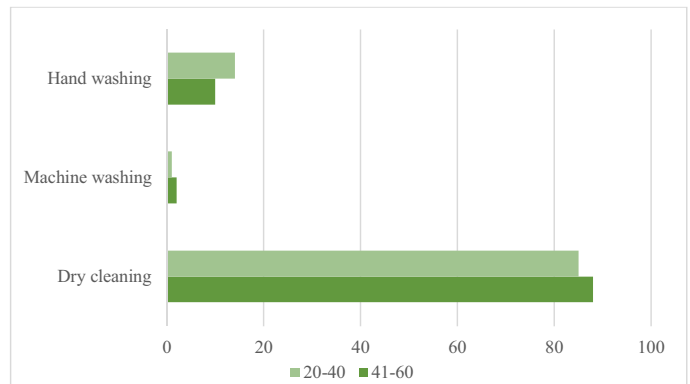


Figure 10 : Percentage of Women Respondents in Different Age Groups Preferring Various Laundry Practices for Silk

The responses to this question strongly indicated that a very large section of consumers in both age categories preferred to dry clean silk. The age of the respondents did not affect the preferred choice of laundering silk textiles. Responses indicate that a large segment of the respondents (85%) preferred professional dry-cleaning of silk items. In contrast, very few adopted hand washing, and only 2 women in each age category machine-washed their silk articles. This trend probably is the reason consumers find care and maintenance inconvenient and thus limit its use to occasional wear. The need to dry-clean is a significant deterrent in the popularity of silk as it escalates maintenance costs, damages the ecosystem, and adds to inconvenience.

A need was felt to identify why consumers favour dry-cleaning silk instead of home laundering. The respondents who attempted home laundering of silks were inquired about their problems faced when silks are washed at. The responses have been depicted graphically in Figure 11.

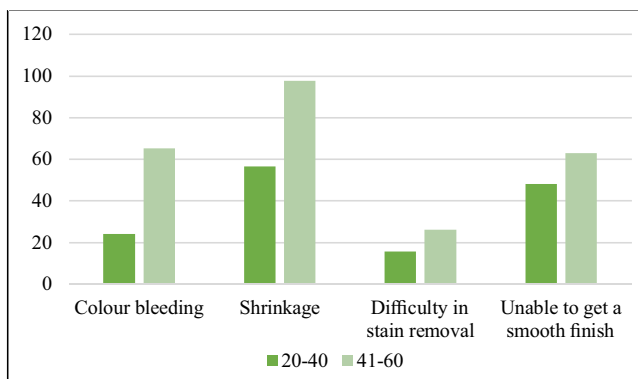


Figure 11 : Percentage of Women Respondents in Different Age Groups Facing Various Concerns in Home Laundering of Silk

Results indicated (Figure 11) brings out that more percentage of respondents in the older age group (41-60) have cited problems in the home laundering of silk. This may be because the women in this age group either use more silk textiles or undertake more hand washing of silk and thus are more aware of the challenges faced. Respondents indicated that colour bleeding, shrinkage, difficulty in stain removal, and the inability to get a perfectly ironed finish were the primary reasons consumers preferred dry-cleaning over home laundering. Shrinkage was reported by 98% of the women in the older age group, whereas only 56% of respondents in the age category of 20-40 years reported problems of shrinkage. Though shrinkage is not a common phenomenon in silk, consumers may have experienced this with silk blend fabrics. A large portion of the women (65%) in the 41-60 years category also reported the problem of colour bleeding, whereas only 24% of the younger age group identified this as a problem with the home washing of silk. It is felt that this discrepancy may be because not many users in the young age category undertake home laundering of silk or use fewer silk articles. Most women expressed dissatisfaction regarding the inability to get a smooth finish by ironing at home after washing. Once again, the percentage

of women reporting this was higher in the 41-60 years group (63%) as compared to the 20-40 years group (48%). A relatively lesser percentage of women also pointed out the difficulty in stain removal from silk articles.

Those respondents who only sent out silk articles for dry-cleaning were asked for reasons for inhibition in the home laundering of silk. The responses have been presented in Figure 12. The responses indicate that the most cited reasons consumers prefer dry-cleaning. Here again, a much larger percentage of respondents from the 41-60 years category have identified the shortcomings that demand the dry cleaning of silks. The reason most highlighted here is the fear of colour loss from the silk textile and the staining of adjacent areas. The largest percentage of respondents, i.e., 65% (41-60 years) and 44% (20-40 years), identified colour bleeding as the problem that requires them to get dry cleaning of silk instead of home laundering. A significant number of respondents also felt silk garments or other products lose their shine and lustre if washed at home. This concern was also related to the colour or dye quality of silk fabrics. Many respondents in the 41-60 and 20-40 year age categories (46% and 37%, respectively) had the perception that silk is weak and thus unsuitable for home laundering. This is a myth, as silk fibre is known for its good tensile strength. A common reason, also cited by a large number of respondents, is the tendency to shrink, either of the fabric shell or of the cotton lining usually used in silk made-ups.

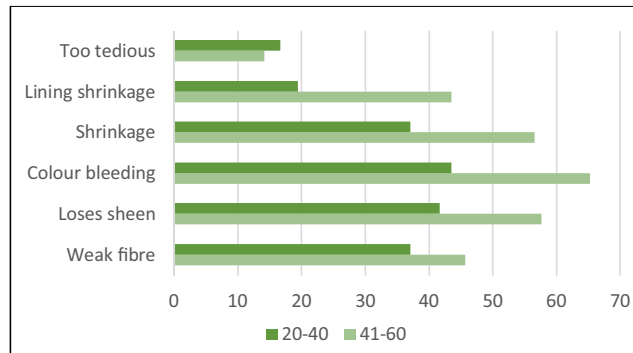


Figure 12: Percentage of Women Respondents in Different Age Groups Citing Various Reasons for Choosing Dry Cleaning of Silk Articles

4. Conclusion

India has been producing silk since the Pre-Vedic era. The Indian subcontinent is well known for its prominent position in the world silk map. The Indian silk industry comprises of silk production including sericulture, yarn production, fabric manufacturing, finishing as well as product development. The silk industry spans across the country and is also a major contributor to the rural economy. Traditional and contemporary methods of production coexist to produce a wide variety of silk fabrics with distinct uses throughout the world. India significantly exports several silk products and at the same time also has a large domestic consumption of silk, particularly owing to our traditional clothing practices. The domestic consumption of silk is primarily comprised of

sarees, blouses, kurtas, dupattas, and other clothing items. Recent times have seen the expansion of the use of silk in the home textiles sector too. The present study focuses on identifying the current status of the industry and understanding consumer concerns about the use of silk products. The findings can be of use in strengthening the position of the silk industry in India. Results indicated that one crucial factor that seems to influence the diminishing use of silk is the consumers' experience that silk requires expensive care and maintenance. Most consumers resort to professional dry-cleaning of silk, which is not only inconvenient and costly but is also essentially

environmentally toxic. One of the main reasons for not being able to launder silk at home was reported to be its tendency to bleed colour and loose sheen. Interestingly, people perceive shrinkage as a problem in silk home laundering. This could actually be due to the shrinkage of cotton lining in most of the silk garments, which is very common and leads to puckers and overall change in the size and fit of the garment. The findings are crucial in identifying the lacunae in the silk dyeing industry, which need to be addressed by proposing dyes and processes for silk colouration that would offer enhanced consumer satisfaction.

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Promotion of Energy Conservation Techniques in Textile processing Industry: A Case Study

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Abstract:

The importance of energy conservation awareness at home is relatively easy to understand, but its thorough implementation is usually delayed in the early stages of energy conservation awareness programs in factory. Therefore, for concrete implementation, it is desirable to develop company-wide coordination measures similar to QC activities in factories. In addition, in order to promote energy-saving measures efficiently, we have identified key areas in which common Energy Savings are achieved through our Experience in Energy Auditing of about 100+ Textile Process house in South Gujarat Region.

Energy conservation is a significant step to overcoming the vital problem of the worldwide energy crisis. In particular, Sub continent countries i.e. India are interested to increase their awareness on the inefficient power generation and energy usage in their country. However, Data of energy use are limited for proper execution of energy conservation.

In developing countries energy saving and conservation technologies should be spread to all governments' organization as well as industrial owners and technocrats. It is essential that they gain practical knowledge of the presently available energy conservation technologies.

Due to high energy intensive industry i.e. textile sector, it is recommended to implements energy conservation technologies using modern energy saving techniques. For example regulating the temperature in the steam pipes, adjusting the air/fuel ratio in the boilers, and installing heat exchangers using warm waste water.

There are several ways to conserve or save energy in textile sector out of which most common suggestions in our Energy Audit will discussed in this paper.

Keywords: Energy conservation, Textile, Automation, Heat exchanger, Steam, Compressor.

Citation: Murtuza Z. Channiwala, Pankaj Gandhi, Bhavdeep Shah, Bharat H. Patel, "Promotion of Energy Conservation Techniques in Textile processing Industry: A Case Study", *Journal of the Textile Association*, 86/6 (March-April,2026), 634-640, <https://doi.org/10.5281/zenodo.20554243>

Article Received :01-01-2024, Revised: 19-04-2026, Accepted: 24-04-2026

1. Introduction

1.1 Most common energy conservation in textile processing; Energy audit case studies

1.1.1 Electrical Demand Control

Increase Contract demand: From bill analysis of last year it is observed that, at present Plant is running with 78 KW contract demand. Minimum billing demand 78 kW. Plant has average Actual MD 122 kW and Maximum MD is 141 kW in Month Oct 22. Billing demand is greater than Actual demand in all month & we have to pay penalty charges in each month for excess demand charges [1]. So, we proposed to increase contract demand to 99 KW than you will save Rs. 5,565/- per Month i.e. Rs. 66,780/- per year. So increase in demand should take consideration of future requirement/expansion of plant.

Detailed calculation shown as under:

Total Saving	=	Rs.66,780/-
Investment	=	Nil
Payback Period	=	Immediate

1.1.2 Reduction in Contract demand

From bill analysis of last year it is observed that, at present Plant is running with 350 KVA contract demand. Minimum billing demand 298 kVA. Plant has average Actual MD 202 kVA and Maximum MD is 277 kVA in Month Dec-21 with PF of 0.974. Billing demand is greater than Actual demand in all month. So, We proposed to reduce contract demand to 300 KVA than minimum billing demand will be 255 KVA then you will save Rs.7,600/- per Month i.e. Rs. 91,200/- per year. Once you reduce demand you cannot further reduces till 1 years. So reduction in demand should take consideration of future requirement/expansion of plant. Detailed calculation shown in table 2 as under.

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Table 1 - Present and future requirement/expansion of Electrical Demand in plant

Sr. No.	Month	Actual MD	DGVC L Unit Consumption	Bill amount	Rate Rs./unit	Fixed Charges	Energy Charges	Present Additional Fix Charges above 78 KW @ 265/KW	Proposed Additional Fix Charges above 99 KW @ 265/KW	Saving
1	Aug - 22	121	52569	441306.81	8.39	21105.0	241817.4	11395.0	5830.0	5565.0
2	Sep - 22	127	55635	467143.60	8.40	22695.0	255921.0	12985.0	7420.0	5565.0
3	Oct - 22	141	54193	459760.51	8.48	26405.0	249287.8	16695.0	11130.0	5565.0
4	Nov - 22	133	48196	409542.43	8.50	24285.0	221701.6	14575.0	9010.0	5565.0
5	Dec - 22	126	52015	444188.98	8.54	22430.0	239269.0	12720.0	7155.0	5565.0
6	Jan - 23	113	49638	426905.81	8.60	18985.0	228334.8	9275.0	3710.0	5565.0
7	Feb - 23	123	50175	436586.62	8.70	21635.0	230805.0	11925.0	6360.0	5565.0
8	Mar - 23	78	29819	255898.34	8.58	9710.0	137167.4	-	-	-
9	Apr - 23	114	46962	414206.67	8.82	19250.0	216025.2	9540.0	3975.0	5565.0
10	May - 23	119	30688	283327.11	9.23	20575.0	141164.8	10865.0	5300.0	5565.0
11	Jun - 23	129	46353	419262.47	9.04	23225.0	213223.8	13515.0	7950.0	5565.0
12	Jul - 23	134	43936	411510.11	9.37	24550.0	202105.6	14840.0	9275.0	5565.0
TOTAL		***	560179	4869639	***	254850	2576823	138330	77115	61215
AVERAGE		122	46682	405803	8.69	21238	214735	12575	7010	5565
Maximum		141	55635	467144	9.37	26405	255921	16695	11130	5565
Minimum		78	29819	255898	8.39	9710	137167	9275	3710	5565

Table 2 - Actual billing and Reduction in billing demand

Sr. No.	Present C.D. 350 KVA, 85 % = 298 KVA					Proposed C.D. 280 KVA, 85 % = 238 KVA		
	Month	Actual M.D.	P.F.	Billing M.D.	Demand Charges	Billing M.D.	Demand Charges	Saving in Demand Charges
1	Apr - 21	162	0.999	298	44700.0	238	35700.0	9000
2	May - 21	158	0.999	298	44700.0	238	35700.0	9000
3	Jun - 21	89	0.998	298	44700.0	238	35700.0	9000
4	Jul - 21	182	0.999	298	44700.0	238	35700.0	9000
5	Aug - 21	171	0.997	298	44700.0	238	35700.0	9000
6	Sep - 21	182	0.996	298	44700.0	238	35700.0	9000
7	Oct - 21	267	0.955	298	44700.0	267	40050.0	4650
8	Nov - 21	274	0.960	298	44700.0	274	41100.0	3600
9	Dec - 21	277	0.974	298	44700.0	277	41550.0	3150
10	Jan - 22	246	0.997	298	44700.0	246	36900.0	7800
11	Feb - 22	209	0.999	298	44700.0	238	35700.0	9000
12	Mar - 22	202	0.999	298	44700.0	238	35700.0	9000
TOTAL		2419	***	3576	536400	2968	445200	91200
AVERAGE		202	0.989	298	44700	247	37100	7600

Total Saving = Rs. 91,200/-

Investment = Nil

Payback Period = Immediate

*Note: Once you reduce demand you cannot further reduces till 1 year.

2. Energy-efficiency improvement opportunities in electric motors

2.1. Replace Existing conventional standard motors by Energy Efficient Motors (IE3):

Energy efficient motors are the motors with design improvements specifically to increase operating efficiency

Table 3 - Effect of Existing conventional standard motors by Energy Efficient Motors

Sr. No.	M/C no	Existing				Proposed				Saving KW
		Rated KW	Measured KW	Eff	Load factor	Rated KW	Measured KW	Eff	Load factor	
1	m/c-02 Motor	1.9	1.953	81.0	1.03	1.9	1.839	86.0	0.97	0.114
2	m/c-03 Motor	1.5	1.595	80.0	1.06	1.9	1.484	86.0	0.78	0.111
3	m/c-03 Motor	1.5	1.685	80.0	1.12	1.9	1.567	86.0	0.82	0.118
4	m/c-04 Motor	1.9	2.07	81.0	1.09	2.2	1.934	86.7	0.88	0.136
5	m/c-04 Motor	1.9	2.11	81.0	1.11	2.2	1.971	86.7	0.90	0.139
6	m/c-08 Motor	1.9	2.232	81.0	1.17	2.2	2.085	86.7	0.95	0.147
7	m/c-08 Motor	1.9	2.095	81.0	1.10	2.2	1.957	86.7	0.89	0.138
8	m/c-09 Motor	1.9	2.175	81.0	1.14	2.2	2.032	86.7	0.92	0.143
9	m/c-09 Motor	1.9	2.169	81.0	1.14	2.2	2.026	86.7	0.92	0.143
10	m/c-11 Motor	1.5	2.278	80.0	1.52	2.2	2.102	86.7	0.96	0.176
Total - A		17.8	20.362			21.1	18.999			1.363
1	m/c-01 Motor	1.9	1.291	81.0	0.68	1.9	1.216	86.0	0.64	0.075
2	m/c-01 Motor	1.9	1.399	81.0	0.74	1.9	1.318	86.0	0.69	0.081
3	m/c-02 Motor	1.9	1.727	81.0	0.91	1.9	1.627	86.0	0.86	0.100
4	m/c-05 Motor	1.9	1.448	81.0	0.76	1.9	1.364	86.0	0.72	0.084
5	m/c-05 Motor	1.9	1.463	81.0	0.77	1.9	1.378	86.0	0.73	0.085
6	m/c-06 Motor	1.9	1.638	81.0	0.86	1.9	1.543	86.0	0.81	0.095
7	m/c-06 Motor	1.9	1.775	81.0	0.93	1.9	1.672	86.0	0.88	0.103
8	m/c-07 Motor	1.9	1.74	81.0	0.92	1.9	1.639	86.0	0.86	0.101
9	m/c-07 Motor	1.9	1.44	81.0	0.76	1.9	1.356	86.0	0.71	0.084
Total - B		17.1	13.921			17.1	13.112			0.809
Grand Total		34.9	34.283			38.2	32.110			2.173

Existing KW	Proposed KW	Annual savings Rs.	Investment Rs.	Payback period
34.283	32.110	1,47,984/-	2,92,000/-	24 Months

Note: 24 hrs/day, 300 days/annum and 9.46 Rs/unit are considered for the calculation purpose

[2]. Design improvements focus on reducing intrinsic motor losses. Improvements include the use of lower loss silicon steel, longer core, thicker wires, thinner laminations, smaller

air gap, use of copper instead of Aluminium bars in the rotor, superior bearings and a smaller fan etc.

3. Air Compressors

3.1. Leakage arresting in compressed air system

Table 4 - Loss and potential saving in compressed air system

Description	System Leakage	
	Comp.1 New	Comp.2 Old
Load time (T)	51	33
Unload time (t)	43	312
% Leakage	54.26	9.57
Leakage CFM	113.39	6.59
Losses in KW	16.797	1.145
Total Loss Kw	17.94	
Permissible % leakage	5%	5%
Potential saving in %age	49.26	4.57
Potential Leakage CFM	102.94	3.15
Saving potential in Kw	15.249	0.546
TOTAL Saving potential in Kw	15.80	

Note: Considering 5% Permissible Leakage

Technical Analysis:

Total Losses in KW : 15.80

Units Wastage Per Year : 85320 units @18 hours, 300 days

Financial Analysis:

Wastage that can be saved per year : Rs. 6,96,211/- @ Rs 8.16 per unit

Investment : Nil

Payback Period : Immediate

3.2. Replacement of old autoclave compressor and Hand print compressor with new compressor

From Pump-up test of compressor, it is found that specific consumption of old autoclave is 0.221 kW/CFM at 4.65 kg/cm² delivery pressure and hand print comp-01 is 0.203 kW/CFM at 6.75 kg/cm² delivery pressure. Specific consumption of both compressor is higher than standard specific consumption at current delivery pressure. New energy efficient compressor can give much lower specific consumption than current operation level [3]. We proposed to replace old compressor with new compressor.

Also, we can reduce current pressure setting of compressors. Proposed Auto clave compressor will be 3 HP Compressor with 3.3-4.5 kg/cm² delivery pressure setting and Hand printing compressor will be 10 HP Compressor with 5.0-6.2 kg/cm² pressure setting. We can remove VFD of Hand print compressor & operate compressor at 50 Hz with Star Delta Starter.

4. Energy-efficiency improvement opportunities in pumping systems

4.1. Optimize RO Plant HP Pump frequency to eliminate valve throttling

At present RO Plant HP Pump is running with 50% Discharge valve throttling. Pump motor is running through VFD with 50 Hz frequency. We have carried flow pattern analysis with respect to frequency and pressure [1]. We proposed to reduce frequency at 47 Hz Open discharge valve by 100% to eliminate valve losses.

Present power consumption of HP Pump = 11.93 kW
Proposed Power consumption of HP Pump = 10.44 kW @ 47 Hz

Annual energy saving = 1.49 X 18 hours X 300 days/annum
= 8046 units per annum

Financial Analysis:

Annual monetary saving = 8046 units X 7.58 Rs./unit
= 60,988/- Rs.

Investment = Nil

Simple payback period = Immediate

Table 5 - Technical Analysis of present and proposed condition

Comp	Present condition			Proposed Condition		Savings in kW
	CFM Generated	kW	SEC kW/CFM	SEC kW/CFM	kW	
Handprint Comp-01	32.697	6.64	0.203	0.17	5.56	1.08
Autoclave Comp	11.431	2.53	0.221	0.15	1.71	0.81
Total						1.89

Table 6 - Financial Analysis of present and proposed condition

Comp	Annual Working Hr	Savings in Unit per annum	Savings per annum Rs.	Investment Rs.	Payback period
Handprint Comp-01	2400	2589	19,622/-	1,00,000/-	61 Months
Autoclave Comp	5400	4381	33,208/-	40,000/-	14 Months
Total		6970	52,829/-	1,40,000/-	32 Months

Table 7 - Technical Analysis

Frequency Hz	Flow lps	Pressure Kg/cm ²	Power kW	% Valve opening	Remark
50	10000	14.5	11.93	50	Valve throttling Loss
45	9000	14	8.87	100	Water starvation
46	9250	14	9.58	100	Water starvation
47	9625	14.5	10.44	100	Optimum Condition
48	10000	15	11.3	100	Excess pressure

4.2. Reduce Inverter Frequency/Speed of Main motors of Jet Dyeing Machine No. 1 & 4 to avoid throttling loss across the valve.

During the Audit period, we found that the inverters are installed on Jet Dyeing M/c No. 1 & 4 but the valves of Jet Dyeing M/c No. 1 & 4 are throttled. It is proposed to reduce inverter frequency of main Motor of Jet Dyeing m/c No. 1 & 4 and keep the valves fully opened to avoid throttling loss across the valve. Technical and financial analysis is done with the assumptions that annual operating hours are 3600.

5. Energy-efficiency improvement opportunities in Fan systems

5.1 Reduce Inverter Frequency/Speed of Main motor of ID Fan to avoid throttling loss across the damper

During the Audit period, we found that the inverter is installed on Main motor of ID Fan but the damper of ID Fan is throttled. It is proposed to reduce inverter frequency of main Motor of ID Fan and keep the damper fully opened to avoid throttling loss across the damper. Technical and financial analysis is done with the assumptions that annual operating hours are 3600.

Table 8 - Effect of Inverter Frequency/Speed of Main motors of Jet Dyeing Machine

M/C No	Before implementation			After implementation			Saving in KW
	% Valve Throttle	Inverter Freq. Hz	Power KW	% Valve Throttle	Inverter Freq. Hz	Power KW	
Jet No. 1	50%	49.13	10.12	Fully Open	41.66	6.54	3.58
Jet No. 4	20%	Display Not Working	11.28	Fully Open	Display Not Working	10.02	1.26
Total			21.40			16.56	4.84

Table 9 - Technical and Financial Analysis Inverter Frequency/Speed of Main motors of Jet Dyeing Machine

Technical Analysis			Financial Analysis		
Before implementation Power Consumption in KW	After implementation Power Consumption in KW	Savings in KW	Investment Rs.	Annual Monetary Savings Rs.	Payback Period
21.40	16.56	4.84	Nil	1,24,930	Immediate

Table 10 - Effect of Inverter Frequency/Speed of Main motor of ID Fan

Thermo pack Boiler	Before implementation			After implementation			Saving in KW
	% Valve Throttle	Inverter Freq. Hz	Power KW	% Valve Throttle	Inverter Freq. Hz	Power KW	
ID Fan	50%	39.26	5.25	Fully Open	34.00	3.66	1.59

Table 11 - Technical and Financial Analysis of Inverter Frequency/Speed of Main motor of ID Fan

Technical Analysis			Financial Analysis		
Before implementation Power Consumption in KW	After implementation Power Consumption in KW	Savings in KW	Investment Rs.	Annual Monetary Savings Rs.	Payback Period
5.25	3.66	1.59	Nil	41,041	Immediate

Note: 12 hrs/day and 300 days/annum and Rs. 7.17 per unit are considered for the calculation purpose

6. Energy-efficiency improvement opportunities in steam systems

6.1. Reduce gas consumption by reduce Radiation & Convection loss in Steam boilers

Reduce Loss Due To Radiation & Convection loss:

In our thermal analysis, efficiency loss due to a radiation & natural convection is to be 2 % which can be reduce by using insulation of ceramic coating of high thermal resistance & low thermal conductivity material [4] from our thermal data external surface temperature of thermo pack shell portion & miscellaneous places of boiler. Following are the Leakage Point.

Consideration: NG flow rate: 1134 Nm³/hr , NCV of Natural Gas: 8544.249 Kcal/sm³, Yearly 8000 hrs operation, NG price: 48.70 Rs/sm³

For 20 TPH Steam Boiler

Existing boiler efficiency: 66.67%
Boiler efficiency with insulation: 68.67%

Energy Saving by Proper Insulation Control:

For 20 TPH Steam Boiler:

Table 11 - Technical and Financial Analysis

Technical Analysis		Financial Analysis		
Savings in s?? ³ /h??	Annual savings NG Units	Investment Rs.	Annual Monetary Savings Rs.	Payback Period
4.51	36080	4,25,000/-	17,57,096/-	2Months

7. Lighting

7.1 Switch off lights during day time

It is found that 42 nos. of light fittings can be switch off during day time as enough illumination is available due to North light & shutter during day time. Details are as per below mentioned table 12.

Table 12 - Effect of Switch off lights during day time

Department/Area	Total No. of Fittings	45 W LED	20 W LED
MNZ A	6	6	-
Near FD Fan Area	7	7	-
Reactor Area (10 mtr)	3	3	-
Packing ID Blower	3	3	-
Staff Canteen	9	-	9
Worker Canteen	8	-	8
MEE (12.5 mtr)	6	6	-
Total Fittings	42	25	17
Total Watts	1465	1125	340

No. of Lamps to be switched off= 42 Nos.
Total Power Consumption = 1.465 KW
For 10 hours = 14.65 KWH
= 14.65 units/per day
Annual Savings in units = 350 days X 14.65 = 5127 units
Annual Savings in Rs. = 5127 X 9.0Rs./unit = Rs. 46,143/-
Investment = --- NIL ---
Simple payback period = Immediate

7.2 Replacement of conventional Ceiling & Wall Fan by energy efficient BLDC Fan

It is proposed to replace the conventional Ceiling & Wall fan (60W&60W) by 34W& 35W Ceiling & Wall Fan by energy efficient BLDC fan respectively [5-8]. The benefits of the above said replacement will be tangible as well as intangible. The benefits are as under:

- i. Power savings up to 60%.
- ii. Remote controller

Technical Analysis

Total no. of fittings = 107 + 63 = 170
Total Power consumption (Present) = (107 X 60) + (63 X 60) W = 10.2 KW
Total Power consumption (Proposed) = (107 X 34) + (63 X 35) W = 5.843 KW
Annual energy saving = 4.357 X 10 hours X 350 days/annum = 15250 units per annum

Financial Analysis

Annual monetary saving = 15250 units X 9.0 Rs./unit = Rs. 1,37,250/-
Investment = (107 X 3400/-) + (63 X 3800/-) = Rs. 6,03,200/-
Simple payback period = 53 months
Note: Saving assuming 18 hrs/day & 300 days/year)

7.3 Replacement of conventional 36W electronic ballasts tube light by 20W LED tube light fitting:

It is proposed to replace the conventional tube light with electronic ballast 36W by 20W LED tube light fitting [6]. The benefits of the above said replacement will be tangible as well as intangible. The benefits are as under:

- a. Power savings up to 50%.
- b. No requirement of starter
- c. Long life up to 10000 hrs as compared to 5000 hrs for standard tube light
- d. High CRI of 85

Technical Analysis:

Total no. of fittings = 47
Total Power consumption (Present) = (47 X 36) W = 1.692 KW
Total Power consumption (Proposed) = (47 X 20) W = 0.94 KW
Annual energy saving = 0.752 X 18 hours X 300 days/annum = 4061 units per annum

Financial Analysis:

Annual monetary saving = 4061 units X 8.16 Rs./unit
 = 33,138/- Rs.
 Investment = (47 X 250/-)
 = 11,750/- Rs.
 Simple payback period = 4 months
 Note: Saving assuming 18 hrs/day & 300 days/year

5. Conclusions

This article provides information on energy-efficiency technologies and measures applicable to the textile industry. At all times, the reader must bear in mind that the values presented in this article are offered as guidelines. Actual cost and energy savings for the measures will vary, depending on plant configuration and size, plant location, plant operating characteristics, production and product characteristics, the local supply of raw materials and energy, and several other factors. For instance, for some of the energy-efficiency measures, the significant portion of the cost is the labour cost. Thus, the cost of these measures in the developed and developing may vary significantly. Therefore, for all energy-efficiency measures presented in this article, individual plants should pursue further research on the economics of the measures, as well as on the applicability of different measures to their own unique production practices, in order to assess the feasibility of measure implementation.

6. Summary of Last Five Years Energy Audit Study in Textile Processing

	Saving Identified in KWh/yr	Accumulative CO2 emissions reduction Kgs	Accumulative tree planting
TOTAL 52 Industries	20411554	17349821	103891

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Enhancement of Flame Resistance in Polyester Blended Furnishing Fabrics Using Dip–Nip Processing Methods

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Abstract:

Flame retardancy is essential for ensuring fire safety compliance in home-furnishing textiles such as curtains and upholstery. Polyester and polyester–cotton (PC) blended fabrics are widely used for these applications; however, their inherent flammability necessitates effective flame-retardant (FR) treatments. In this study, 100% polyester, 80:20 PC, and 67:33 PC fabrics were treated with a halogen-free flame-retardant formulation using a pad–dry–cure process with controlled dip–nip sequences (1D–1N, 2D–2N, and 4D–4N), both with and without sodium hydroxide pre-treatment. The effect of dip–nip repetition on FR uptake, vertical flammability behaviour, and washing durability was evaluated using ASTM D6413 and ISO 6330 standard test methods. The results showed a significant reduction in char length from approximately 15 cm (untreated samples) to 4.5–5.5 cm (post FR treatment). Although FR uptake increased with the number of dip–nip cycles, no substantial improvement was observed beyond the 2D–2N sequence. The treated samples retained palpable flame-retardant performance of up to four laundering cycles, indicating moderate durability of the applied finish. Among the investigated samples, the 80:20 Polyester–Cotton blend exhibited the best flame-retardant performance, attributed to enhanced interaction between the flame-retardant formulation and the hydroxyl groups present in the cellulosic component. The study demonstrates that an optimized 2D–2N sequence provides an effective balance between chemical uptake, flame-retardant performance, and durability for polyester-based home-furnishing textiles.

Keywords: Flame retardancy, Home furnishings, Laundry cycle, Nip–Dip, Polyester–cotton blends

Citation: Pragnya Kanade, Niteen Kumar, Akash Bind, Dhruv Kayada, “Enhancement of Flame Resistance in Polyester Blended Furnishing Fabrics Using Dip–Nip Processing Methods”, *Journal of the Textile Association*, **86/6** (March–April, 2026), 641–645, <https://doi.org/10.5281/zenodo.20553437>

Article History : Article Received : 15-04-2026, Revised: 25-04-2026, Accepted: 30-04-2026

1. Introduction

Home-furnishing textiles such as curtains, upholstery, and decorative fabrics are widely used in interior environments but pose significant fire hazards due to their large exposed surface area and combustible nature. During ignition, these materials can accelerate flame spread and release toxic fumes, endangering occupants and property. Such fire incidents accelerate due to rapid heat release and flame propagation, highlighting the need for effective flame-retardant treatments for indoor applications. [1]

Polyester is widely used in home furnishings for its high strength, dimensional stability, and aesthetic properties; however, it exhibits thermoplastic behaviour and tends to melt and drip when heated, which can intensify fire hazards. Unlike cellulosic fibres, polyester does not readily form a protective char layer, further contributing to its higher flammability. Flame-retardant finishes applied through pad–dry cure processes improve resistance to ignition and flame propagation while maintaining acceptable fabric properties. [2]

Polyester–cotton blends are also widely used, combining the durability of polyester with the comfort of cotton. The presence of cellulosic hydroxyl groups enhances the interaction and retention of flame-retardant agents, promoting char formation and reducing flammability. This synergistic effect makes blended fabrics suitable for improved flame-retardant performance.

Although several flame-retardant finishing techniques exist, many involve complex processing or higher chemical consumption. The dip–nip (padding) method offers a simple and scalable approach, enabling controlled FR chemical pickup and uniform distribution of flame-retardant agents across the fabric surface. However, limited studies have systematically evaluated the effect of repeated dip–nip cycles on flame-retardant uptake and performance, particularly in blended fabrics. In addition, the durability of the applied finish under laundering conditions is a critical requirement for practical applications.

This study investigates the effect of controlled dip–nip sequences on flame-retardant uptake, performance, and washing durability of a halogen-free finish applied to polyester and polyester–cotton fabrics.

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2. Material and Methods

2.1 Materials

Three woven fabrics 100% polyester (S1), 80:20 Polyester–Cotton (S2), and 67:33 Polyester–Cotton (S3); sample code mentioned within brackets, were procured from the local market. The fabrics were of plain-weave structure and commonly used for home-furnishing applications. Fibre composition and blend ratios were confirmed using standard chemical solubility methods (ISO 1833) and burn tests. A halogen-free phosphorus-based flame-retardant formulation (Flame Guard–DPS, supplied by Sarex, India) was used for finishing. The fabric specifications are presented in Table 1.

Table 1 - Physical and Structural Properties of Fabrics

Fabric Property	S1 (100% PES)	S2 (80:20 PC)	S3 (67:33 PC)
EPI	132	98	92
PPI	64	78	56
Warp Count	40	40	30
West Count	40	40	30
Warp Crimp (%)	4.24	4.27	4.35
West Crimp (%)	6.28	4.50	5.70
GSM (g/m ²)	90	112	109
Thickness (mm)	0.20	0.22	0.23

2.2 Pre-treatment

All fabric samples were initially washed in accordance with ISO 6330:2012 to remove impurities and residual finishes. Alkali pre-treatment was performed using aqueous NaOH under controlled conditions to enhance surface wettability while limiting fibre damage (weight loss < 5%). Different NaOH concentrations (5, 10, and 15 g/L) were evaluated along with varying treatment temperatures (70 °C, 90 °C & 110 °C) and durations of (30 minutes, 45 minutes & 60 minutes), keeping a material-to-liquor ratio of 1:100, to optimise the process; optimised values shown in Table 2. The required NaOH concentration was calculated using Equation (1).

$$C=(S \times P)/100 \dots\dots\dots \text{Equation (1)}$$

where C is the concentration (g/L), S is the stock solution strength, and P is the percentage dilution. Based on experimental trials, an optimum condition of 10 g/L NaOH at 90 °C for 45 min was selected for further trials. The weight loss of the fabric samples due to pre-treatment was calculated using Equation (2).

$$\text{“Weight Loss(%)”} = (W1 - W2)/W1 \times 100 \dots\dots\dots \text{Equation (2)}$$

where W1 and W2 are the fabric weights before and after treatment, the observed weight loss (1.87–4.17%) indicates controlled surface modification without significant fibre degradation. Pre-treatment, however, showed no significant influence on flame-retardant performance and was therefore excluded from further optimization [3].

Table 2 - Optimized test-bath variables

Parameter	Concentration (10 gpl)	Temp. (90°C)	Time (45 min)
Weight Loss (%)	1.87	3.21	4.17

2.3. Flame-Retardant Application

Flame-retardant (FR) finishing was carried out using a laboratory padding mangle with an aqueous halogen-free FR formulation (160 g/L, as received, without additional additives). The fabrics were subjected to controlled dip–nip sequences, namely 1 dip–1 nip (1D–1N), 2 dip–2 nip (2D–2N), and 4 dip–4 nip (4D–4N), as illustrated in Figures 1–3.

In each cycle on the padding mangle, the fabric was immersed (dip) in the FR solution for 20 minutes, and squeezed (nip), completing one cycle. The padding operation was carried out under controlled conditions with a nip pressure of 1.75 kg/cm² and roller speed of 150 RPM, maintaining a uniform wet pick-up of approximately 70 ± 2% (70% expression). After completion of the respective dip–nip sequences, the treated samples were cured in an oven at 125°C for 5 minutes. The flame-retardant add-on (%) was calculated based on percentage weight increase using Equation (3).

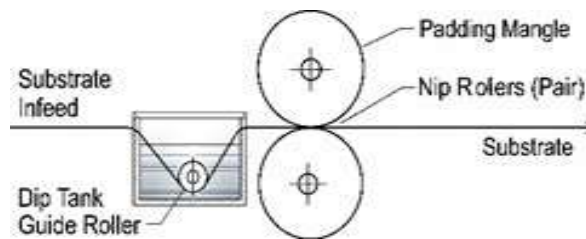


Figure 1 - One dip, one nip

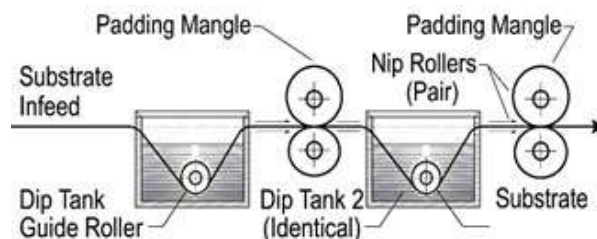


Figure 2 - Two dip, two nip

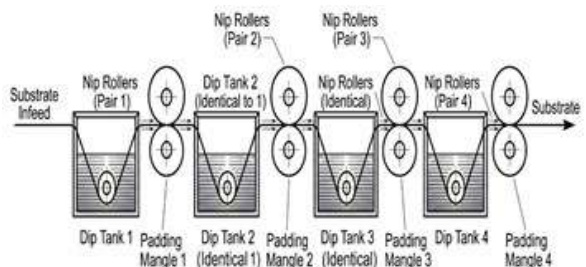


Figure 3 - Four dip four nip

“Add-on(%)” = $(W2 - W1) / W1 \times 100$ Equation (3)

where W1 and W2 represent the fabric weight before and after treatment, respectively.

2.4. Evaluation of Fabric Properties

The structural and mechanical properties of untreated and flame-retardant-treated fabrics were evaluated using standard test methods. Fabric thickness was measured according to ASTM D1777, areal density (GSM) as per ASTM D3776, crimp (%) according to ASTM D3883, and tensile strength using ASTM D5035 (strip method). All samples were conditioned at $65 \pm 2\%$ relative humidity and $27 \pm 2^\circ\text{C}$ before testing. Flame-retardant performance was assessed using the vertical flammability test (ASTM D6413), where char length was measured after flame exposure. All tests were conducted in triplicate, and average values are reported. The same testing procedures were applied to S1, S2, and S3 fabrics to ensure consistent and comparative evaluation. [5]

2.5 Washing fastness

ISO 105-C06 is the standard test method for assessing the resistance of textile colors to domestic and commercial laundering. Since the fabrics were not given the dyeing treatment, this method was used to assess the fabrics' resistance to the removal of FR applied to them.

3. Result and Discussion

3.1 Effect of Nipping–Dipping Cycles on Add-On

Table 3 shows that the addition of flame-retardant increased with dip–nip cycles, from 0.50–0.60% at 1D–1N to ~0.89–1.11% at 2D–2N, indicating improved chemical uptake. However, a further increase to 4D–4N cycle showed a negligible change (0.92–1.11%), suggesting saturation of the fabric structure. Polyester–cotton blends (S2 and S3) exhibited slightly better add-on due to enhanced interaction of the flame-retardant with the hydroxyl groups present in the cellulosic component compared to S1.

Table 3 - %Add-on of the FR solution on the fabric sample

Sample code	1D–1N (%)	2D–2N (%)	4D–4N (%)
S1	0.50	1.11	1.11
S2	0.50	0.89	1.07
S3	0.60	0.92	0.92

Thus, increasing the dip–nip cycles beyond 2D–2N did not significantly increase the add-on percentage, indicating saturation of flame-retardant uptake, while increasing chemical consumption without corresponding improvement in flame-retardant performance. Therefore, 1D–1N and 2D–2N sequences were identified as optimal processing conditions and selected for further experimental evaluation. [4]

3.2 Effect of Nipping–Dipping Cycles on Fabric Structure and Strength

3.2.1 Effect of Nipping–Dipping Cycles on Fabric Structural Parameters

Table 1 shows the fabric properties of the reference (untreated) samples. The structural properties of FR-treated fabrics (without pre-treatment) are presented in Table 4. Besides the usual coding of S1, S2, S3, N & D, the numbers 1, 2, & 4 indicate the nip-dip cycles.

Table 4 - Fabric properties of samples with FR treatment and without pre-treatment

Sample code	Thickness (mm)	GSM	Count (Nc)		Threads/inch		Crimp %	
			Warp	Weft	EPI	PPI	Warp	Weft
S1D1N1	0.22	90.05	40	40	131	62	4.24	6.28
S1D2N2	0.22	91	40	40	130	59	4.24	6.28
S1D4N4	0.22	91	40	40	130	59	4.24	6.28
S2D1N1	0.22	112.06	40	40	95	74	4.27	4.48
S2D2N2	0.22	113	40	40	95	73	4.27	4.5
S2D4N4	0.22	113.2	40	40	93	72	4.27	4.5
S3D1N1	0.23	109.06	30	30	90	56	4.35	5.7
S3D2N2	0.23	110	30	30	89	55	4.35	5.7

No significant variation was observed in thickness, GSM, yarn count, thread density (EPI/PPI), or crimp percentage across different dip–nip cycles, with all values remaining consistent within experimental limits. The results in Table 4 further confirm that FR treatment has a negligible influence on fabric structural characteristics, which can be attributed to the relatively low FR add-on levels (0.5% – 1.11%), as discussed in Section 3.1, combined with controlled padding conditions that enable uniform chemical deposition without inducing fibre swelling, compaction, or yarn displacement. Thus, the absence of measurable structural changes suggests that repeated dip–nip processing does not alter fabric construction or geometry, thus preserving the dimensional stability and structural integrity of both polyester and polyester–cotton blended fabrics, irrespective of pre-treatment and the number of dip–nip cycles.

The one-way ANOVA for GSM is presented in Table 5.

Null hypothesis (H0): The FR treatment does not significantly affect the GSM of S1 (1D-1N).

Alternate hypothesis (H1): The FR treatment has a significant influence on the GSM of S1 (1D-1N).

Table 5 - ANOVA for the selected model GSM

Anova: Single Factor				
Groups	Count	Sum	Average	Variance
UT	3	311	103.6667	142.3333
FRT	3	311.17	103.7233	142.47

Sour. Of variation	SS	df	MS	F	P-value
Between Groups	0.0048	1	0.0048	3.38E-05	0.9956
Within Groups	569.6067	4	142.4017		

The p-value of 0.996 indicates that the null hypothesis holds. Thus, statistically, the applied FR treatment does not significantly influence the GSM of the fabrics. The same can be done for the other samples and other nip-dip cycles.

3.2.2 Effect of Dip–Nip Cycles on Tensile Strength (Warp Direction)

The warp-way tensile test results (Table 6) show that the FR treatment reduced the maximum load of 100% polyester (S1) from 45.48 to 39.31 Kgf (~13.6%) and decreased strain, indicating increased stiffness.

Table 6 - Effect of Nipping–Dipping Cycles on Tensile Strength in Warp Direction

Sample Code	Treatment	Avg. Maximum Load (kgf)	Avg. Deflection at Max Load (mm)	Avg. % Strain at Max Load
S1	Untreated	45.48	54.17	27.09
S2	Untreated	52.13	40.92	20.46
S3	Untreated	46.11	35.40	17.70
S1	FR Treated	39.31	39.56	19.78
S2	FR Treated	51.07	36.66	18.33
S3	FR Treated	47.65	36.26	18.13

In contrast, the 80:20 Polyester–Cotton blend (S2) exhibited only a minor strength loss (~2%), while the 67:33 blend (S3) showed slight improvement (46.11 to 47.65 Kgf) with comparable strain. Overall, FR treatment adversely affects pure polyester, whereas polyester–cotton blends retain or show slight improvement, likely due to better fibre–matrix interaction.

3.2.3 Effect of Dip–Nip Cycles in Tensile Strength (Weft Direction)

The weft-way tensile test results (Table 7) indicate that FR treatment increased the maximum load of 100% polyester

(S1) from 33.76 to 42.23 Kgf (~25%) with negligible change in strain, suggesting structural stiffening due to enhanced inter-yarn friction rather than intrinsic fibre strengthening.

The 80:20 Polyester–Cotton blend (S2) showed a moderate load increase (~7%) with a slight reduction in strain, while the 67:33 blend (S3) exhibited a smaller improvement (~5%) accompanied by reduced extensibility. Overall, FR treatment in the weft direction promotes fabric consolidation and inter-yarn cohesion, maintaining or improving load-bearing capacity, particularly in blended fabrics, with minimal compromise to structural integrity.

Table 7 - Effect of Nipping–Dipping Cycles on Tensile Strength in Weft Direction

Sample Code	Treatment	Avg. Maximum Load (kgf)	Avg. Deflection at Max Load (mm)	Avg. % Strain at Max Load
S1	Untreated	33.76	27.67	13.83
S2	Untreated	46.15	51.45	25.73
S3	Untreated	57.51	46.70	23.35
S1	FR Treated	42.23	27.90	13.95
S2	FR Treated	49.33	47.94	23.97
S3	FR Treated	60.29	44.21	22.10

3.3 Vertical Flammability Performance

Vertical flammability results (ASTM D6413) in Table 8 show that untreated fabrics exhibited higher char lengths of 9.5 cm (S1), 15.0 cm (S2), and 15.0 cm (S3), indicating rapid flame propagation.

After FR treatment, char length was reduced to 5.5 cm (S1), 4.5 cm (S2), and 5.0 cm (S3). All treated samples showed negligible after-flame and after-glow times (~0–1 s), confirming self-extinguishing behaviour. Polyester–cotton blends (S2 and S3) exhibit better flame retardancy than 100% polyester, mainly due to the better attachment of the FR chemical with the cellulosic component of the fabric

Table 8 - Vertical flammability test results (ASTM D6413)

Sample code	State	Dip–Nip	After-flame Time (s)	After-glow Time (s)	Char length (cm)	Sample code
S1	UT	–	3	2	9.5	S1
S1	FRT	2D-2N 4D-4N	Negligible	Negligible	5.5	S1
S2	UT	–	7	10	15.0	S2
S2	FRT	2D-2N 4D-4N	Negligible	Negligible	4.5	S2
S3	UT	–	7	10	15.0	S3

Note: UT = Untreated (without FR), FRT = FR Treated

** Untreated fabrics exhibited char lengths of approximately 15 cm, which decreased to 4.5–5.5 cm after flame-retardant application.*

substrate. No significant difference was observed between 2D–2N and 4D–4N treatments, indicating saturation beyond 2D–2N, with the 80:20 blend (S2) showing the best performance with the lowest char length.

3.4 Washing Durability of Flame-Retardant Finish

The washing durability results of the FR finish (ISO 6330) shown in Table 9 show a gradual increase in char length with successive laundering, indicating partial loss of the finish. For S1, char length increased from 5.5 to 7.0 cm after 4 washes, while blends showed better retention, with S2 increasing from 4.5 to 5.6 cm and S3 from 5.0 to 6.2 cm. Despite this, all FR treated samples maintained lower char lengths than untreated fabrics up to 4 washes, confirming

Table 9 - Effect of Washing on Flame-Retardant Performance (Char Length)

Sample code	Wash Cycle	Char Length (cm)
S1*	0	5.5
S1	1	5.8
S1	2	6.2
S1	3	6.5
S1	4	7.0
S2 *	0	4.5
S2	1	4.8
S2	2	5.0
S2	3	5.3
S2	4	5.6
S3*	0	5.0
S3	1	5.3
S3	2	5.6
S3	3	5.9
S3	4	6.2

*Note: * stands for unwashed*

retained flame retardancy. However, after the 5th wash, char lengths of all samples approached those of the untreated fabrics, indicating near-complete loss of FR effectiveness. The improved durability in blends is attributed to stronger FR–cellulose interaction. Overall, the FR system exhibits moderate durability, remaining effective up to 4 laundering cycles.

4. Conclusion

This study evaluated the effect of dip–nip processing on the flame-retardant performance, structural stability, mechanical behaviour, and washing durability of polyester and polyester–cotton fabrics. The application of a halogen-free FR finish significantly reduced char length from 9.5–15.0 cm to 4.5–5.5 cm, with negligible after-flame and after-glow, confirming effective flame retardancy.

FR add-on increased slightly (~0.5–1.1%) with dip–nip cycles, with no significant improvement beyond 2D–2N, indicating saturation and establishing it as the optimal condition. Polyester–cotton blends showed better performance than 100% polyester due to enhanced interaction with cellulosic components.

Structural properties remained unchanged, confirming that the process preserves fabric integrity, while blended fabrics exhibited better mechanical stability than 100% polyester fabrics. The FR finish showed moderate durability, retaining up to four wash cycles.

Overall, the 2D–2N dip–nip process provides an effective balance between flame-retardant performance, durability, and process efficiency, with the 80:20 Polyester–Cotton blend showing the best performance for home-furnishing applications due to lower char length.

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Artificial Intelligence and Machine Learning Applications in the Textile Industry: A Review

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Abstract:

The textile industry is undergoing a transformation driven by Artificial Intelligence (AI) and Machine Learning (ML), progressing toward the "Fashion 4.0" paradigm. In this review, a systematic evaluation is carried out for AI and ML applications across the textile lifecycle, fiber classification, yarn production, fabric formation, dyeing, printing, quality control, supply chain management, and sustainability. Drawing on peer-reviewed studies published between 2015 and 2026, the review reports experimental performance benchmarks, such as convolutional neural networks (CNNs) achieving over 99% accuracy in fabric defect detection. Furthermore, ML-based dyeing optimization reduces water consumption and chemical usage. LSTM and Transformer-based models improve demand forecasting accuracy relative to statistical baselines. Persistent challenges include data scarcity, model interpretability, and integration with legacy systems. The review also identifies future research directions, including federated learning, digital twins, and foundation models. Overall, these findings indicate that AI and ML technologies can substantially enhance production efficiency, product quality, and environmental sustainability in the textile industry.

Keywords: artificial intelligence, deep learning, defect detection, Industry 4.0, machine learning, quality control

Citation: Sanjaykumar Patil, "Artificial Intelligence and Machine Learning Applications in the Textile Industry: A Review", *Journal of the Textile Association*, **86/6** (March-April, 2026), 646-650, <https://doi.org/10.5281/zenodo.20554381>

Article History : Received : 15-04-2026, Revised: 20-04-2026, Accepted: 30-04-2026

1. Introduction

The growth of the global textile and apparel industry is projected from USD 2,666.42 billion in 2023 to USD 4,047.99 billion by 2033, at a compound annual growth rate (CAGR) of 4.26% [1]. Employing over 300 million people worldwide [2], the environmental sustainability, and the industry 4.0 shift in the textile value chain can open new opportunities for innovation. The industry can integrate rapidly advancing AI and ML technologies to address issues of demand forecasting [3]. Industry 5.0 further extends this transformation by emphasizing human-centric, sustainable, and resilient production [4].

Classical statistical process control and deterministic modeling approaches do not capture the nonlinear, multivariable interactions governing textile production quality and efficiency. ML based approaches learn the complex patterns from industrial data [5]. Emerging technologies include convolutional neural networks (CNNs), recurrent neural networks (RNNs) and LSTM models for process time-series modeling, generative adversarial networks (GANs) for design innovation, and reinforcement learning for process optimization. This review synthesizes peer-reviewed literature from 2015–2026, examining AI/ML applications across all major textile manufacturing stages and identifying challenges and future directions.

2. Methodology

A systematic literature review was conducted following

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PRISMA guidelines. The Scopus, Web of Science, and IEEE Xplore databases were searched using combinations of terms including "artificial intelligence," "machine learning," "deep learning," "textile," "fabric," and "manufacturing." Inclusion criteria were: (a) peer-reviewed journal articles or conference papers, (b) published between January 2015 and February 2026, and (c) focused on AI/ML applications in textile production, quality control, or supply chain management.

Extracted data included the AI/ML technique employed, textile manufacturing stage addressed, dataset characteristics, reported performance metrics, and validation methodology. Studies were categorized across seven application domains: fiber and yarn production, fabric formation, dyeing and color management, finishing, quality control, supply chain management, and sustainability.

AI/ML Applications Across the Textile Value Chain

Fiber and Yarn Production

Cotton fiber grading using High-Volume Instrument (HVI) generating rich multivariate fiber quality data encompassing length, strength, micronaire, uniformity, and color measurements, was among the earliest textile ML applications. Artificial neural networks (ANNs) significantly improved yarn tenacity and elongation prediction accuracy compared to multiple linear regression [6], while support vector machines (SVMs) demonstrated superior generalization on small datasets due to their structural risk minimization principle [7]. Spinning process optimization benefits from hybrid genetic algorithm-ANN (GA-ANN) models that combine the ANN's ability to model complex

process-quality relationships with the GA's global search capability, enabling simultaneous optimization of yarn unevenness (CV%), imperfections, hairiness, and tenacity [8].

Machine learning techniques can be integrated in the air-jet spinning nozzle design process optimization. Airflow dynamics can be improved by the efficient nozzle design process that optimizes certain parameters [9].

The research on theoretical understanding of color prediction in complex textile systems and precise digital control of yarn color offers practical tools for more sustainable and efficient manufacturing that reduce water consuming processes. The back-propagation neural network model predicts blend ratios from spectral reflectance data and CIELAB values from known blend ratios. Both achieved high accuracy, with mean squared error below 0.03 and typical color differences (ΔE) around 2.0, confirmed by yarn samples whose colors closely matched their targets visually and spectrophotometrically [10].

Fabric Formation

Analysis of the impact of AI-driven technologies on sustainability and comparison with applications of TPS (Toyota Production System) found the AI-enabled technologies contributing to sustainable production, reduced waste by reduction in knitted fabric defects [11].

A data-driven approach in the Reinforcement Learning (RL) based adaptive WIP control achieves 0.3% to 2.3% Mean Absolute Percentual Errors (MAPE) in the throughput, calculated as the percentage difference between the actual and the target throughput with 5.5% to 8.4% standard deviation. In stochastic environments, this is beneficial over analytical methods which have limitations [12].

LBP method is useful for woven defect recognition and classification. Using texture analysis method and a support vector machine (SVM), a novel algorithm developed for automatic fabric defect classification [13].

In knitting, the use of Linear Regression, Random Forest, XGBoost, and Support Vector Machine Regression algorithms based on a dataset for predicting fabric GSM, revealed that the Random Forest model achieved an R^2 score of 98%, a Mean Absolute Error of 1.6, and a Mean Squared Error of 139 [14]. Generative models (IDF GANs) are accelerating design exploration [15].

Dyeing, Printing and Color Management

Visual and spectrophotometric target color matching can be achieved using predicted recipes. In one of the studies, the

BPNN model was validated practically for yarns produced with Backpropagation Neural Network (BPNN) recipes found to give MSE values for ratio prediction consistently below 0.03 and $\Delta E_{CMC2:1}$ for color prediction around 2.0 [10].

RL agents optimize temperature-time profiles for dyeing processes, while transfer learning and physics-informed neural networks improve model portability across substrates and facilities [16]. In the adoption of digital fabric printing technologies, use of design software enabled the shortening of lead time, reduced wastewater, and short batch processes in the textile supply chain [17].

Quality Control and Defect Detection

Automated fabric inspection, the most extensively studied AI application in textiles, is driven by the high economic cost of downstream defects and the availability of image data from commercial inspection systems. The field evolved through statistical texture analysis (GLCM, Gabor filters, wavelet decomposition), structural and morphological approaches, and contemporary deep learning architectures [18]. Statistical methods perform well for periodic textures but struggle with complex patterns, subtle defects, and variable lighting conditions. YOLOv4 algorithm upgrades mAP (Mean Average Precision) by 6% and FPS (Frames Per Second) decreases by 2, provides highly accurate fabric defect detection. The model is suitable for efficient industrial fabric defect detection [19]. Fiber composition identification of waste textile materials using CNN model FabricNet achieved accuracy greater than 97% using near-infrared (NIR) spectroscopy [20].

Supply Chain and Demand Forecasting

Complex models such as ARIMA exhibit limited accuracy advantage in forecasting performance, while the LSTM models perform well when used in repeatable temporal structures. For model selection, data-driven criteria are recommended [21].

Production systems can be improved using deep Reinforcement Learning (RL) based optimization in production to handle the supply chains with diverse product ranges, unpredictable events, and shorter product development cycle challenges. The real-time responses to system changes can be generated by RL based on recently collected sensor data. This has contributed to data-driven and flexible processes in different production systems [22].

3. Experimental Results

Table 1 summarizes the key AI/ML techniques and their reported performance metrics across the textile manufacturing value chain, as compiled from the reviewed literature.

Table 1 - Summary of AI/ML Performance Metrics Across Textile Manufacturing Applications

Application	Technique	Metric	Performance	Source
Fabric defect detection	YOLOv4	mAP	+6%	Liu et al. (2017)
Air-jet Weaving	ML	R ² and MSE	R ² improvement 0.905 to 0.950; MSE decreased 32.369 to 16.239	Yu et al. (2025)
Color recipe	BPNN	ΔE	2.0	[10]
Classification Model	NN	Accuracy	71–73%	[3]
Color Spun Yarn	BPNN	Color Prediction	MSE < 0.03; ΔE CMC (2:1) ~ 2.0	[10]
Fiber Composition	CNN and NIS	Accuracy	97.3%	[20]
WIP	DRL and DES	MAPE in throughput	0.3–2.3%	[12]
Dyeing	MILP	Water Consumption	71.39%	[25]

Note. FPR = first-pass-right; ΔE = color difference; MAPE = mean absolute percentage error; CV% = coefficient of variation; NIS = near infrared spectroscopy; BPNN = Backpropagation Neural Network; mAP = Mean Average Precision; WIP = Work in Progress; DRL = Deep Reinforcement Learning; DES = Discrete Event Simulation; MILP = Mixed Integer Linear Programming; MSE = Mean Squared Error.

Table 2 presents the quantified resource savings achieved through AI/ML-based optimization in textile manufacturing, as reported across the reviewed literature.

Table 2 - Resource Savings from AI/ML-Based Process Optimization in Textile Manufacturing

Process Area	Optimization Type	Savings Range	Source
Dyeing	Water Consumption	71.39%	[25]
Knitting	Waste Reduction	–	[11]
Dyeing	Color Matching (Water Saving & Coloration)	–	[10]
Adaptive Manufacturing	Work in Progress	–	[12]
Textile waste sorting	Fiber ID accuracy	>97%	[20]

Note. All values represent ranges reported across multiple studies included in the review.

4. Discussion

The experimental results compiled in this review identify patterns regarding AI/ML adoption in textile manufacturing. Quality control and defect detection emerge as the most technically mature application area, with improved models consistently achieving higher accuracies [19]. This maturity is attributable to the availability of image data from commercial inspection systems and the direct applicability of transfer learning from large-scale computer vision benchmarks.

The sustainability impact of AI/ML-based process optimization is substantial and multi-dimensional. ML-optimized dyeing alone can reduce water consumption by 10–25%, chemical usage by 8–18%, and energy consumption by 5–12%. Given that the textile industry consumes approximately 93 billion cubic meters of water annually [23], even modest percentage reductions translate to significant absolute resource savings. The shift from classical ML (SVMs, ANNs) to deep learning (CNNs, LSTMs, Transformers) reflects broader AI trends but is influenced by textile domain constraints. Physics-informed neural networks offer a promising way to integrate domain knowledge and enhance model extrapolation [16].

RL-based applications show strong potential for closed-loop process optimization in production manufacturing, dynamic WIP management, and adaptive manufacturing control for Industry 4.0 standards [22, 12]. The reward function formulation remains an active research challenge, as it must balance competing objectives such as quality, efficiency, and resource consumption.

Despite these advances, data scarcity and quality remain the most fundamental barriers, with operational data often siloed across incompatible systems [5]. The opacity of deep learning models hinders adoption in quality-critical environments where process engineers require interpretable decisions. Legacy equipment lacking Industry 4.0 connectivity requires costly retrofitting, and organizational change management adds further complexity. Emerging technologies, including federated learning for cross-site model training, digital twin infrastructure, and foundation models capable of multi-modal reasoning, offer pathways to address these limitations [21].

5. Conclusion

This review has synthesized current research on AI and ML applications across the textile industry value chain. The

evidence demonstrates that these technologies are transitioning from academic proof-of-concept to industrial deployment, with quality control, process optimization, and demand forecasting representing the most mature domains. Deep learning—particularly CNNs, LSTMs, and Transformers emerged as the dominant paradigm, while transfer learning has been instrumental in overcoming the limited dataset sizes characteristic of textile applications. Reinforcement learning represents an important growth area for closed-loop process optimization, with laboratory results beginning to translate to industrial pilots.

The compiled experimental results confirm significant performance improvements: defect detection accuracies exceeding 99%, color prediction improvements of 15–40% in ΔE , demand forecasting MAPE reductions of 15–30%, and resource savings spanning water, chemicals, and energy in dyeing operations. Data scarcity and quality, model interpretability, legacy system integration, and organizational change management challenges are

identified. These challenges are substantial but not insurmountable. Progress is active on each front through synthetic data generation, XAI methods, edge computing platforms, and federated learning. These findings collectively support the conclusion that AI and ML offer a transformative pathway toward a more productive, quality-consistent, and environmentally sustainable global textile industry.

For researchers, this review highlights the need for accessible benchmark datasets, more rigorous comparative evaluation, and greater attention to the full deployment lifecycle beyond model accuracy metrics. For industry practitioners, it provides a structured overview of the most promising application areas and implementation considerations. Future research should prioritize explainable AI methods suitable for manufacturing operators, federated architectures enabling secure cross-organizational learning, and digital twin frameworks for seamless model deployment.

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Impact of Transparency on Ethical Consumer Loyalty in the Textile and Garment Industry

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Abstract:

Background: The global textile industry significantly contributes to environmental degradation and resource depletion through its linear "take-make-dispose" model, generating millions of tonnes of waste annually. The concept of a circular economy offers a transformative solution by promoting reuse, repurposing, and recycling of materials. This paper investigates the role of transparency in textile management as a driver of brand loyalty among conscious consumers.

Methods: Primary data was collected through an online survey administered via Google Forms. The questionnaire was designed to capture consumer perceptions, attitudes, and behaviours regarding transparency in textile management and its influence on brand loyalty. The survey link was disseminated through various online channels to reach a diverse sample, ensuring anonymous and confidential responses.

Results: The survey revealed that while traditional factors like price, quality, style, and comfort remain primary purchasing drivers, transparency is a crucial underlying factor for brand loyalty. A high percentage of consumers are aware of the textile industry's environmental and social impacts. A substantial majority (83.9%) consider transparency "extremely" or "very" important, and 93.5% reported that transparency "strongly" or "moderately" influences their purchasing decisions. Furthermore, 77.5% expressed willingness to pay a premium for products from transparent brands, and 83.9% are "very" or "extremely" likely to repurchase from and recommend such brands. Notably, 87.1% have switched brands due to concerns about a lack of transparency or sustainability.

Conclusion: Despite a "say-do" gap where direct purchasing factors sometimes overshadow stated values, the findings strongly indicate that transparency in textile management significantly increases consumer trust, positively influences purchasing decisions, and fosters a stronger emotional connection, ultimately driving brand loyalty and advocacy. For brands seeking sustained loyalty, actively communicating transparent and sustainable practices is a fundamental and profitable strategy.

Keywords: Advocacy, Consumers, Loyalty, Recycling, Transparency

Citation: T. Suganthi, R. Thiru Murugan, P. Suganya, R. Paranthaman, "Impact of Transparency on Ethical Consumer Loyalty in the Textile and Garment Industry", *Journal of the Textile Association*, **86/6** (March-April, 2026), 651-656, <https://doi.org/10.5281/zenodo.20554347>

Article History : Received : 08-10-2025, Revised: 17-04-2026, Accepted: 22-04-2026

1. Introduction

The growing global focus on environmental issues has empowered consumers to become active participants in the debate, using their purchasing decisions to signal their commitment to environmental and social causes [1-3]. This consumer-driven pressure has created a dual challenge for businesses: maintaining profitability while fulfilling social responsibilities [4]. Consequently, the strategic importance of ethical consumerism a framework that includes a company's non-traditional social and environmental components has risen dramatically [5, 6]. This movement is reflected in the widespread adoption of Corporate Social Responsibility (CSR), which refers to a company's societal duties and obligations to its stakeholders [7].

The global textile industry, a cornerstone of economic

activity and a significant employer worldwide, is simultaneously a major contributor to environmental degradation and resource depletion. Characterized by a linear "take-make-dispose" model, the industry generates an alarming volume of waste, with an estimated 92 million tonnes of textile waste produced globally each year, a figure projected to rise to 134 million tonnes by 2030 if current trends persist [8, 9]. This waste, predominantly ending up in landfills or incinerators, contributes to greenhouse gas emissions, water pollution, and the depletion of finite resources, highlighting an urgent need for systemic change [10, 11]. The production of textiles is also highly resource-intensive, requiring vast amounts of water, energy, and chemicals, further exacerbating its environmental footprint [12, 13].

In response to these pressing environmental and resource challenges, the concept of a circular economy has emerged as a transformative paradigm [14]. Unlike the traditional linear model, a circular economy aims to keep resources in use for

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as long as possible, extract the maximum value from them whilst in use, then recover and regenerate products and materials at the end of each service life [15]. For the textile sector, this translates into a shift from discarding materials to continuously reusing, repurposing, and recycling them, thereby minimizing waste and maximizing resource efficiency [16]. However, the transition to a truly circular textile economy is fraught with complexities, including challenges in sorting mixed materials, developing scalable recycling technologies, and establishing efficient collection and reverse logistics systems [17, 18].

Amidst these industry-wide shifts, consumer behaviour plays a pivotal role [19]. A growing segment of conscious consumers is increasingly aware of the environmental and social impacts of their purchasing decisions [20]. This manuscript, investigates the critical role of brand transparency in influencing the loyalty of these informed consumers. Through a comprehensive survey, this study explores how a textile brand's openness about its supply chain and sustainable practices directly impacts consumer trust, emotional connection, willingness to pay a premium, brand advocacy, and ultimately, repeat business. By understanding these dynamics, the paper aims to provide actionable insights for textile brands seeking to build lasting loyalty in an increasingly sustainability-driven market.

2. Methodology

The authors prepared a well-designed questionnaire for the empirical component of this manuscript, "Impact of transparency on ethical consumer loyalty in the textile and garment industry." Primary data were collected through an online survey administered via Google Forms. This platform was chosen for its user-friendly interface, accessibility, and robust data collection capabilities, allowing for efficient distribution and automatic compilation of responses. The survey instrument was meticulously designed to capture respondents' perceptions, attitudes, and behaviours regarding transparency in textile management, their brand loyalty towards textile companies, and demographic information. Questions were a mix of Likert scale items to gauge agreement levels, multiple-choice questions for categorical data, and open-ended questions to gather qualitative insights into consumer decision-making. The survey link was disseminated through various online channels, including social media platforms, relevant online communities, and direct outreach, aiming to reach a diverse sample of consumers. All responses are anonymous and confidential, and participants were informed about the study's purpose and their rights before participation, ensuring ethical data collection practices.

3. Result and discussion

For this study a survey made more than 500 respondents of various age groups, income, and profession. This article presents survey findings primarily reflecting the attitudes of younger to middle-aged, highly educated male consumers. Over 61% of respondents are aged 25-44, suggesting a strong engagement with conscious consumerism and textile

transparency among Millennials and younger Gen X. The survey is heavily skewed male (61.3%), indicating its conclusions are most applicable to male purchasing behaviours. Furthermore, over 93% of participants hold at least a Bachelor's Degree, implying the insights gathered are largely from a well-educated demographic with potentially higher awareness of ethical and sustainability issues. These demographic insights are crucial for interpreting the survey's findings on transparency and brand loyalty.

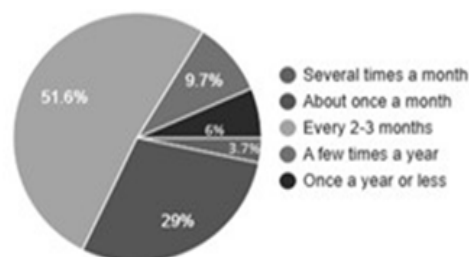


Figure 1 - Purchasing habits of new clothing or textile products

3.1 Purchasing habits of new clothing or textile products

The survey participants are not frequent buyers of textile products. The vast majority of respondents make purchases infrequently. Over half of the participants (51.6%) buy textile products only "Every 2-3 months." Additionally, 29% make a purchase "About once a month," and another 9.7% buy only "A few times a year." The smallest groups are those who buy "Several times a month" or "Once a year or less," with the latter not having a percentage labelled but appearing small.

This data suggests that the "conscious consumers" who participated in this survey are not high-frequency shoppers. Their purchasing habits align with a more deliberate, less impulsive approach to consumption, which is consistent with the survey's focus on transparency and brand loyalty. It implies that these consumers are likely to put more thought into each purchase, making factors like a brand's transparency in textile management a more significant driver of their loyalty than it might be for a more frequent, less deliberate shopper.

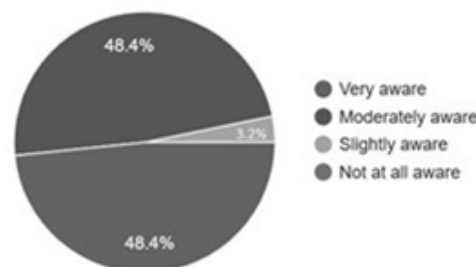


Figure 2 - Consumer Awareness of Textile Industry Impacts

3.2 Consumer Awareness of Textile Industry Impacts

The survey participants, despite their low prioritization of transparency in purchasing decisions, demonstrate high awareness of the environmental and social issues within the textile and fashion industry.

A significant portion of respondents, 48.4%, reported being "Very aware" of transparency and textile management issues, with an equal number (another 48.4%) reporting being "Moderately aware."

This means a striking 96.8% of respondents are at least moderately aware of these topics. This finding creates an interesting contrast with previous data showing that only a very small percentage (6.5%) of these same respondents actually prioritize "Transparency" in their buying habits. The inference is that while consumers are highly informed and conscious of issues like ethical production and transparency, this awareness does not translate into it being a primary purchasing factor. This suggests that other factors like price, quality, and style remain more influential, even among a self-selected group of "conscious consumers." It implies a gap between consumer values and their actual purchasing behavior, which brands need to address if they want to leverage transparency as a tool for brand loyalty.

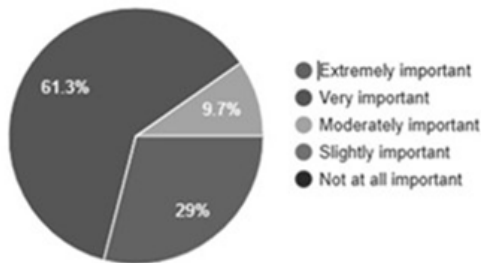


Figure 3 - Textile brand practices sustainability

3.3 Textile brand practices sustainability

Survey data reveals that brand loyalty programs are a critical factor for a significant majority of consumers. An impressive 90.3% of respondents rated these programs as either "very important" or "extremely important." This overwhelmingly high percentage shows that consumers are not only conscious about their purchases but also actively seek and value brands that reward their continued business. The findings strongly suggest that investing in robust loyalty programs is an effective strategy for building and maintaining strong customer relationships, particularly among consumers who value these kinds of incentives.

For brands looking to foster loyalty, these programs are no longer just a bonus they are a key component of their overall strategy.

3.4 Aspects of transparency/sustainability considering a textile brand

This survey, conscious consumers have a clear set of priorities when it comes to brand transparency in the textile industry. The most important factors are directly related to environmental and ethical impact. The top three concerns are chemical reduction (90.3%), the use of sustainable or recycled materials (87.1%), and a reduction in water usage (83.9%). Fair labour practices are also a critical concern for over 80% of respondents, highlighting a strong ethical commitment to worker welfare. with this engaged group of consumers.

While other factors like waste reduction and animal welfare are important to a majority, the top-tier priorities revolve around tangible, impactful actions that directly address the environment and human rights. This indicates that for brands to build loyalty, they must focus their efforts on these key areas, as simply providing information without taking action is less likely to resonate

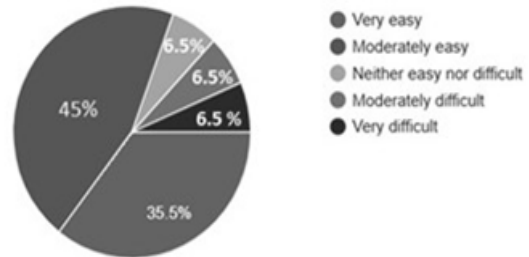


Figure 4 - Brand's transparency and sustainability

3.5 Information about a textile brand's transparency and sustainability practices

According to the survey, most conscious consumers find it relatively easy to verify a textile brand's claims about transparency and sustainability. A combined 80.7% of respondents reported that it was either "very easy" or "moderately easy" to check these claims. This finding suggests that brands are becoming more accessible with their information, and engaged consumers are actively seeking and able to find the data they need.

However, a small but notable segment of consumers still face challenges, indicating that some brands could improve the clarity and accessibility of their information. This highlights a crucial point: to build and maintain loyalty, brands must not only make claims about their practices but also ensure they provide concrete, verifiable evidence to back them up.

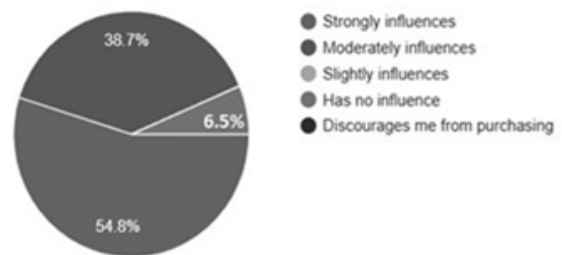


Figure 5 - Transparency on Purchase Decisions

3.6 Influence of Transparency on Purchase Decisions

The survey demonstrates a strong and direct link between a brand's transparency and a consumer's decision to purchase. A clear majority, 54.8%, of respondents stated that transparency "Strongly influences" their decision to purchase, with another 38.7% indicating it "Moderately influences" their decision. Combined, a remarkable 93.5% of participants are influenced by a brand's transparency when making a purchasing decision.

This finding directly contradicts previous data showing that only 6.5% of respondents initially listed "Transparency" as a primary purchasing factor. This discrepancy suggests that

while consumers may not initially consider transparency a top-of-mind factor alongside price and quality, when asked directly, they confirm its significant influence. This implies that transparency is a powerful underlying force driving purchasing decisions, particularly for the "conscious consumer." Only a small segment (6.5%) stated transparency "Has no influence," and no one was discouraged from purchasing, reinforcing that transparency is a crucial element for brands to attract and retain the loyalty of this consumer group.

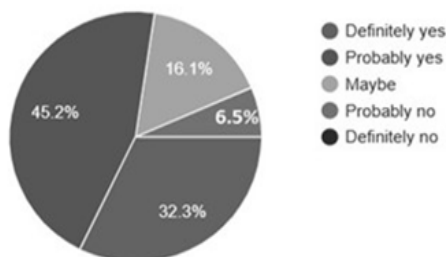


Figure 6 - Pricing for an ethical, sustainable brand

3.7 Premium pricing for an ethical, sustainable brand

The survey indicates that a significant majority of conscious consumers are willing to pay a higher price for textile products from brands that are transparent about their ethical and sustainable practices. An overwhelming 77.5% of participants are likely to accept a higher price, with 32.3% saying "definitely yes" and 45.2% saying "probably yes." The fact that no one said "definitely no" shows that paying a premium for transparency is a widely accepted idea among this group.

This suggests that for brands aiming to build loyalty and command a higher price point, investing in and clearly communicating ethical and sustainable practices is a viable and potentially profitable strategy. This willingness to pay more reinforces the idea that transparency is not just a secondary value but a powerful driver of purchasing behavior for the "conscious consumer" demographic.

3.8 Rating of Perception of Transparency & Influence on Purchasing

An analysis of the survey results shows that transparency is a crucial factor in building consumer trust and loyalty for textile brands. A strong majority of consumers believe that transparent brands are more trustworthy and are proactive in seeking out information on a brand's ethical and sustainable practices. This proactivity highlights the importance of providing accessible and verifiable information. The survey also found that transparency fosters a positive emotional connection, with a high percentage of consumers feeling better about their purchases from transparent brands, which is a powerful driver of repeat business. Furthermore, the data suggests that consumers generally trust that brands' transparency claims are genuine, indicating that brands' efforts to communicate their practices are effective and credible. In conclusion, for a textile brand to build and maintain loyalty, it must not only be transparent but also take

tangible actions related to ethical and sustainable practices, as these are the issues that truly resonate with the "conscious consumer." "Based on the document, a key inference is that transparency is a fundamental pillar of trust and a powerful driver of loyalty for "conscious consumers" in the textile industry. The data shows that consumers actively seek out information on ethical and sustainable practices, and they overwhelmingly agree that transparent brands are more trustworthy. This trust, in turn, leads to a positive emotional response, making consumers feel better about their purchases, which is a strong driver of repeat business. The high level of consumer belief that textile brands are genuinely transparent suggests that brands' efforts to communicate their practices are being received as authentic and credible, which is a crucial factor in building and maintaining brand loyalty. Therefore, for a textile brand to succeed with this consumer segment, it must focus on tangible, impactful actions related to sustainability and ethical production and ensure that this information is easily accessible and verifiable.

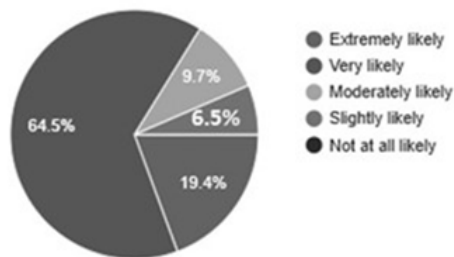


Figure 7 - Brand Loyalty and Repurchasing

3.9 Sustainability: A Key to Brand Loyalty and Repurchasing

The survey results provide compelling evidence that transparency and sustainability are key drivers of repeat business and brand loyalty. A remarkable 83.9% of respondents indicated they were either "very likely" or "extremely likely" to repurchase from a brand they perceive as transparent and sustainable. The data shows that this is a direct translation of a brand's perceived transparency into a high probability of a repeat purchase. The fact that not a single respondent was "not at all likely" to repurchase further reinforces this conclusion.

This demonstrates that for conscious consumers, a brand's commitment to ethical and sustainable practices is a core reason for continued loyalty, making these factors an essential part of any long-term brand strategy.

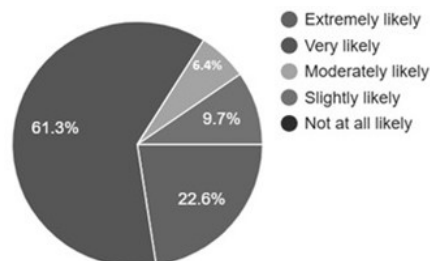


Figure 8 - Power of Transparency and Sustainability

3.10 The Power of Transparency and Sustainability in Driving Brand Advocacy

The survey provides a very strong conclusion that transparency and sustainability are powerful drivers of brand advocacy. An overwhelming 83.9% of respondents are either "very likely" (61.3%) or "extremely likely" (22.6%) to recommend a brand they perceive as transparent and sustainable. This data demonstrates that transparency not only drives trust and repurchasing but also transforms satisfied customers into brand evangelists. The fact that no one was "not at all likely" to recommend reinforces this conclusion.

For the "conscious consumer," a brand's commitment to ethical and sustainable practices is something they are proud to share and recommend to their social circles. This positive word-of-mouth is a highly effective form of marketing and a key indicator of strong brand loyalty

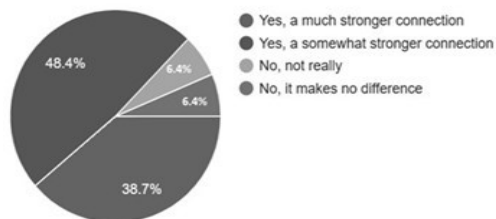


Figure 9 - Emotional Connection Through Transparency

3.11 Emotional Connection Through Transparency

The survey provides a very strong conclusion that brand transparency and ethical practices are effective in building a deeper emotional connection with consumers. A significant majority of respondents feel a stronger emotional bond with transparent and ethical brands. An overwhelming 87.1% of the respondents feel a more profound emotional connection, with 48.4% reporting a "somewhat stronger connection" and 38.7% feeling a "much stronger connection."

Only a small minority of the participants, 6.4%, said it made "no difference" and another 6.4% said "no, not really." This data demonstrates that transparency is a powerful tool for moving beyond a transactional relationship with consumers to a more emotional and values-based one. The inference is that for the "conscious consumer," a brand's ethical stance is a key part of their identity, and they feel a genuine bond with companies that align with their values. This emotional connection is a critical component of lasting brand loyalty, as it makes customers more resilient to competitive pressures and more likely to advocate for the brand.

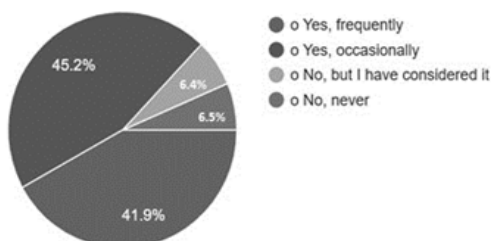


Figure 10 - Transparency Drives Brand Loyalty

3.12 Transparency Drives Brand Loyalty

A lack of transparency or sustainability is a significant reason for consumers to switch brands. An overwhelming 87.1% of survey participants have switched brands at least occasionally due to these concerns, with 41.9% stating they do so "frequently" and 45.2% "occasionally."

Only a small minority (6.5%) stated they had "never" switched for these reasons. This data is a powerful testament to the influence of transparency on brand loyalty.

For the "conscious consumer," ethical and sustainable practices are not just a "nice-to-have" but a core expectation that, if not met, can lead to customer defection. This highlights a clear risk for brands that are not transparent and a significant opportunity for those that are. Transparency not only attracts new customers but is also a key factor in retaining existing ones.

4. Conclusion

The article concludes that even though primary buying decisions continue to be influenced by considerations such as price, quality, and fashion, transparency is an important and influential spur to brand loyalty in the textile sector.

Research backs up the high level of consumer concern around the social and environmental footprint of the industry, presenting a major opportunity for open brands. Although there is a "say-do" gap between what consumers express that they value and their spontaneous purchases, an overwhelming majority asserted that transparency significantly affects their decision-making, builds trust, and yields a psychological payoff. In addition, the information suggests that consumers who are conscious of their purchases will pay extra for products from ethically and transparent brands, and transparency thus becomes an element that can be used as a reason for charging more. It is also a major spur for repeat customers and word-of-mouth referrals. By contrast, a lack of sustainability or transparency is a significant risk factor, as it is now an essential customer expectation that gets a large portion of customers to switch brands. Thus, openly declaring transparent and sustainable operations is a key strategy for brands if they are to be successful in the long run and build customer loyalty.

5. Acknowledgment

The authors are thankful to the Vignan's Foundation for Science, Technology and Research – VFSTR (Deemed to be University) Guntur, Andhra Pradesh, Jai Shriram Engineering College, Tirupur, PSG College of Arts and Science (Autonomous), Coimbatore and Kalasalingam Academy of Research and Education, Virudhunagar, for their support to taking the survey.

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Sustainable Development and Functional Characterization of Bamboo Lyocell/Cotton Blended Knitted Fabrics

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Abstract:

Bamboo lyocell fiber had gained global recognition for its sustainability and functional performance. In this experimental work there is analysis and characterization of four types of knitted fabrics having blend compositions such as 100 % bamboo lyocell, 100 % cotton, 70:30 bamboo lyocell/cotton, and 50:50 bamboo lyocell/cotton. The yarn and fabric samples were analyzed for their functional properties such as pilling resistance, dimensional stability (shrinkage), air permeability, water vapor transmission, and wicking behavior. The one way ANOVA results indicate that fiber blend proportion significantly influences most of the evaluated fabric properties. No significant effect was observed for shrinkage in the wale direction ($p=0.9820$). However, course-wise shrinkage, air permeability, water vapour permeability and wicking behavior exhibited highly significant difference ($p<0.001$). Fabrics with higher bamboo content demonstrated a more pronounced effect on these performance characteristics. The findings of experiment revealed that the 100% bamboo fabric exhibited superior air permeability ($125\text{cm}^3/\text{cm}^2/\text{s}$) and water vapor transmission ($5.88\text{ g/m}^2/\text{day}$), outperforming other blends. Results highlighted the potential of bamboo lyocell and bamboo lyocell/cotton blends to deliver enhanced moisture management and breathability, offering sustainable solutions for both performance and casual wear applications. The functional performance had shown that the bamboo lyocell's may be potential source of sustainable, high comfort alternative in knitted apparel fabrics, offering significant environmental benefits.

Keywords: *Bamboo lyocell, Cotton and blends, Permeability, Shrinkage behavior, Sustainability*

Citation: Aastha Rajawat, Virendra Kumar Gupta, "Sustainable Development and Functional Characterization of Bamboo Lyocell/Cotton Blended Knitted Fabrics", *Journal of the Textile Association*, **86/6** (March-April, 2026), 657-663, <https://doi.org/10.5281/zenodo.20552546>

Article History : Received : 15-03-2026, Revised: 11-04-2026, Accepted: 15-04-2026

1. Introduction

In present scenario, sustainable textile production is in demand and it is driven by growing environmental concerns. There is growing consumer demand for eco friendly and high-performance apparels. Conventional cotton cultivation requires consumption of natural resources such as approximately 7,000–29,000 L of water per kilogram of lint [1-4]. Besides high-water requirement, pesticides and fertilizers were also consumed in cotton production, contributing to soil degradation and environmental stress [4, 5]. Regenerated bamboo lyocell, had gained importance for their environmentally responsible production methods and favourable functional characteristics [6-8]. Bamboo lyocell fibre is produced via a closed-loop solvent spinning process using N-methyl morpholine-N-oxide (NMMO), which is nearly 99% recyclable, thereby minimizing chemical discharge and water usage. The resulting fibre exhibits excellent moisture and air permeability and a soft tactile feel, making it suitable for many applications, such as sportswear, leisurewear, and intimate apparel [9-11].

Recent studies had explored the potential of blending bamboo lyocell with cotton fibre in different ratio, aiming to combine bamboo's superior breathability and moisture-wicking capabilities with the mechanical properties of cotton fibres. Several researchers had studied bamboo/cotton knitted fabrics, and reported improved air permeability and reduced surface imperfections compared to pure cotton

fabrics [12, 13]. Similar studies had reported enhanced hand feel and reduced yarn faults in bamboo/cotton blends, supporting their potential application in premium apparel manufacturing. Some researchers had examined the mechanical and comfort properties of bamboo blends with other regenerated fibres, noting improvements in tensile strength, elastic modulus, and thermal comfort [14, 16-18].

Most studies and industrial applications had focused on bamboo rayon, while research on bamboo lyocell is now gaining momentum as sustainability concerns drive interest in eco-friendlier alternatives [15, 19]. Existing research had focussed on woven structures; while knitted fabrics, crucial for comfort remain under explore [12-14]. This study aimed to cover these gaps by systematically developing and characterizing four distinct knitted fabric compositions such as 100% bamboo lyocell, 100% cotton, 70:30 bamboo lyocell /cotton, and 50:50 bamboo lyocell /cotton. In this experimental work there were evaluation of functional characteristics such as pilling resistance, dimensional stability (shrinkage), air permeability, water vapour transmission, and wicking behaviour to establish correlations between blend composition and fabric performance.

2. Materials and Method

2.1 Fibres and yarn preparation

2.1.1 Fibres

The Lyocell fibre was procured from RSWM Bhilwara (Raj). Table 1 shows the fibre characteristics. In this experiment, it

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was tried to maintain constant fibre specifications in Cotton and Bamboo-Lyocell fibres, however the availability of fibre on commercial level produced some variability, which were statistically negligible. The important fibre properties which may affect the fabric comfort level were considered in this experiment as per table No.1.

Table 1: Fibre characteristics

Property	100% Cotton	100% Bamboo-Lyocell
Length (mm)	29	31
Denier	1.5	1.6
Strength (g/Tex)	21.6	24.2
Elongation (%)	3.6	4.5
Maturity Ratio	0.86	0.89

2.1.2 Yarn

The experimental work involved production of four yarn blends such as 100% Lyocell bamboo, 100% Cotton, 70:30 Bamboo/Cotton, and 50:50 Bamboo/Cotton spun to 30s count yarn, the different 30s yarn count were knitted and four fabric samples were produced. The yarns were spun using a ring spinning system to ensure optimal fibre alignment, uniformity, and tensile properties essential for achieving consistent loop formation during knitting. The different yarn properties were summarized in table no.3.

2.2 Fabric Manufacturing

Knitted fabrics were manufactured on TRYTEX Circular Knitting machine using the four different yarn compositions. The knitting machine settings, including a gauge of 28 needles per inch (28G) and loop lengths ranging from 2.5 to 3.5 mm, were carefully calibrated and validated prior to the sample preparation. Table 2 shows the fabric characteristics of four knitted fabric samples.

Table 2: Fabric Characteristics

Fabric Type	GSM	Thickness (mm)	Courses/Wales (inch)
100% Bamboo	150	0.45	31 / 30
50:50 Bamboo/Cotton	178.2	0.54	31 / 30
70:30 Bamboo/Cotton	172.8	0.59	52 / 40
100% Cotton	185	0.74	52 / 40

Tension control mechanisms were implemented to ensure consistent yarn feeding and uniform loop formation throughout the knitting process. For each yarn blend, preliminary trial runs were performed to optimize machine parameters.

2.3 Test Methods

The evaluation of yarn and fabric properties was conducted using international test standards. The yarn strength and elongation properties were measured with the Single Yarn Strength Tester following ASTM D2256. A total of five tests

were conducted. Yarn evenness and defects were evaluated using the Uster Evenness Tester following ISO standard procedures. The key parameters measured include Um% (mass unevenness), which reflects the variation in yarn mass along its length and impacts fabric uniformity; CVm% (coefficient of mass variation), a statistical indicator of yarn mass consistency; and neps, which are small entangled fiber clusters that contribute to fabric imperfections. The yarn twist level was evaluated by measuring Twist per Inch (TPI) and Twist per Meter (TPM) using a Twist Tester instrument in accordance with ASTM D1423 standard. Each measurement was conducted with a minimum of five test runs. Fabric thickness was determined using a Digital Thickness Tester following ASTM D1777. The Pilling resistance was evaluated with a Martindale Abrasion & Pilling Tester according to ASTM D4970. The samples were tested for 5000 rubbing cycles. The air permeability test is carried out to find the rate of airflow through a fabric by the Air Permeability Tester as per ASTM D737. Water vapour permeability finds the moisture transmission rate through the fabric, indicating its breathability and comfort level. The water vapour permeability of the fabric samples was determined with a Gester Water Vapour Permeability Tester in accordance to ASTM E 96. Wicking behaviour was assessed with a Vertical Wicking Tester based on AATCC 197. All tests were performed at least five times.

2.4 Statistical Analysis

A one-way ANOVA assessed the effect of blend ratio on each property at $\alpha = 0.05$. Where appropriate, F and p values are reported.

3. Result and Discussion

3.1. Effect on yarn characteristics

The yarns utilized for fabric development were manufactured from 100% Cotton and 100% Bamboo fibres, each exhibiting distinct morphological and mechanical properties as outlined in Table 1. Bamboo fibres, with slightly greater staple length (31 mm), higher denier (1.6), and superior tensile strength (24.2 g/Tex), were particularly suited for ring spinning process. The ring spinning is known for producing fine, strong, and uniform yarns with excellent fibre orientation [22]. The higher elongation percentage (4.5%) and maturity ratio (0.89) of bamboo fibre further contributed to enhanced spinnability and reduced neps during drafting, as confirmed by physical characterization (Table 3). Table 3 presents a comparative evaluation of yarn characteristics derived from varying bamboo/cotton fibre blends. Cotton fibres, though marginally shorter in length (29 mm) and having lower tenacity (21.6 g/Tex), were also blended with bamboo via ring spinning to maintain consistency in yarn structure and facilitate comparative analysis. The comparative assessment of yarns produced from 100% cotton, 100% bamboo, and bamboo/cotton blends demonstrates significant differences in mechanical behaviour and structural consistency, reflecting the inherent characteristics of each fibre type.

3.1.1 Twist parameters (TPI and TPM)

The analysis of twist parameters indicates that blended yarns exhibit higher twist per meter (TPM) values, ranging from 833.7 to 844, which surpass those observed in the 100% bamboo and 100% cotton fibre yarns. This enhancement in twist efficiency is associated to the improved inter-fibre cohesion between bamboo and cotton during the spinning process. The 50:50 bamboo/cotton blends demonstrate the highest TPM, suggesting the formation of a more compact and structurally stable yarn. The higher twist per inch in blended yarn resulted in stiffer fabrics as compared 100 % cotton and bamboo yarn fabrics. This indicate the 100 % pure cotton and bamboo fabrics are softer than their blends.

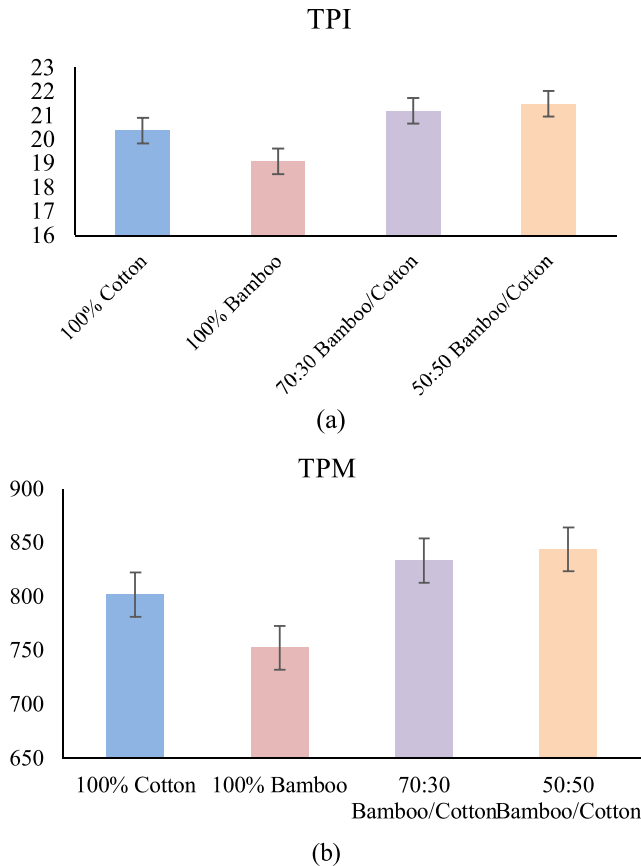


Figure 1 : Effect of Bamboo/Cotton fibre blending ratios on (a) Single yarn strength and (b)Elongation %

Figure 1 shows that yarn twist parameters vary significantly with bamboo/cotton blending ratios. For 100% cotton, TPI (~20) and TPM (~800) are higher than 100% bamboo (~18 TPI; ~725 TPM), reflecting cotton's higher crimp and surface friction. From figure 1 it has been observed that there is no significance difference between both blend yarn samples. Both blend samples with 70:30 and 50:50 bamboo/cotton shows ~21 TPI and higher TPM ~825 and ~850, respectively. The increased twist in blends may result from the corresponding interaction of bamboo's smoothness and cotton fibre's convolutions, enhancing fibre cohesion and yarn compactness. These results indicate that moderate blending optimises twist characteristics, potentially improving yarn strength, uniformity, and processing performance in ring spinning applications.

3.1.2 Single yarn strength and elongation%

In case of single yarn strength, the 100% bamboo yarn exhibits the better strength, than the 100% cotton yarn and the blended yarn structure. This superior strength of bamboo yarn is due to inherent tenacity and extensibility of bamboo fibres as per table no. 1. Among the blended yarn samples, the 70:30 and 50:50 bamboo/cotton compositions achieve a comparable strength value, indicating the mechanical integrity of the yarn were preserved at levels suitable for diverse textile applications as compare to 100% cotton .The synergistic cohesive force between bamboo and cotton fibres contributes to the overall performance of the blended yarns. Similarly, the good elongation % highlighted the mechanical advantages of bamboo fibres. The 100% bamboo yarn exhibits a significantly higher elongation value of 15.2%, compared to 4% for the cotton yarn. The better elongation % of bamboo yarn may be due to weaker cohesive force among the fibres that resulted in better elongation%. The incorporation of cotton into the blend resulted in a proportional decrease in elongation %, with the 70:30 blend yielding an intermediate value of 8%. This balance between elasticity and dimensional stability enhances the suitability of the blended yarns for robust and durable fabric constructions. The effect of bamboo/cotton fibre blending ratios on single yarn strength and elongation had been depicted in figure 2. These findings suggest that bamboo fibres contribute positively to both strength and elongation, whereas blending offers a balanced performance followed by optimising mechanical properties for diverse textile applications.

Table 3: Influence of Bamboo/Cotton Fibre Blends on Yarn Structural and Mechanical Properties

Yarn Type	TPI	TPM	Strength (gf)	Elongation (%)	Um %	CVm %	Thin (-50%)/Km	Thick (+50%)/Km	Neps (+280%)/Km	Hairiness
100% Cotton	20.39	801.82	325	4	9.61	12.14	0	20.25	13.75	7.52
100% Bamboo	19.1	752.6	348	15.2	9.42	11.86	0	3.22	4	6.50
70:30 Bamboo/Cotton	21.2	833.7	337	8	9.17	11.72	0	3.35	7.25	6.80
50:50 Bamboo/Cotton	21.5	844	332	6.5	9.21	11.77	0	4.5	9.3	7.00

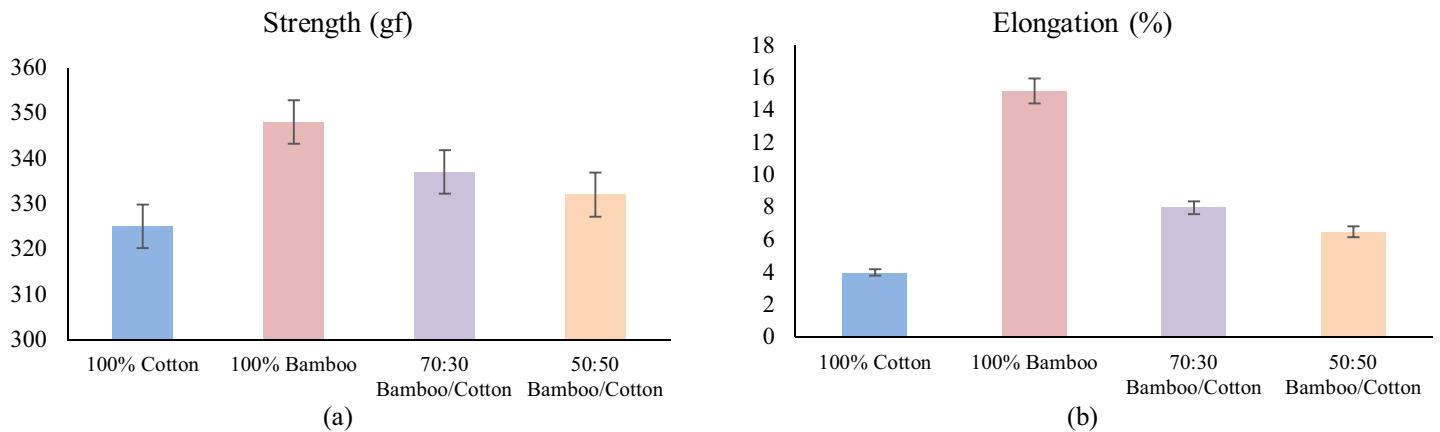


Figure 2: Effect of Bamboo/Cotton fibre blending ratios on (a) Single yarn strength and (b) Elongation %

3.1.3. Evenness parameters and Yarn faults

The assessment of yarn evenness (Um% and CVm %) revealed similar performance across compositions, although the 70:30 blend shows the lowest CVm% (11.72), signifying improved mass evenness. The imperfection analysis presented in Table 3 had shown absence of thin places across all yarn samples, indicating effective control over the drafting process during spinning. The 100% bamboo yarn samples exhibited lowest level of yarn faults (imperfections), with zero thin places, (3.22) thick places/km and 4 neps/km, showing superior fibre uniformity and favourable spinnability. In contrast, the 100% cotton yarn exhibited substantially higher imperfections, with 20.25 thick places/km and 13.75 neps/km. These imperfections are likely associated with the shorter fibre length and lower fibre evenness as shown in Table 1. The blended yarns had exhibited intermediate imperfections, reflecting a balance between the properties of bamboo and cotton fibres. The increased proportion of cotton fibre in the blend may correlates with aincrease in yarn imperfections, signifying that fibre composition plays a critical role in determining yarn quality and uniformity. These results demonstrate that 100% bamboo yarn is characterized by superior single yarn strength, higher extensibility, and minimal imperfections, making it highly suitable for performance-oriented textile applications. In contrast, cotton yarn exhibits comparatively lower elongation and a higher frequency of yarn defects, which affect its mechanical and quality performance. In case of blended bamboo/cotton yarn samples, particularly those with 70:30 ratios, offer a balanced combination of mechanical resilience and uniformity, supporting their potential in functional and sustainable apparel manufacturing.

3.1.4 Hairiness

From Fig 3 the results had shown that 100% cotton yarn exhibited higher hairiness value (7.52), indicating a greater number of fibres ends protruding from the yarn surface. This can be attributed to the shorter fibre length distribution and higher cleaning intensity required during cotton blow room processing. In contrast, 100% bamboo lyocell yarn demonstrated lower hairiness (6.50), which might be linked to its smoother, more uniform fibre morphology and lower beating points requirements during blow room operations,

reducing fibre damage and surface distortion. The blended yarns (70:30 and 50:50 bamboo/cotton) had shown values in range of 6.80–7, suggesting that the incorporation of bamboo fibres had reduced hairiness of cotton yarn due to improved fibre packing and cohesion. From a sustainability perspective, lower hairiness in bamboo and blended yarns indicates a reduction in fabric defects such as pilling, leading to longer garment life and decreased fibre waste in subsequent finishing and usage stages.

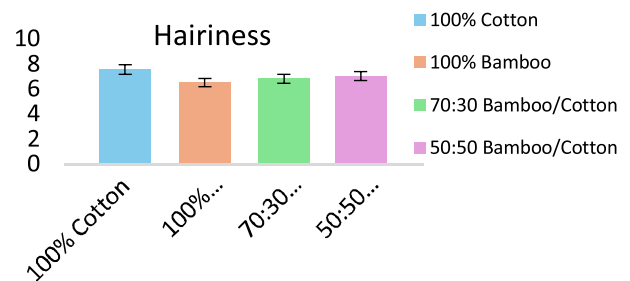


Figure 3: Effect of Bamboo/Cotton fibre blending ratios on Yarn Hairiness

3.2 Influence of Bamboo/Cotton Yarn Blends on Fabric Performance Characteristics

The study investigates the influence of different fibre proportion in blended yarn on the functional performance of four different knitted fabric samples 100% bamboo lyocell,

Table 4: Comparative Analysis of Fabric Characteristics Developed from Varying Bamboo/Cotton Yarn Blends

Test Parameters	100% Lyocell Bamboo	100% Cotton	70:30 Bamboo / Cotton	50:50 Bamboo / Cotton
Abrasion Resistance Rating (1–5)	4	3	3-4	3-4
Pilling Resistance Rating (1–5)	3-4	3-4	3-4	3-4
Shrinkage Course wise (%)	14	12	10	14
Shrinkage Wales wise (%)	1	1.5	1	1
Air Permeability (cm ³ /cm ² /s)	125	100	115	110
Water vapor Permeability (g/m ² .day)	5.88	3.2	3.18	4.76
Wicking (cm/5 Min)	7.5	6.2	7.3	7.2

100% cotton, 70:30 Bamboo/Cotton, and 50:50 Bamboo/Cotton. Table 4 demonstrate trends in abrasion resistance, pilling behaviour, dimensional stability (shrinkage %), air permeability, and wicking behaviour of four samples.

3.2.1. Abrasion and Pilling Resistance

The 100% bamboo fabric exhibited better abrasion resistance rating (4), while the blended variants (70:30 and 50:50 bamboo/cotton) showed slightly lower ratings (3–4) followed by 100% cotton fabric samples. The poor abrasion resistance of cotton is due to the lower tensile strength and shorter staple length. The smoother fibre surface and longer staple length of bamboo fibre contributes to enhanced resistance against frictional force [4]. Pilling rating of all four samples were in the range (3–4), indicating that the yarn blend % had poor impact on surface fuzz formation. The constant value of pilling rating in all samples demonstrate that yarn spinning technique and fabric construction parameters played a more dominant role in controlling pilling behaviour rather fibre composition. Figure 4, demonstrates no significant difference in abrasion resistance of both blended fabric samples.

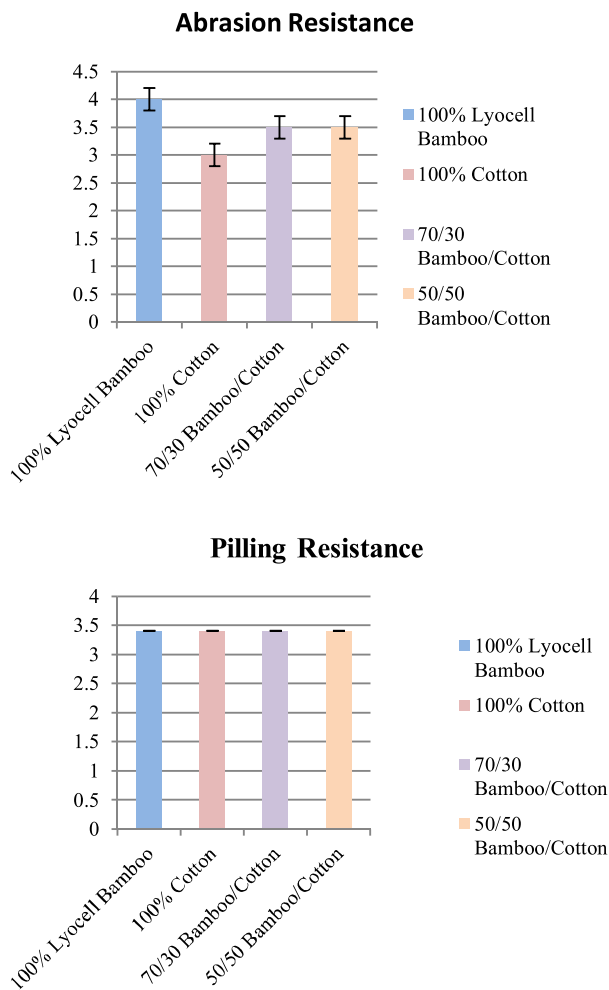


Figure 4: Effect of Bamboo/Cotton fibre blending ratios on Abrasion and Pilling Resistance of Fabric

3.2.2. Shrinkage Behaviour

From Table 4 & Fig.5 the Course-wise lowest shrinkage was observed in 70:30 bamboo/cotton blend (10%), followed by 100% cotton (12%), while both the 100% bamboo and 50:50 bamboo/cotton blends exhibited higher shrinkage at 14%.The improved dimensional stability in 70:30 blended fabric sample might be due to lower cotton's % as compared to 50/50 blend % .The higher moisture absorption in bamboo fibre contributed higher shrinkage in 100% bamboo and higher bamboo-content blends.The bamboo fibre has lower degree of polymerization hence higher number of reactive sites for water molecules absorption. Wales-wise shrinkage remained uniform across all samples (1%), suggesting that vertical dimensional changes are more influenced by knitting tension and loop configuration than fibre type.

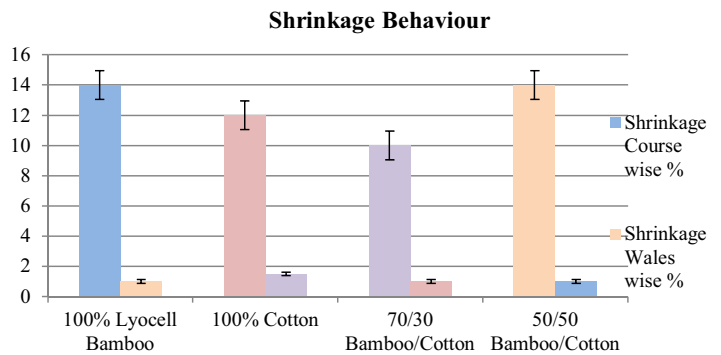


Figure 5: Effect of Bamboo/Cotton fibre blending ratios on Shrinkage Behaviour of Fabric

3.2.3. Air and Water Vapour Permeability

From table 4 & Fig.6, the highest air permeability was observed in the 100% bamboo fabric (125 cm³/cm²/s), followed by the 50:50 and 70:30 blends (115 and 110 cm³/cm²/s, respectively), whereas the 100% cotton fabric

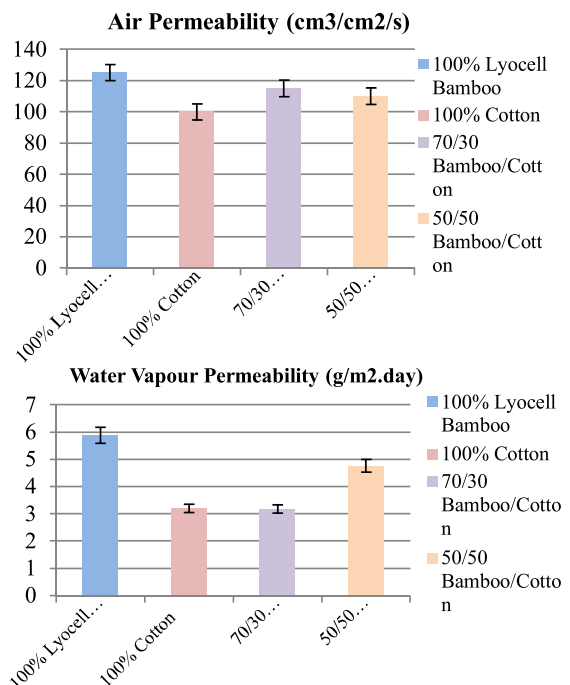


Figure 6: Effect of Bamboo/Cotton fibre Blends on Air Permeability and Water Permeability

show the lowest air permeability ($100 \text{ cm}^3/\text{cm}^2/\text{s}$). The higher % of interstices between loop and wales of knitted structure and smoother surface of bamboo fibre improved airflow, whereas the dense inter yarn spacing due to strong cohesive force in 100 % cotton knitted fabric, decreased the permeability.

Water vapour permeability followed a similar trend, with the 100% bamboo sample depicting the higher transmission rate ($5.88 \text{ g/m}^2/\text{day}$) as compared to the 100% cotton samples ($3.2 \text{ g/m}^2/\text{day}$). The 70:30 blended fabric had shown lower vapour permeability ($3.18 \text{ g/m}^2/\text{day}$), indicated that increased cotton % decreased moisture diffusion due to increased cohesive force among fibres and increased binding of fibres. Figure 3 illustrated the influence of bamboo/cotton blend proportion on the air and water vapour permeability of knitted fabrics. These results suggested that bamboo-rich fabrics offer superior breathability and moisture management.

3.2.4. Wicking Behaviour

The wicking results presented in Table 4 & Fig.7 clearly indicate that fabric composition plays a crucial role in influencing moisture transport properties. The 100% bamboo sample exhibits the highest wicking height, reaching approximately 7.5 cm, which indicates superior capillary action and efficient moisture movement. The 70:30 bamboo/cotton blends show a slightly reduced wicking height of around 7.3 cm, suggesting the possible influence of cotton fibre which moderates the bamboo's inherent moisture transport capability. The 50:50 bamboo/cotton blend observed the wicking value, approximately 6.9 cm, reflecting further reduction in wicking efficiency as cotton content increases, which is further confirmed by the lowest wicking behaviour of 100% cotton (6.2 cm). These results suggest that as the proportion of bamboo fibre decreases, the ability of the fabric to wick moisture decreases. The naturally hollow structure and hydrophilic properties of bamboo enhance moisture transfer, while the denser morphology and lower absorbency of cotton as compared to bamboo lyocell limit capillary activity. Consequently, fabrics with higher bamboo lyocell content are better suited for end uses where rapid moisture movement and comfort are essential, such as sportswear and active apparel [6, 8].

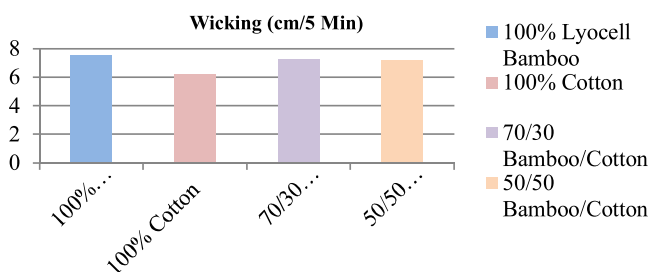


Figure 7: Effect of Bamboo/Cotton fibre Blends on wicking behaviour

3.3 ANOVA Analysis

The one-way ANOVA (Table 5) shows the significance of fibre proportion on different fabric structures. The yarn blend composition significantly affects most fabric properties except shrinkage in the wale direction ($p = 0.9820$). Course-

wise shrinkage, air permeability, water vapour permeability, and wicking properties shows significant differences ($p < 0.001$), with bamboo-rich fabrics generally show greater significance as compared to other 100% cotton fabric samples in moisture management and breathability due to their higher hydrophilicity, capillary action, and hollow structure. The absence of variation in wale-wise shrinkage suggests that knitting structure dominates dimensional stability in that direction, while the strong influence of blend ratio on other parameters highlights the enhanced comfort-related performance in bamboo knitted fabrics.

Table 5: One Way ANOVA Summary for Fabric Characteristics across various Yarn Blends

Parameter	DF (Between)	DF (Within)	F-Value	P-Value	Significance ($\alpha=0.05$)
Shrinkage Course-wise (%)	2	12	97.89	0.0001	Significant
Shrinkage Wale-wise (%)	2	12	0.14	0.5255	Not Significant
Air Permeability ($\text{cm}^3/\text{cm}^2/\text{s}$)	2	12	16.20	0.002	Significant
Water Vapour Permeability ($\text{g/m}^2/\text{d}$)	2	12	462.61	0.0031	Significant
Wicking (cm)	2	12	34.76	0.0001	Significant

4. Conclusion

This study revealed that the yarn blend % significantly influenced many functional properties of knitted fabrics. The findings suggested that the 100% bamboo fabric consistently had exhibited superior air permeability ($125 \text{ cm}^3/\text{cm}^2/\text{s}$) and water vapor transmission ($5.88 \text{ g/m}^2/\text{day}$), and outperforming other blends ($p < 0.001$). The 70:30 blend had shown significant improvement in shrinkage control (10%) compared to other samples. The fibre interaction (cohesive force) and fibre distribution in yarn affected wicking behavior and exhibited a similar trend in all samples. 100% bamboo fabric offers superior breathability, moisture management, and abrasion resistance, making it suitable for performance-oriented applications. The 70:30 blends had possessed better shrinkage control but compromises on wicking and vapor permeability. The 50:50 blends offers a balanced structure, offering moderate durability and comfort. The yarn blend composition had a statistically significant effect on the knitted fabric properties ($p < 0.001$), with no significant effect on wale wise shrinkage ($F(2, 12) = 0.14, p = 0.5255$). The higher elongation (15.2%), greater single yarn strength (348 gf), and improved yarn evenness (fewer thick places and neps) in the bamboo lyocell yarn's make it superior as compared to 100% cotton in various moisture management applications. Their superior moisture management, breathability, and wearer comfort make them a compelling choice for sustainable fabric development.

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AHMEDABAD UNIT

Nutrition Kit Distribution

The Textile Association (India) Ahmedabad Unit & SIDBI jointly organized a seminar on “ESG related Compliance for Competitiveness & Business Continuity for MSMEs”. Ms. Sivaranjani Subramanian, Chief Operation Officer and Mr. Prahlad Tewari, Vice President of Environmental Management Centre Pvt Ltd delivered the speech on the subject matter. During the deliberations speaker focused on integrating ESG into their core strategies. MSMEs can drive long-term growth, attract investments, and contribute to a more sustainable and inclusive global economy. The discussions during the seminar were highly informative for the audience.



15th September, 2025

A half day technical program was organized on Textile Start Up Ecosystem. About 10 textile startups were invited and they made presentation in front of investors who were invited from industry. Two startups were given assurance about mentoring. The startups were in the areas of product design, technical textile, smart textiles, wearable electronics, waste recycling etc.

19th September 2025

A full day conference was organized on Investor Conclave on Comprehensive Sportswear Manufacturing Projects in India. The conference witnessed a remarkable step toward shaping the future of sports textiles and activewear manufacturing. The event was aimed to encourage industrialists and investors to explore this high-growth sector. Over 70 potential investors joined the event, with engaging presentations led by Mr. Ravi Bhushan Arora (CEO) and Mr. Kr Abhishek Ambasthaa (MD), Unified Knowledge Services Private Limited, Textile Business Digest - TBD.

Event Highlights: Dr. Ashwin Thakkar emphasised the growing importance of sports textiles in India's dynamic market. Mr. Arora showcased various sports apparel and activewear products, highlighting domestic and global opportunities.

Leading Indian sportswear brands like STRCH, Mr. Sharad Tandon and SPORTSKIN INTERNATIONAL PRIVATE LIMITED, Mr. Mridul Das expressed strong interest in sourcing from Indian manufacturers, provided global standards of quality and scale are met.

Mr. Dinesh Keswani, Hyosung India Pvt. Ltd. assured raw material supply consistency, while technology providers from Taiwan, Korea, and Europe demonstrated advanced machinery for sportswear production.

The biggest achievement of the event was direct networking between investors, raw material suppliers, brand owners, and machinery firms. This event not only spotlighted the untapped potential of sports textiles in India but also positioned Ahmedabad as an emerging hub for sports apparel manufacturing.



25th September, 2025

A half day technical program was organized on Impact of Geopolitical Issues and Tariff Restructuring on Textile Industry. Mr. Eishiro Takeishi, Asia Editor of the Asahi Shimbun, Japan deliberated on various issues with reference to current geopolitical issues and its impact on South Asian Countries especially India. He also talked about tariff restructuring across various trade blocks and its impact on textile trade between India and Japan. The program was well accepted by the audience.

27th September, 2025

Prize distribution function to the Bright Students:

The Textile Association (India) Ahmedabad Unit arranged a prize distribution function to the bright students from donations of “Late Shri B. A. Shah Educational & Welfare Fund; Hirabhai J. Patel Textile students' diploma/degree fund and other funds” held on 27th September' 2025 at Dinesh Hall, Ashram Road, Ahmedabad. During the prize distribution function, the association distributed total 28 Mementoes and 40 certificates to the selected qualified students of SSC/CBSE, HSC-Science & Commerce, Ph. D in Textile Engineering, Bachelor & Master of Pharmacy, LLB, BDS & other Engineers (Computer, Electrical etc).



Shri Hirabhai J. Patel, Vice President handed over the certificates & mementoes to the Textile Manufacturing, Textile Technology & Textile Engineering rankers' student of LDCE & RCTI, Ahmedabad. Every year association has been organizing this function to encourage the students. One memento with certificate handed over to a student who successfully completed ATA diploma on Textile Yarn Manufacturing group through TAI-Ahmedabad unit in the year 2024 from the T. L. Patel, ATA prize fund.

Life Time Achievement awards 2025:

As a part of the prize distribution function The Textile Association-Ahmedabad Unit also handed over Lifetime Achievement Awards to the most senior and honorable members Shri Kanaiyalal J. Patel & Shri Gaurang J. Dwivedi who rendered their valuable services towards the association & Textile Industries for almost 40 years in different way. Their contributions were memorable to the association. This lifetime achievement award was donated by Late Shri B. R. Shah, Past President and Trustee of the TAI-Ahmedabad Unit.



78th Annual General Body Meeting of the Textile Association (India) Ahmedabad Unit

The Textile Association (India) Ahmedabad Unit arranged its 78th Annual General Body Meeting on 27th September 2025 at its premises Dinesh Hall, Ashram Road, Ahmedabad.

The AGM was conducted as per the agenda, and Shri Haishchandra C. Shah, Hon. Secretary welcomed the meeting and presented the association's activities from 1st April, 2024 to 31st March 2025. Shri Hasmukhbhai S. Patel, President remarked in his speech that the association organized regular technical programs and also carried out activities for member's welfare and now association is also working towards the society activities. Not only that association also arranged Internship textile training program for the textile engineering students of L. D. College of Engineering and RCTI, Ahmedabad.



12th October 2025



A Ras Garba Mahotsav was done at the premises of Dinesh Hall. All committee members with their families enjoyed the festival. Prizes were also given to winners of the Mahotsav.

21 & 22 November 2025

All the GC members and 5 Office Bearers attended 78th All India Textile Conference held on 21st & 22nd November 2025 at Hotel Le Meridine, Coimbatore, Tamil Nadu. From our association two honourable senior members were awarded Service Gold Medal and Service Memento for the period (2024-25) during the inaugural function of the said conference.



Shri Ashokkumar D. Patel, GC member of TAI-A'bad Unit was receiving Service Gold Medal (2024-25) & Certificate



Shri Mahendrabhai G. Patel, GC member of TAI-Abad Unit was receiving Service Memento (2024-25) & Certificate Donated by Shri J. J. Randeri



29th November 2025

A get together function for all members of the association was arranged. The social and message-oriented drama “Mobile ne Melo: Medan Ma Khelo” was shown to all members. About 700 members and their family attended the function. The program was followed by dinner.

CONGRATULATIONS

The committee members of TAI-Ahmedabad Unit being selected as office bearers & Trustee of The Textile Association (India) Central Office for the term 2025-2027.



Mr. Mahendrabhai G. Patel
Vice President



Mr. Ashokkumar D. Patel
Hon. Jt. Gen. Secretary



Mr. Hareshkumar A. Patel
Trustee

22nd December 2025 – 6th January 2026

Under the member's welfare activity every year The Textile association (India) Ahmedabad Unit is distributing groundnut oil tins to the needy members with 30-35% subsidy on its market price. This year, total 3318 groundnut oil tins were distributed among the members.



24th December 2025

Under the society welfare activities, the Association distributed nutrition kits to the pregnant women in the Ahmedabad (E) area who are suffering from malnutrition during the pregnancy period. Around 147 kits distributed on 24th December and 53 kits on 25th January 2026.

23rd January 2026

The all members of The Textile Association (India) Ahmedabad have enthusiastically welcomed the recent amendments made in the new Textile Policy 2024, implemented by the Gujarat Government with a view to the all-round development of the textile industry. A brief program was organised to apprise all members about the new amendments in the Gujarat Textile Policy 2024. The event was followed by a press conference.

A press conference was organized by The Textile Association (India) Ahmedabad Unit at meeting room of Dinesh Hall regarding these reforms. In the press conference, Textile Association's Chairman, Dr. Ashwin Thakkar said that the

government's decision to allow non-polluting units in metropolitan areas is historic. This step will benefit small and medium-sized units under various government assistance schemes and will give a new direction and momentum to the state's textile industry.

On this occasion, Trustee of the Association Shri T. L. Patel welcomed the government's decision and said that now that units operating in metropolitan cities are legally recognized, the operators will get many practical benefits. The obstacles in the operation of the units will be removed and the industry will get great benefits from various incentives like capital subsidy, interest subsidy on loans and power tariff subsidy. These reforms made by the government have increased the confidence of the traders and will provide stability to the industry.

It is worth mentioning that according to the new amendments made by the Gujarat government in the Textile Policy-2024, now non-polluting units will be allowed in metropolitan areas as well, so that they can get the benefit of various incentives provided by the government. Along with this, self-help groups run by women and single groups have also been covered under the benefit of all types of incentive assistance.

It was also said that women play an important role in the textile industry, especially in the garment industry. For this reason, through these reforms, the government's approach to women is not just as a beneficiary but as an economic partner. It is also hoped that these reforms will give a new inputs to women's empowerment. The members expressed the hope that all these reforms will open new doors of development for the textile and garment industry of Gujarat.



Gujarat Textile Policy 2024 Brings Big Relief to Urban Units



31st January 2026

The Textile Association (India) Ahmedabad Unit arranged a natak/drama in collaboration with the Ahmedabad Municipal Corporation Primary Education Committee, Ahmedabad on “Mobile Melo Maidan ma Khelo” for the primary children of corporation schools. The producer of the said natak is Shri Prashantbhai Barod (CHANDRAKALA). It's an awareness program among the children who are maximum missusing the mobile in their teenage. Every Saturday from 9am – 12noon the natak plays at Dinesh hall auditorium of the textile association. As a refreshment, a drinking water bottle and a packet of biscuit are being provided by the Association for every student after the every show.



7th, 14th, 21st & 28th February 2026

The Textile Association (India) Ahmedabad Unit arranged a natak/drama in collaboration with the Ahmedabad Municipal Corporation Primary Education Committee, Ahmedabad on “Mobile Melo Maidan ma Khelo” for the primary children of Munciple Corporation schools. The producer of the said natak is Shri Prashantbhai Barod (CHANDRAKALA). It's an awareness program among the children who are addict to mobile. Every Saturday from 9am – 12noon the natak plays at Dinesh hall auditorium of the textile association.



As a refreshment, a drinking water bottle and a packet of biscuit are being provided by the Association for every student after the every show.

10th February 2026

Bureau of Indian Standards Ahmedabad in association with TAI-Abad Unit organized a seminar on “Industrial Awareness Programme” held at C. C. Vakil Meeting room of Association. In the meeting eminent speakers delivered speech on the following subject matter:

- Introduction to BIS and its activities
- Discussion on Quality Control Orders (QCOs) applicable to textile products
- Conformity Assessment Schemes
- Benefits of ISI Mark Certification for textile manufacturers & special concessions



About 30-35 leading industrialists attended the said seminar.

16th & 17th February 2026

The 63rd Joint Technological Conference (JTC) organised by the India's leading textile research associations, ATIRA, BTRA, SITRA and NITRA at J.B. Auditorium, AMA, Ahmedabad. In this prestigious conference, The Textile Association (India) Ahmedabad Unit played a vital role as one of the Supporting Organisations to extending and encouraging wider participation from the industry stakeholders.



13 office bearers & Managing Committee members attended the said two days' conference. Dr. Ashwin Thakkar, Chairman worked as Jury member for the awards to best papers.

22nd & 23rd February

Chairman of TAI-AU Dr. Ashwin Thakkar was invited by Quality Council of India, Delhi to participate in National Quality Conclave held at WTC and Bharat Mandapam Delhi. Dr Thakkar provided various suggestions regarding Quality Improvement and implementation of Standards in the field of Textile.



27th February 2026

The Textile Association (India) Ahmedabad Unit donated two interactive smart panel boards for the class room of Textile Manufacturing Technology and Textile Processing Technology Department of R. C. Technical Institute, Ahmedabad. The said boards inaugurated by the worthy hands of Shri T. L. Patel, Trustee of our association. In such auspicious moment some Office bearers of association, faculties & students were present of R. C. Technical Institute.



9th March 2026

Under the society welfare activities, the Association distributed nutrition kits to the pregnant women in the Ahmedabad (E) area who are suffering from malnutrition during the pregnancy period. Around 21 kits distributed on that day.

17th March 2026

The Textile Association (India) Ahmedabad Unit will be hosting 79th All India Textile Conference (AITC) at Dinesh Hall, Ahmedabad tentatively in November 2026. A small group of senior leaders from various industry associations were invited from the textile, apparel and technical textile segments, for a short brainstorming discussion to have their insights in shaping the context and key themes for the conference.

The interactions were concise, meaningful, and focused on real industry opportunities. Around 22 leaders from different industries and senior office bearers interacted during the meeting.



25th March 2026

The Textile Association (India) Ahmedabad Unit, in association with the Quality Council of India (QCI), organized a Technical Seminar on “Comprehensive Quality Management in Textile” on 25th March 2026 at the meeting room, 1st Floor, Dinesh Hall, Ahmedabad. Mr. T. L. Patel, Trustee of the association welcomed all the speakers by offering flower of bouquets and also welcomed all the invitees in the seminar. Around 30-35 industrial key personalities attended the seminar. 7 eminent speakers delivered their speech on the subject matters during the seminar. Subjects covered like: Overview of Quality Council of India and its activities, Ensuring Quality of Test Results through NABL Accredited Testing Lab (In-house/third party) for Global Acceptance, Enhancing Competitiveness through Zero Defect Zero Effect (ZED) and LEAN competitive Schemes, Why regulatory Compliance Matters: Key Benefits for MSMEs, AI Centre of Excellence on the new technologies, Guidance and handholding support to achieve world-class manufacturing standards through Accreditation and Certification (ISO Certification/GOTS Overview /Better Cotton initiative Certification), about NABL Accredited Lab Testing Facilities.



International Conference on Futuristic Trends in Textiles – 2026

SVKM's NMIMS Centre for Textile Functions Successfully Organized International Conference on “Futuristic Trends in Textiles – 2026”

The International Conference on “Futuristic Trends in Textiles – 2026 (FTT-2026)” was successfully organized on 27th and 28th March 2026 at the Centre for Textile Functions (CTF), under SVKM's NMIMS Deemed-to-be University, Shirpur Campus. The conference was conducted in hybrid mode (online and offline) in collaboration with The Textile Association (India).

The two-day international event witnessed participation from more than 150 students, academicians, researchers, and industry experts representing 13 textile institutes from across India, along with eminent international speakers, making it a significant platform for global knowledge exchange in the field of textiles.

Objectives of the Conference

The conference aimed to:

- Provide a platform for researchers, academicians, and industry professionals to share innovative ideas and research findings
- Highlight emerging trends in artificial intelligence, sustainability, and advanced textile technologies
- Strengthen industry-academia collaboration
- Encourage students to engage in research and innovation in textile engineering

Leadership and Guidance

The event was organized under the guidance of SVKM's leadership including Hon'ble Chancellor and former Minister Shri. Amrishbhai Patel, Co-President Shri. Bhupeshbhai Patel, Vice President Shri. Chintanbhai Patel, Management Committee Member Shri. Rajgopal Bhandari, Campus In-charge Mrs. Rita Patel, and Campus Director Dr. Sunita Patil.

Inauguration Ceremony

The conference was inaugurated with Saraswati Poojan and ceremonial lamp lighting in the presence of distinguished guests. The dignitaries included Vice President of the Textile Association of India and industrialist Mr. Mahendrabhai G. Patel, Representative Director – India (Mumbai Frontier Cool, Taiwan) Dr. Vijay D. Gotmare, Country Director of Clean Globe, Mumbai Mr. Abhishek S. Kamble, Campus Director Dr. Sunita Patil, Associate Dean Dr. Vijay Shivankar, and General Manager of Deesan Tex Fab Mr. Laxman C. Patil.

In his address, Mr. Mahendrabhai G. Patel, Guest of Honour of the conference, emphasized that students should not rely solely on job opportunities but should also explore entrepreneurship and innovation in the textile sector.

Dr. Sunita Patil highlighted that in the era of automation and artificial intelligence,

equal importance must be given to sustainability and innovation in smart textiles. She stated that such conferences provide an effective platform for researchers, academicians, and experts to present their ideas and research work.

Dr. Vijay Shivankar mentioned that the Centre for Textile Functions (CTF) plays a crucial role in bridging the gap between industry and academia by offering industry-oriented programs, thereby creating opportunities for both rural and urban students in textile education and research.

Technical Sessions and Expert Talks

The two-day conference featured renowned experts, academicians, and researchers from India and abroad. The conference included keynote lectures, plenary sessions, and technical paper presentations.



- Prof. Dr.-Ing. habil. Lars Hahn, Full Professor of Sustainable Textile Materials Engineering, Hof University of Applied Sciences, Hof, Germany, delivered a session on “From 2D to 3D Textile Technologies for Fiber Composites.”
- Dr. Nimesh Kankariya, Director, Texmat Research Limited, Auckland, New Zealand, spoke on “Technical Textiles: Trends and Future Innovation.”
- Dr. Vijay D. Gotmare, Representative Director – India, Mumbai Frontier.cool Inc., Taiwan, and Former Professor & Head, Textile Manufactures Department, VJTI, Mumbai, India, delivered the keynote lecture on “The Intelligent Textile Era: AI-Driven Innovation for a Sustainable Apparel Future.”
- Dr. Javed Sheikh, Associate Professor, Department of Textile and Fibre Engineering, Indian Institute of Technology (IIT) Delhi, New Delhi, India, presented research on advanced functional textiles.
- Mr. Abhishek Shankar Kamble, Country Director – India, Clean Globe, Mumbai, Maharashtra, India, discussed “Sustainability Certification in Textiles.”
- Mr. Baiju Babu, Regional Product Manager, Rieter India Private Limited, Pune, Maharashtra, India, delivered a session on “Digital and Automation,” highlighting the role of smart manufacturing and Industry 4.0 in modern spinning processes.
- Mr. Shridhar Kane, Regional Product Manager, Rieter India Private Limited, Pune, Maharashtra, India, spoke on “Potential for Sustainable Spinning,” focusing on energy efficiency, waste reduction, and sustainable yarn production practices.
- Mr. Deepak S. Karade, Senior Manager – Sales, A.T.E. India Limited, Mumbai, Maharashtra, India, presented on “Technical Textiles,” emphasizing how engineering precision, functionality, and performance are redefining product value and driving transformation in the textile sector.
- Mr. Amar Surve, Deputy General Manager – Sales, A.T.E. India Limited, Mumbai, Maharashtra, India, spoke on “Sustainable Nonwovens,” discussing eco-friendly nonwoven materials using cotton and pulp-based systems with industrial applications.
- Mr. Manish Mashilkar, Senior Manager – Sales, A.T.E. India Limited, Mumbai, Maharashtra, India, delivered insights on “Composites and Geotextile Machinery,” detailing recent machinery innovations with practical examples from industry applications.

Technical Paper Presentation Competition

During the technical paper presentation competition held as part of the conference, students demonstrated outstanding performance and were recognized for their excellence. The presentations were conducted in two tracks Track I for undergraduate students and Track II for postgraduate students.

A total of 70 papers were presented in Track I and 31 papers in Track II, with participation from more than 150 students representing 13 textile institutes across India.

The selected research papers will be published in Scopus-indexed journals, namely the Journal of Textile Association and Man-Made Textiles in India, contributing significantly to academic research dissemination.

Awards and Recognition

At the undergraduate level, Barath Balaji R.N., Bhoomika V., Nandhini R., Sejal Nakati, and Varad Prasad Deulkar received prizes for their commendable research contributions.

At the postgraduate level, Dr. Ashish Hulle, Dr. Subhankar Maity, and Adamali Shaukatali Ansari were also awarded prizes for their exceptional work.

These recognitions reflect the high quality of research, innovation, and practical relevance demonstrated by the participants.

Media and Publication Support

The conference received extensive support in terms of publicity and academic dissemination from reputed organizations in the textile sector. Textile Value Chain, Textile Daddy, and SASMIRA (Synthetic & Art Silk Mills' Research Association) extended their support as media partners, ensuring wider outreach and visibility of the event across the textile industry and academic community.

Additionally, the Journal of Textile Association and Man-Made Textiles in India supported the conference as publication partners, facilitating the publication of selected research papers and contributing to the dissemination of high-quality research at both national and international levels.

Conference Outcomes and Impact

The conference served as an effective platform for knowledge exchange, networking, and collaboration between academia and industry. The discussions highlighted key emerging areas such as artificial intelligence, sustainability, smart textiles, and advanced materials.

Participants gained valuable insights into industry trends, research opportunities, and technological advancements, thereby enhancing their academic and professional development.



Coordination and Support

The conference was successfully coordinated by Dr. Sujit Gulhane and Dr. Prafull Kolte under the guidance of Dr. Sunita Patil and Dr. Vijay Shivankar. Administrative Officer Mr. Shivaji Gaikwad and his team played a vital role in the smooth execution of the event.

The event was made possible with the collective efforts of all CTF faculty members, staff, and student representatives.

The management and leadership appreciated the successful organization of the conference. The overwhelming response and active participation highlight the growing importance of such platforms in advancing textile research and innovation.

Building on the success of FTT-2026, the institute aims to continue organizing such international conferences in the future to strengthen global collaboration, promote sustainable practices, and foster innovation in the textile sector.

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TIT&S Bhiwani Inaugurates COLORANT Centre of Excellence

A Meaningful Gurudakshina by Alumnus Mr. Subhash Bhargava to His Alma Mater



The Technological Institute of Textile & Sciences (TIT&S), Bhiwani, achieved a significant milestone with the inauguration of the COLORANT Centre of Excellence (CoE) during the National Workshop on “Responsible Textile Colouration” held on 23rd May 2026.

The Centre was inaugurated by Mr. Subhash Bhargava, Founder & Managing Director of COLORANT Limited and a proud alumnus of TIT&S Bhiwani. The occasion became especially emotional and inspiring as the initiative was seen as a true “Gurudakshina” - a meaningful contribution by a former student toward the growth and advancement of his alma mater. Mr. S. K. Ojha, Executive Vice-President of Vardhman Textiles, attended the event as Guest of Honour.

The newly established Colorant Centre of Excellence has been designed to bridge the gap between academic learning and industrial practices in textile dyeing, chemical processing, quality control, and sustainable colouration technologies. Equipped with advanced modern laboratory infrastructure, the centre will provide practical industrial exposure to students, researchers, and textile professionals.

The Colorant Centre of Excellence has been equipped with advanced laboratory instruments and pilot-scale processing machinery to provide students with hands-on industrial exposure in textile colouration, dyeing, quality control, and

fastness evaluation. The facility includes modern testing and colour assessment systems such as a Spectrophotometer with Transmission Kit, Color iQC & Quality Control Software, Nano Vision Lite Color Matching Cabinet, SmartRub XT Advanced Crock Meter, Wash Fastness Tester (Laundrometer), Digital Sublimation Fastness Testing Equipment, and a Humidity Chamber. To strengthen practical understanding of textile processing operations, the centre also houses an Infra Colour Dyeing Machine with standard accessories, Universal Padding Mangle, Continuous Dyeing Range, Universal Steamer, Hot Air Oven, and Mini Stenter, creating a comprehensive industry-oriented learning environment for future textile professionals.

Addressing the gathering, Mr. Subhash Bhargava emphasized the importance of sustainability, innovation, and industry-oriented skill development in the evolving textile sector. He encouraged students to combine technical excellence with responsible manufacturing practices to meet global textile industry standards.

The event witnessed enthusiastic participation from academicians, students, and textile industry professionals, reaffirming TIT&S Bhiwani's commitment toward promoting responsible textile innovation and stronger industry-academia collaboration.

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The Textile Association (India) – Central Office

(Registered under the Society's Registration Act XXI of 1860 and under Bombay Public Trust Act XXIX of 1950)
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RESULTS FOR ATA PART I - PASSED/ATAHE CANDIDATES DECEMBER, 2025

Centre / Result	PASS	ATAHE
Ahmadabad	2025/01, 2025/02, 2025/03, 2025/04	-
Bhilwara	2025/10, 2025/11, 2025/12	-
Coimbatore	2025/20, 2025/21, 2025/22	-
Delhi	2025/30, 2025/31, 2025/32	-
Ichalkaranji	2025/40	-
Mumbai	NIL	-

Total	Registered	Appeared	Passed	ATAHE	PASS %
	15	14	14	NIL	100%

RESULTS FOR ATA PART II- DECEMBER, 2025

Centre / Result	PASS	ATAHE
Ahmadabad	2025/501, 2025/502	-
Bhilwara	NIL	-
Coimbatore	NIL	-
Delhi	2025/510, 2025/511	-
Ichalkaranji	2025/520	-
Mumbai	2025/530, 2025/531	-

Total	Registered	Appeared	Results	ATAHE	Passed %
	7	7	7	NIL	100%

ATA Part-II Result is withheld for Roll No. 2025/510, 2025/511 & 2025/520 for want of submission of Industrial Report.

RESULTS OF ATA PART III - PASSED CANDIDATES DECEMBER, 2025

Centre	Yarn Manufacture	Fabric Manufacture	Textile Wet Processing	Knitting & Garment Manufacture
Ahmedabad	2025/601 2025/602, 2025/603	-	-	-
Bhilwara	2025/610	-	-	-
Coimbatore	2025/620	-	-	-
Delhi	-	2025/701	-	-
Ichalkaranji	-	-	2025/801, 2025/802	-
Mumbai	2025/630	-	-	-

ATA Part-III Result will be declared after submission of Industrial Report for Roll No. 2025/602

Candidate	Yarn Manufacture	Fabric Manufacture	Textile Wet Processing	Knitting & Garment Mfg.	Total
Registered	6	1	2	-	9
Appeared	6	1	2	-	9
Results	6	1	2	-	9

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Schedule of A.T.A. Part - I, II & III December, 2026

ATA Part - I	Time 10.00 a.m. to 1.00 p.m.	ATA Part - II	Time: 2.00 p.m. to 5.00 p.m.
Date	Subjects	Date	Subjects
21-12-2026	Basic Engineering Sciences	21-12-2026	Principles of Yarn Manufacture
22-12-2026	General Engineering	22-12-2026	Principles of Fabric Manufacture
23-12-2026	Textile Fibres	23-12-2026	Principles of Textile Wet Processing
24-12-2026	Elements of Textile Technology	24-12-2026	Principles of Textile Testing and Statistics
25-12-2026	Elements of Comp. and its Applications	25-12-2026	Industrial Organization and Management

ATA Part - III - Time: 10.00 a.m. to 1.00 p.m.

Compulsory Subjects

20-12-2026	Elements of Technical Textiles
21-12-2026	Man-Made Fibre Technology

Optional Subjects

Date	Yarn Manufacture Group	Fabric Manufacture Group	Textile Wet Processing Group	Knitting & Garment Manufacture Group
23-12-2026	Process Control in Yarn Mfg.	Process Control in Fabric Mfg.	Wet Processing-I	Knitting Technology
24-12-2026	Modern Yarn Manufacture	Modern Fabric Manufacture	Wet Processing-II	Garment Technology

1. Last Date for receiving applications at unit **25th July 2026.**
2. Last Date for receiving all the applications with late fee at unit **25th August 2026.**
3. Last Date for receiving applications at the central office **25th September 2026.**

Sd/-
Dr. G. S. Nadiger
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RESULTS FOR GMTA SECTION A/B/C PASSED CANDIDATES DECEMBER, 2025

Centre	Section A	Section B	Section C
Ahmadabad	Nil	Nil	2025/AHC/01 2025/AHC/02
Delhi	2025/DEA/01	2025/DEB/01	NIL
Ichalkaranji	2025/ICA/10, 2025/ICA/11 2025/ICA/12, 2025/ICA/13 2025/ICA/14 2025/ICA/15 2025/ICA/16, 2025/ICA/17 2025/ICA/18, 2025/ICA/19 2025/ICA/21, 2025/ICA/22 2025/ICA/23, 2025/ICA/24 2025/ICA/25	2025/ICB/11, 2025/ICB/12 2025/ICB/13, 2025/ICB/14 2025/ICB/15, 2025/ICB/16 2025/ICB/17, 2025/ICB/18 2025/ICB/19, 2025/ICB/21 2025/ICB/23, 2025/ICB/24 2025/ICB/25	2025/ICC/10 2025/ICC/11 2025/ICC/12
Mumbai	2025/MUA/30, 2025/MUA/31	2025/MUB/30 2025/MUB/31 2025/MUB/32	2025/MUC/20 2025/MUC/21

Candidates	Section - A	Section - B	Section - C	TOTAL
Registered	20	21	07	48
Appeared	18	19	07	44
Result	18	17	07	42

Pass 95.00 %

RESULTS FOR GMTA SECTION D & E PASSED CANDIDATES DECEMBER, 2025

Centre	Section D			
	Yarn Manufacture	Fabric Manufacture	Textile Wet Processing	Apparel Manufacture
Ahmadabad	NIL	NIL	2025/AHD/01/WP 2025/AHD/02/WP	NIL
Delhi	NIL	NIL	NIL	NIL
Ichalkaranji	2025/ICD/01/YM	2025/ICD/01/FM 2025/ICD/02/FM	NIL	2025/ICD/01/AM
Mumbai	NIL	2025/MUD/10/FM	2025/MUD/10/WP	NIL

Candidates	Section - D				
	Yarn Manufacture	Fabric Manufacture	Text. Wet Processing	Apparel Manufacture	Total
Registered	01	03	03	01	08
Appeared	01	03	03	01	08
Passed	01	03	03	01	08

Pass 100.00%

Candidates	Section - E			
Ahmadabad	NIL			
Delhi	NIL			
Ichalkaranji	2025/ICE/01, 2025/ICE/02, 02025/ICE/03, 2025/ICE/04			
IMumbai	2025/MUE/10, 2025/MUE/11, 2025/MUE/12			

Candidates	Section - E			
Registered	07			
Appeared	07			
Results	07			

Results is withheld for Roll No. 2025/MUE/10 for want of submission of the project report.

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Schedule of G.M.T.A. Examination December 2026

Section A Date	Time 10.00 a.m. to 1.00 p.m. Subject No. & Title	Section B Date	Time: 2.00 p.m. to 5.00 p.m. Subject No. & Title
21-12-2026	A-1 Engineering Physics	21-12-2026	B-1 Yarn Manufacture
22-12-2026	A-2 Engineering Chemistry	22-12-2026	B-2 Fabric Manufacture
23-12-2026	A-3 Engineering Mathematics	23-12-2026	B-3 Textile Wet Processing
24-12-2026	A-4 General Engineering	24-12-2026	B-4 Apparel manufacture
25-12-2026	A-5 Professional Orientation	25-12-2026	B-5 Textile Testing

Section C Date	Time 10.00 a.m. to 1.00 p.m. Subject No. & Title
21-12-2026	C-1 Textile Fibre Science
22-12-2026	C-2 Polymer Technology
23-12-2026	C-3 Textile Engineering Mechanics
24-12-2026	C-4 Applied Statistics
25-12-2026	C-5 Data Management and Information System

Date	Section D - Time: 2.00 p.m. to 5.00 p.m.			
	Yarn Manufacture	Fabric Manufacture	Text. Wet Processing	Apparel Manufacture
21-12-2026	Short Staple Yarn Mfg.	Advanced Fab. Manufacture	Wet Proc-Pre Treat. & Bleaching	Apparel Technology
22-12-2026	Long Stap & other Yarn Mfg.	Knitting Technology	Wet Proc.-Dyeing	Supply Chain Mange in Apparel Mfg.
23-12-2026	Engg Design & Yarn Structure	Engg. Design of Fab. Structure	Wet Proc-Printing & Finishing	Apparel Merchandising
24-12-2026	Process & Quality Management & Yarn Mfg.	Process Control & Qual. Mrkt in Fab. Mfg.	Analytical Chem. In Textiles	Garment Proce. Tech.
25-12-2026	Man-made Fibre Technology	Fabric Structure & Design	Processing & Quality Manage In Wet Proce.	Process Control & Quality Manage in Apparel Mfg.

Optional Papers

26-12-2026	Specialty & High Performance Yarns(s)	Non-Woven Technology	Colour Tehory & Col. Matching	Social & Trade Compliances
27-12-2026	Silk Reeling & Throwing Technology	Technical Textiles	Effluent Treat & Eco Friendly Proce.	Garment Acces. & Fashion Forecasting
28-12-2026	Quality & Envir. System in Yarn Mfg.	Quality & Environment Systems In Fab. Mfg.	Quality & Environ System in Wet Proc.	Visual Merchandising

Section E Date	Time 10.00 a.m. to 1.00 p.m. Subject No & Title
24-12-2026	E-1 Industrial Engg. & Mill Management
25-12-2026	E-2 Energy Environment & Efficiency in Textiles

Optional Papers

26-12-2026	EOD-1 International Trade Management
27-12-2026	EOD-2 Control Systems in Textile Machines
28-12-2026	EOD-3 Entrepreneurship Development

1. Last Date for receiving applications at unit **25th July 2026**
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Sd/-
Dr. G. S. Nadiger
Chairman, P. A. C.

Sd/-
D. K. Singh
Hon. Gen. Secretary

**JOURNAL OF THE TEXTILE ASSOCIATION
FORM IV - MAY 2025 TO APRIL 2026**

FORM IV (See Rule 8)

**Statement about Ownership and other Particulars about Newspaper
JOURNAL OF THE TEXTILE ASSOCIATION**

1. Place of Publication : The Textile Association (India), Central Office
702, Santosh Apartment, 7th Floor, 72-A, Dr. M. B. Raut Road,
Shivaji Park, Dadar (W),
Mumbai – 400 028 MS
2. Periodicity of Publication : Bi-Monthly (Six issues in a year)
3. Printer's Name : Ms. Shubhangi Gawde, S. S. Enterprises
Nationality : Indian
Address : Flat No. 30, Swagat, A Wing,
CIBA Industrial Workers CHS Ltd.
Ghatkoper (w),
Mumbai – 400 086 Maharashtra
4. Publisher's Name : Shri J. B. Soma
Nationality : Indian
Address : 701, C Wing, Kalpak Shrushti,
Behind Sun Gloria Complex, Dalvi Nagar,
Katraj-Narhe Road, Ambegaon Budruk,
Pune – 411 046 MS
5. Editor's Name : Dr. Aadhar A. Mandot
Nationality : Indian
Address : HoD, Textile Dept.,
The M. S. University of Baroda,
Pratapgunj,
Vadodara - 390 002 GUJ.
6. Name and address of individuals who own the newspaper
and partners holding more than 1% of the total capital : The Textile Association (India), Central Office
702, Santosh Apartments, 7th Floor,
72-A, Dr. M. B. Raut Road,
Shivaji Park, Dadar (W),
Mumbai – 400 028 MS

I, J. B. Soma, hereby declare that the particulars given are true to the best of my knowledge and belief.

Mumbai
1st APRIL 2026

(Sd/-)
J. B. SOMA
Hon. Asso. Editor & Publisher

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