

Troubleshooting & Performance Guide

Durafil Tex 40 Heat Fusible Blind Hem Yarn

Performance Optimisation for Blind Hem Reinforcement and Internal Garment Stabilisation

1. Purpose

This guide helps users optimise sewing, pressing, and final garment performance when using Durafil Tex 40 Heat Fusible Thread.

Because bonding performance depends on heat, pressure, dwell time, garment construction, and fabric type, controlled trials are essential before bulk production.

2. Common Performance Issues and Corrective Actions

Issue	Likely Cause	Corrective Action
Weak hem reinforcement	Insufficient heat or dwell time	Increase press temperature or dwell time gradually
Uneven bonding along hem	Inconsistent pressure or poor hem construction	Check press flatness and sewing consistency

Bond visible through fabric face	Excessive heat or pressure	Reduce temperature, dwell time, or pressure
Fabric shine / marking	Overheating sensitive fabric	Lower temperature and use protective cloth if suitable
Hem stiffness	Excess bonding material activated	Reduce heat intensity or thread usage
Puckering after pressing	Tension imbalance or distortion during pressing	Review sewing tension and pressing method
Bond failure after washing	Incomplete activation during pressing	Improve initial bonding process and cooling stage
Thread sticking in sewing area	Excess friction heat during sewing	Reduce speed, tension, or needle heat exposure

3. Sewing Performance Guidance

Recommended use is within blind hem construction or suitable internal seam areas.

Best practice:

- Maintain balanced thread tensions
- Avoid excessive machine speed if friction heat develops
- Ensure smooth thread path

- Keep guides and tension discs clean
 - Confirm consistent stitch formation before pressing
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4. Pressing Performance Guidance

Heat activation occurs during garment pressing.

Key variables:

- Press temperature
- Dwell time
- Pressure applied
- Fabric thickness
- Moisture conditions
- Number of fabric layers

Small controlled adjustments are recommended rather than major changes.

5. Fabric Performance Considerations

Generally suitable for trials on:

- Polyester fabrics
- Polyester / viscose blends
- Cotton blends
- Polyamide blends
- Many uniform and trouser fabrics

Always trial first on:

- Heat-sensitive fabrics
 - Delicate finishes
 - Coated fabrics
 - High-shine fabrics
 - Lightweight open constructions
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6. Cooling and Handling Performance

After pressing:

- Allow bonded hem to cool in stable position
- Avoid immediate folding or stretching
- Avoid stacking hot garments under pressure

Premature handling may reduce bond consistency.

7. Process Discipline Checklist

Before production:

- Trial approved fabric
 - Confirm press settings
 - Confirm seam construction
 - Check wash durability requirement
 - Approve final appearance
 - Record standard operating conditions
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8. Important Note

Final performance depends on garment construction, fabric type, pressing conditions, operator discipline, and process control.

Users are responsible for testing, process adjustment, and validation before bulk production.

9. Contact for Technical Support

Email: info@durafil-group.com