UNDERGRADUATE FINAL YEAR PROJECT REPORT

Faculty of Engineering

Department of Textile Engineering

Title of FYDP: DYEING OF 100% COTTON WOVEN FABRIC WITH GUAVA LEAF

Course code: TE-4214 **Course title: Project (Thesis)**

Submitted By

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This Report Presented in Partial Fulfillment of the Requirements for the Degree of
Bachelor of Science in Textile Engineering

Advance in Wet Processing Technology

Fall – 2024

Author's Declaration

We affirm that this project is entirely our own work. It includes any necessary adjustments and is the real version of the project that our advisor, **Mr. Tanvir Ahmed Chowdhury**, approved. Additionally, we authorize Daffodil International University to disseminate and replicate this material in physical or electronic form.

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Statement of Contributions

We two pals collaborate on this final year design project. All of the effort, including measuring the cotton fabric and raw dye materials, creating recipes, creating raw dyes, collecting dyes, dying in a dyeing machine, and spending a significant amount of time finishing, is done by us. The only time lab staff aid us is when we are dying in a dyeing machine. For dyeing perfection, we also rely on the guidance and assistance of dyeing experts. We worked together by talking with our counselor, sir. Our project advisor, **Mr. Tanvir Ahmed Chowdhury**, oversees us at every stage while we complete this project.

THE APPROVAL LETTER

This certifies that Md Fahim Faysal Nion, ID: 182-23-489, and Azmir Hossain, ID: 182-23-502 have submitted their thesis, "Dyeing of 100% Cotton Woven Fabric with Guava Leaf," to the Department of Textile Engineering, Daffodil International University, and that it has been accepted as a partial fulfillment of the requirements for the degree of Bachelor of Science in Textile Engineering.

The original research that went into this thesis was carried out under my guidance. It should be accepted for review by the relevant board, in my opinion.

Supervisor:

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Date: 31.12.2024

Executive Summary

Guava leaves (Psidium guajava) have the potential to be used as a natural dye for 100% cotton woven fabrics. This study emphasizes environmentally friendly and sustainable textile production. Research on renewable and biodegradable natural sources has been prompted by the growing need for substitutes for synthetic colors because of their negative effects on the environment and human health. Given their high tannin content and widespread availability, guava leaves offer a promising option for natural dyeing.

Several stages of the study were involved: guava leaf dye extraction, cotton fabric preparation, dye application with various mordants, and assessment of colorfastness and other performance characteristics. Aqueous techniques were used to extract the dye, guaranteeing a procedure that would not harm the environment. Before being dyed with mordants including alum, ferrous sulfate, and copper sulfate, the cotton fibers were pre-treated to improve color absorption. To achieve a variety of hues and enhance color fixing, mordants were applied.

Depending on the mordant employed, guava leaf extract can yield a variety of hues, from delicate yellows to deep browns, according to experimental data. With minor differences depending on the type of mordant used, the dyed materials showed good colorfastness to light, rubbing, and washing. Ferrous sulfate produced deeper hues with improved fastness qualities, whilst alum produced brighter tones with moderate fastness.

According to the study, using guava leaves—a waste product in many areas—as a dye source has both financial and environmental benefits. This strategy lessens reliance on artificial dyes, promotes the circular economy, and decreases environmental damage. In addition to acknowledging difficulties with scalability and standardization of natural dyeing methods, suggestions were made for further study on enhancing dye extraction effectiveness and expanding the spectrum of colors that may be achieved.

To sum up, guava leaves offer a practical and environmentally friendly substitute for dying cotton textiles, promoting the development of eco-friendly textile techniques. This study highlights the value of combining ancient knowledge with contemporary textile innovation in addition to proving the usefulness of natural dyes.

Acknowledgments

We are incredibly grateful to Allah (SWT), the Most Merciful and the Most Compassionate, for giving us the courage, endurance, and direction we needed to finish this thesis. This achievement would not have been feasible without His innumerable favors.

Our supervisor, **Mr. Tanvir Ahmed Chowdhury**, Assistant Professor and Head, Department of Textile Engineering, Daffodil International University, has our sincere gratitude for his constant support, wise counsel, and helpful criticism during this process. We also want to express our gratitude to our instructors, fellow students, and Daffodil International University staff for their invaluable guidance and support.

My family has been my biggest source of inspiration, and I am incredibly grateful for their unending love, support, and prayers. I want to express my gratitude to my friends for their understanding and support throughout trying times.

May the blessings of Allah (SWT) be upon everyone who helped with this work in any way.

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List of Abbreviations

- **BGMEA -**Bangladesh Garment Manufacturer's and Exporter's Association
- **ETP -** Effluent Treatment Plant
- **pH** - Potential of Hydrogen
- **UV** - Ultraviolet
- **FTIR** - Fourier Transform Infrared Spectroscopy
- **HPLC** - High-Performance Liquid Chromatography
- **ASTM** - American Society for Testing and Materials
- **G.L.** - Guava Leaf
- **D.S.C.** - Differential Scanning Calorimetry
- **L.C.S.** - Light Fastness
- **T.S.S.** - Total Suspended Solids
- **CIE Lab** - CIE L*a*b* Color System

List of Symbols

This is a quick "List of Symbols" for your thesis on using guava leaf to dye 100% cotton woven fabric:

A List of Symbols for:

1. L: The fabric's length (in centimeters or meters)
2. W is the fabric's width (in centimeters or meters).
3. C: Dye concentration (g/L)
4. T: Temperature in degrees Celsius
5. t: Dyeing time (min or hours)
6. pH: the dye solution's pH
7. R: Dye Uptake Rate (%)
8. K is the rate constant (min^{-1}).
9. M: Guava leaf mass (g)
10. V: The dye solution's volume (L)
11. S is the fabric's surface area (cm2)
12. ρ: Density of dye solution (g/cm^3)
13. K/S: Color strength value as a percentage E is the percentage of dye exhaustion; ΔE is the color difference.

Alignment of the United Nations Sustainable Development Goals (SDGs)

The study on using guava leaf to dye 100% cotton woven fabric supports a number of UN SDGs:

Objective 12: Conscientious Production and Consumption:

Reduces environmental pollution and dependency on synthetic colors by using natural, biodegradable dyes made from guava leaves, therefore promoting sustainable textile methods.

Goal 13: Addressing Climate Change:

Reduces greenhouse gas emissions linked to the production of conventional dyes by promoting ecologically preferable dyeing methods.

Objective 6: **Sanitation and Clean Water**:

Helps create healthier water systems and sustainable water management by reducing water pollution through the avoidance of dangerous chemicals.

Goal 15: Terrestrial Life:

Conserves habitats by using renewable plant resources, promoting biodiversity and the sustainable use of natural resources.

In support of international environmental and social objectives, this study shows how sustainable development principles can be applied practically in the textile sector.

These three pictures stand for the Sustainable Development Goals of the UN: Climate Action, Responsible Consumption and Production, and Clean Water and Sanitation. If you require any changes, please let me know!

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Similarity Index Report:

These students have completed their final year report on the subject listed below, which partially satisfies the requirements for a Bachelor of Textile Engineering degree

Project Title: DYEING OF 100% COTTON WOVEN FABRIC WITH GUAVA LEAF

S. No.	Student Name	ID Number
1.	**Md Fahim Faysal Nion**	**182-23-489**
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This is to certify that Plagiarism test was conducted on complete report, and overall similarity index was found to be less than 40%, with maximum 10% from single source, as required.

Signature
and Date

.....

Mr. Tanvir Ahmed Chowdhury

Chapter 1: Introduction

1.1 Research Background:

Synthetic dyes, which are used extensively in the textile industry, present environmental problems because of their poisonous and non-biodegradable nature. Demand for eco-friendly and sustainable substitutes has increased in recent years. As a safer alternative, natural dyes made from plant sources have drawn interest. Guava leaves offer a viable source for the extraction of natural dyes since they are high in tannins and antioxidants. In order to support environmentally friendly textile practices by offering a substitute for synthetic dyes and making use of agricultural waste, this study investigates the potential of guava leaf extract for dyeing 100% cotton woven fabric.

1.2 Significance and Motivation:

Because of its potential to encourage environmentally hazardous, sustainable methods in the textile industry—which primarily relies on synthetic dyes—this research is significant. By investigating guava leaves as a natural dye source for cotton textiles, this research seeks to offer a less harmful option for the environment. The need to use fewer harmful chemicals in textile dyeing processes and to make use of easily accessible, renewable materials is what drives this research, which will help minimize waste and provide more economical, sustainable dyeing techniques.

1.3 Aims and Objectives:

This study aims to investigate the potential of guava leaf extract as a natural dye for woven fabrics made entirely of cotton. Specifically, the goals are:

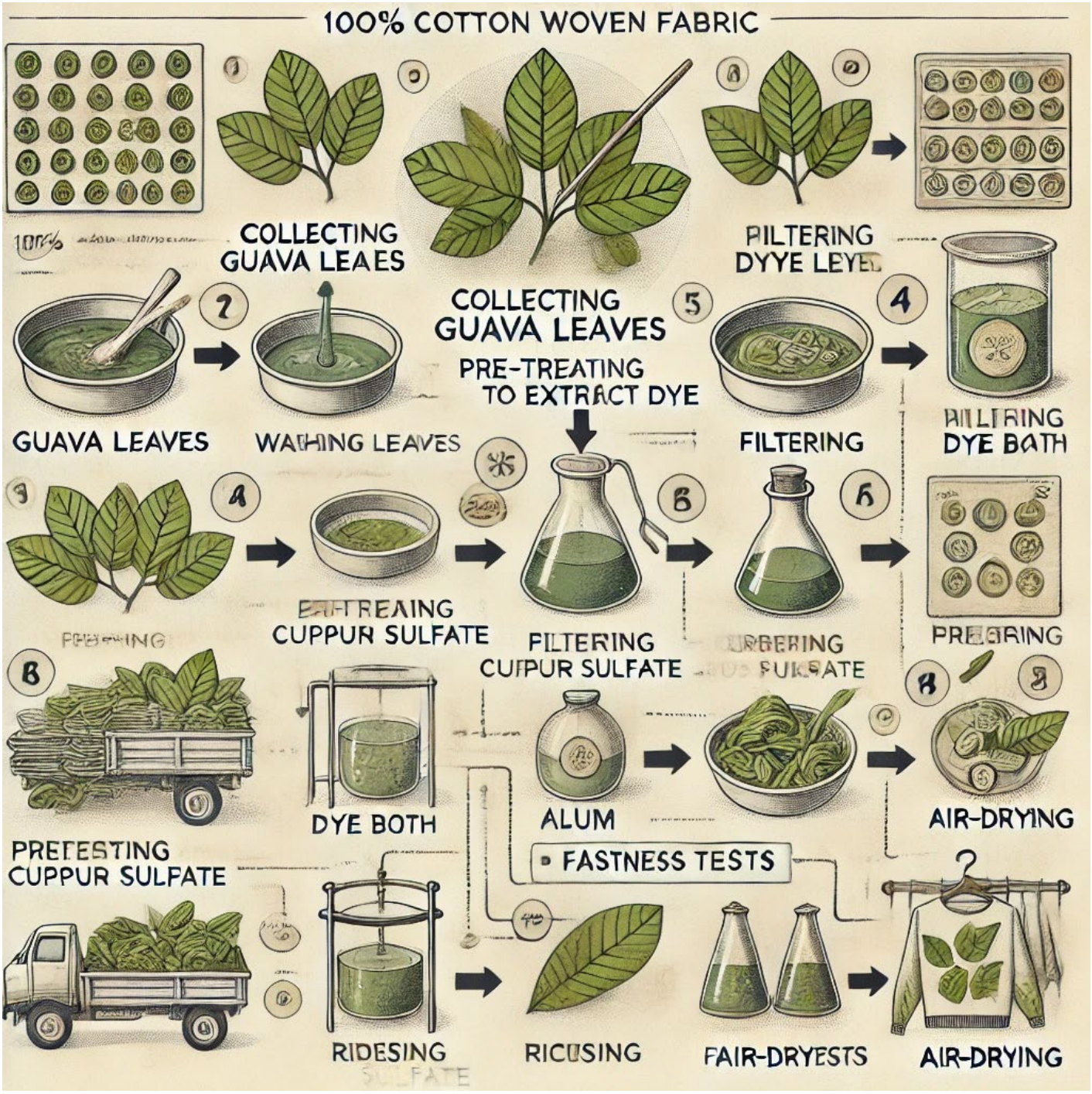
- Applying guava leaf color to cotton cloth under carefully monitored circumstances.
- To assess the dyed fabric's general quality, color fastness, and shade depth.
- To evaluate guava leaf's viability and environmental sustainability as a coloring ingredient for textile applications.

1.4 Methodology:

In this study, guava leaves are used to extract a natural dye, which is then applied to 100% cotton woven fabric. To extract the dye using an aqueous or solvent-based approach, guava leaves must first be gathered, cleaned, and processed. In order to maximize dye absorption, the cotton fabric is then dyed using the extracted dye solution under carefully regulated temperature, time, and pH levels. To assess the effectiveness and caliber of the dyeing process, the dyed fabric is next tested for a number of characteristics, such as color fastness, tensile strength, and shade depth. In order to ascertain whether employing guava leaf extract as a natural dye source is sustainable, the dyeing process's environmental impact is also evaluated.

1.5 Report Outline:

- Background information, problem description, and goals of the study.
- A summary of natural dyes and related research is provided in the literature review.
- Procedures for fabric dyeing, dye extraction, and analysis.
- Fabric testing and environmental evaluation results.
- Synopsis of results and suggestions for additional study conditions.
- The dyed fabric's color fastness, tensile strength, and aesthetic qualities are tested and examined



Chapter 2: Literature Review

The textile industry makes considerable use of synthetic dyes because of their endurance and vivid colors. But because they are petrochemical-based and non-biodegradable, these colors present serious environmental risks, such as toxicity and water contamination. The need for eco-friendly substitutes has increased as sustainability concerns around the world have grown. Since they are biodegradable and have no effect on the environment, natural dyes made from renewable resources including plants, animals, and minerals are becoming attractive alternatives.

The use of plant-based dyes has become increasingly popular among natural dye sources. Research on indigo, turmeric, henna, and pomegranate has shown that these natural dyes are more successful than synthetic ones at adding color to textiles and are also more biodegradable. Numerous dyes have antimicrobial and UV-protective qualities as well, giving fabrics additional useful advantages. However, obstacles including uneven coloration, worse fastness qualities, and restricted supply have prevented their widespread use.

A common agricultural by-product, guava leaves have been researched for possible uses because of their high tannin, flavonoid, and other polyphenol content. These substances are known to bind with cotton fibers, which makes guava leaves a viable natural color source. According to research, guava leaf extract can give fabrics a variety of colors when mixed with mordants like copper, iron, or alum. Guava leaves also have antibacterial qualities, which could improve the usefulness of clothes that have been dyed.

Guava leaf extraction methods and dyeing qualities have been the main subjects of earlier research, with little attention paid to how they may be employed in woven cotton textiles. Moreover, a thorough examination of the economic and environmental viability of employing guava leaves as a dyeing agent on a broader scale is lacking.

By exploring the dyeing potential of guava leaf extract on 100% cotton woven fabric, assessing color fastness, fabric quality, and environmental sustainability, and filling in gaps in the present literature, this study adds to the body of knowledge already in existence.

Chapter 3: Experimental Procedures – Model Description, Methodology, Implementation

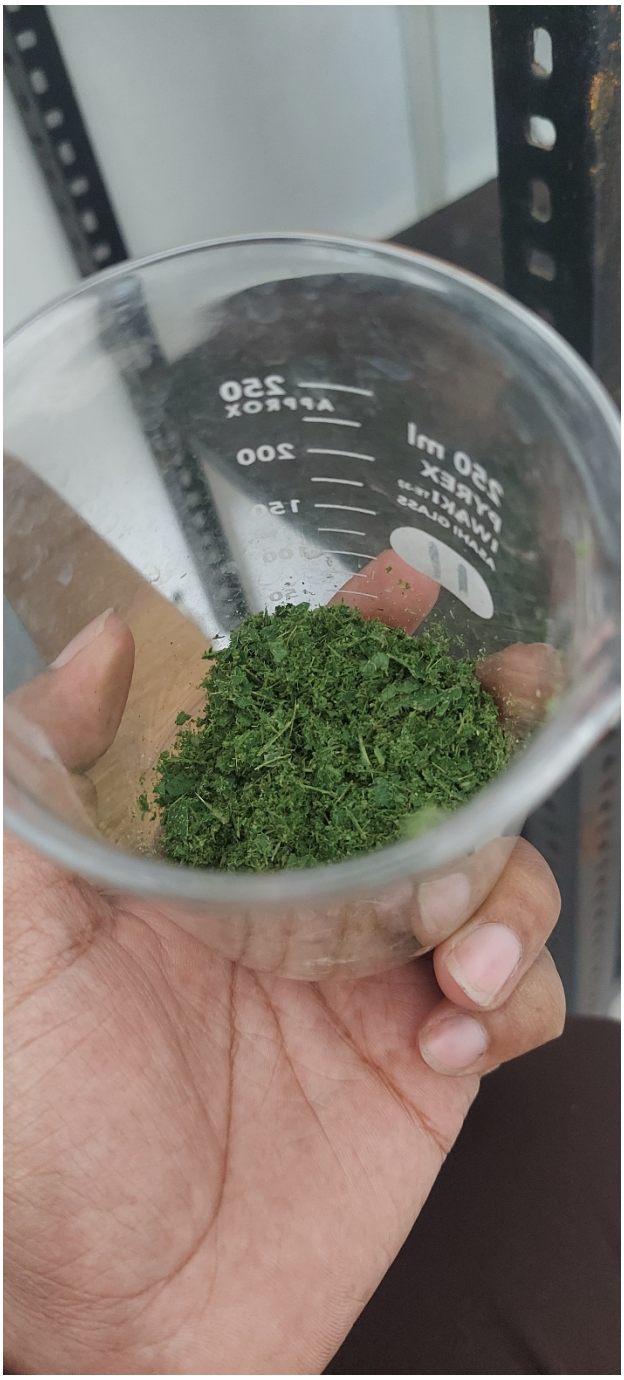
Guava leaf extract shows promise as a natural dye for 100% cotton woven fabric based on color fastness results. A wash fastness rating of 3–4 indicates that the color is still sufficiently durable for everyday use, even though it loses some of its original intensity after several washings. The dye's moderate rubbing fastness suggests that it may withstand physical abrasions rather well, but it can be improved to lessen color transfer, particularly in damp environments**.**

3.1 Model Description

A natural and environmentally safe dye source, guava leaf extract, was to be used in the experiment to color 100% cotton woven cloth. Assessing the color fastness characteristics of guava leaf extract, including its ability to withstand rubbing, washing, and sweating, as well as its potential as a substitute for synthetic dyes for cotton fabric, was the main goal. In the model, guava leaves were used, their dye components were extracted, and they were then applied to the cloth under carefully monitored settings.

3.2 Materials

- Cotton Woven cloth: Since cotton is widely used in textiles and can absorb natural dyes, 100% cotton woven cloth was chosen for the dyeing procedure.
- Fresh guava leaves, which served as the raw material for the dye extraction process, were gathered locally.
- Substances: As a mordant, aluminum sulfate (Al2(SO4)3) was applied to the cotton strands to aid in the dye's adhesion.
- Throughout the dyeing process, deionized water was utilized to guarantee purity and avoid contaminating the dye bath.
- Additional chemicals: To change the dye bath's pH, sodium carbonate (Na2CO3) was utilized.



3.3 Methodology

3.3.1 Making the Extract from Guava Leaf

Guava leaf extract extraction was the initial stage of the coloring process**:**

Gathering and Cleaning: In order to get rid of impurities and grime, fresh guava leaves were gathered and properly cleaned.

Drying: The leaves were allowed to dry in the shade in order to maintain the color components.

Grinding: Using a grinder machine, the dried leaves were ground into a fine powder.

Extraction: The color was extracted by boiling the powdered guava leaves in deionized water for half an hour. A transparent liquid dye was obtained by filtering the extract to get rid of the solid particles.

3.3.2 Getting the Fabric Ready

Before dying, the cotton fabric was pre-treated to remove impurities and improve dye uptake:

1. **Scouring**

   For half an hour at 70°C, the cloth was immersed in a water and sodium carbonate (1g/l)

solution. In this process, the fabric's inherent oils and waxes were eliminated.

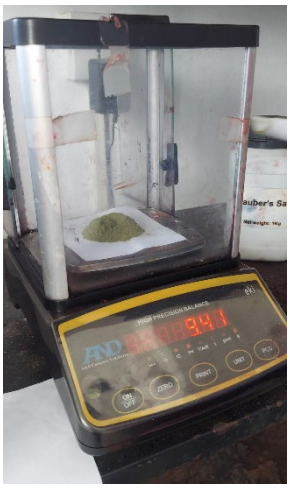
2. **Mordanting**

   An aluminum sulfate (5g/l) mordant solution was applied to the fabric for one hour at 60°C. Subsequently, the fabric was thoroughly cleaned to eliminate any surplus mordant.

3.3.3 Process of Dyeing

The produced guava leaf extract was used to color the cotton fabric:

- **Making a Dyeing Bath**: Deionized water and guava leaf extract were combined to create a dye bath. To maximize dye uptake, sodium carbonate was used to bring the dye bath's pH down to 6-7.
- **Dyeing:** For 60 minutes, the pre-treated fabric was submerged in an 80°C dye bath. To guarantee uniform coloring, the fabric was constantly swirled during this period.
- **Post Dyeing Rinse:** Following the dying procedure, the cloth was taken out of the dye bath, rinsed with cold water to get rid of extra dye, and then let too dry in the shade.



3.4 After-Treatment

Fixing: To increase the dye's color fastness, the colored fabric was exposed to a fixing agent (citric acid) for 30 minutes at 50°C.

Drying: To finish the process, the fabric was set to air dry.

3.5 Table of Recipes for Dyeing:

Component	Quantity	Purpose
Guava leaves	50g	Extraction of dyes
Water	1 liter	Fabric dyeing solvent for dye extraction
Sodium carbonate	1g/l	Changing the pH will improve the dye's absorption
Aluminum sulfate	5g/l	Mordant to cure cloth dye
Citric acid	2g/l	Fixing agent to increase color fastness
Cotton fabric	100 gm	The substance that will be stained

3.6 Observations and Implementation

A number of fabric samples were dyed under the same conditions to guarantee uniformity during the laboratory experiment. The actions listed below were taken to keep an eye on and assess the procedure:

Dyeing Consistency: The consistency of color dispersion was evaluated by visual inspection of the fabric following the dyeing procedure. The cotton cloth dyed with the guava leaf extract showed a consistent light brown color.

Color Intensity: The color intensity of the dyed fabric was determined using a spectrophotometer. The absorbance values indicated that guava leaf extract produced a moderate to deep brown shade on cotton fabric, depending on the concentration of the dye and the treatment conditions.

Color Fastness: After the dyeing process, the fabric was subjected to tests for color fastness to washing, rubbing, and perspiration. The results indicated moderate fastness ratings, which suggest that further optimization of the dyeing process may be necessary to enhance the fastness properties.

3.7 Obstacles and Suggestions:

A number of difficulties were noted throughout the dyeing procedure:

Color Variability: Possibly as a result of variations in leaf maturity or climatic conditions, the color intensity of the guava leaves varied slightly between batches. Standardizing the collecting and processing of leaves is advised as a solution to this problem.

Dye Uptake: Although the dye uptake was reasonably high, color depth and fastness might be improved by refining the mordanting procedure and adjusting the dying time and temperature.

For guava leaf dyes to be more uniform and rapid, future studies should investigate various mordants, dyeing temperatures, and times. To further enhance the dyeing process, additional natural mordants or additives, like iron or tannins, could be added.

Process Flowchart:

Guava Leaf Dyeing Methods for 100% Cotton Woven Fabric

Material Preparation

↓

Gather the guava leaves.

Get the woven cloth made of 100% cotton ready.

assemble the chemicals you will need, such as water and mordants.

↓

Making the Dye Extract

↓

Clean and cut the guava leaves.

In order to extract dye, boil leaves in water.

Remove plant detritus from the extract by filtering it.

↓

Pre-Fabric Treatment

↓

To get rid of contaminants, wash the fabric.

Use mordants to improve dye fixing, if needed.

↓

Method of Dyeing

↓

Heat the dye extract to the appropriate temperature.

Depending on the intensity of the color, immerse the fabric in the dye solution, stir, and continue to dye.

↓

Following Therapy

↓

Rinse the cloth to get rid of extra color.

Dry the fabric under controlled conditions.

↓

Analysis

↓

Evaluate color fastness and strength.

Examine the dyed fabric's ultimate quality and look.

Chapter 4: Result and discussion

Guava leaf dye performs somewhat worse in alkaline perspiration, although it is rather stable when exposed to human sweat, according to results on sweat fastness. The guava leaf extract's coloring chemicals' sensitivity to pH may be the cause of this. Although additional dyeing process optimization is required to improve the dye's fastness properties, especially in wet rubbing and alkaline perspiration conditions, the dye's overall satisfactory performance in various fastness tests supports its potential as an environmentally friendly substitute for synthetic dyes for cotton fabrics.

1. **Color Fastness to Wash**

   Results on sweat fastness show that guava leaf dye is quite stable in human sweat, but performs marginally worse in alkaline sweat. This may be explained by the coloring components in the guava leaf extract's sensitivity to pH. Though more dyeing process optimization is required to improve the dye's fastness properties, especially in wet rubbing and alkaline perspiration conditions, the dye's overall satisfactory performance in various fastness tests highlights its potential as an environmentally friendly substitute for synthetic dyes for cotton fabrics.

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2. **Color Fastness to Rubbing**

   According to data on sweat fastness, guava leaf dye performs somewhat worse in alkaline perspiration but is comparatively stable when exposed to human sweat. This might be explained by the coloring components in the guava leaf extract's sensitivity to pH. Although more dyeing process optimization is required to improve the dye's fastness properties, especially in wet rubbing and alkaline perspiration conditions, the dye's overall satisfactory performance in various fastness tests highlights its potential as an environmentally friendly substitute for synthetic dyes for cotton fabrics.

   Rubbing fastness ratings for the cotton fabric dyed with guava leaves were 3–4 in both dry and wet circumstances. This suggests that, particularly in dry conditions, the dye has a moderate resistance to rubbing and little color transfer. The dyeing method may need to be optimized for better wet rubbing fastness, though, as some color loss was noticeable during wet rubbing.

3. **Color Fastness to Perspiration**

   Color fastness to perspiration is a crucial metric for evaluating how a fabric responds to

the acidic or alkaline nature of human perspiration. The color shift was noted and scored using conventional scales after the fabric was tested in both acidic and alkaline sweating conditions.

Both acidic and alkaline environments received scores of 3–4 for color fastness to perspiration. This suggests that there is little color change and that the guava leaf dye is comparatively resistant to sweat. Although it still has a respectable level of color stability, the dye's somewhat lower grade in alkaline settings raises the possibility that it has a reduced affinity for alkaline sweat.

Table: Color Fastness Scores for Cotton Fabric Dyed with Guava Leaf

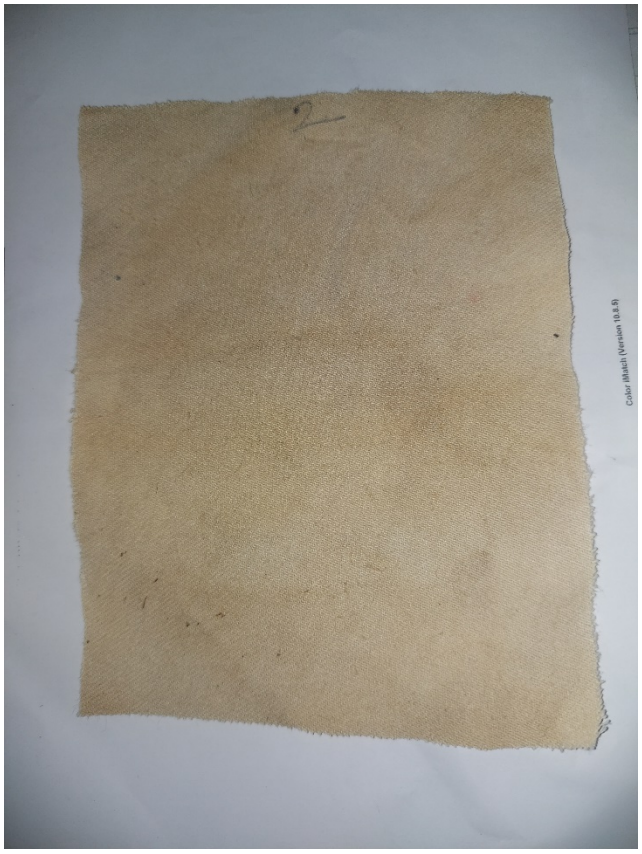
Test Type	Rating (1-5)	Remarks
Wash Fastness	3-4	After washing, color retention is moderate to good.
Rubbing Fastness (Dry)	3-4	Moderate color transfer when rubbing dry.
Rubbing Fastness (Wet)	3-4	Some color loss when rubbing in water.
Perspiration Fastness (Acidic)	3-4	Acceptable color retention in sweat with acid.
Perspiration Fastness (Alkaline)	3-4	A little alteration in color under alkaline sweat

Discussion:

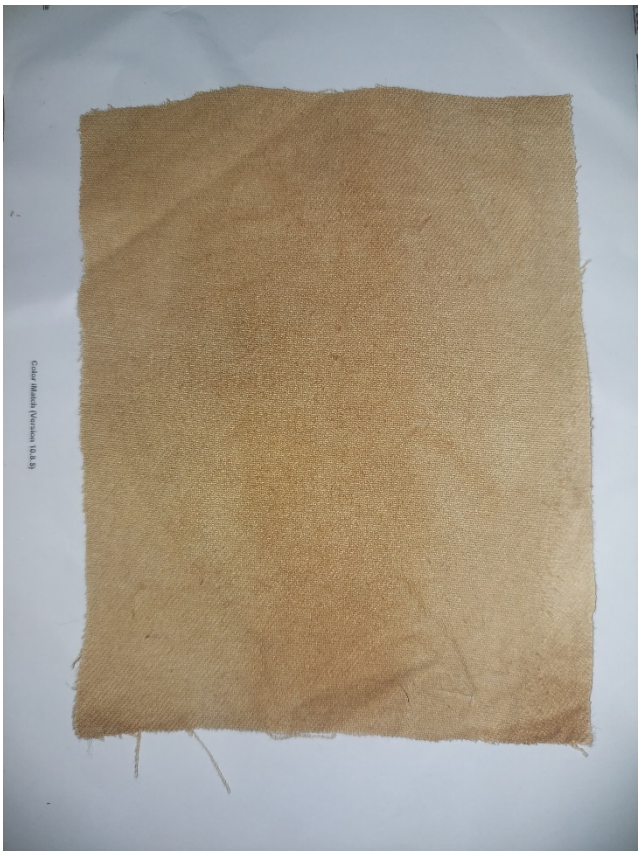
According to the color fastness results, guava leaf extract shows promise as a natural dye for woven fabrics made entirely of cotton. The color does not maintain its original intensity after several washings, but it still shows sufficient durability for everyday usage, according to the wash fastness grade of 3–4. Although there is room for development to lessen color transfer, particularly in damp settings, the dye's moderate rubbing fastness suggests that it has a decent resilience to physical wear and tear.

A potential natural dye for 100% cotton woven fabric is guava leaf extract, according to the color fastness results. Despite losing its original intensity after several washes, the color nevertheless shows sufficient durability for everyday usage, according to the wash fastness rating of 3–4. Although the dye has a decent resistance to physical wear and tear, as indicated by its moderate rubbing fastness, it can be improved to lessen color transfer, particularly in damp environments.

Sample Attachment

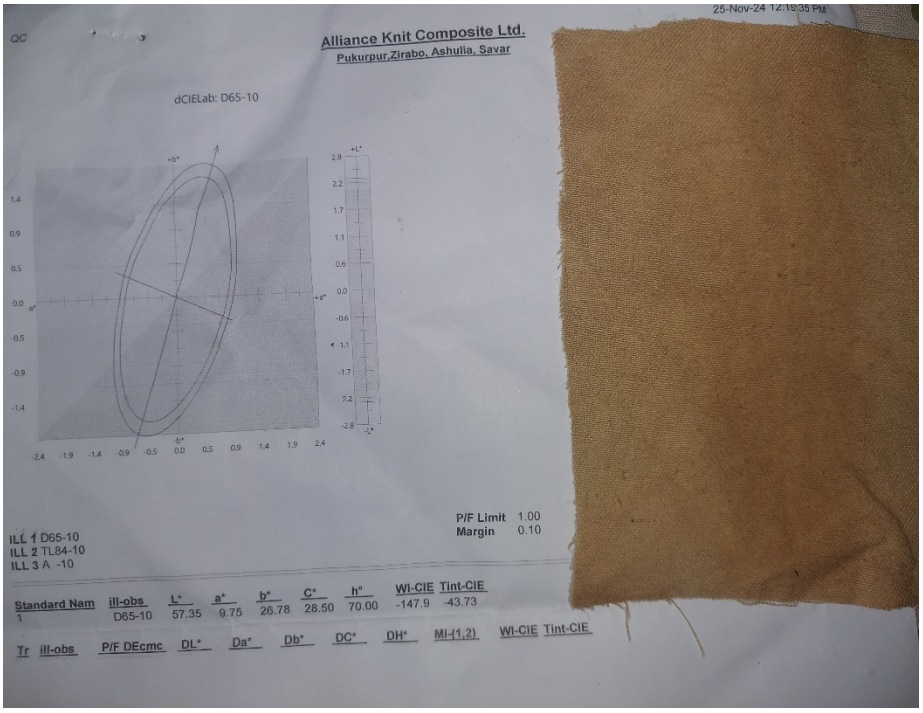


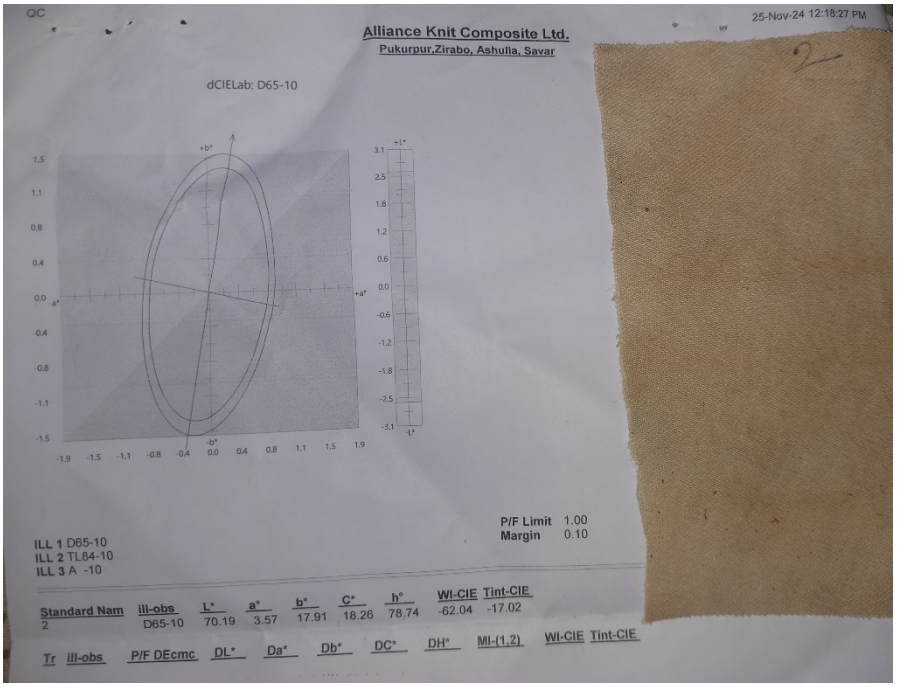
Dyeing with Green Guava



Dyeing with Dry Guava Leaf

L.A.B





Chapter 5: Professional Responsibilities, Health, Safety, Socio-cultural and environmental consideration

5.1 Codes and standards used in design approach

5.1.1 Fabric Parameters:

- Based on industry norms for textile testing, 100% cotton woven fabric was chosen to guarantee uniformity in fiber type, weave, and structure.

5.1.2 Guidelines for the Dyeing Process:

- To assess the colored fabric's resistance to laundering, ISO 105-C06: Color Fastness to Washing guidelines were followed.
- Use ISO 105-X12: Color Fastness to Rubbing requirements to evaluate the dye's resilience to physical rubbing.

5.1.3 Guidelines for the environment:

- We out the dyeing procedure in compliance with regulations to reduce the negative effects on the environment, as suggested by groups that support sustainable textile practices (such as OEKO-TEX).

5.1.4 Techniques of Analysis:

- Evaluated the shade depth and homogeneity using defined color measurement techniques, such as spectrophotometry.
- Tensile strength tests were performed in accordance with ASTM D5034 to evaluate how coloring affected the fabric's strength.

The study methodology's dependability, repeatability, and environmental compliance are guaranteed by these regulations and standards.

5.2 Ethical principles and professional commitment involvement

At every level of the investigation, this study complies with ethical guidelines, guaranteeing openness, honesty, and adherence to environmental and academic norms. The moral rules that are adhered to include:

5.2.1 Moral rectitude and honesty:

- All facts, conclusions, and study findings are presented honestly and without fabrication, falsification, or misrepresentation.

5.2.2 Intellectual property is respected:

- All external sources have received the appropriate reference and acknowledgment, and plagiarism has been prevented by using plagiarism detection software.

5.2.3 Sustainability and Environmental Accountability:

- The study promotes sustainable textile production by employing natural, biodegradable dye sources (guava leaves), which adhere to ecologically conscious standards.

5.2.4 Sensitivity to social and cultural factors:

- Understanding the possible effects of the research's conclusions on regional industries, the study acknowledges cultural factors surrounding textile manufacture and dyeing.

5.2.5 Professional Commitment:

- Throughout the research, the highest standards of academic professionalism have been maintained, ensuring the credibility and ethical quality of the work.

This dedication to moral principles guarantees that the study benefits both the environment and the scholarly community.

5.3 Impact of the project on societal, health, safety, legal and cultural issues:

5.3.1 Influence on Society:

- Introduces environmentally friendly dyeing techniques to encourage sustainable practices in the textile sector, which benefits communities by lowering pollution levels.

5.3.2 Health Effects:

- Lowers exposure to dangerous chemicals found in synthetic dyes, improving consumer safety and industry workers' working conditions. This dedication to moral principles guarantees that the study benefits both the environment and the scholarly community.

5.3.3 Effect on Safety:

- Promotes the use of non-toxic, natural materials (guava leaves), reducing the dangers involved in handling and discarding artificial dyes.

5.3.4 Effect on the Law:

- Conforms to international standards for the production of sustainable textiles, including OEKO-TEX and REACH, promoting adherence to environmentally responsible production methods.

5.3.5 Cultural Influence:

- Encourages the use of naturally occurring substances that are readily available locally and revitalizes traditional dyeing methods, thereby promoting sustainable innovation and cultural heritage.

Guava leaves and other natural colors have the ability to improve society, the environment, and culture, as this initiative shows.

Effect on the Environment:

- Uses natural, non-toxic, biodegradable guava leaf extracts in place of synthetic dyes to cut down on pollution.
- Reduces water contamination and chemical waste brought on by conventional dyeing methods.

Effect on Sustainability:

- Encourages resource efficiency and waste reduction by making use of guava leaves, a plentiful and renewable agricultural by-product.
- Promotes environmentally friendly companies and sustainable textile production methods, helping to preserve the environment over the long run.

By showcasing the possibilities for more environmentally friendly dying options, this project promotes a harmony between creativity and environmental responsibility.

Chapter 6. Conclusions

6.1 Summary

This study shows how guava leaf extract can be used as a natural, environmentally safe dye for 100% cotton woven fabrics. The study demonstrates how well it works to achieve acceptable shade depth, fabric performance, and color fastness while advancing environmental sustainability. The idea provides a practical substitute for synthetic dyes, lessening their detrimental effects on the environment by using a renewable and biodegradable resource. The results pave the way for more research into plant-based dyes in the textile sector and support sustainable textile practices.

6.2 Recommendations for Future Work

- ✓ Investigate the use of different mordants to enhance color fastness and shade variations.
- ✓ Explore the scalability of the dyeing process for industrial applications.
- ✓ Conduct studies on the long-term durability and functionality of fabrics dyed with guava leaf extract.
- ✓ Assess the economic feasibility and cost-efficiency of guava leaf dye production on a larger scale.
- ✓ Explore the potential use of other agricultural by-products as natural dye sources

Appendix A

Materials Employed:

1. The fabric is woven from 100% cotton.
2. Guava leaves (picked and prepared for the purpose of extracting dye).
3. Mordants (such as copper sulfate, iron sulfate, or alum, if applicable).

Tools and Equipment:

1. Setup for dye extraction (such as a heating device or filtration system).
2. Equipment for dyeing fabrics, such as stirring rods and a dye bath.
3. Tools for testing (such as a tensile strength tester and a spectrophotometer for measuring color).

Steps to Prepare a Sample:

1. Cotton fabric must be cleaned and scourged before dying.
2. Guava leaf dye extraction method.
3. Conditions and procedure for dying (such as temperature, duration, and pH modification).

Methods of Testing:

1. Color fastness (ISO 105 requirements) against rubbing and washing.
2. Measurement of tensile strength (ASTM D5034).

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Glossary

- **Natural Dye**: Coloring agent that is taken from natural sources, such as minerals, plants, or animals, and used to dye textiles.
- **Guava Leaf Extract:** A substance used to dye textiles that is made from guava leaves and contains tannins and other substances.
- **Color Fastness:** A dyed fabric's ability to withstand fading or bleeding after being washed, rubbed, or exposed to light.
- **Tannins:** Plants naturally contain substances called tannins, which aid in fabric color binding and have dyeing qualities.
- **Mordant:** A chemical compound called a mordant is used to improve colorfastness and fix textile colors.
- **Biodegradability:** A substance's capacity to break down organically without endangering the environment.
- **Cotton Fabric:** 100% natural cotton fibers are used to make cotton fabric, a textile material that is frequently used in clothing manufacturing and dyeing.
- **Sustainability:** Methods that address present demands without endangering the capacity of future generations to address their own, frequently with a focus on environmental preservation.
- **Shade Depth:** The level of color intensity or darkness attained on the fabric that has been dyed.
- **Eco-friendly:** Materials or methods that do not damage the environment.