**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**

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.
## PRODUCT RANGE

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

## THERMAL PROPERTIES

- Polyester melts at 250 - 260°C, softens at 220 - 240°C
- Cotton discoulors 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
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 coats.com

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.

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

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.