

Processing Procedure Satin Band Napery

HANDLING RECOMMENDATIONS

- A. All new items should be washed separately prior to use. A full wash cycle should be used to remove sizing and fugitive dyes that are normal and expected. Water used to process new colored items should not be reused in order to prevent dye redeposition onto other products.
- B. All soiled linen should be shaken out so debris (food and sharp objects) will not be loaded into the washer with the table linen.
- C. Sorting. Blended napery should be handled separately. Whites must be washed alone. If volume allows, individual colors should be washed separately. Laundry experience will dictate the necessary separation.
- D. Load equipment to 80% of rated capacity.

PROCESSING REQUIREMENTS

- A. Formula. **This formula is only a guideline.** Alterations should be made at the discretion of the laundry professional, based on specific requirements, supplies, equipment and experience.

		WATER			
<u>OPERATION</u>	<u>TIME</u>	<u>LEVEL</u>	<u>TEMP.</u>	<u>SUPPLIES PER 100 LB. LOAD</u>	
1. Flush	2 min.	High	100°F	--	
2. Break	7 min.	Low	160°F	8 oz. nonionic detergent & 16 oz. alkali	
3. Suds	5 min.	Low	160°F	4 oz. nonionic detergent	
4. Rinse	2 min.	High	140°F	--	
6. Rinse	2 min.	High	110°F	--	
8. Sour	7 min.	Low	90°F	Sour to pH of 5.5 - 6.5	

- B. The use of fabric softeners is not recommended.
- C. Although bleach is not recommended, it can be used to remove stubborn stains. Use 1 qt. 1% sodium hypochlorite. The bleach step should follow the suds step and this step should use a low water level, 140°F – 155°F with a pH of 10.5. Using an anti-chlor in the last rinse is also recommended.
- D. Extraction time should be adjusted so that the load has 10-20% retained moisture after extraction. This moisture is necessary to ensure a wrinkle-free appearance, especially if a flatwork ironer is used. Extraction time should be between 1-3 minutes.

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PROCESSING REQUIREMENTS (Cont.)

- E. Dryer temperatures must be set for permanent press (medium heat setting range from 150°F to 170°F). For dryers with inlet and outlet controls, inlet can be set at 290°-310°F and outlet at 160°F. Linen must be dry before “cool-down” cycle is started. The linen and walls of the dryer should be cooled down to body temperature before the dryer is stopped.
- F. Tops and napkins should **immediately** be unloaded from the dryer and folded. Tops should be draped or spread across a cart or folding table as unloaded. Napkins should be unloaded from dryer and stacked flat and as high as handling will permit.

Note: To achieve the best wrinkle free appearance, ironing is recommended (see below).

IRONING

- A. To achieve the best wrinkle-free appearance, use of a flat work iron is recommended. chest temperature should be set at 290-320°F with a run speed of 70-110 ft./min.
- B. Preconditioning for 3-5 minutes at 160°F is recommended to initiate drying and loosen the products within the load so that it is easier for operators to pull items out of bins and feed into the ironers.

EQUIPMENT PREVENTATIVE MAINTENANCE

- A. Equipment should be free of burrs and sharp edges.
- B. Washing equipment should have adequate level and temperature controls.
- C. Drying equipment must have adequate temperature and cool-down controls.
- D. Lint screens on dryers must be cleaned daily.