MADE IN GREEN

Implementation Examples

OEKO-TEX® MADE IN GREEN

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OEKO-TEX®
International Association for Research and Testing in the Field of Textile and Leather Ecology
Internationale Gemeinschaft für Forschung und Prüfung auf Gebiet der Textil- und Lederökologie

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Annex 4.2: Implementation Examples of MADE IN GREEN criteria in relation to STeP certifications

1. Outerwear example

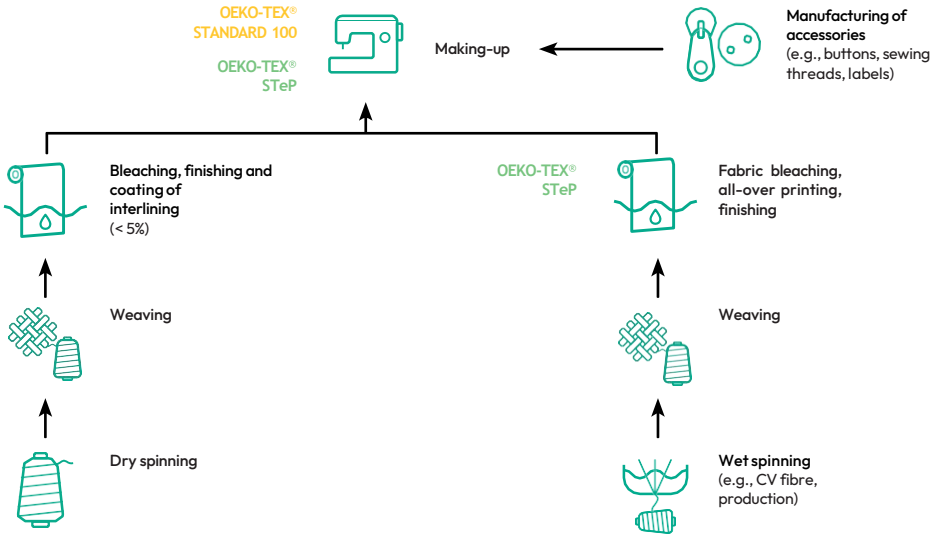
1.1 All-over printed blouse

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (bleached, all-over printed) *	90 %	required for fabric bleaching, all-over printing, finishing	wet/chemical ≥ 5 %
Buttons	4 %	not required	not considered **
Interlining (coated woven fabric)	3.3 %	not required	wet/chemical < 5 %
Sewing threads	0.5 %	not required	wet/chemical < 5 %
Labels	2.1%	not required	wet/chemical < 5%

* All-over print should be considered in the same way as the main fabric component.
** Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Blouse
(bleached, all-over printed)

Example production steps:



1. Outerwear example

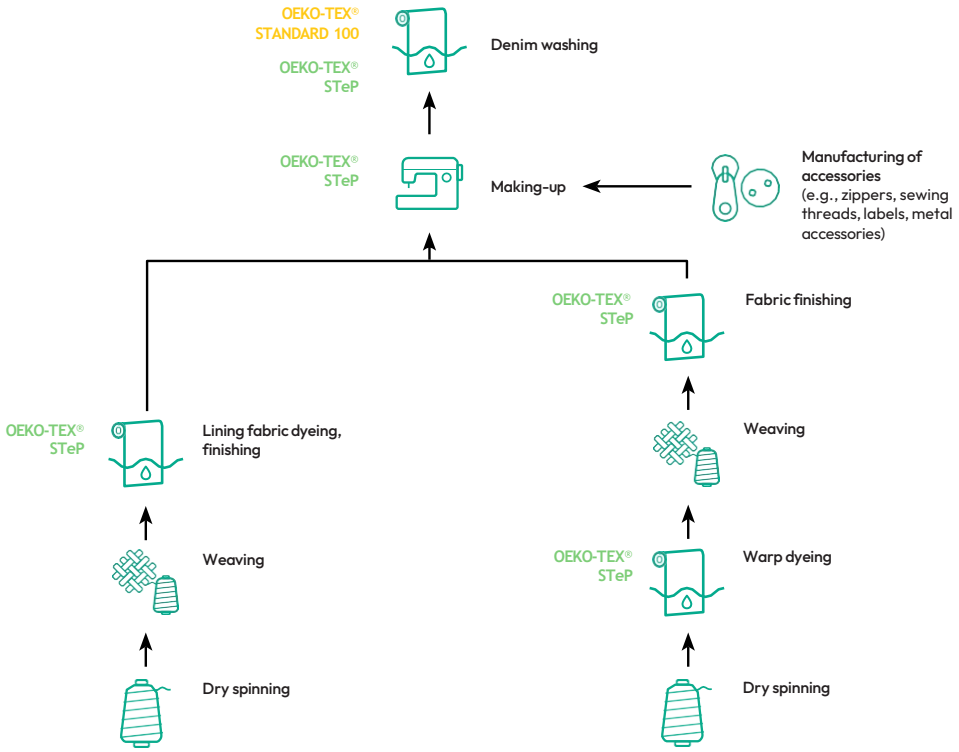
1.2 Denim jeans

Components of the product	Weight	STeP certification	Criteria
Denim washing	90 %	required	wet/chemical ≥ 5 %
Ready-made article		always required	making up
Denim woven fabric (warp-dyed)	88 %	required for warp dyeing, fabric finishing	wet/chemical ≥ 5 %
Lining	5 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Metal accessories	3 %	not required	not considered *
Zipper	3 %	not required	not considered *
Sewing threads	0.9 %	not required	wet/chemical < 5%
Labels	0.1 %	not required	wet/chemical < 5%

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Jeans (warp-dyed, finished, washed)

Example production steps:



1. Outerwear example

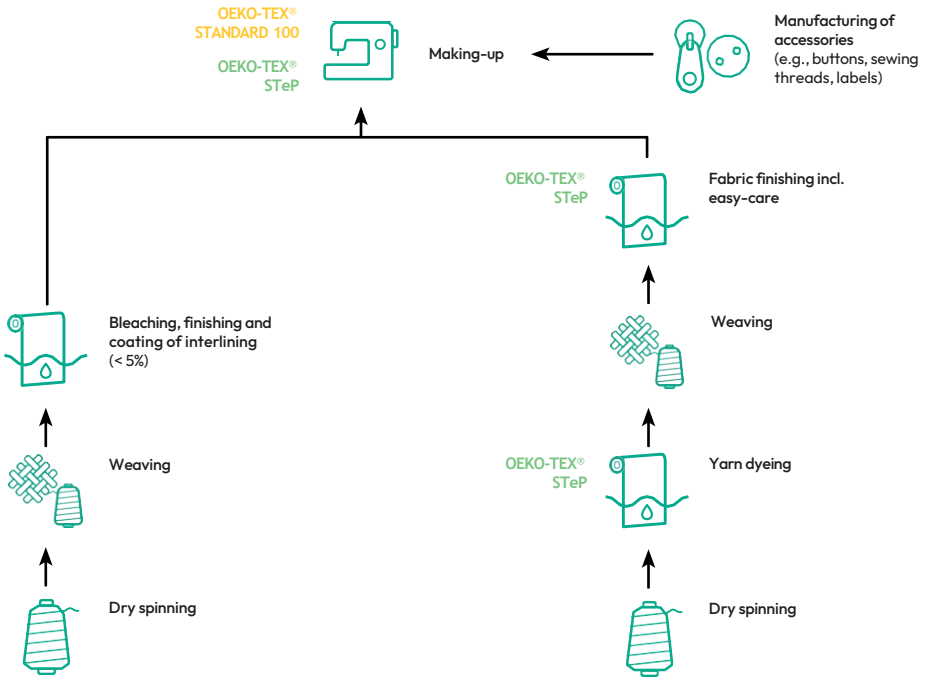
1.3 Easy-care finished dress shirt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (yarn-dyed)	90 %	required for yarn dyeing, fabric finishing incl. easy-care	wet/chemical ≥ 5 %
Sewing threads	2.1 %	not required	wet/chemical < 5 %
Buttons	4 %	not required	not considered *
Interlining (coated woven fabric)	3.8 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Dress shirt (yarn-dyed, easy-care finished)

Example production steps:



1. Outerwear example

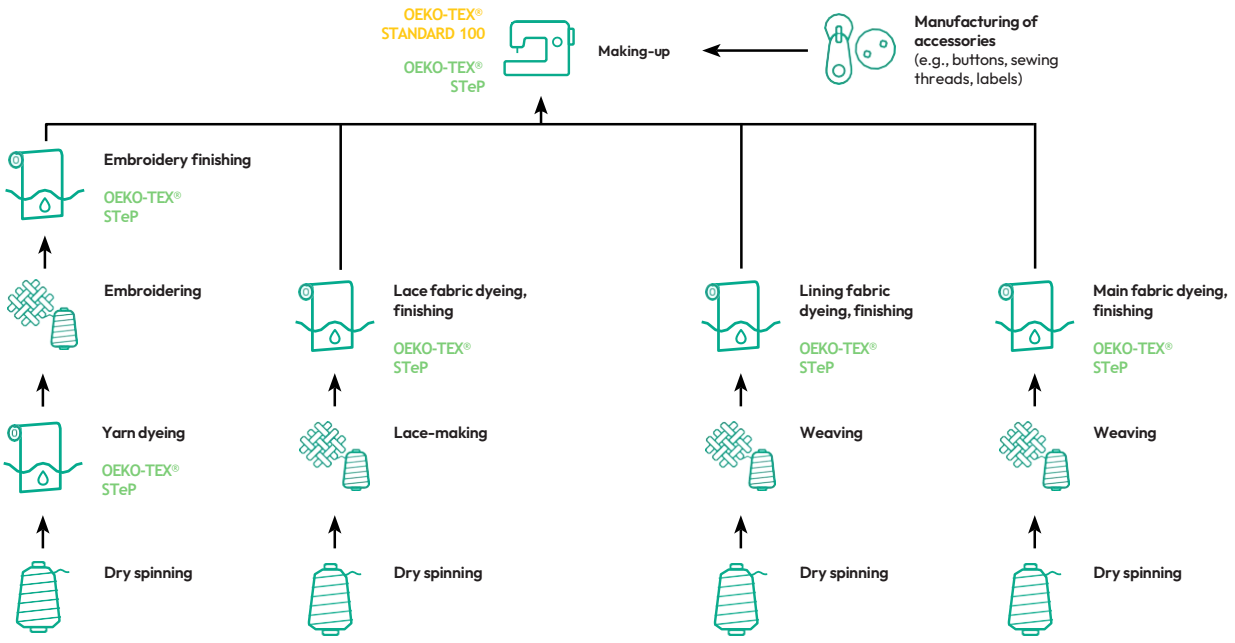
1.4 Embroidered dress

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (piece-dyed)	40 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Lining	25 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Embroideries	10 %	required for yarn dyeing, finishing	wet/chemical ≥ 5 %
Lace	5 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Interlining (thermally bonded nonwovens)	5 %	not required	not wet/chemical
Sequins / Glass applications	3 %	not required	not considered *
Zipper	3 %	not required	not considered *
Fusible interling (thermally bonded nonwoven)	3 %	not required	not wet/chemical
Elastic tape	2 %	not required	wet/chemical < 5 %
Buttons	2 %	not required	not considered *
Sewing threads	1 %	not required	wet/chemical < 5 %
Labels	1 %	not required	wet/chemical < 5 %

Dress
(piece-dyed, embroidered)

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



1. Outerwear example

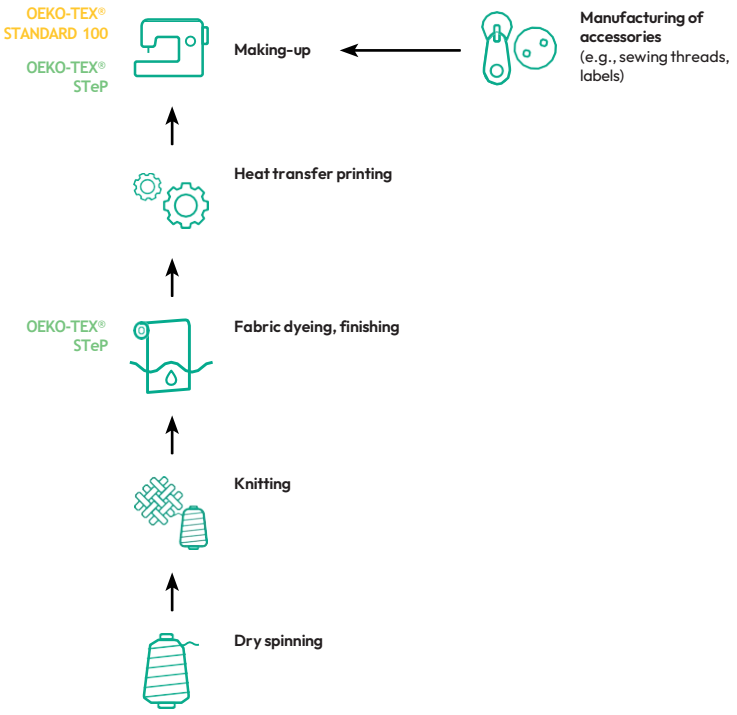
1.5 Heat transfer printed T-shirt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Heat transfer print *	12 %	not required	not considered
Main fabric (piece-dyed)	86.9 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Sewing threads	1 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

* In general, heat transfer prints are not considered since there are no wet/ chemical processes. This also refers to companies that do an inkjet printing on paper first and then the heat transfer textile printing afterwards. It is not possible to issue a MADE IN GREEN label for heat transfer printed paper itself since it is out of MADE IN GREEN scope.

T-shirt (piece-dyed, heat transfer printed)

Example production steps:



1. Outerwear example

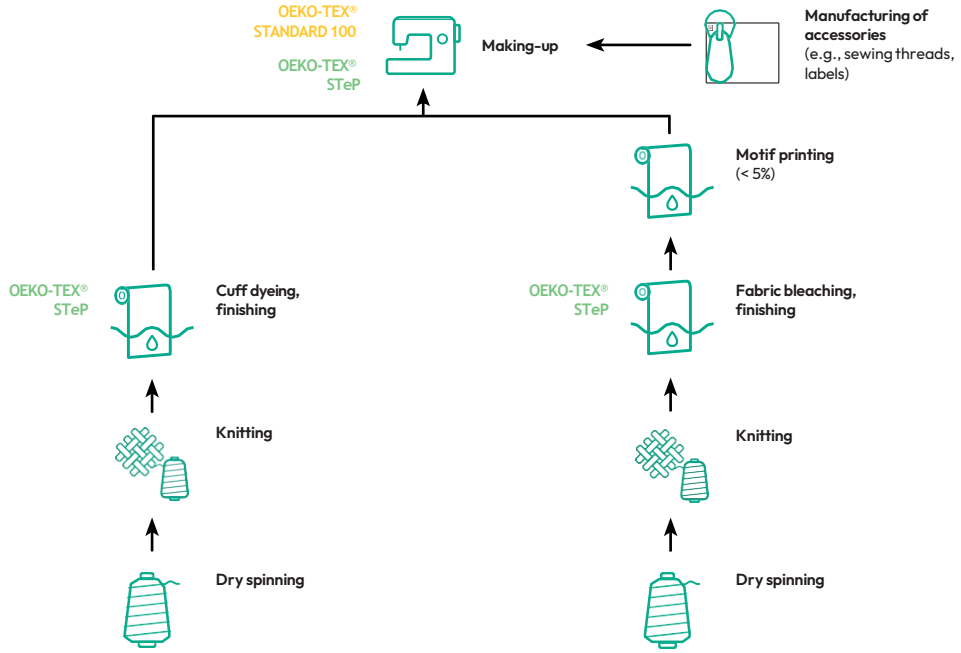
1.6 Motif printed T-shirt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Motif print *	4.5 %	not required	wet/chemical < 5 %
Main fabric (bleached)	87.9 %	required for fabric bleaching, finishing	wet/chemical ≥ 5 %
Cuffs	5.5 %	required	wet/chemical ≥ 5 %
Sewing threads	2 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

* Printed part including fabric in weight. If it is more than 5% of the total weight of the product, STeP certification is always required. Wet/ chemical textile printing processes are considered: screen, flock, rubber, inkjet printing, etc. Heat transfer print is not considered as a wet/ chemical process (see example 1.5).

T-shirt
(bleached, motif printed)

Example production steps:



1. Outerwear example

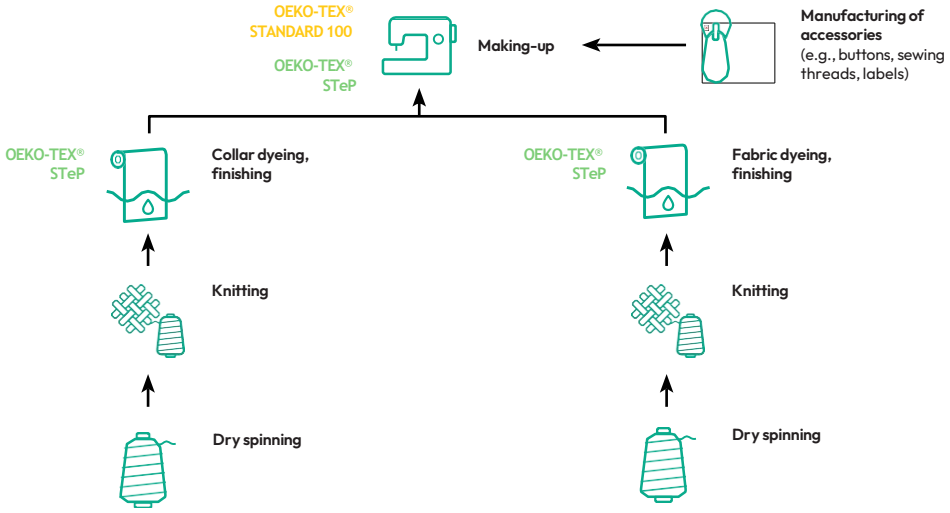
1.7 Piece-dyed polo-shirt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (piece-dyed)	90.5 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Collar (piece-dyed)	5.5 %	required for collar dyeing, finishing	wet/chemical ≥ 5 %
Sewing threads	1.5 %	not required	wet/chemical < 5 %
Buttons	2.4 %	not required	not considered *
Labels	0.1 %	not required	wet/chemical < 5 %

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Polo-shirt (piece-dyed)

Example production steps:



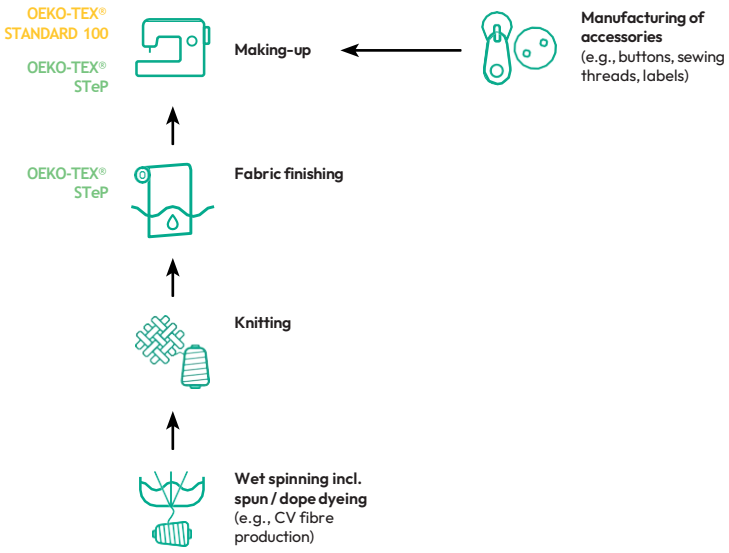
1. Outerwear example

1.8 Spun-dyed jumper

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (spun-dyed)	98.3 %	required for fabric finishing	wet/chemical ≥ 5 %
Sewing threads	1.6 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

Jumper (spun-dyed)

Example production steps:



1. Outerwear example

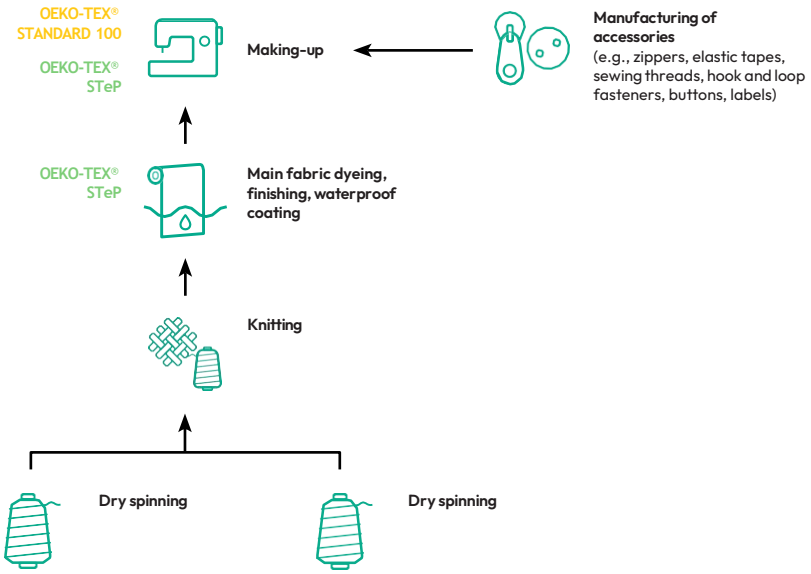
1.9 Waterproof coated soft-shell jacket

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (piece-dyed)	87.2 %	required for fabric dyeing, finishing, waterproof coating	wet/chemical ≥ 5 %
Zipper	5.2 %	not required	not considered *
Elastic and in-elastic tapes	3.5 %	not required	wet/chemical < 5 %
Sewing threads	2 %	not required	wet/chemical < 5 %
Hook and loop fastener	1 %	not required	wet/chemical < 5 %
Metal and plastic accessories	1 %	not required	not considered *
Labels	0.1 %	not required	wet/chemical < 5 %

Soft-shell jacket (piece-dyed, waterproof coated)

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



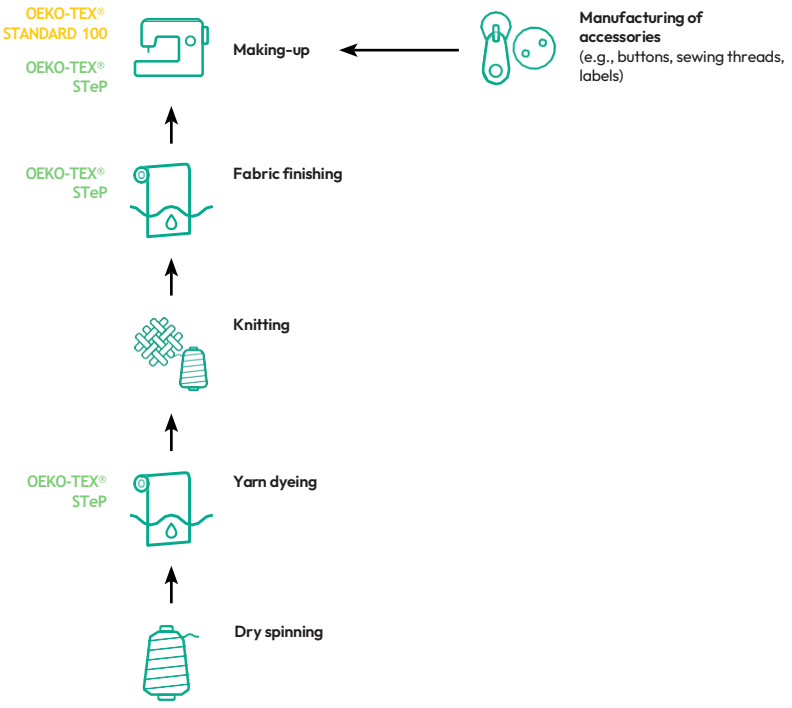
1. Outerwear example

1.10 Yarn-dyed sweatshirt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (yarn-dyed)	97.9 %	required for yarn dyeing, fabric finishing	wet/chemical ≥ 5 %
Sewing threads	2 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

Sweatshirt (yarn-dyed)

Example production steps:



2. Underwear and nightwear example

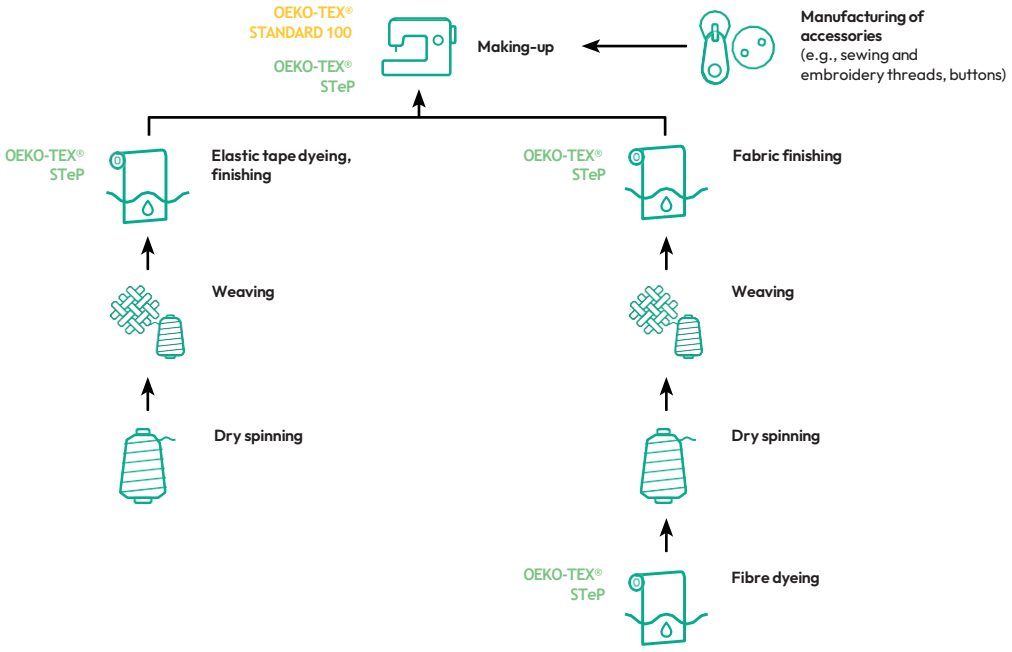
2.1 Fibre-dyed pyjamas

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Grey mélange fabric (fibre-dyed)	84.5%	required for fibre dyeing, fabric finishing	wet/chemical ≥ 5%
Elastic tapes	5.5%	required for fabric dyeing, finishing	wet/chemical ≥ 5%
Buttons	3.5%	not required	not considered *
Interlining (thermally bonded nonwovens)	2.5%	not required	not wet/chemical
Sewing threads	2%	not required	wet/chemical < 5%
Embroidery threads	2%	not required	wet/chemical < 5%

Pyjamas (fibre-/ stock-dyed, 2 pieces)

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



2. Underwear and nightwear example

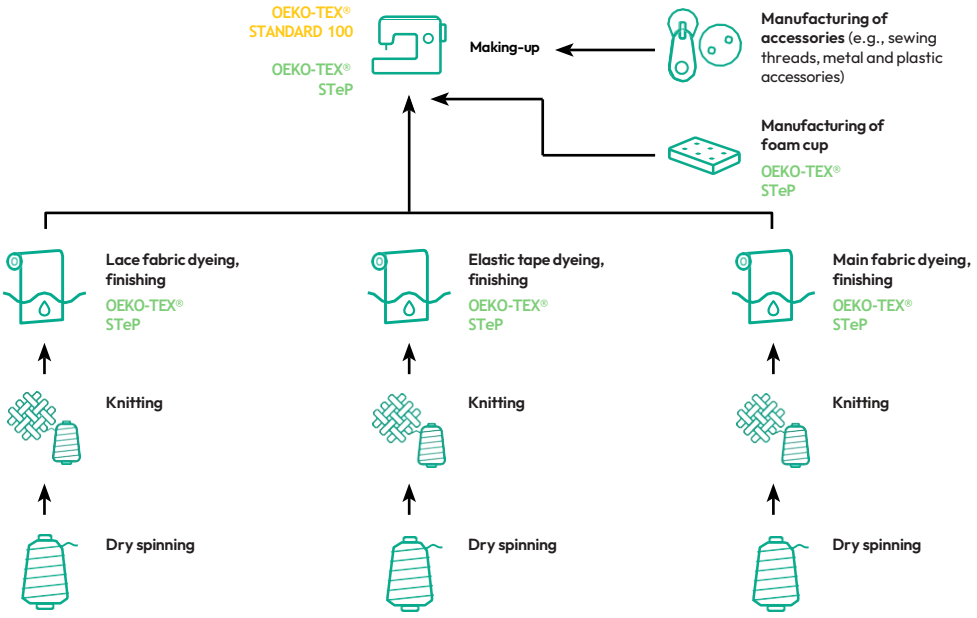
2.2 Piece-dyed bra

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (piece-dyed)	35%	required for fabric dyeing, finishing	wet/chemical ≥ 5%
Foam cups	45%	required for manufacturing of foam	wet/chemical ≥ 5%
Elastic tapes	8%	required for fabric dyeing, finishing	wet/chemical ≥ 5%
Lace	7%	required for fabric dyeing, finishing	wet/chemical ≥ 5%
Metal hook and eyes	2%	not required	not considered *
Plastic bow	2%	not required	not considered *
Sewing threads	1%	not required	wet/chemical < 5%

Bra
(piece-dyed, with foam cups)

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



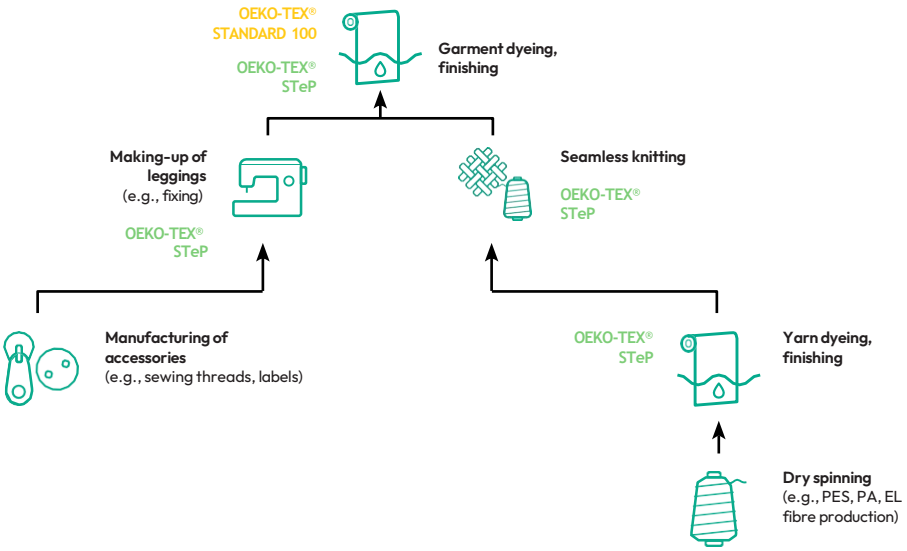
2. Underwear and nightwear example

2.3 Seamless leggings

Components of the product	Weight	STeP certification	Criteria
Garment dyeing and finishing	100 %	required for garment dyeing, finishing	wet/chemical ≥ 5 %
Ready-made article (inl. seamless knitting)		always required	making up
Knitting yarns (yarn-dyed)	99.8 %	required for yarn dyeing, finishing	wet/chemical ≥ 5 %
Sewing threads	0.1 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

Seamless leggings (garment-dyed)

Example production steps:



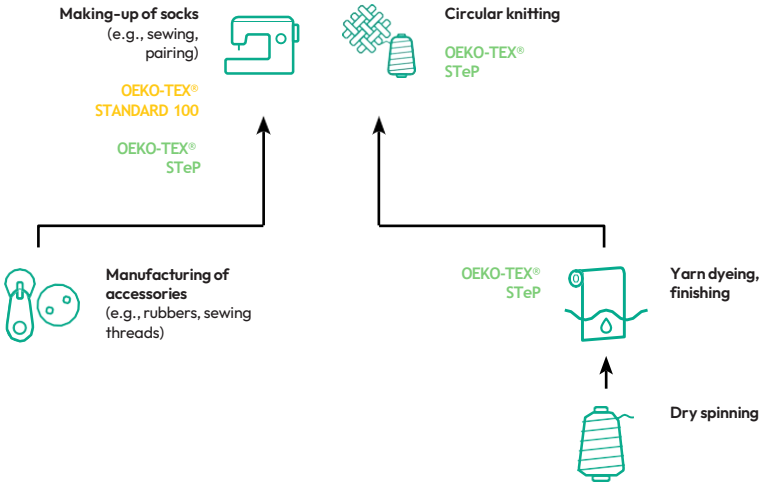
2. Underwear and nightwear example

2.4 Yarn-dyed pair of socks

Components of the product	Weight	STeP certification	Criteria
Ready-made article (inl. circular knitting)		always required	making up
Knitting yarns (yarn-dyed)	99.5 %	required for yarn dyeing, finishing	wet/chemical ≥ 5 %
Rubber	0.4 %	not required	not considered
Sewing threads	0.1 %	not required	wet/chemical < 5 %

Pair of socks (yarn-dyed, circular knitted)

Example production steps:



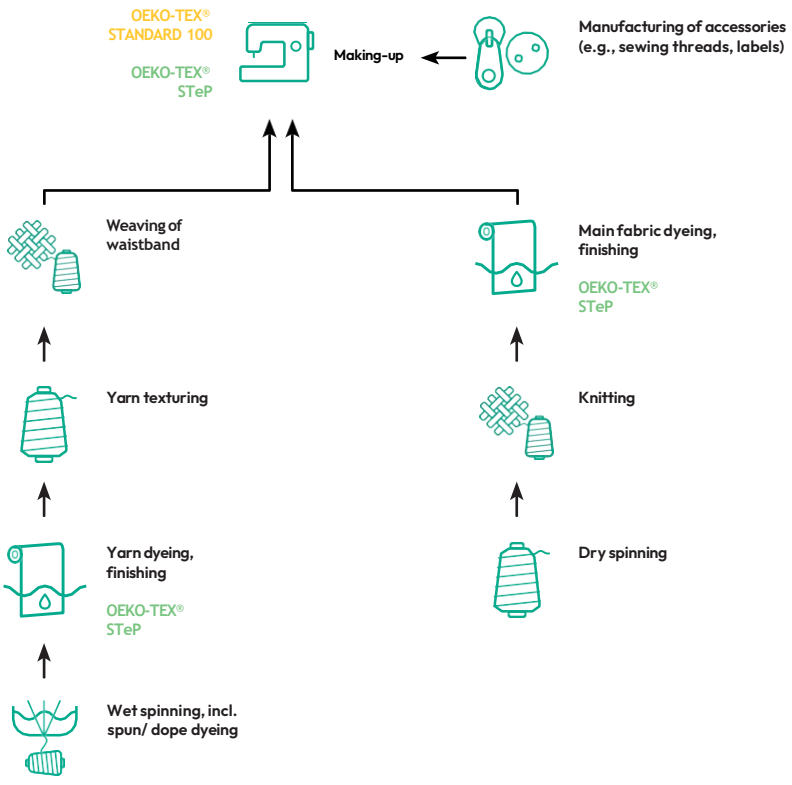
2. Underwear and nightwear example

2.5 Boxer briefs

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (piece-dyed)	73.8 %	required for fabric dyeing, finishing	wet/chemical ≥ 5 %
Elastic waistband (yarn-dyed)	24.5 %	required for yarn dyeing, finishing	wet/chemical ≥ 5 %
Labels	1.3 %	not required	wet/chemical < 5 %
Sewing threads	0.4 %	not required	wet/chemical < 5 %

Boxer briefs (piece-dyed, with elastic waistband)

Example production steps:



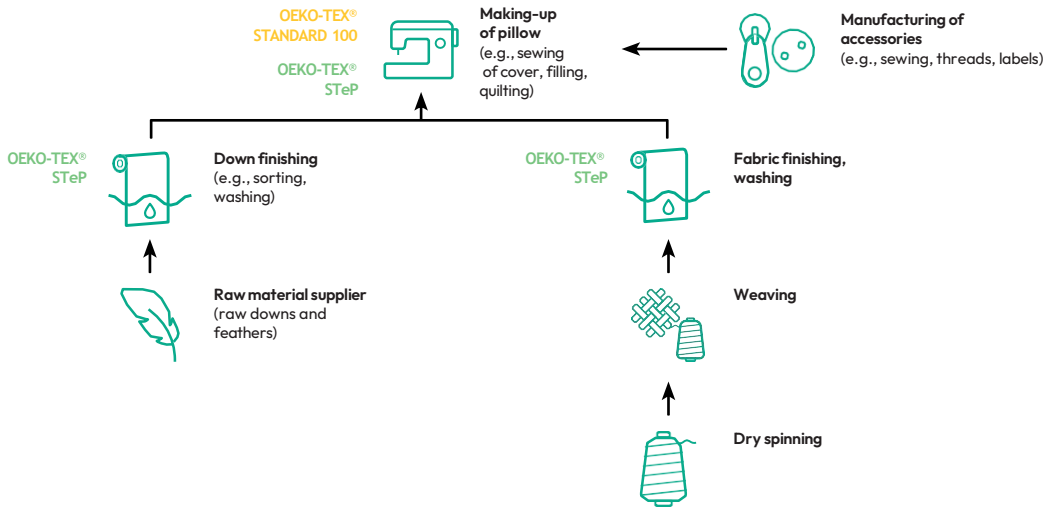
3. Home textiles example

3.1 Down feather pillow

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (raw white, finished)	15.7 %	required for finishing, washing	wet/chemical ≥ 5 %
Filling material (finished downs and feathers)	83 %	required for down washing, finishing	wet/chemical ≥ 5 %
Sewing threads	1 %	not required	wet/chemical < 5 %
Labels	0.3 %	not required	wet/chemical < 5 %

Pillow
(down and feather filled)

Example production steps:



3. Home textiles example

3.2 Foam mattress

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (bleached)	35 %	required for bleaching dyeing, finishing, washing	wet/chemical ≥ 5 %
Foam	48 %	required for manufacturing of foam	wet/chemical ≥ 5 %
Filling material *	8 %	not required	not wet/chemical
Interlining (chemically bonded nonwovens)	4 %	not required	wet/chemical < 5 %
Zipper	2.9 %	not required	not considered **
Sewing threads	2 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

Foam mattress (without pocket spring *)

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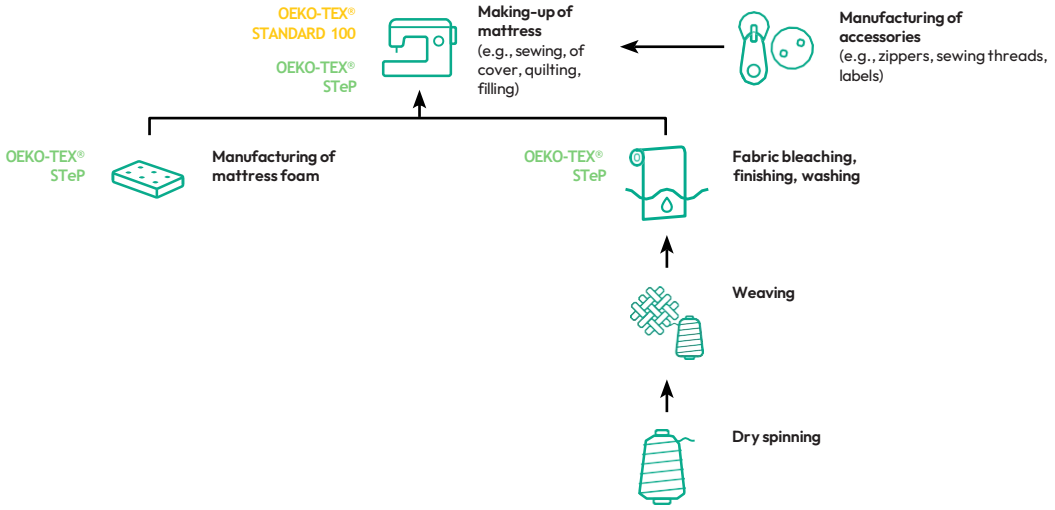
* In case of metal spring core mattresses, metal spring core filling is not considered as MADE IN GREEN criteria.
** Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



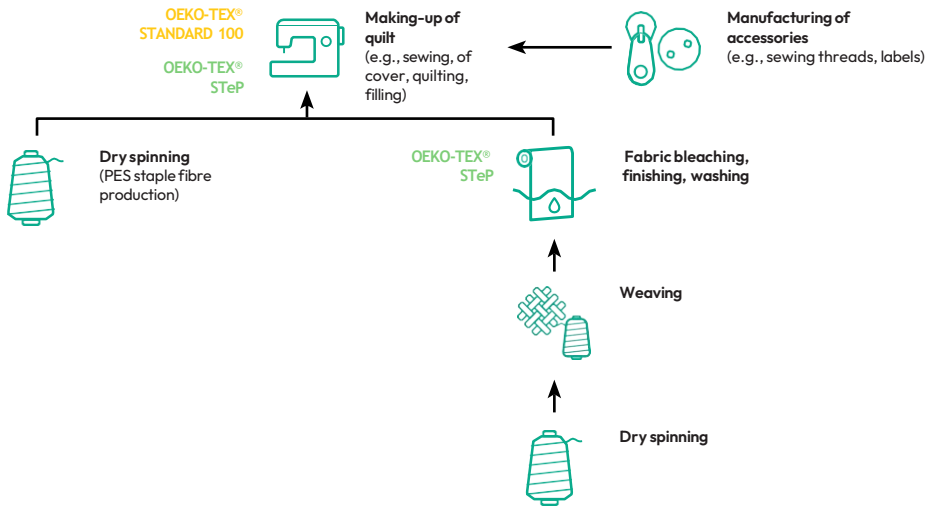
3. Home textiles example

3.3 Polyester quilt

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main fabric (bleached)	45 %	required for bleaching dyeing, finishing, washing	wet/chemical ≥ 5 %
Filling material (greige PES staple fibres)	48 %	not required	not wet/chemical
Piping	3.9 %	not required	wet/chemical < 5 %
Sewing threads	3 %	not required	wet/chemical < 5 %
Labels	0.1 %	not required	wet/chemical < 5 %

Quilt
(PES fibre filled)

Example production steps:

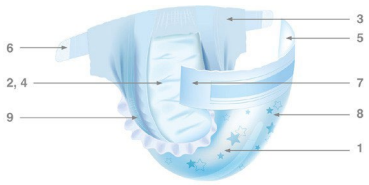


4. Sanitary articles example

4.1 Diaper

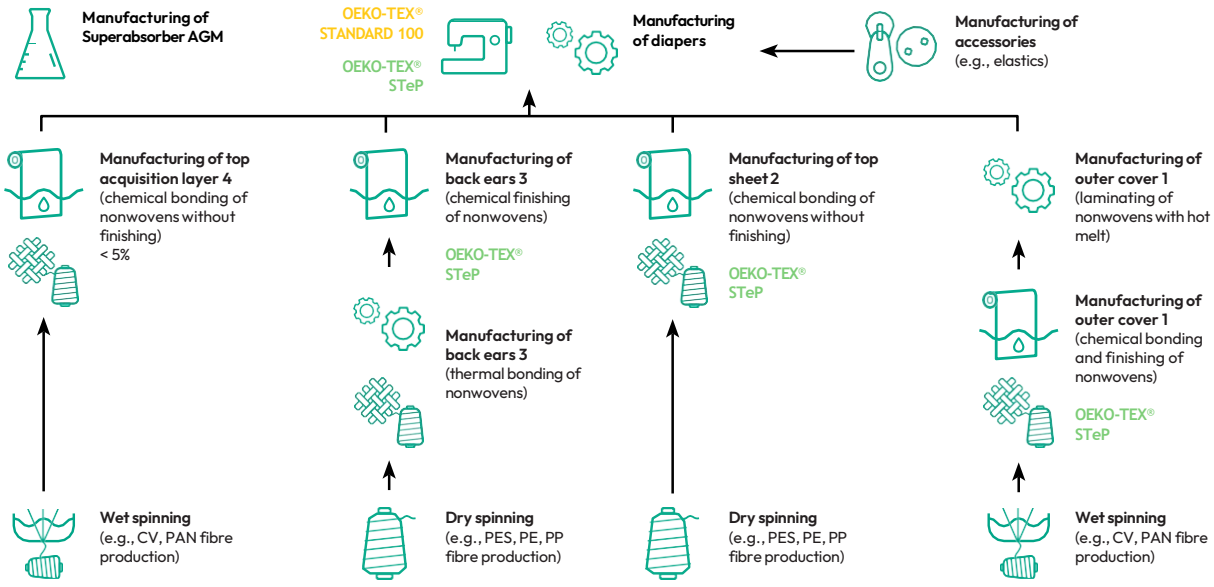
Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required for manufacturing of diapers	making up
Superabsorber AGM *	51 %	not required	not considered
Outer cover (1) (laminated, chemically bonded, finished, nonwovens)	14.9 %	required for chemical bonding and finishing of nonwovens	wet/chemical ≥ 5 %
Top sheet (2) (chemically bonded, not finished nonwovens)	14.5 %	required for chemical bonding of nonwovens	wet/chemical ≥ 5 %
Back ears (3) (thermally bonded, finished nonwovens)	5.5 %	required for chemical finishing of nonwovens	wet/chemical ≥ 5 %
Acquisition layer (4) (chemically bonded, not finished nonwovens)	3.5 %	not required	wet/chemical < 5 %
Fastening hooks (5) (chemically bonded, not finished nonwovens)	1.2 %	not required	wet/chemical < 5 %
Fastening tapes (6) (chemically bonded, not finished nonwovens)	1.2 %	not required	wet/chemical < 5 %
Front ears (7) (thermally bonded, not finished nonwovens)	1.4 %	not required	not wet/chemical
Printing zone (8) **	0.9 %	not required	wet/chemical < 5 %
Elastics (9)	0.6 %	not required	wet/chemical < 5 %
Adhesive *	4.7 %	not required	not considered
Lotion *	0.6 %	not required	not considered

Diaper



* Superabsorber AGM, adhesive and lotion (chemical products) are not standard subject to STeP certification for MADE IN GREEN.
** Printed part including nonwoven in weight. If it is more than 5% of the total weight of the product, STeP certification for wet/chemical printing processes is required (see examples 1.3. and 1.4).
*** Modified cellulose (fiber production/fluff pulps, wet spinning process) is currently not subject to STeP certification for MADE IN GREEN.
**** Definition for chemical, mechanical and thermal bonding (see MADE IN GREEN Standard, Annex 5: Terms and definitions).

Example production steps:



5. Leather articles example

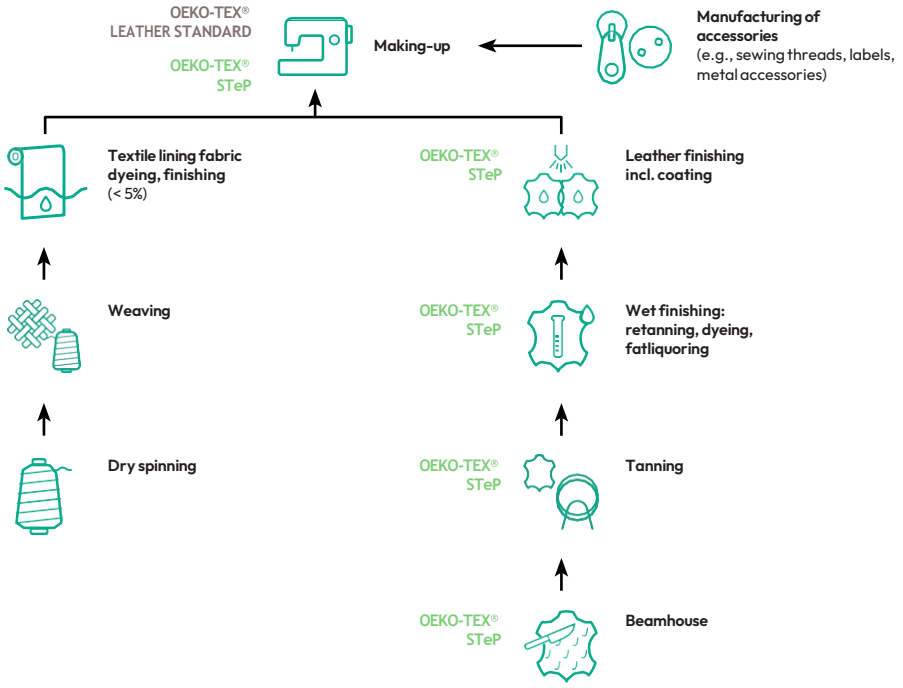
5.1 Leather bag

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main leather	90.2%	required for leather finishing, wet finishing, tanning, beamhouse	wet/chemical ≥ 5%
Textile lining (piece-dyed woven fabric)	1.8%	not required	wet/chemical < 5%
Zippers	3.5%	not required	not considered *
Metal accessories	2.1%	not required	not considered *
Strap stiffener, piping (plastic)	1.1%	not required	not considered *
Bottom stiffener (cardboard)	1.3%	not required	not considered *
Sewing threads	< 0.1%	not required	wet/chemical < 5%
Labels	< 0.1%	not required	wet/chemical < 5%

Leather bag

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



5. Leather articles example

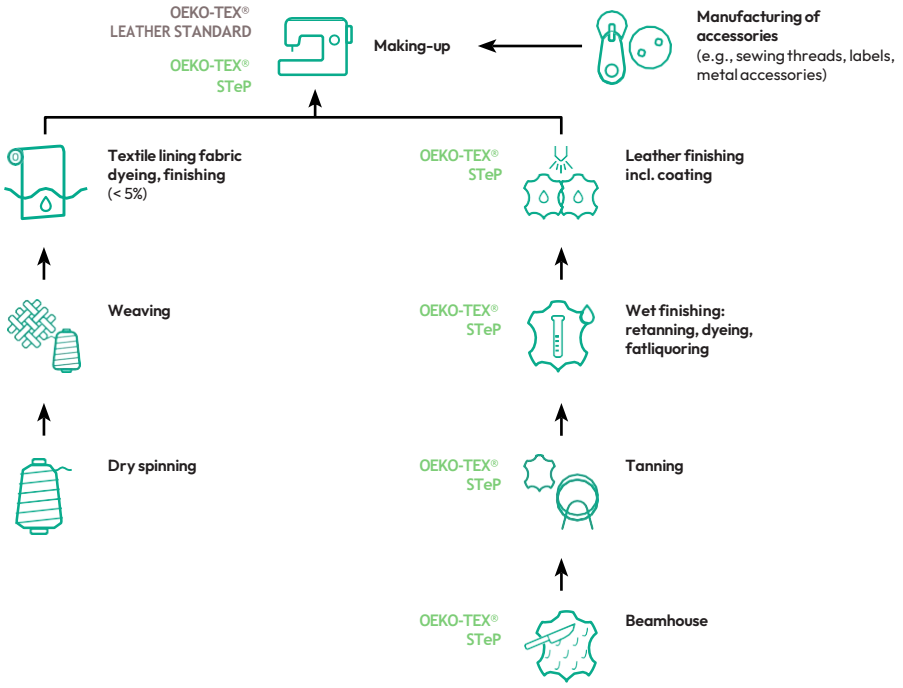
5.2 Leather jacket

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main leather	89.7 %	required for leather finishing, wet finishing, tanning, beamhouse	wet/chemical ≥ 5 %
Textile lining (piece-dyed woven fabric)	2.9 %	not required	wet/chemical < 5 %
Zippers	3.4 %	not required	not considered *
Metal accessories	2.1 %	not required	not considered *
Shoulder pads (foam)	1.2 %	not required	wet/chemical < 5 %
Fusible interfacing (coated nonwoven)	0.7 %	not required	wet/chemical < 5 %
Sewing threads	< 0.1 %	not required	wet/chemical < 5 %
Labels	< 0.1 %	not required	wet/chemical < 5 %

Leather jacket

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



5. Leather articles example

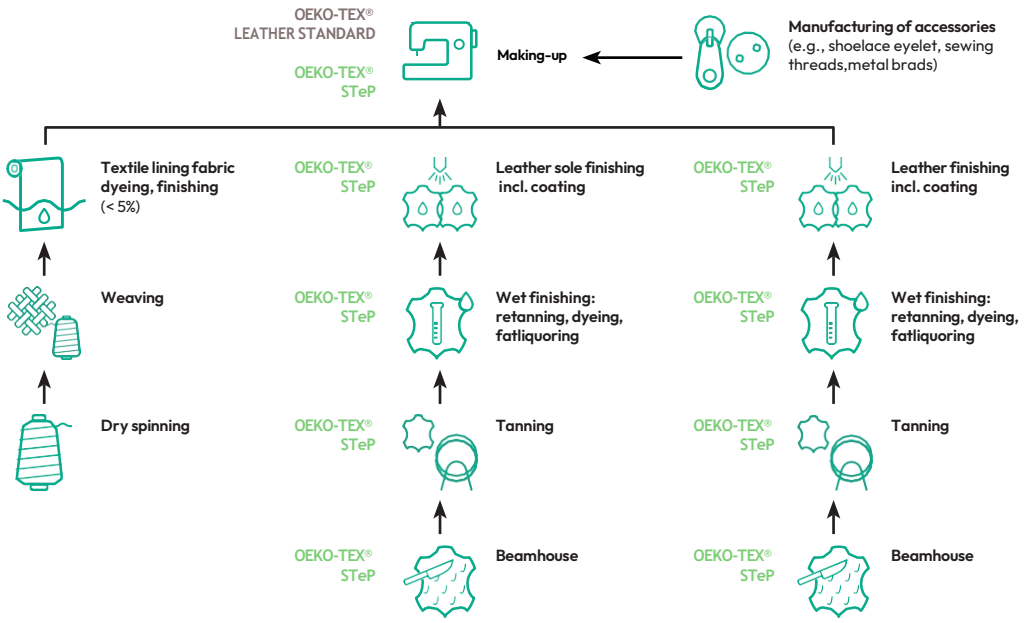
5.3 Leather shoe

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main leather	16.1 %	required for leather finishing, wet finishing, tanning, beamhouse	wet/chemical ≥ 5 %
Leather sole	48.1 %	required for leather finishing, wet finishing, tanning, beamhouse	wet/chemical ≥ 5 %
Middle sole	12.8 %	not required	not considered *
Inner sole	4.7 %	not required	wet/chemical < 5 %
Sole filling	4.2 %	not required	not considered *
Stiff strengthening components	4.0 %	not required	wet/chemical < 5 %
Flexible strengthening components	3.4 %	not required	wet/chemical < 5 %
Leather lining	2.9 %	not required	wet/chemical < 5 %
Textile lining	1.8 %	not required	wet/chemical < 5 %
Shoelace	0.9 %	not required	wet/chemical < 5 %
Eyelet	0.5 %	not required	not considered *
Sewing threads	0.3 %	not required	wet/chemical < 5 %
Metal brads	0.3 %	not required	not considered *

Leather shoe

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



5. Leather articles example

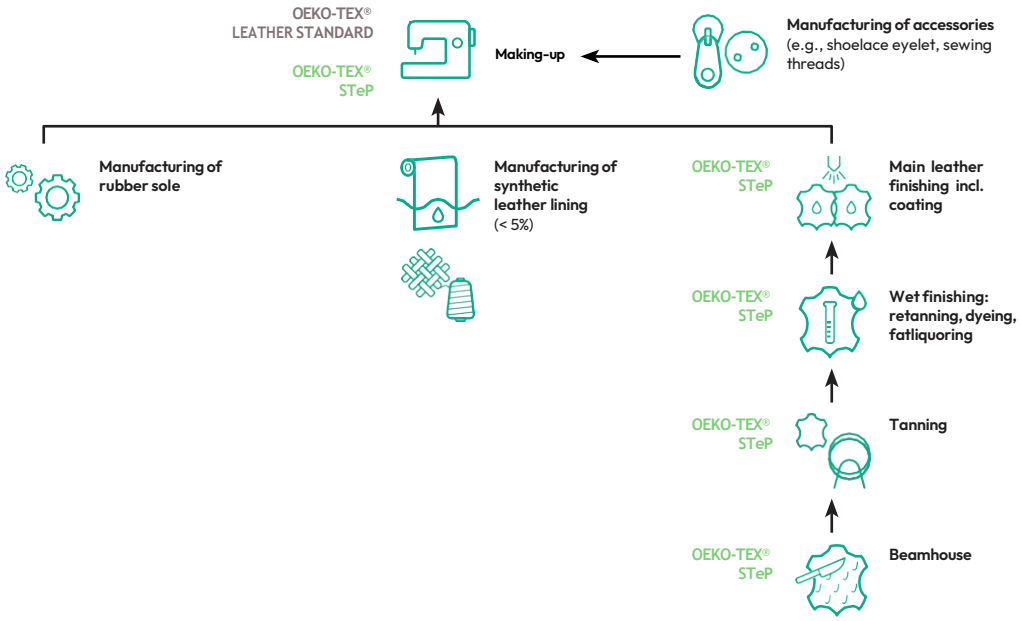
5.4 Leather sneaker

Components of the product	Weight	STeP certification	Criteria
Ready-made article		always required	making up
Main leather	13.6 %	required for leather finishing, wet finishing, tanning, beamhouse	wet/chemical ≥ 5 %
Rubber sole	60.7 %	not required	not considered *
Stiff strengthening components	4.7 %	not required	not considered *
Synthetic leather lining	4.6 %	not required	wet/chemical < 5 %
Textile lining	4.4 %	not required	wet/chemical < 5 %
Inner sole	3.6 %	not required	wet/chemical < 5 %
Middle sole	2.6 %	not required	not considered *
Shoelace	2.5 %	not required	wet/chemical < 5 %
Eyelet	2.0 %	not required	not considered *
Flexible strengthening components	1.0 %	not required	wet/chemical < 5 %
Sewing threads	0.3 %	not required	wet/chemical < 5 %

Leather sneaker

* Metal, rubber and cardboard are currently not considered as MADE IN GREEN criteria.

Example production steps:



6.MADE IN GREEN & ORGANIC COTTON example

6.1 All-Over-Printed Organic Cotton T-Shirt

Components of the product	Weight	Process Certificate: OEKO-TEX® STeP	OEKO-TEX® MADE IN GREEN Criteria	Product Certificate:	OEKO-TEX® MADE IN GREEN Criteria	Dashboard Data Entry	OEKO-TEX® MADE IN GREEN Criteria
Finished article: T-shirt		**required**	2 (making up)	**required** (OEKO-TEX® ORGANIC COTTON)	1 (laboratory testing)	**required**	4 (traceability)
Knitted fabric: 100% organic cotton Processed state:	96%						
Fabric bleached		**required**	3 (wet / chemical ≥ 5%)	---	---	**required**	4 (traceability)
Flock all-over printed		**required**	3 (wet / chemical ≥ 5%)	---	---	**required**	4 (traceability)
Knitted		recommended	---	**required** (OEKO-TEX® ORGANIC COTTON)	1 (verified transaction)	**required**	4 (traceability)
Spun		recommended	---	**required** (OEKO-TEX® ORGANIC COTTON)	1 (verified transaction)	**required**	4 (traceability)
Ginned		recommended	---	**required** (OEKO-TEX® ORGANIC COTTON)	1 (verified transaction)	**required**	4 (traceability)
Farmed		---	---	**required** (IFOAM)	1 (verified transaction)	recommended	4 (traceability)
Textile accessories:							
Neckline tape	3.4%	recommended	3 (wet / chemical < 5%)	recommended (OEKO-TEX® STANDARD 100	---	recommended	4 (traceability)
Woven and printed label	0.5%	recommended	3 (wet / chemical < 5%)	recommended (OEKO-TEX® STANDARD 100	---	recommended	4 (traceability)
Sewing threads	0.1%	recommended	3 (wet / chemical < 5%)	recommended (OEKO-TEX® STANDARD 100	---	recommended	4 (traceability)

Addition to MADE IN GREEN Criteria 1 for articles based on ORGANIC COTTON:

To ensure full traceability for any article carrying the OEKO-TEX® MADE IN GREEN label that is based on OEKO-TEX® ORGANIC COTTON certification, the MADE IN GREEN supply chain shall match the corresponding ORGANIC COTTON supply chain, as verified through the OEKO-TEX® ORGANIC COTTON transaction certificates – at least to the ginning stage (mandatory) and preferably back to the cotton farm (voluntary).

All articles sold with the OEKO-TEX® MADE IN GREEN label shall be covered in the scope of the corresponding OEKO-TEX® ORGANIC COTTON certificate and transaction certificates.

For each OEKO-TEX® MADE IN GREEN article main component, the relevant OEKO-TEX® ORGANIC COTTON certificate number shall be entered in the MADE IN GREEN dashboard.

Example production steps: