



Benchmarks values

benchmarking energy efficiency in apparel production

Leading author Gherzi, editing Euratex, contributions from the full SESEC consortium

Benchmarks: Summary

Segment		T-shirts and related - knitted	Shirts and blouses - woven	Trousers and skirts (casual and denim) - woven	Suits & overall jackets - coats	Pullovers flat knitted	Underwear and bras	Technical products
per unit	spreading							
	cutting							
	sewing							
	spreading/cutting/sewing	0.16	0.31	0.44	2.01	0.25	0.072	
	knitting					0.38		
	lighting	0.052	0.10	0.13	0.51	0.33	0.021	
	steam		0.063	0.55	7.84	0.78		
	compressed air		0.027	0.072	0.32	0.0134	0.0009	
	total energy	0.902	1.02	8.33	19.17	6.15	0.19	
per employee	spreading							
	cutting							
	sewing							
	spreading/cutting/sewing	635	492	588	860	174	2000	
	knitting					578		
	lighting	214	145	178	163	34.9	572	
	steam		89.2	739	3'362	1'178		
	compressed air		42.9	96.8	45.4	14.5	26.3	
	total energy	278	1'323	11'192	2'392	1'292	5'167	
per working minute	spreading							
	cutting							
	sewing							
	spreading/cutting/sewing		0.081	0.008	0.012	0.007	0.0131	
	knitting					0.02		
	lighting		0.017	0.0024	0.013	0.0031	0.0038	
	steam		0.010	0.010	0.093	0.077		
	compressed air		0.0072	0.0013	0.0027	0.0004	0.0002	
	total energy		0.015	0.15	0.164	0.175	0.034	
per floor size	spreading							
	cutting							
	sewing							
	spreading/cutting/sewing		56.25	180.13	42.39	10.47	61.59	
	knitting					27.8		
	lighting	22.78	17.04	26.58	8.31	3.88	17.63	
	steam							
	compressed air							
	total energy	392	134	268	225	77.5	159.2	

All values in kW/reference value

Benchmarks as a result of 27 audited companies and 42 sets of data.

For full understanding of the above benchmarks [please refer to the document:](#)

[Benchmarking energy efficiency in apparel production](#) ¹

¹ Document available on the SESEC website