

**SUPPORTING INFORMATON**

<b>Bath Name</b>	<b>Chemical</b>	<b>Range</b>
<b>Desizing (n=3)</b>	Acidic pH adjuster	0.5-1 g/L
	Amylase Enzyme	0.8 g/L
<b>Neutralizing (n=34)</b>	Acetic Acid	1 g/L
	Acidic pH adjuster	1-2 g/L
	Anti-Fracture	2 g/L
	Dirt, stain and oil remover	1-2 g/L
<b>Scouring/ Bleaching (n=11)</b>	Anti-Fracture	0.5 g/L
	Ion immobilizer	1 g/L
	Caustic Soda	2-8 g/L
	Reduction inhibitor	1-2 g/L
	Degreaser, cleaner and wetting agent	1-2 g/L
	Stabilizer	1 g/L
	Peroxide	4 g/L
	Penetration enhancer	0.5 g/L
	Softener chemical	1 g/L
<b>Enzymatic Processes (n=5)</b>	Acidic pH adjuster	1-2 g/L
	Cellulase Enzyme	0.6 %-0.8 g/L
	Catalase enzyme	0.5 g/L
<b>Reactive Dyeing (n=12)</b>	Dyestuff affinity enhancing material	15-80 g/L
	Demineralization agent	0.5-0.8 g/L
	Anti-Fracture	0.5-1.5 g/L
	Reaktive Dyestuff	0.00180-7 %
	Soda Ash	1-15 g/L
	Reactive dyeing process accelerator	0.5 g/L
	Glauber's salt	45-6 g/L
	Wet fastness enhancer	1.5 %-1.5 g/L
<b>Disperse Dyeing (n=3)</b>	Demineralization agent	0.5 g/L
	Anti-Fracture	1-1.5 g/L
	Acid buffer	2 g/L
	Dispersing-leveling agent	1 g/L
	Diffusion enhancing leveler and dispersant	0.5 g/L
	Disperse Dyestuff	0.029-0.14 %
<b>Acid Dyeing (n=2)</b>	Leveling agent	0.6 g/L
	Anti-Fracture	0.5 g/L
	Acid Dyestuff	0.00065-0.13 %
	Organic acid donating	2.2 g/L
<b>Soap Washing (n=15)</b>	Washing material	0.3-0.5 g/L

<b>Reductive Washing (n=1)</b>	Hydrosulfite Soda Ash	2 g/L 2 g/L
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<b>Acid Washing (n=1)</b>		No chemical
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<b>Rinsing (n=45)</b>		No chemical
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