

COATS
dual duty



**POLYESTER
CORESPUN WITH
COTTON WRAP**

Coats® Dual Duty™

Coats Dual Duty is a premium 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.

WHY CHOOSE DUAL DUTY?

- Dual Duty delivers excellent sewing performance in the most demanding applications
- The high tenacity polyester filament core allows the use of finer thread sizes improving seam appearance without compromising seam strength
- Excellent wash-down characteristics make Dual Duty ideal for denimwear and jeans
- Outstanding abrasion resistance for demanding jeans and workwear applications
- Certified to Öko-Tex Standard 100, class I, the most stringent class covering textile items for babies and toddlers
- Meets Coats restricted substance list

MAIN USES:

- Classic denimwear and jeans
- Heavy duty outdoor wear and cargo pants
- For soft, natural feel seams on fine cotton fabrics and for premium lingerie
- High speed sewing operations for towels and home furnishings



Coats Dual Duty

PRODUCT RANGE

Art / Tkt	TEX	Ticket	Length	Strength cN	Elongation % Min - Max	Needle Size Metric
1569 180	21	180	5000m	840	13 - 18	65 - 75
1569 120	24	120	5000m	1040	18 - 22	75 - 90
1569 100	30	100	5000m	1320	18 - 22	75 - 90
1569 075	40	75	5000m	1860	18 - 24	90 - 100
1569 050	60	50	5000m	2840	18 - 24	100 - 120
1569 050	60	50	5000m	3040	18 - 24	100 - 120
1569 036	80	36	5000m	3530	18 - 24	110 - 130
1569 030	105	30	5000m	3720	18 - 24	110 - 130
1569 025	120	25	5000m	5390	20 - 26	120 - 140
1569 020	150	20	5000m	7150	20 - 26	120 - 140
1554 012	210	12	2500m	10680	24 - 28	130 - 160
1554 008	300	8	2500m	15880	24 - 30	160 - 200

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

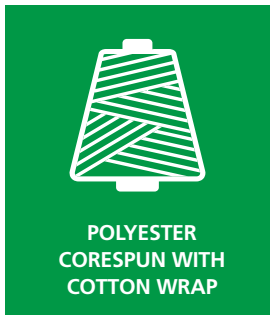
CHEMICAL PROPERTIES

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%

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

* Note: some Vat dyed PCC heavy shades (colour group: 47, 55) will not be able to achieve rub fastness standard. Only Grade 3; also reactive dyed PCC will not meet bleach and possibly light fastness standards. This is currently the case in Europe and shade cards should include a note to that effect



Coats Dual Duty

EXPERT REAL WORLD SUPPORT

The final cost of any thread also includes hidden costs, fuelled by the methods and tools applied to it. Our experts know exactly how to reduce those costs, save time and increase productivity.



Seamworks

Install our Seamworks software to accurately calculate costs prior to production, putting an end to the risk of over or under ordering materials, and incurring unnecessary extra costs. The Seamworks tool is provided with installation, training and ongoing support included.



One to One Visits

There's no need to come to us, our experts will travel to your site. In person, online or via the phone, our trained consultants deal with the kind of issues any busy factory may face, providing a solution for today and a blueprint for future efficiency.



Training and Presentations

From thread selection to stitch formation, the use of colour to solutions for common production issues, we take the learning gathered through years of hands on experience and present it in the form of high impact seminars, workshops and presentations.



Embroidery Service Centre

Our Embroidery Service Centre makes embroidering a design much easier, increasing productivity at the same time as enhancing the design itself. Email the design and any problematic issues to us and our technicians will email the improved design right back.

To drive your hidden costs down, talk to Coats. From thread audits in pre-production to the latest technological bulletins, we'll provide support that achieves measurable results.

For more information, talk to your Coats representative today or visit www.coats.com/dual-duty

OTHER PRODUCTS IN THE DUAL DUTY RANGE

To complement the Dual Duty range, we also have a selection of specialist Dual Duty threads. Each of these have additional benefits specific to the end use.

Product Name	Description
Dual Duty Multi	Attractive two coloured heather-effect or melange thread that is ideal for embroidery and decorative stitching on denim.
Dual Duty Supercotton	Premium quality corespun sewing thread that has been especially developed for post dyed cotton garments.
Dual Duty True Indigo	Durable corespun sewing thread that is dyed with natural indigo and fades during the denim wash process to give each garment a unique finish.

Specialist Dual Duty products are typically available across a select range of ticket sizes and technical information will in some cases vary from the above table.



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