SABOLAY WITKEY SPORTS

# Swimwear Development & Fabric Systems

CORE CAPABILITY

## Bonded Racing Swimwear

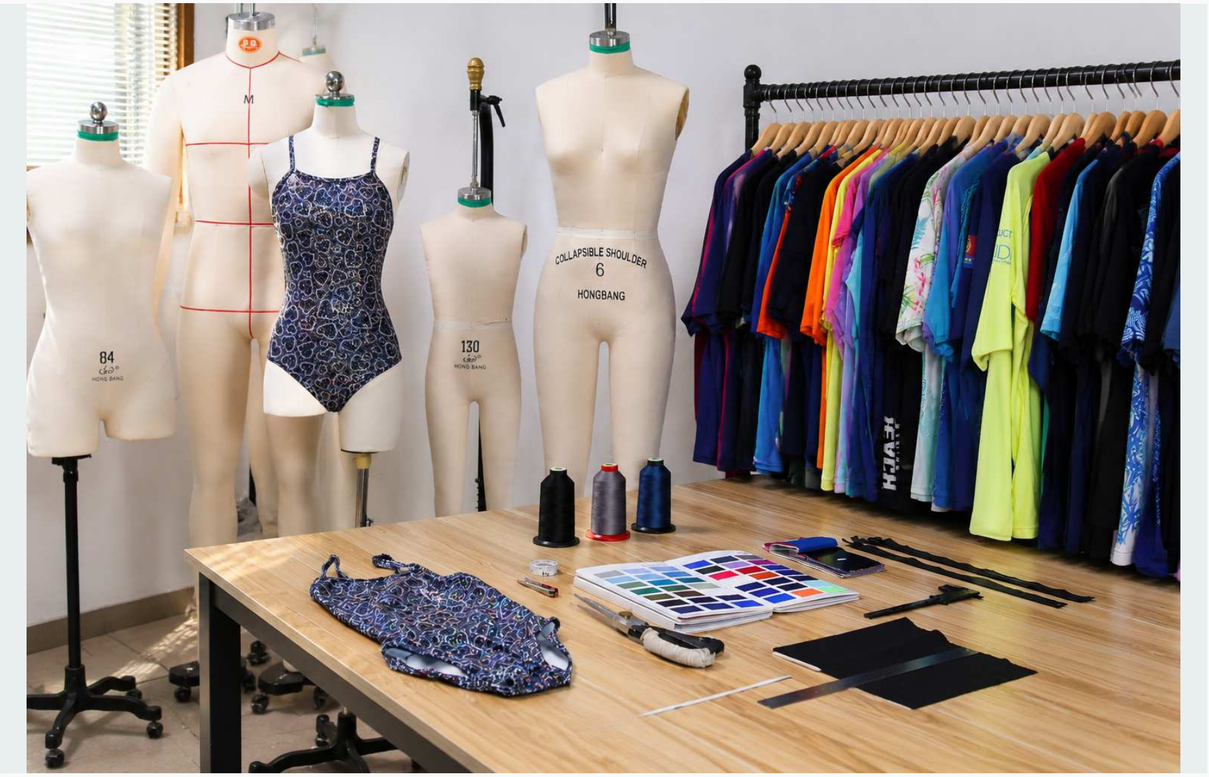
Company & Fabric Catalogue



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# Company Profile




Sample development and display area

## About Us

Founded in Dongguan in 2015, SABOLAY develops and manufactures swimwear.

## Who We Work With

Swimwear brands, clubs, teams and youth training programmes.

## Development & Production

One team handles fabric selection, sampling and bulk production.

# From Brief to Production

## Fabric Selection

Match fabric weight, stretch and opacity to the intended use.

## Fit & Construction

Check freedom of movement, fit and seam construction.

## Production Standards

Produce to the approved sample and retain fabric lot, pattern and process records.

# Product Development Workflow

**01**

## Fabric Selection

**02**

## Sample Approval

**03**

## Bulk Production

**04**

## Order Dispatch



Patterns, fabric swatches and cutting preparation

# Product Range



Style examples

## Racing Swimwear



Style examples | Digital print on white fabric

## Training Swimwear



Style examples

## Other Watersports Apparel

# Fabric Selection Guide

Select a fabric name or page number for details.

## Racing & Single-Layer Suits

130 g/m² Lightweight Racing 08

195 g/m² CARVICO Racing 09

280 g/m² DuPont Chlorine-Resistant 10

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40D Volume Fabrics 20

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## Comfort & Recycled Fabrics

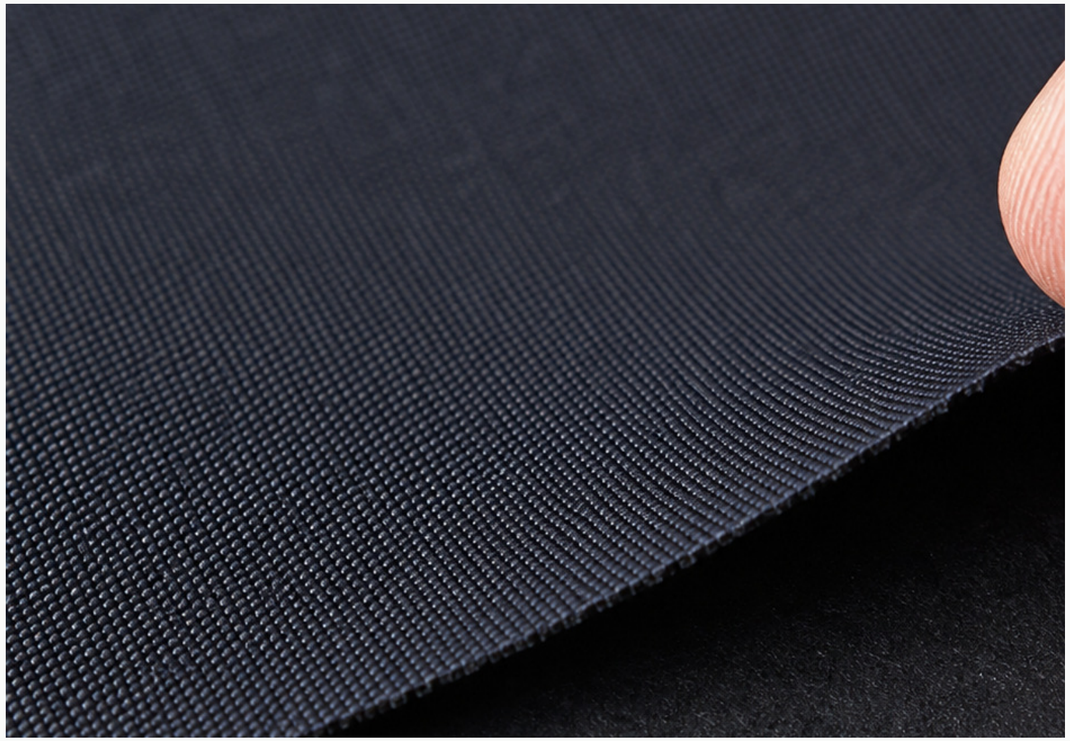
170 g/m² Sorona® Stretch 17

270 g/m² Recycled Polyester 18

230 g/m² REPREVE® Training 19

High-Gloss Foil & Embroidery 22

# Lightweight Racing Fabric



Lightweight racing fabric swatch

**130** g/m² Fabric Weight

## Composition

65% nylon / 35% elastane

## Applications

For lightweight bonded racing suits and jammers.

## Processing Options

Seam tape and leg-opening grippers are available. Not for all-over printing. Test water repellency and bond strength on swatches.

# CARVICO Racing Fabric



Kneesuit style example

**195** g/m² Fabric Weight

## Composition

71% nylon / 29% elastane

## Applications

A firm fabric for supportive styles, including women's kneesuits and men's racing jammers.

## Processing Options

Suitable for bonded or sewn construction.
Water-repellent finish optional. Sample dyeing, screen printing and trim on the selected fabric.

# DuPont High-Opacity, Chlorine-Resistant Fabric



High-opacity single-layer styles | Digital print on white fabric

LYCRA® reports up to 10 times the durability of unprotected elastane fibres. This is not a garment lifespan claim.

**280** g/m² Fabric Weight

## Composition

70% polyester / 30% LYCRA® XTRA LIFE™ elastane

## Applications

Dense construction for single-layer one-pieces, knee-length training suits and men's square-leg swim shorts.

## Processing Options

Digital printing on white base fabric. Dyeing and foil stamping are also available.

# 40-Gauge / 40D Single-Layer Racing Fabric



Single-layer racing style | Digital print on white fabric

See page 20 for volume-production fabrics.

**240** g/m² Fabric Weight

## Composition

80% polyester / 20% chlorine-resistant LYCRA® elastane

## Applications

For mid-range single-layer racing swimwear.

## Processing Options

Digital printing on white base fabric. Dyeing and foil stamping are also available.

# Elastane-Free PBT Training Fabric



PBT fabric shown under stretch

**175** g/m² Fabric Weight

## Composition

53% polyester / 47% PBT

## Applications

Stretch comes from the fibres and knit structure. Chlorine-resistant fabric for swim schools, teams and frequent pool training.

## Processing Options

Solid colours or digital printing on white base fabric.

# Core Nylon-Elastane Fabric



Core nylon-elastane styles

**200** g/m² Fabric Weight

## Composition

82% nylon / 18% Hyosung elastane

## Applications

Soft fabric for one-pieces, separates, swim shorts and sun-protective swimwear. Not intended for elite racing suits.

## Processing Options

Solid colours and colour blocking are available.

# Polyester-Elastane Fabric for Digital Printing



Style examples | Digital print on white fabric

**200** g/m² Fabric Weight

## Composition

82% polyester / 18% elastane

## Applications

For printed adult and children's swimwear, custom teamwear and sun-protective swimwear.

## Processing Options

Digital printing on white base fabric.

# Chlorine-Resistant Nylon-Elastane for White Panels



White panel construction examples

**210** g/m² Fabric Weight

## Composition

80% nylon / 20% LYCRA® XTRA LIFE™ elastane

## Applications

For white or light-coloured panels in training swimwear, swim shorts and sun-protective styles.

## Panel Testing

Check for colour transfer between light and dark panels. Test white panels for wet opacity and colour change after soaking in chlorinated water.

# Semi-Dull, Chlorine-Resistant Print Fabric



Semi-dull fabric | Digital print on white fabric

**200** g/m² Fabric Weight

## Composition

80% polyester / 20% LYCRA® XTRA LIFE™ elastane

## Applications

A subtle sheen for printed training suits, custom teamwear and sun-protective swimwear.

## Processing Options

Digital printing on white base fabric.

# Sorona® Stretch Fabric



Sorona® fabric texture and drape

See page 22 for raised embroidery.

**170** g/m² Fabric Weight

## Composition

46% polyester / 54% Sorona®

## Applications

Soft fabric for double-layer women's one-pieces and separates. Only the Sorona® polymer is partially bio-based.

## Processing Options

Embroidery is available on solid colours. Check motif placement and how the embroidered area stretches during sampling.

# High-Opacity Recycled Polyester Fabric



High-opacity one-piece examples

**270** g/m² Fabric Weight

## Composition

73% recycled polyester / 27% Hyosung elastane

## Applications

Dense fabric for single-layer one-pieces and men's square-leg swim shorts that need greater opacity.

## Processing Options

Digital printing on white base fabric or dyeing.
Wet-opacity testing is available for light shades.

# REPREVE® Recycled Training Fabric



Training and sun-protective swimwear examples

**230** g/m² Fabric Weight

## Composition

83% REPREVE® recycled polyester / 17% Hyosung elastane

## Applications

For adult and children's training swimwear, swim shorts and sun-protective styles.

## Processing Options

Digital printing on white base fabric, dyeing or colour blocking. Material branding and documentation depend on the fabric selected.

# 40D Fabrics for Volume Production



Core swimwear and fabric examples

| | |
|---|---|
| Weight | 180-230 g/m² |
| Composition | 85% polyester<br>15% Hyosung elastane |

See page 11 for single-layer racing fabric.

## Order Types & Applications

Core one-pieces, separates and swim shorts for brands and cross-border sellers, including Amazon merchants.

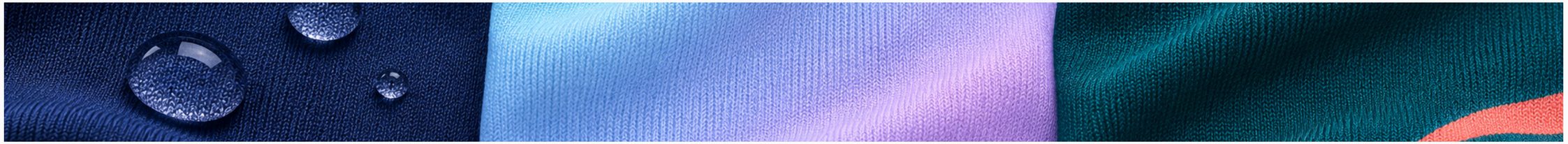
## UPF 50+ Sun Protection

Optional sun-protective finish. The rating depends on test results under the applicable standard for the target market.

## Volume Pricing & Quality Control

Tiered pricing and repeat orders are available. We check fabric weight, shade variation, stretch and garment measurements against the approved sample.

# Functional Finishes & Direct-to-Fabric Printing



## FUNCTIONAL FINISHES

Illustrative examples: water repellency, pale gradients and fluorescent colours

### UPF 50+ Sun Protection

For swimwear and long-sleeve rash guards. Verify UPF against the target market standard.

### Water-Repellent Finish

Check water repellency and durability after washing.

### Antibacterial Finish

Antibacterial performance and wash durability are subject to test results.

## PRINTING OPTIONS

We print both the background and the design onto white base fabric.

### Direct Printing on Nylon

For multicolour designs and fine lines. Check colour, appearance under stretch and colourfastness.

### 8-Colour Polyester Printing

Light and dark inks support pastel gradients. Check batch colour against the approved swatch.

### Fluorescent Polyester Prints

Approve fluorescent shades and colourfastness separately. Combining with 8-colour printing is not standard.

Finishes are optional. Dyeing is also available.

# High-Gloss Foil & Raised Embroidery



Illustrative finish

## High-Gloss Foil Stamping

A bright metallic finish. Sample the foil and design on the selected base fabric.

### Sample Checks

Check gloss, adhesion and resistance to cracking when stretched. Check appearance after chlorine exposure where relevant.



Illustrative finish

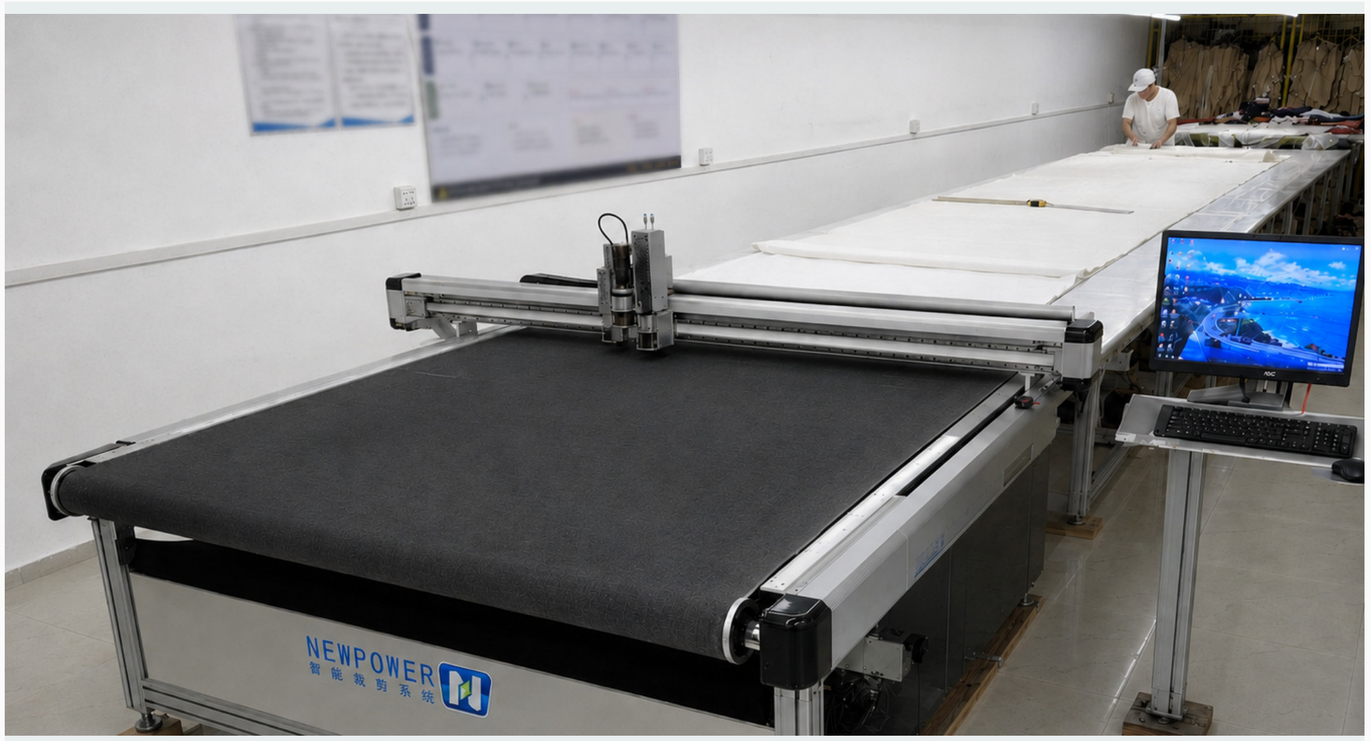
## Raised Embroidery

Optional imported specialty threads add raised outlines and texture. Ideal for small motifs, badges and logos.

### Sample Checks

Check motif placement and stitching, then assess flatness under stretch and comfort against the skin.

# Automated Cutting




Automated cutting machine and table

## Print Registration

Align the cut with the printed design.

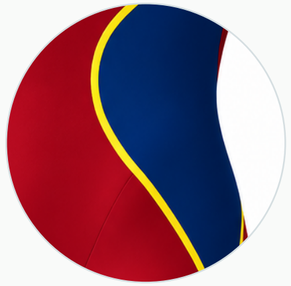
## Complex Pattern Pieces

Select a rotary or oscillating blade to suit the shape of each piece.

# Bonded Construction for Racing Swimwear

## Women's Racing Kneesuit



**01 Bonded Side Seam**

Front and three-quarter views | Style example

## Men's Racing Jammers





**Leg Gripper & Internal Bonding Tape**

Shown on a different sample

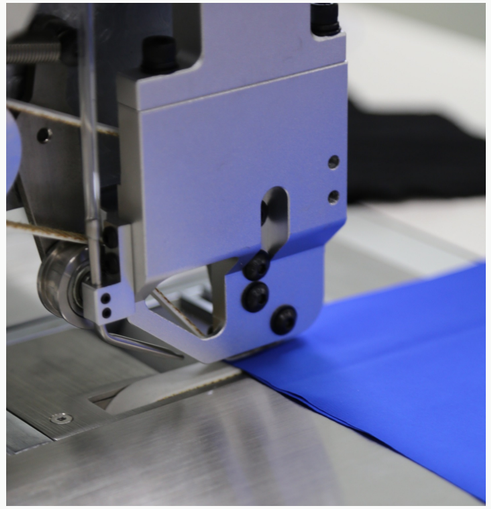
Three-quarter and front views | Style example

# Racing Swimwear Bonding Line

A dedicated bonding line for sampling and refining the construction of stitch-free racing swimwear.



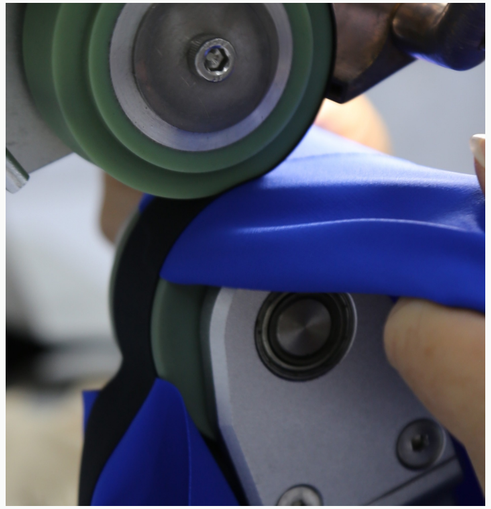
**Ultrasonic Welder** Reference



**Panel Joining**



**Hot-Air Taping Machine** Reference



**Tape Application**

## Welding & Bonding

Ultrasonic welder; hot-air taping machine
Automatic adhesive applicator;
panel and overlay bonding machines

## Stitch-Free Edge Finishing

Binding and hemming machines;
dedicated leg-opening hemming machine

## Heat Pressing & Re-Pressing

Flat heat press; side-seam press;
second-pass seam tape press

We use World Aquatics (formerly FINA) swimwear rules as a development reference. Competition eligibility depends on approval of the finished model.

# Production & Quality Control

## 01

### Fabric Selection

Confirm fabric, weight and colour.

## 02

### Sample Approval

Approve fit, measurements and construction.

## 03

### Bulk Production

Check print placement, stitching and bonded seams.

## 04

### Order Dispatch

Inspect, pack and ship finished garments.

# Environmental & Compliance Documentation

## Material Documentation

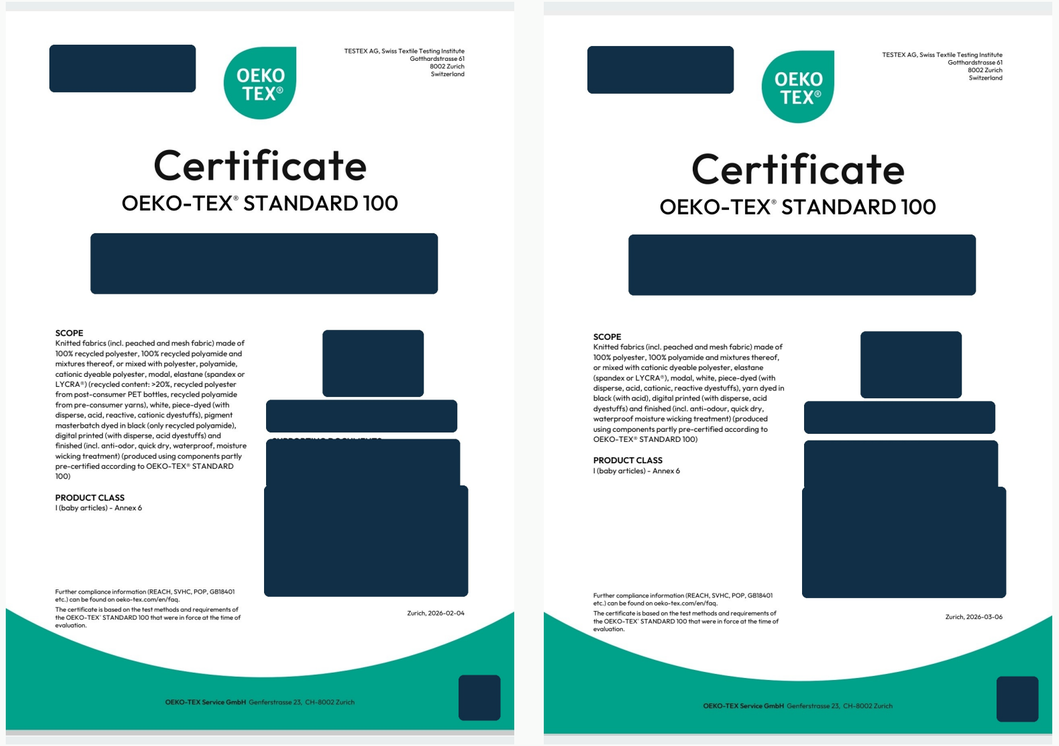
Check test reports and certificates for the materials selected for the order.

## Certification Scope

Fabric certification does not cover the finished garment.

## Verification

Check the original document number, validity and materials covered.




Redacted examples only. Not proof of certification for an order or garment.

# How to Work With Us

**01**

## Fabric Selection

**02**

## Sample Approval

**03**

## Bulk Production

**04**

## Order Dispatch

## Contact

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| | |
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