

# World of Coats *dual duty*

Coats *dual duty* is a top quality corespun thread that combines a high tenacity polyester filament core with a natural cotton cover. The filament core offers excellent strength and durability, while the long staple cotton wrap ensures excellent sewing performance and protects the core from needle heat.

**Main Uses:**

- Fine cotton, denim shirts and suits
- Fine fabrics and premium lingerie
- Leather goods, towels and home furnishings
- Classic jeans and outdoor wear



**Features and Benefits:**

- Coats *dual duty* is a high-tech corespun thread that combines the tenacity and strength of a polyester filament core with a cotton wrap, delivering excellent sewing performance in the most demanding applications
- Special lubricant ensures smooth, trouble-free sewing
- Cotton wrap protects the polyester core from needle heat and high ironing temperatures
- Strong polyester filament core allows the use of finer thread sizes improving seam appearance without compromising seam strength
- Extensive colour range
- Excellent wash-down characteristics make Coats *dual duty* ideal for jeans
- Outstanding abrasion resistance for demanding jeans and workwear applications
- Certified to Öko-Tex Standard 100, class 1, the most stringent class covering babywear

## World of Coats

- Coats is the world's leading industrial thread business with a 200 year history of pioneering innovation.
- Providing complementary and value added products and services to the apparel and footwear industries.
- Applying new techniques to manufacture and supply engineered threads and yarns to a wide range of speciality segments.
- With manufacturing plants in over 70 locations and sales and distribution in many more, Coats is uniquely placed to serve your thread needs anywhere in the world.
- Our range of value adding services and tools is being expanded to help customers adapt and meet the challenges of our industry today. For example, the award winning 'Coats Colour Express' sampling service enables a fast and accurate global thread sampling capability and is backed by Coats' well known advanced colour management systems.

**One colour range. One specification. Worldwide.**

Coats operates to a global specification for Coats *dual duty* with quality audited by a centrally located team.

[www.coatsindustrial.com](http://www.coatsindustrial.com)

COATS  
*dual duty*



POLYESTER  
CORESPUN WITH  
COTTON WRAP

Product Information



## Product Guidelines:

Global Offer Tex No.	Ticket No. (Nm)	Ply	Average Strength		Elongation % Min - Max	Recommended Needle Size*	
			cN	Grams		Singer	Metric
24	120	2	1,039	1,059	17 - 23	10 - 14	70 - 90
40	75	2	1,862	1,899	18 - 24	14 - 18	90 - 110
60	50	3	2,842	2,898	17 - 23	16 - 19	100 - 120
60	50	2	3,038	3,098	17 - 23	16 - 19	100 - 120
80	36	2	3,528	3,598	18 - 24	18 - 21	110 - 130
105	30	2	3,724	3,797	17 - 23	18 - 21	110 - 130

\* Needle size recommendations are a guide only and ultimately depend on the sewing application. Since conditions and applications vary considerably in the use of thread, the thread user should assure herself or himself by preliminarily testing that the thread is suitable for the end use intended. Technical information listed above is based on current averages and should be taken only as indicative.



### Physical and chemical properties of polyester corespun with cotton wrap:

#### Thermal Properties:

- Polyester melts at 250 - 260°C, softens at 220 - 240°C
- Cotton discolours after prolonged exposure to high temperatures
- Thread shrinkage less than 1% @ 150°C

#### Chemical Properties:

- Mineral acids: Polyester: is resistant to most mineral acids  
Cotton: disintegrates in hot dilute and cold concentrated acids
- Alkalis: Polyester: essentially unaffected by weak alkalis, but less resistant to stronger alkalis, especially at higher temperatures  
Cotton: swells in caustic, no appreciable strength loss
- Organic solvents: Polyester: generally unaffected, but soluble in some phenolic compounds  
Cotton: degraded by some solvents
- Bleaching: Polyester: unaffected  
Cotton: bleached by hypochlorite and peroxides
- Insects / microorganisms (mildew, rot): Polyester: unaffected  
Cotton: degrades but can be treated with special finishes
- Laundering / dry cleaning: Unaffected
- Moisture regain: Polyester: 0.4%, Cotton: 8%

#### Coats dual duty fastness properties:

- |                             |                         |         |
|-----------------------------|-------------------------|---------|
| • Washing at 60°C           | (ISO 105 C10:2006 C(3)) | Grade 4 |
| • Water Fastness            | (ISO 105 E01:2010)      | Grade 4 |
| • Rub Fastness              | (ISO 105 X12:2001)      | Grade 4 |
| • Hypochlorite Fastness     | (ISO 105 N01:1993)      | Grade 4 |
| • Dry Cleaning Fastness     | (ISO 105 D01:2010)      | Grade 4 |
| • Perspiration Fastness     | (ISO 105 E04:2009)      | Grade 4 |
| • Artificial Light Fastness | (ISO 105 B02:1994)      | Grade 4 |

Some very bright shades do not possess the high level of bleach fastness displayed by the majority of shades. We recommend that these be checked before use in any application involving bleaching agents, in particular for swimwear or garment finishing processes.



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