

INCH-POUND
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MIL-DTL-32072  
JAN 8, 2002  
SUPERSEDI NG  
V-T-285F  
January 3, 1991

## DETAIL SPECIFICATION

### THREAD, POLYESTER

#### 1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers polyester thread used for machine sewing (see 6.1).

1.2 Classification.

1.2.1 Types and classes. The thread must be furnished in the following types, classes, and subclasses as specified. (see 6.2)

##### Types:

- |     |   |                               |
|-----|---|-------------------------------|
| I   | — | Twisted soft multiple cord.   |
| II  | — | Twisted bonded multiple cord. |
| III | — | Bonded monocord,              |
| IV  | — | Soft air entangled.           |
| V   | — | Bonded air entangled.         |

##### Classes:

- Class 1 — Normal elongation.  
Class 3 — Heat stable — low shrinkage.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Supply Center Philadelphia, Clothing and Textiles Directorate, Attn.: DSCP-COCT, 700 Robbins Ave., Philadelphia PA., 19111-5092.
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AMSC N/A

FSC 8310

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## Subclasses:

Subclass A	-	General purpose
Subclass B	-	Nonwicking finish
Subclass C	-	No finish

- 1.2.1.1 Subclass references. In end item specifications where neither subclass designation “A” “B” or “C” is indicated, the requirements for subclass “A” shall apply.

## 2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3 and 4. This section does not include documents cited in other sections or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements and documents cited in sections 3 and 4, whether or not they are listed.

### 2.2 Federal publications

#### CODE OF FEDERAL REGULATIONS

Title 40, part 798.4470 (primary dermal irritation)

(This reference may be found on the Internet at [www.access.gpo.gov/nara/cfr/cfr-table-search.html](http://www.access.gpo.gov/nara/cfr/cfr-table-search.html))

2.2 Non-Government publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DoDISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS are the issues of the documents cited in the solicitation (see 6.2).

#### AMERICAN NATIONAL STANDARDS INSTITUTE (ANSI) / AMERICAN SOCIETY for QUALITY (ASQ)

ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection of Attributes.

(Application for copies should be addressed to American National Standards Institute, 11 West 42nd Street, New York, NY 10036-8002)

#### AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM) PUBLICATION

ASTM D - 204	-	Standard Methods of Testing Sewing Threads
ASTM D – 1423	-	Standard Test Method for Twist in Yarns by the Direct Counting Method

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(Application for copies should be addressed to American Society for Testing and Materials, 100 Barr Harbour Drive, West Conshohocken, PA 19428)

### AMERICAN ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS (AATCC)

AATCC – 15	Colorfastness To Perspiration
AATCC – 16	Colorfastness to Light
AATCC – 20	Fiber Analysis: Quantitative
AATCC – 111	Weather Resistance: Sunshine Arc Lamp Exposure with Wetting
AATCC – 117	Colorfastness to Heat: Dry (Excluding Pressing)
AATCC – 132	Colorfastness to Dry Cleaning

Applications for copies should be addressed to American Association of Textile Chemists and Colorists (AATCC) PO Box 12215, Triangle Park, NC 27709-2215)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services)

### MISCELLANEOUS

Principals and Methods of Toxicity, A. Wallace Hayes (editor), 1989, pp. 394-396

(Applications for copies of referenced documents should be addressed to Raven Press, New York, NY)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

## 3. REQUIREMENTS

3.1 Standard sample. When a standard sample is available, the thread shall match the standard for shade and shall be equal to or better than the standard sample with respect to all characteristics for which the standard sample is referenced (see 6.3).

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3.2 Materials.

3.2.1 Yarn. The yarn for all types shall be bright, continuous multifilament polyester (polyethylene glycol terephthalate) having a specific gravity within the range 1.36 to 1.40 when tested as specified in 4.2.1.

3.2.2 Bonding agent. The bonding agent used in types II, III and V thread shall be colorless.

3.3 Color. The color (shade) shall be as specified in the applicable end item specification or in the contract or purchase order (see 6.2).

3.3.1 Matching. The shade of the thread shall be a good (good is defined as a perceptible not appreciable difference in color) match to the standard sample see (6.3), when viewed under filtered tungsten lamps which approximate artificial daylight having a correlated color temperature of  $2300 \pm 200$  K, with illumination, of  $100 \pm 20$  foot candles, and shall be a good match to the standard sample under incandescent lamplight at  $2300 \pm 20$  foot candles.

If no standard sample is available then the thread shall be a good match to the standard sample of the end item base cloth, when viewed under filtered tungsten lamps that approximate artificial daylight and that have a correlated color temperature of  $7500 \pm 200$  K with illumination of  $100 \pm 20$  foot candles, and shall be a good match to the standard sample under incandescent lamplight at  $2300 \pm 200$  K.

When end item use of the thread is not known, thread sizes 150 or finer shall be evaluated for shade after removal of finish. Thread to be used for dry-cleanable wool or dry-cleanable wool blend clothing or in end items requiring dry cleaning shall be evaluated for shade matching after removal of finish. Removal of finish from thread when required, shall be as specified in 4.4.1.1.

3.3.2 Colorfastness. The colorfastness of dyed and finished thread shall be as specified in the applicable end item specification or as set forth in the contract or purchase order (see 6.2 and 6.4), except that when colorfastness requirements are not stated or not referenced to a standard sample, the thread shall show a colorfastness of 3.5 minimum on the AATCC Gray Scale for Color Change to laundering (after 3 cycles) perspiration, and light and the thread shall have a of 3.5 minimum on the AATCC Gray Scale for Color Change for colorfastness to dry heat for both color change and color transfer. When a standard sample for colorfastness is referenced, the thread shall be equal to or better than the standard sample for the specified colorfastness properties or (when properties are not specified ) for colorfastness to laundering ( after 3 cycles), perspiration, light, and dry heat. Tests for colorfastness (including wet dry cleaning, and weathering (when specified) shall be as specified in 4.2.1 as applicable.

3.4 Construction.

3.4.1 Type I. The type I thread shall be of twisted, multiple cord (ply) construction. Each of the individual plies shall be twisted initially with not less than the number of turns per inch (t.p.i.) to be used in the final twist, and in the opposite direction to the final twist (see 3.5). Type I thread shall be unbonded, with a soft finish.

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3.4.2 Type II. Type II thread shall have the same construction as type I, except that the type II thread shall be bonded.

3.4.3 Type III. Type III thread shall be essentially a single ply, monocord construction. Constituent yarns before combining shall contain only original producer's twist and the final twist shall be no more than 5 t.p.i. Type III thread shall be bonded to unite all the filaments to form a smooth even monocord

3.4.4 Type IV. Type IV thread shall be composed of one or more constituent yarns which are air entangled together by the manufacturing process to form a single ply thread with a final twist of no more than 10 t.p.i. (See 3.5).

3.4.5 Type V. Type V thread shall have the same construction as type IV except that the type V thread shall be bonded.

3.5 Twist direction. Unless otherwise specified (see 6.2). the direction of the final twist shall be "Z" except that larger sizes or types I and II threads used for sole stitching of footwear may be "S" or "Z" depending upon the initial twist when tested as specified in 4.2.1.

3.6 Physical requirements. The finished thread shall conform to the applicable requirements for the specified type, class, and size set forth in table I through VI when tested as specified in 4.2.1

TABLE I. Type I class 1 thread requirements

<u>Tex size</u>	<u>Breaking Strength LBS.</u>	<u>Elongation % Max</u>
16	1.4	26
24	2.0	26
30	3.0	26
45	4.3	26
70	8.0	26
90	10.6	26
135	16.0	26
210	24	26
270	32	26
350	40	26
400	48	26
450	54	26
500	60	26
700	70	26

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TABLE II. Type I class 3 thread requirements

Tex size	Breaking Strength LBS.		Elongation %	
	MIN		MAX	
16	1.25	15	35	
24	1.90	15	35	
30	3.80	15	35	
45	6.80	15	35	
70	7.60	15	35	
90	16.00	15	35	
210	19.00	15	35	
270	27.25	15	35	
350	34.00	15	35	
400	41.00	15	35	
450	47.70	15	35	

TABLE III. Type II class 1 thread requirements

Tex size	Breaking Strength LBS.	Elongation % Max
16	1.5	26
24	2.3	26
30	3.0	26
45	4.5	26
70	8.0	26
90	10.6	26
135	16.0	26
210	25	26
270	34	26
350	42	26
400	48	26
450	54	26
500	60	26
700	70	26

TABLE IV. Type III class 1 thread requirements

Tex size	Breaking Strength LBS.	Elongation % Max
16	1.4	26
24	2.6	26
30	3.0	26
45	5.3	26
70	8.0	26
90	10.6	26
135	16	26

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TABLE IV. Type III class 1 thread requirements con't

<u>Tex size</u>	<u>Breaking Strength LBS.</u>	<u>Elongation % Max</u>
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210	24	26
270	32	26
350	40	26
400	48	26
450	54	26
500	60	26
700	70	26

TABLE V Type IV, soft air entangled thread requirements

<u>Tex size</u>	<u>Breaking Strength LBS.</u>	<u>Elongation % Max</u>
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16	1.0	26
21	1.4	26
24	1.6	26
27	1.8	26
30	2.0	26
40	2.8	26
50	3.6	26
60	4.3	26
80	5.4	26
90	5.9	26
105	6.9	26

TABLE V Type VI, bonded entangled thread requirements

<u>Tex size</u>	<u>Breaking Strength LBS.</u>	<u>Elongation % Max</u>
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16	1.0	26
21	1.4	26
24	1.6	26
27	1.8	26
30	2.0	26
40	2.8	26
50	3.6	26
60	4.3	26
80	5.4	26
90	5.9	26
105	6.9	26

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3.6.1 Knots. Tex size 150 and finer thread shall average not more than one thread knot per 2 ounces, and Tex size 210 and heavier thread shall average not more than one thread knot per 4 ounces.

3.6.2 Shrinkage (class 3 only). The shrinkage of class 3 thread shall be not more than 3.0 percent, when tested as specified in 4.2.1.

3.7 Finish and bond. No chemical finishes or bonding agents shall be applied except those necessary to provide good sewing quality and as applicable for bonding types II, III and V. Finishes shall not transport or wick in any manner as to cause staining or discoloration of the sewn materials.

3.7.1 Nonwicking finish (subclass B). The subclass B thread shall be finished with a commercial nontoxic nonwicking finish uniformly applied. The use of compounds containing mercury in any form is prohibited. The finished thread shall resist the wicking of water when tested as specified in 4.2.1.

3.8 Put-up. Unless otherwise specified (see 6.2), the thread shall be put-up on a nominal weight per holder basis on holders as specified in the contract or purchase order in accordance with table VII. When put-up on ready-made lockstitch bobbins is specified, the style of bobbin and the length of thread therein shall be in accordance with the contract or purchase order. The average weight per holder shall be not less than the specified nominal weight minus 3.0 percent tolerance when examined (on a 10-holder basis) as specified in 4.4.3. The thread shall be put-up in one continuous length per holder and shall be so wound that each turn and layer is free from entanglement.

TABLE VII Put-up

Thread Type	Size	Holder Type
I	All sizes	Single head Spools
I, II, III	All sizes	Single head plastic tubes
IV, V	All sizes	Spools Cones or tubes

3.9 Identification marking. Except when commercial identification markings are specified in the invitation for bid, each holder except the ready made lockstitch bobbins shall have a label attached in such a manner as to remain in place and be clearly legible until all thread has been removed. In the case of ready made lockstitch bobbins; the label shall be put on the outside of the unit pack (bulk pack). The label shall be printed with the information as specified below:

Nomenclature  
National stock number  
Weight (net)



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Direction of twist  
 Color  
 Tex size  
 Type and class  
 Contract or purchase order number  
 Date manufactured (month and year)  
 Name of contractor

For type I, class 3 thread, the date of manufacture of thread shall be included on the label.

3.10 Toxicity. The finished cloth shall not present a dermal health hazard when used as intended (see 4.3).

#### 4. VERIFICATION

4.1 Classification of inspection. The inspection requirements specified herein are classified as follows:

Quality conformance inspection (see 4.2).

4.2 Quality conformance inspection. Sampling for inspection shall be performed in accordance with ANSI/ASQC Z1.4, except where otherwise indicated.

4.2.1 End Item Testing. The end items shall be tested for the characteristics Listed in table VIII. The methods of testing as listed in table VIII shall be followed. The lot size shall be expressed in units of holders except that for ready made bobbins the lot size shall be expressed in units of one gross of bobbins. The sample unit shall be one holder or sufficient holders to provide enough thread for the Applicable tests.

TABLE VIII. End item tests

Characteristic	Requirement paragraph	Test method
Polyester yarn:		
Identification	3.2.1	AATCC 20 <u>1/</u>
Specific gravity	3.2.1	AATCC 20 <u>1/</u>
Bright	3.2.1	Visual <u>1/</u>
Continuous multifilament	3.2.1	Visual <u>1/</u>
Shade match	3.3.1	4.5.1 <u>2/</u>
Colorfastness to:		
Laundering (after 3 cycles)	3.3.2	ASTM-D-204 <u>3/ 4/</u>
Perspiration	3.3.2	AATCC 15
Light	3.3.2	AATCC16 Opt A
Dry heat	3.3.2	AATCC 117 <u>5/</u>
Wet dry-cleaning	3.3.2	ASTM-D-204

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TABLE VIII. End item tests con't

Characteristic	Requirement paragraph	Test method
Weathering	3.3.2	AATCC 111A
Direction of twist: Initial	3.5	ASTM-D-1423
Final	3.5	ASTM-D-1423
Breaking, strength	3.6	ASTM-D-204 <u>8/</u>
Elongation	3.6	ASTM -D-204
Shrinkage (class 3)	3.6.2	ASTM-D-204 <u>9/</u>
Nonwicking (subclass B)	3.7.1	4.3.2

- 1/ Unless otherwise specified, a certificate of compliance shall be submitted and will be acceptable for the stated requirement.
- 2/ In case of dispute, shade match shall be determined with finish. Procedures for removal of the finish shall be as specified in 4.5.1.1
- 3/ The specimens must be dried after each of the 3 laundering cycles.
- 4/ The color transfer cloth evaluation shall not apply. No appreciable change in shade or loss of color of the tested specimen shall be visible when compared to the untested thread retained.
- 5/ The heat at which the specimen is to be tested shall be  $351^{\circ} \pm 6^{\circ}$ .
- 6/ The test for turns per inch (t.p.i.) in the individual cords (strands) shall be made in conjunction with that for the final twist. After recording the final twist and while the individual cords (strands) are straight between the jaws, all cords but one shall be cut out and removed. The clamp shall then be opened, the slack drawn through, and the strand reset under the specified tension. The counter shall be reset to zero. The jaw shall then be rotated until all twist has been removed as determined by free passage of the needle between filaments.. The t.p.i. shall be calculated in accordance with the general procedure of ASTM-D-1423.
- 7/ One determination per sample unit and the result reported as "pass" or "fail".
- 8/ Except that five determinations shall be made per sample unit.
- 9/ Shall be tested in accordance with the dry heat method.

4.3 Toxicity Assessment. The contractor must furnish information that certifies that the finished product is composed of materials that have been safely used commercially or provide sufficient toxicology data to show compatibility with prolonged, direct skin contact. At a minimum, toxicity data should include results from a primary dermal irritation study in laboratory animals (see 2.2.2) and a repeated insult human patch test (Modified Draize procedure) (see 2.3). The later must be

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conducted under the supervision of a qualified dermatologist using at least 100 free living individuals.

#### 4.4 Visual examination

4.4.1 Thread on holder examination Thread on holders shall be examined for the defects listed in table IX. The lot size shall be expressed in units of holders except that for ready made bobbins, the lot size shall be expressed in units of one gross of bobbins. The sample unit shall be one holder except that for ready made bobbins the sample unit shall be one gross of bobbins. The inspection level shall be S-3 and the acceptable quality level (AQL) will be in accordance with the contract or procurement order.

TABLE IX. Thread on holder defects

Examine	Defect	Major	Minor
Identification label	Missing, incorrect, incomplete, illegible, or insecurely attached.		201
Type of holder	Other than specified.	101	
Surface condition	Loose ply.	102	
	Cut, tear, chafe, or slip, affecting strength of thread or interfering with easy location of end and initial unwinding.	103	
Cleanliness	Dirt, spot, or stain clearly noticeable.		202
Finish	Other than specified. Uneven, lumpy, bare, or thin spots.		203 204

4.4.2 Thread as unwound examination. The thread shall be examined while unwinding for the defects listed in table X. All defects shall be counted regardless of their proximity to each other. The lot size shall be expressed in units of holders except that for ready-made bobbins the lot size shall, be expressed in units of one gross of bobbins. The sample unit shall be one holder except that for ready made bobbins the sample unit shall be one gross of bobbins. The inspection level shall be S-3 and the AQL shall be in accordance with the contract or procurement order.

TABLE IX. Thread as unwound defects

Examine	Defect	Major	Minor
Continuous length	Not in continuous lengths.		201
Knot and splices	Size 150 and finer thread shall average not more than one thread knot per 2 ounces, and size 3 and heavier thread not more than one thread knot per 4 ounces.		202

Winding	MIL-DTL-32072 Improperly or not firmly wound resulting in kinks, knots, or slippage during unwinding or otherwise affecting free unwinding of the thread.	101
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TABLE IX. Thread as unwound defects

Examine	Defect	Major Minor
Tackiness or Adhesion	Strands adhere to each other or to holder affecting unwinding tension	203
Color	Other than specified. Uneven, apparent on successive layers Or end to end	102

4.4.3 Net weight per holder examination. The sample for this examination shall be 10 wound holders taken at random from the lot. The holders shall be weighed individually and the net weight of thread determined. The values obtained shall be averaged and this average shall represent the net weight per holder in the lot. The lot shall be unacceptable if the average net weight per holder is less than the specified weight minus the 3.0 percent tolerance (see 3.8).

#### 4.5 Methods of inspection.

##### 4.5.1 Shade match evaluation.

4.5.1.1 Removal of finish. When removal of finish is required (see 3.4.1), before evaluation for shade matching, the sample of thread shall be wet dry cleaned in accordance with AATCC 132. Excess solvent shall be removed by centrifuging or wringing. The sample shall then be rinsed in distilled water at 120° to 160°F, and dried at a temperature not exceeding 180°F. The dried sample shall then be conditioned for a minimum of 4 hours prior to evaluation for shade match.

4.5.1.2 Shade matching procedure. The sample shall be wound or prepared for examination in a manner similar to that for the standard shade sample. The color of the sample shall match the standard sample when viewed under filtered tungsten lamps that approximate artificial daylight and that have a correlated color temperature of 7500 + 200 K, with illumination of 100 + 20 foot candles, and shall be a good match to the standard sample under incandescent lamplight at 2300 + 200 K.

##### 4.5.2 Heat stability shrinkage test (for class 3 thread only).

4.5.2.1 Preparation of specimens. The sample unit shall consist of five 14- inch test specimens. Each specimen shall be formed into a loop by knotting the ends together. Condition each specimen for a minimum of 4 hours at standard. Place the specimen on the hook of a vertical stand so that the

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knots rest on the hook. Take care that the loop does not twist upon itself. On the free end of the loop hang a metal hook (as specified in ASTM D 204) and the applicable weight as specified in table XI. While, the loop is under tension, measure the length of the loop to the nearest 1mm.

TABLE XI. Weight for heat stability shrinkage test

Thread Size	Weight(oz)
16	1
24	1
30	1
45	1
70	2
90	2
135	2
210	4
270	4
350	8
400	8
450	8
500	8

4.5.2.2 Test procedure. The previously measured specimens shall be tied and freely suspended from some stationary point inside an oven which has been preheated to 350°F. Specimens should remain inside the oven for 1 hour at  $350^{\circ} \pm 5^{\circ}\text{F}$ . Upon removal from the oven, the specimens shall be conditioned at standard conditions for a minimum of 4 hours, and the length of the loop shall be re-measured in the same manner as described in 4.5.2.1. The shrinkage shall be determined as a percent change from the original measured length and the average test result of the five specimens shall be reported to the nearest 0.1 percent.

## 5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When actual packaging of material is to be performed by DoD personnel, these personnel need to contact the responsible packaging activity to ascertain requisite packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activity within the Military Department or Defense Agency, or within the Military Department's System Command. Packaging data retrieval is available from the managing Military, Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

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**6. NOTES**

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The threads are intended for machine sewing of clothing, tentage, equipage, and footwear. The type I, class 3 (subclass A) thread is specifically intended for use in parachutes that are subject to exposure at elevated temperatures. Subclass B threads are intended for tentage, equipage, and other items where water resistance of seams is required, and are related to type I.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Type, class, subclass, and letter or number size of thread required (see 1.2.1 and 3.6).
- c. Color (shade) required (see 3.3).
- d. Colorfastness properties required (see 3.3.2).
- e. Direction of twist, if other than specified (see 3.5).
- f. Put—up required (see 3.8).

6.3 Sample. For access to samples, address the contracting activity issuing the invitation for bids or request for proposal, or as directed by the contracting activity.

6.4 Colorfastness guidelines. Normally, colorfastness requirements for thread are to be specified in keeping with those for the basic material into which the thread will be sewed (see 3.3.2). Typical examples are:

Use <u>Colorfastness</u>	
Thread for sewing wool clothing which is dry cleaned.	perspiration, and light.
Thread ,for sewing wool clothing which is laundered.	Good fastness to laundering and perspiration.
Thread for sewing cotton clothing which is laundered.	Good fastness to laundering, perspiration, and light.
Thread for sewing synthetic fiber	Good fastness to weathering.
clothing which is laundered.	No colorfastness tests apply.
Thread for sewing tentage.	
Thread for sewing footwear.	Good fastness to laundering and weathering.
Thread for sewing equipage. Good fastness to wet dry cleaning, perspiration, and light.	
Good fastness to laundering,	

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Thread for sewing cotton polyester  
perspiration,  
blend fabrics for durable press  
garments.

Good fastness to laundering,  
and dry heat.

6.5 Subclass C. Subclass C thread covers the larger sizes of thread used in footwear and other leather items which are waxed at the sewing machine and require that no sewing or other type finish be applied.

6.6.2 Formula disapproval (subclass B). For the information of the contractor, the use of proteins and their derivatives, starch, hydrophilic materials, oxidizing oils, oxidizing resins, and resin or compounds to increase hydro-scopicity may lead to formula disapproval.

6.7 Size conversion table.

<u>Letter/Size Number</u>	<u>Tex Size</u>
OO	16
A	24
B	45
E	70
F	90
FF	135
3	210
4	240
5	350
6	450
7	500

6.8 Subject keyword listing

Equipage  
Machine Sewing  
Shoe  
Sewing  
Tentage  
Parachute

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MILITARY INTRESTS:

Custodians

Army – GL

Navy – NU

Air Force – 11

Review Activities

Army-MD, EA, AR

Navy – AS, MC, OS

Air Force - 99

DNA - DS

CIVIL AGENCY CORDINATING ACTIVITIES:

GSA – FSS

JUS – FPI

VA – OSS

Preparing Activity

DLA-CT

Project 8310 – 0218



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**STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL****INSTRUCTIONS**

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7 and send to preparing activity.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

**I RECOMMEND A CHANGE:**

**1. DOCUMENT NUMBER**  
MIL-DTL-32072

**2. DOCUMENT DATE (YYYYMMDD)**

2002/01/16

**3. DOCUMENT TITLE**  
THREAD, POLYESTER

**4. NATURE OF CHANGE** (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

**5. REASON FOR RECOMMENDATION****6. SUBMITTER**

a. NAME (Last, First, Middle Initial)

b. ORGANIZATION

c. ADDRESS (Include Zip Code)

d. TELEPHONE (Include Area Code)  
(1) Commercial

7. DATE SUBMITTED  
(YYYYMMDD)

(2) DSN  
(If applicable)

**8. PREPARING ACTIVITY**

a. NAME  
DEFENSE SUPPLY CENTER PHILADELPHIA  
DSCP-C

b. TELEPHONE (Include Area Code)  
(1) Commercial (2) DSN  
(215) 737- 444-

c. ADDRESS (Include Zip Code)  
700 Robbins Ave (Bldg 6, C&T)  
PHILADELPHIA, PA 19111-5092

**IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:**  
Defense Standardization Program Office (DLSC-LM)  
8725 John J. Kingman Road, Suite 2533  
Fort Belvoir, Virginia 22060-6221  
Telephone (703) 767-6888 DSN 427-6888

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WHS/DIOR, Feb 99

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