

# Carnegie

## Suggested Upholstery Procedures for Xorel Knit

Furniture upholsterers use a variety of techniques to sew fabrics for use in upholstery. The construction details will vary depending on the individual chair design. Below are general suggestions. They are not considered absolute methods for upholstery fabrication. These best practices are derived feedback from some key manufacturing partners. It is still advisable for the fabricator to evaluate this material for its suitability on a specific chair design:

1. Due to its construction, Xorel Knit may appear too transparent for the application of contact adhesives. However, its thick structure keeps the glue on back surface. As such, there is no penetration of the glue through to the face of the material. We can also add our optional X-Protect moisture barrier backing to the material.
2. We recommend a minimum ½ inch seam allowance with a Plain Lock stitch conforming to Type 301 of ASTM D 6193 (formerly Federal Standard No. 751a.), but additional stitch types can be used at the discretion of the fabricator.
3. The recommended needles are # 16, #18 or 22 ball point<sup>1</sup> maximum or equivalent and 100% nylon or polyester bonded monocord thread.
4. A minimum of 8 stitches per inch is recommended to insure adequate seam strength.
5. Take appropriate measures to minimize needle heat during sewing.<sup>2</sup>
6. Spun polyester thread is recommended in this type of operation, but nylon is an acceptable option for sewing this product.
7. Steam can be used to finish / shape the fabric around more contoured elements of a chair. A hand-held commercial upholstery steamer is fine for this purpose.
8. Xorel Knit is recommended for tight seating. We do not recommend Xorel for use on foams larger than 3". When foam is used, the foam should be a firm foam with a minimum Indentation Load Deflection (I.L.D) of at least 55 lbs with a density of 2.5 lb/ft<sup>3</sup> or greater.
9. Due to its construction, you may see a slight distortion of the pattern when fabricating more contoured sections of the chair unit, but this can be minimized by adjustments in handling and the natural recovery of this material.



<sup>1</sup> Singer 135 x 17, size 22 light ballpoint or Schmetz NM 140 light ball point or equivalent.

<sup>2</sup> For more information see Technical Bulletin: Minimizing Needle Heat - [bit.ly/xorelknit-procedures](http://bit.ly/xorelknit-procedures)