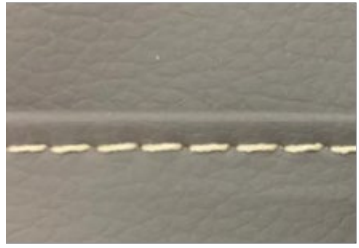


Sewing and Maintenance Guide

Needle	Brand	SCHMETZ (or equivalent)		
	Series	 SD1 - Round point with small triangular tip		 DI - Diamond point
	Size	#18 (135×17 SD1) (DP×17 SD1)	#19 (134-35 SD1) (2134-35 SD1) (DP×35 SD1)	#19 (134-35 DI) (DP×35 DI)
Seam types		 Superimposed seam/Plain seam		 Lapped seam/Decorative seam/ Flat-felled seam
Thread		Select thread proportionate to needle size to ensure seam integrity.		
Stitches		Use UV- and chemical-resistant synthetic thread appropriate to the application. Adjust needle size and machine tension based on thread thickness.		
Sewing Note		1) The above recommendations are examples; similar alternatives may be used. 2) Add a lock stitch to enhance seam security. 3) Ensure the sewing machine timing is properly calibrated to avoid needle drag during withdrawal. 4) Avoid presser feet with sharp edges, which can damage the fabric surface. 5) Calibrate the sewing machine's speed and sewing foot guide settings to avoid fabric drag or enlargement of thread holes. Newer machines often have settings specifically for coated fabrics. 6) For marine applications, some customers find better performance using a smaller needle, such as size #17.		
Lamination tips		1) To prevent migration of volatile compounds from the foam into Sileather, we recommend covering the foam with PE/PP films or using low-emission aliphatic polyester foam. Use machine lamination or a roller tool to apply adhesives evenly. Avoid leaving excessive adhesive residue on the backing, which may seep into the top coating. 2) For marine upholstery, Sileather performs best when laminated with open-cell, reticulated, quick-drying foam. A waterproof barrier between the fabric and foam is recommended. 3) We recommend using water-based adhesives PUR lamination 4) H.B. Fuller HP-2000 solvent-based canister adhesive has been tested and is recommended by H.B. Fuller. Always perform your own testing before applying any adhesive to the material.		

Processing Technique	Silicone is a thermosetting material. Compared to traditional thermoplastic PVC and PU leather, Sileather has specific processing limitations. These methods show what is suitable & what should be avoided when working with Sileather.	
	Applicable Processes: • Sewing • Perforation • Lamination (flame or adhesive) • Embroidery • Laser engraving	Not Applicable Processes: • Heat-pressed logos • High-frequency welding • High-frequency (RF) processing • Hot stamping

Sileather® Maintenance Guide

This material features an advanced, stain-resistant molecular structure created by Siotech® silicone technology. Prompt cleaning and regular maintenance are recommended to preserve appearance and performance. Cleaning procedures vary by stain type and intensity.

REGULAR CLEANING AND MAINTENANCE

Clean the soiled area using a soft cloth or sponge with mild soap and water. Gently wipe until the stain is removed. Rinse thoroughly with clean water and allow to air dry. Residue from cleansers should always be removed promptly to prevent surface dullness or shortened product life.

FOOD STAINS & OILS

Remove excess residue with a soft cloth. Clean with mild soap and water using a soft cloth or sponge, then rinse with clean water and air dry. For persistent stains, wipe with a solution of 70% isopropyl alcohol, then rinse with clean water and wipe dry.

INK, LIPSTICK & OTHER DIFFICULT STAINS

Wipe the affected area with a damp cloth using 70% isopropyl alcohol or other professional cleaning agents. Repeat if necessary. Rinse with clean water and wipe dry. For best results, clean within 24 hours of staining.

HEALTHCARE / DISINFECTION

Clean the soiled area with a diluted bleach solution (1 part household bleach to 4 parts water). After applying the solution, rinse the area thoroughly with fresh water and wipe dry. Always test disinfectants in an inconspicuous area before full application.

DENIM DYE TRANSFER

Sileather's silicone surface resists most indigo dye transfer. If faint transfer occurs, clean with a 70% isopropyl alcohol, then rinse with clean water and wipe dry. While Sileather offers excellent protection, full dye removal cannot be guaranteed—especially from wet or heavily dyed denim.

COMPATIBLE CLEANSERS

Different cleaning products vary in formulation. To prevent unintended surface dullness or residue buildup, please refer to our [Marine Tested Cleanser Lists](#) and [Healthcare Tested Cleanser Lists](#) to confirm compatibility with your preferred brand. If a product is not listed, test it on a small hidden area first.

CAUTION

- Ensure adequate ventilation when using alcohol or bleach-based cleansers.
- Test all cleansers in a small, hidden area before full use.
- Use only soft cloths, non-abrasive sponges, or soft nylon brushes for textured surfaces.
- Do not apply aftermarket top treatments such as UV protectants, vinyl conditioners, leather conditioners, silicone dressings, waxes, or stain-resistant sprays. These products are not needed and may leave residue, cause surface haze, or reduce cleanability.
- Avoid harsh chemicals such as hydrocarbons, ketones, industrial degreasers, Goo-Gone type solvents, and cyclosiloxane-based solvents.
- Alcohol-based cleansers are flammable; keep away from heat, sparks, and open flame.
- Wear protective gloves when handling concentrated cleaning agents.
- Regular monthly cleaning and inspection are recommended.

The information in this guide is based on laboratory and customer feedback under controlled conditions. This guide does not constitute a guarantee and does not relieve the user of responsibility for proper and safe use of the product and cleaning agents. Sileather® shall not be liable for any incidental or consequential damages arising from misuse, mishandling, or exposure to chemicals.