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June 2025

A Textile Today Initiative | Published with Volume 18, Issue 06 | Pages 75 to 88



Eco-driven chemistry as the core of OHYOUNG's commitment

**Jinwook Chung**  
President,  
OHYOUNG Inc.

**Bangladesh rises as a global denim leader in 2025**



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# Bangladesh rises as a global denim leader in 2025

Mohammad Mezbah Uddin

The global denim industry is navigating a period of deep transformation in 2025. Shaped by post-pandemic recovery, persistent economic uncertainty, and growing pressure on sustainability, global fashion brands are reassessing their sourcing strategies. Amid this realignment, Bangladesh has emerged as one of the most competitive and reliable players in the denim space, combining sustainability, scale, and supply chain agility.

No longer just a low-cost manufacturing hub, Bangladesh is now a strategic partner for global denim brands seeking resilience, quality, and ethical production. Its position in the global market is becoming more prominent, as evidenced by remarkable export growth, investments in green manufacturing, and a shift toward innovation.

## Bangladesh's denim exports show impressive growth

In the first quarter of 2025, Bangladesh's denim exports recorded impressive year-on-year growth, reflecting renewed confidence from global buyers. According to data reported by The Financial Express, denim exports to the United States jumped by 56 percent, while shipments to the European Union rose by 32 percent. These results have further strengthened Bangladesh's position as the second-largest denim supplier to the EU and the third-largest to the US.

This growth comes at a time when the overall global market remains volatile. High inflation, cautious consumer spending, and political uncertainties have led to slow demand in the West. Yet, Bangladesh has continued to win the trust of major fashion retailers like Levi's, PVH, H&M, C&A, and Zara. These brands are increasingly relying

## Key Highlights:

- » +56% to the US and +32% to the EU in Q1 2025
- » Major buyers like Levi's, H&M, PVH, and C&A boost sourcing from Bangladesh for reliability and compliance
- » 200+ LEED-certified factories using laser, ozone, and waterless tech for sustainable production
- » From spinning to finishing, Bangladesh offers fast, transparent, end-to-end denim solutions
- » Poised to enter high-end denim with investments in design, finishing, and value-added capabilities
- » Targeting growth beyond the EU and US—Latin America, Middle East & Africa on the radar
- » Adopting digital sampling, AI, and traceability tech to meet global sourcing demands.

on Bangladesh not just for pricing but for performance—on-time delivery, strong compliance standards, and increasingly, sustainability credentials.

In a market where reliability and ESG alignment are becoming non-negotiable, Bangladesh is offering a powerful value proposition.

## Green manufacturing and vertical integration fuel competitiveness

The country now boasts more than 200 LEED-certified green factories, the highest concentration in the world. Many of these are denim-specific, equipped with technologies such as laser finishing, ozone washing, and waterless dyeing that reduce environmental impact and meet the

rigorous standards of international buyers.

Vertical integration has also played a vital role. Unlike some competitors that rely on fragmented supply chains, Bangladesh offers end-to-end solutions, from spinning and dyeing to finishing and garmenting.

Bangladesh's factories have also embraced automation, ERP systems, and digitized inventory management, which improves both efficiency and transparency. Coupled with a resilient and skilled labor force, the industry has created a modern ecosystem capable of fulfilling high-volume orders without compromising on compliance or quality.

## Strategic pathways: Premium segments and new markets

Premium denim, once dominated by countries like Italy, Japan, and Turkey, presents a promising opportunity. With rising production costs in those regions, brands are looking for partners who can offer luxury aesthetics at scale. If Bangladesh invests in design development, premium washes, and limited-run capsules, it can make significant inroads into this space.

There's also potential in expanding export destinations. While the EU and US remain key markets, regions like Latin America, the Middle East, and parts of Africa are showing growing denim demand. Diversifying export destinations will reduce dependency on traditional buyers and spread risk more evenly across global markets.

Innovation will also be key. By integrating digital sampling, AI-based inventory planning, and blockchain traceability, Bangladesh can further differentiate itself. Global sourcing heads are no longer impressed by just output—they want agility, sustainability, and innovation in a single package.

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### DT Editorial

Bangladesh rises as a global denim leader in 2025

77

### Denim Today



Denim industry's sustainable future depends on adopting technology and shifting mindsets

79

### TTH 8.0



Comparative evaluation of traditional pumice stone washing and enzyme-based waterless washing for sustainable denim finishing

80

### Event Review



Bangladesh Denim Expo concludes with strong focus on post-LDC strategy

82

### Expert Views



DyeMate solutions Combining indigo and sulfur for next-gen denim finishing

83-84

### Interview



Eco-driven chemistry as the core of OHYOUNG's commitment

86-87

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An initiative of Textile Today

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# Denim industry's sustainable future depends on adopting technology and shifting mindsets

Najmus Sakib

At the 18th edition of Denim Expo, held at the International Convention City Bashundhara (ICCB), experts from the denim industry gathered at the Denim Solution Booth to discuss how to make denim washing more sustainable in the face of the ongoing energy crisis. The discussion was moderated by Engr. Md. Mehedi Hasan, General Manager of Starling Laundry Ltd.

A.M. Abdullah Al Mamun Uzzal, General Manager and Head of Production at Laundry Industries Ltd., shared how Denim Expo plays a vital role in helping the industry stay informed about the latest technologies and innovations. He pointed out that Bangladesh's denim industry has secured a strong position thanks to ongoing efforts, studies, and case analyses. To achieve true sustainability in denim production, we need to consider more than just the chemicals we use - the machines and tools play a big role too. He went on to say, "We keep learning how to use new machines and tools well, and we're teaching the next generation about these ideas to keep sustainable practices going."

S.M. Sohel Rana, Managing Director of Denim Solutions Ltd., raised a serious concern, saying that the next war could be over energy, environment, and sustainability. He pointed out, "Even if we produce garments in a sustainable way, if that product travels 5,000 kilometers before reaching the end consumer, it can no longer be called sustainable." He emphasized that we need to think about how much clean water we are leaving for our next generation. "We must protect our rivers. When using machines, we must consider



Figure: Denim Solutions Ltd. Booth at Denim Expo. From left S.M. Sohel Rana, MD of Denim Solutions Ltd., Md. Tazul Islam, General Manager (Washing) of Islam Garments Ltd., Md. Moniruzzaman Babu, Deputy Director (Washing & Dyeing) at Crown Wears (Pvt.) Ltd.

how much energy and water those machines are saving. And when choosing chemicals, we must evaluate their environmental impact." According to him, such considerations are essential for ensuring a safe future for our children and keeping the economy strong.

Md. Tazul Islam, General Manager (Washing) of Islam Garments Ltd., said, "We have invested in the latest machines that use a low liquor ratio, but we are not implementing them properly." He explained that the habit of frequently checking garments during the washing process often leads to skipping steps or performing unnecessary rewashing. He suggested that establishing a Standard Operating Procedure (SOP) would reduce rewash rates and help shift mindsets away from overchecking.

Md. Moniruzzaman Babu, Deputy Director (Washing & Dyeing) at Crown Wears (Pvt.) Ltd., stated, "We are now living in the age of the 4th Industrial Revolution. We have to ensure maximum use of machinery and minimal use of chemicals." He

explained that using fewer chemicals not only supports sustainability but also aligns with modern manufacturing principles. Sustainable chemical use can shorten processing time, reduce the number of steps, and allow combining multiple processes, which results in lower water and energy consumption and shorter dosing times.

He also highlighted the importance of training the workforce in new technologies. "If the workforce is properly trained, the factory owners will ultimately benefit, both in terms of efficiency and cost-effectiveness."

Md. Reza-E-Rabbi, Head of Operation (Laundry) at Vertex RMG Division, made a powerful point: "We are still getting water for free, which is why many don't think about saving it. The day we start paying for water is the day true sustainability will begin." He also said that accepting a broader shade range can significantly contribute to sustainable practices. End users typically don't notice slight shade variations, so allowing a wider shade tolerance reduces waste and reprocessing, which in turn saves resources.

# Comparative evaluation of traditional pumice stone washing and enzyme-based waterless washing for sustainable denim finishing

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Figure: The enzyme wash method significantly reduces water usage by saving one water batch and two rinse cycles,

## Abstract

The textile industry is increasingly adopting sustainable practices to improve garments quality while minimizing environmental impact. Traditional techniques such as pumice stone washing, widely used in denim washing production, contribute to significant environmental and economic challenges, including high water consumption, elevated operational costs, and the formation of pumice sludge that burdens effluent treatment plants (ETP).

A key concern is the environmental footprint of denim washing processing, specifically the excessive water and energy consumption associated with stone washing. Our findings indicate that the stone-free enzyme wash process presents a more sustainable and efficient alternative.

While both traditional stone washing and enzyme washing require similar processing times, the enzyme wash method significantly reduces water usage by saving one water batch and two rinse cycles, ultimately optimizing water and cost efficiency.

Additionally, this technique optimizes both water and cost efficiency by eliminating the need for pumice stones. Furthermore, the enzyme wash method improves labor efficiency by reducing the need for manual handling of stones. By conducting a comprehensive life cycle assessment, this article evaluates the environmental and financial benefits of the stone-free enzyme wash, demonstrating its potential as a more sustainable alternative

to conventional stone washing in the denim industry.

## Keywords:

Denim Finishing Techniques, Sustainable Denim Processing, Aqualess enzyme washing, and Pumice Stone Washing.

## 1. Introduction

The finishing techniques employed in the denim washing industry have undergone constant change as the customers demand unique textures, extensive range of hand feel and various other aesthetics in denim garments. Out of the available traditional methods, stone washing employing pumice stones has been widely used on denim fabrics in efforts to achieve a worn out and faded out look which adds a vintage look on garments. However, with the advancements in textile processing technologies, enzyme washing techniques have emerged to be efficient and environmentally responsive. There are three washing methods that are examined in this report two of which are chemical aided procedures based on enzymes with different formulations.

By evaluating their effectiveness on denim Garments. In terms of appearance properties, fabric performance properties and environmental properties, the study demonstrates how conventional methods and new technologies can be used alongside each other. The results are expected to provide.

## 2. Challenges of traditional stone-washing in the denim industry

- **High resource consumption:** Requires large amounts of water, energy, and labor.
- **Environmental impact:** Generates significant waste, reduces Effluent Treatment Plant (ETP) capacity, and increases sludge production.
- **Worker health risks:** Causes potential health hazards, including inhalation issues from pumice stone dust.
- **Wastewater strain:** Disposal of pumice stones adds pressure on wastewater treatment facilities.
- **Financial impact:** Significantly reduce the lifetime of a machine.

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# Bangladesh Denim Expo concludes with strong focus on post-LDC strategy

## Desk Report

*The 18th edition of the Bangladesh Denim Expo wrapped up on Tuesday, May 13, spotlighting the industry's readiness to navigate the country's upcoming graduation from Least Developed Country (LDC) status. The two days event in Dhaka drew significant attention to innovation, sustainability, and workforce capacity building as key tools for ensuring continued global competitiveness. The expo hosted 57 exhibitors from 13 countries, including Bangladesh, India, Pakistan, China, Turkey, Spain, Italy, Vietnam, UAE, Germany, Switzerland, and the USA.*

These participants showcased cutting-edge technologies and sustainable denim solutions aimed at preparing the industry for a new chapter in international trade.

In the opening session, Mostafiz Uddin, Founder and CEO of the Bangladesh Denim Expo said, "Bangladesh has emerged as the fastest-growing apparel exporter to the United States in the first quarter of 2025, recording a year-on-year growth of 26.64%."

The country's denim sector must leverage its strengths in innovation, skill development, and sustainability to remain competitive amid global trade shifts, particularly under new U.S. tariffs introduced by the Trump administration, he added.

As Bangladesh prepares for its transition to developing country status



Figure: The expo hosted 57 exhibitors from 13 countries, including Bangladesh, India, Pakistan, China, Turkey, Spain, Italy, Vietnam, UAE, Germany, Switzerland, and the USA.

in 2026, the industry faces potential changes to its preferential trade agreements.

Notably, Bangladesh is currently benefiting from duty-free access to the European Union under the Everything But Arms (EBA) initiative and the Generalised Scheme of Preferences (GSP). However, the country may lose these privileges by 2029 unless it qualifies for GSP Plus.

During the Denim Expo 2025, industrialists expressed their concern on country's economy and said, the denim industry must now concentrate on building institutional and workforce capacity to adapt and thrive in a more competitive and evolving global trade environment—especially as Bangladesh prepares for its graduation from LDC status.

Accordingly, Mohammad Jahangir Alam, Head of Operations (Garment Unit) at Square Denims Ltd. offered in his session, titled "The Denim Business Beside Sewing and Wash Production," a comprehensive look at the less visible yet crucial components of the denim value

chain that extend beyond traditional manufacturing processes.

He discussed how value addition in denim manufacturing now goes far beyond basic sewing and washing, and highlighted the growing importance of process integration, supply chain efficiency, sustainable chemical use, and advanced fabric finishing techniques.

In terms of global buyers are shifting preferences, Alam stressed the need for Bangladeshi denim producers to invest in training, technology, and infrastructure upgrades to remain competitive in the post-LDC global market.

Along with two important panel discussions, the event also featured a fashion trend zone, offering attendees a glimpse into the future of denim through sustainable fabric innovations and locally developed technologies.

With growing interest from global buyers and a renewed commitment to innovation, the Bangladesh Denim Expo once again affirmed the country's position as a key player in the international denim supply chain.

# DyeMate solutions

## Combining indigo and sulfur for next-gen denim finishing

**DyeMate is the new patented Tonello technology that revolutionizes and reinterprets the traditional indigo garment dyeing process, taking it to a new evolutionary stage and making it automatic and repeatable, efficient and sustainable.**

**Syed Maruf Ahmed**, Technical Officer, Ha-meem Group

### Indigo dyeing with DyeMate

In traditional indigo dyeing, garments are dipped multiple times in a leuco (reduced) indigo solution and then exposed to air to oxidize and develop the characteristic blue color.

DyeMate has automated and made this entire process more efficient.

### In the DyeMate process

- » A fully automated machine is used where the fabric or garments are loaded.
- » Leuco indigo (the reduced form of indigo) is prepared, usually using hydrosulfite and caustic soda.
- » Garments are dipped through short, controlled cycles in the indigo solution.
- » Oxidation is carried out either by air exposure or oxygen injection, which develops the blue color.
- » Each step is precisely monitored by process sensors, ensuring consistent results batch after batch.

**Outcome:** An authentic indigo look is achieved with less chemical usage, reduced water consumption, and shorter processing times.

### Sulfur dyeing with DyeMate

Sulfur dyes are typically insoluble pigments and must be chemically reduced to become soluble for dyeing.

### In the DyeMate process

- » Sulfur dyes are reduced using sodium sulfide or alternative reducing agents.
- » Garments are dyed in this solution. (Traditionally, sulfur dyeing requires

temperatures between 60–80°C, but DyeMate enables dyeing at room temperature or optimized lower temperatures.)

- » Oxidation is then applied to reconvert the dyes into their insoluble form inside the fiber, fixing the color.

### Advantages of DyeMate

- » Better dye penetration,
- » Less streaking and uneven dyeing,
- » Easy reproducibility.

**Result:** Deep shades (such as black, green, and red) with a denim-like appearance, developed consistently and efficiently.

### Sulfur Essence – combined bath dyeing

Sulfur Essence is the most advanced process developed by DyeMate. Here, indigo and sulfur dyes are applied together in a single bath.

### Traditional challenges

- » Indigo and sulfur dyes require different pH levels and reduction conditions.
- » Compatibility issues between the two dye types.

### DyeMate solution

- » Special dye formulations have been developed to allow both dyes to work together in a single bath.
- » Digitally managed reduction and oxidation controls are used.
- » An optimized chemical balance ensures no dye dominates the other.

### Results

- » Discharge-like effects are achieved,
- » Enhanced depth and texture are developed,

- » The one-step process saves time, water, and energy.

### Supporting technologies

- » Core 2.0, EGO, NoStone® — advanced finishing technologies fully compatible with DyeMate-dyed fabrics. (Example: NoStone® achieves abrasion without using real stones.)
- » Laser marking compatibility — DyeMate dyes respond perfectly to laser effects, which is ideal for sustainable garment distressing.

### Sustainability highlights

- » Lower water usage (single bath processing reduces the need for multiple baths),
- » Lower temperatures (saving significant energy),
- » Reduced chemical waste,
- » High reproducibility, minimizing the need for reprocessing.

### Dyeing recipes

#### 1. Indigo dyeing recipe (per liter of bath)



Figure: DyeMate would not have been possible without the precious support of Archroma, which provided Denisol Pure Indigo 30 liq, an aniline-free indigo solution.



- » Indigo Paste: 1.5–2.0 g/L
- » Caustic Soda (NaOH): 1.0–1.5 g/L
- » Sodium Hydrosulphite: 2.0–3.0 g/L
- » Wetting Agent: 0.5 g/L

**Procedure:**

- » Pre-wet garments.
- » Prepare indigo bath with the above chemicals.
- » Adjust pH to 11.5–12.0.
- » Temperature: 50°C
- » Dyeing time: 15–20 minutes
- » Finish with H<sub>2</sub>O<sub>2</sub> or air oxidation for color fixing.

**2. Sulfur dyeing recipe (per liter of bath)**

- » Sulfur Dye (Black/Olive/Green): 1.0–2.5 g/L
- » Caustic Soda (NaOH): 1.5–2.0 g/L
- » Sodium Hydrosulphite: 2.0–3.5 g/L
- » Levelling Agent: 0.5 g/L

**Procedure:**

- » Prepare the dye solution properly.
- » Submerge garments and dye at 40–50°C.
- » Dyeing time: 20–30 minutes.
- » Oxidize and fix color.

**3. Sulfur essence (double dye recipe, per liter of bath)**

- » Indigo Paste: 1.0–1.5 g/L
- » Sulfur Dye (Black/Olive): 1.5–2.0 g/L
- » Caustic Soda (NaOH): 1.5 g/L
- » Sodium Hydrosulphite: 2.5–3.0 g/L
- » Wetting + Levelling Agent: 0.5 g/L

**Procedure:**

1. Pre-wet garments and load into the machine.
2. Prepare a combined dye bath.
3. Pre-reduction and dyeing at 45–50°C for 15–20 minutes.
4. Followed by oxidation using H<sub>2</sub>O<sub>2</sub> or air.
5. Finish with softener or acid wash and drying.

**Challenges & solutions**

Challenge	Cause	Solution
pH Conflict	Indigo prefers pH 11–13, Sulfur 9–11	Balanced formulation maintaining pH 11.5–12
Uneven Dyeing	Fast reactivity of sulfur dye	Slow addition, constant agitation
Staining/ Streaking	Two dyes oxidizing together	Controlled oxidation using mild oxidizers
Compatibility Issues	Dye degradation in each other's presence	Use only compatible sulfur dyes, validate by lab trials
Over-reduction	Excess hydrosulfite prevents color development	Correct dosage, ORP control

**How DyeMate Processes Work**  
(From Submersive Dyeing to Sulfur Essence)

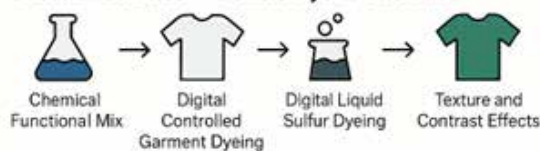
**1. Indigo Dyeing**



**2. Sulfur Dyeing**



**3. Sulfur Essence — Double Dye in One Bath**



**Compatible Technologies:**

- Core 2.0
- EGO
- NoStone®
- Less Water Usage
- Lower Temperature Dyeing
- Reduced Chemical Load

**Machine suggestions for DyeMate process**

- » Fully automated rotary-drum type garment dyeing machine,
- » Integrated pH & ORP sensors,
- » Auto chemical dosing system,
- » Air injection or vacuum oxidation stages.

**Oxidation phase (post-dyeing step)**

- » Air dry garments or,
- » Hydrogen Peroxide (1–2 g/L) + Acetic Acid bath for oxidation and fixing,
- » Final wash with detergent and softener.

By combining precision, reproducibility, and environmental responsibility, DyeMate simplifies complex dyeing challenges—especially in denim manufacturing. Its compatibility with modern finishing technologies like laser and NoStone® ensures that it is not only efficient but also future-ready. As the textile industry continues to evolve, innovations like DyeMate will play a key role in meeting the growing demands for quality, consistency, and sustainability.



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# Eco-driven chemistry as the core of OHYOUNG's commitment

Amzad Hossain Monir



Figure 1: Jinwook Chung, President of OHYOUNG Inc.

**Textile Today:** Could you please provide a brief overview of OHYOUNG and its history, highlighting key milestones and achievements that have shaped the company?

**Jinwook Chung:** Since established in 1981, OHYOUNG has been developing and producing reactive dyes and disperse dyes for textiles in its own factory in Korea. Our sales revenue in 2024 was 150M USD and we export our products to over 50 countries around the world. Turkey, Vietnam, Bangladesh, Pakistan, and Egypt are key countries we're exporting now. Our business motto, "Color is demand, reliability is our response" shows how OHYOUNG is thinking of our business. Quality consistency is our core value which can not be compromised in any case. OHYOUNG is still manufacturing more than 90% products from low materials in single Korean factory site to keep our core value.

**Textile Today:** Can you share any recent technological innovations or product developments that have significantly impacted your manufacturing processes or product offerings?

**Jinwook Chung:** Sunfix HP and Suncron APEX products are representative examples we introduce today in seminar. Sunfix HP products are reactive dyes that best meet the needs of recent cotton clothing. As the need for sustainability has been highlighted, the clothes we wear have been required to have properties that are strong enough to withstand repeated washing, and dyestuffs that do not change color for a long time have been required.

In addition, as wash-off properties have been improved, sufficient fastness has been achieved with only a milder, low-temperature washing process, and water, energy, and dyeing time have been drastically

*OHYOUNG Inc., a prominent South Korean manufacturer, specializes in innovative textile auxiliaries and chemical solutions that enhance performance, sustainability, and process efficiency. With a strong global footprint, the company is known for its commitment to eco-friendly and advanced chemical technologies.*

*Jinwook Chung, President of OHYOUNG Inc., is a visionary leader driving the company's global expansion and innovation strategy. Under his leadership, OHYOUNG continues to strengthen its position as a trusted partner to the textile industry worldwide.*

*During his recent visit to Bangladesh, Chung shared exclusive insights with Textile Today, highlighting OHYOUNG's strategic vision, collaboration potential, and commitment to supporting the region's evolving industry landscape. His visit marks a promising step toward deeper partnerships and technological advancements in Bangladesh's textile sector.*

saved due to the reduced washing process. Ultimately, it is a dyestuff suitable for reducing carbon dioxide emissions.

Suncron APEX products are disperse dye products that best meet the needs of recent polyester dyeing trends. First of all, it shows excellent durability in polyester or polyester/cotton blend dyeing. It can satisfy most the properties required for activewear, uniforms, and workwear.

**Textile Today:** As the textile and apparel industry in Bangladesh continues to grow, how does OHYOUNG view this market in terms of opportunities and challenges? What role does Bangladesh play in your regional strategy?

**Jinwook Chung:** The Bangladesh market is a market with high-level dyeing technicians and excellent understanding of new technologies and innovations. When developing new products or incorporating new



Figure 2: The seminar was honored by the presence of His Excellency Park Young-sik, Honorable Ambassador of the Republic of Korea to Bangladesh; Jinwook Chung, President of Ohyoung Inc.; and senior members of Ohyoung's Global Technical Team. Representing the local counterpart, Md. Anwarul Haque Tutul, Managing Partner of TeXco Tech.

dyeing technologies, OHYOUNG first introduces and receives feedback from the Bangladesh dyeing market. Bangladesh already occupies a very important position in the global textile industry, but I believe that if the utility infrastructure that can expand dyeing factories capacity can be invested, and the government's interest in and support for the textile industry are added, Bangladesh will occupy an even more important position than it is now.

**Textile Today: With increasing competition and shifting supply chain dynamics—especially the rise of China and India in dyestuff production—how is OHYOUNG adapting to maintain its global competitiveness?**

**Jinwook Chung:** The rise of China and India in the dyestuff industry has been already started since 2000, and OHYOUNG had already experienced harsh times to overcome difficulties in cost but OHYOUNG has continuously made efforts to secure cost competitiveness as much as possible through efficiency and innovation of internal processes. For example, OHYOUNG's production and sales have quadrupled compared to 20 years ago, but the number of workers has remained the same. In addition, while Chinese or

Indian dyestuff companies are limited towards the B to B model, OHYOUNG has been consistently working to develop our own B to C business model. Chinese or Indian players may compete to the extent of supplying products at competitive prices, but OHYOUNG has established differentiated values that Chinese or Indian companies cannot provide, and these aspects are the driving force behind the continuous growth of OHYOUNG, which has a production base in Korea even today.

**Textile Today: Sustainability is now a critical requirement in the textile value chain. What steps has OHYOUNG taken to ensure compliance with global Restricted Substances Lists (RSLs), and how do you address environmental challenges like wastewater and energy use?**

**Jinwook Chung:** The textile industry, which was represented by mass production and mass consumption led by the existing fast fashion, has developed in the direction of pursuing sustainability in the textile industry after going through COVID-19. This pursuit of sustainability existed in the past, but if it was rather conceptual in the past, the difference is that it is now being practically implemented in all

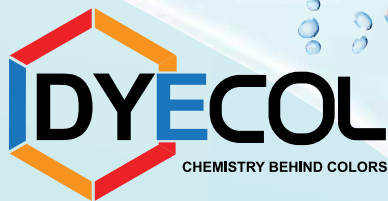
fields. The dyeing industry is even currently facing strong challenges regarding is sustainability from environmental activist groups such as Greenpeace, and efforts to reduce water, energy, and CO2 emissions in all possible fields will continue in the future.

**Textile Today: What are Ohyoung's future plans regarding investments in new facilities, geographic expansion, and advancements in sustainability?**

**Jinwook Chung:** The role of dyestuff companies in the future should evolve from manufacturers to service providers. The demands that dyeing factories receive from buyers or local communities are becoming increasingly complex and demanding.

These immediate challenges are no longer something that dye factories can solve on their own, and dye factories will now need dye companies that fully understand various demands and can provide appropriate solutions, rather than dye companies that simply supply products.

OHYOUNG has been preparing for this future role change for a long time, and we would like to communicate directly with customers through this seminar.



Chemistry  
Behind  
Colors

REACTIVE DYES AND DYE INTERMEDIATES

## Dyecol Care ESN

- ◆ More of the dye is absorbed by the fabric, using less salt.
- ◆ Fixation is better as compared to conventional dyes.
- ◆ The unfixed dye is also easier to remove at lower washing-off temperatures.
- ◆ The processing mills can dramatically increase productivity, since the dyeing and washing-off cycles are substantially shorter, while also making significant savings.
- ◆ Less water and salt are required and energy consumption and CO<sub>2</sub> emissions are greatly reduced because water used in the dyeing and washing-off process never exceeds 60°C.



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