



THREAD, POLYAMIDE, THREE PLY, TEX 135

WSS-M15H67-A

1. SCOPE

The material defined by this specification is a polyamide thread manufactured as a single cord incorporating three separate plies.

2. APPLICATION

This specification was released originally for material used as a sewing thread for the Euro Stitch on steering wheel application.

3. REQUIREMENTS

In addition to the requirements quoted herein, this material must meet the requirements of the Sewing Thread Performance Specification, WSS-M8P5-C.

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 APPEARANCE
(FLTM BI 109-01)

The color, pattern, and finish shall match the approved Design Center master sample, or shall be as specified on the Engineering Drawing.

3.3 YARN CONSTRUCTION AND DESCRIPTION
(ASTM D 1244)

The thread is manufactured from three separate ends of 45 tex f 68, multifilament, bright, high tenacity polyamide 6.6 yarn. These are twisted together in Reverse (Z) direction.

3.4 PHYSICAL REQUIREMENTS

3.4.1	Thread Size, range (ASTM D 204-2)	135 +/- 10 Tex
3.4.2	Tensile Strength (ASTM D 204-2)	87 N min

Date	Action	Revisions
2009 08 06	Revised	Updated per WSS-M8P5-A
2003 10 13	Activated	

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3.4.3	Elongation at Break, range (ASTM D 204-2)	15 - 30%
3.4.4	Twist, range (ASTM D 204-2)	280-440 turns/m

5. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification.

5.1 FINISH 8.0 – 22%

The finish shall consist of hard polyamide resin as a bonding agent and a suitable lubricant, e.g., a polyethylene and silicone type. The primary criterion for acceptability of the finish shall be the thread's sewability. Finish content outside this range may be considered acceptable providing that the amount of lubricant or resin does not adversely affect the sewability performance or yield of the thread.