



PERFORMANCE, SEWING THREAD

WSS-M8P25-C

PERFORMANCE, SEWING THREAD, DRY, SHIFT BOOT

WSS-M8P25-D

1. SCOPE

This specification defines the performance requirements for sewing threads used in functional and decorative purposes for interior trim vehicle components.

2. APPLICATION

This specification was released originally for material used in sewing operations in the manufacture of interior trim vehicle components. Table 1 indicates recommended usage per thread size (Tex/Metric-M) and fiber content. Other applications not listed in this table will be considered after evaluation by Materials Engineering based on the proposed use.

Nylon is the recommended fiber content. Certain regions (for example China) may require the use of polyester due to fiber availability. Polyester thread will be required for areas of high UV exposure such as Instrument Panels (IP's) for decorative stitching.

WSS-M8P25-C contains the typical lubricant on the thread as *selected by the thread supplier*.

WSS-M8P25-D is produced dry to aid in the shift boot component level testing for liquid penetration.

3. REQUIREMENTS

Threads to be used in the application of serging and embroidery for floor mats must meet WSS-M8P22-A, *Performance, Floor Mat, Serge and Embroidery Thread*. In addition, specific material specification WSB-M15H64-A/latest will need to be met based on application use.

3.1 APPROVED SOURCES

This specification requires the use of approved sources. Only the sources identified on the Ford Approved Source List (ASL) can be used when this specification is listed on the drawing, CAD file, or other documents. The list of approved sources is located within Ford at www.mats.ford.com or available externally through a Ford Materials Engineer.

3.2 APPEARANCE

The color, pattern, and finish shall match the approved Corporate Design master sample

3.3 BALANCE

Take a one meter length of sewing thread drawn freely from the side of the spool (without undue tension and without passing it through any restriction such as fingers, etc.) and bring the thread together to form a free hanging loop. In this position, the thread must not twist upon itself more than twice.

3.4 NUMBER OF KNOTS

The thread spool shall be free from all imperfections of such character which would cause the thread to break during sewing.

Date	Action	Revisions	Rev. 02
2018 04 09	Editorial	See Summary of Revisions	D. Murtonen, NA
2018 01 24	Editorial	Added examples in table 1	D. Murtonen, NA
2016 02 29	Released		D. Murtonen, FNA



3.5 IDENTIFICATION

Each spool of thread must bear the name of the manufacturer, color suffix, and yarn size.

3.6 PACKING

The material must be packed in such a way that no slippage of the thread layers or any other damage occurs during transit.

3.7 CONSTRUCTION PROPERTIES

All properties must be tested per each color package submitted, per each Tex/Metric-M

Table 1 indicates performance requirements per Thread Type Designation for Thread Size (Tex or Metric-M and Fiber and common applications for each Thread type.

3.7.1	Tensile Strength (ISO 2062, Method A, B or C)	See Table 1
3.7.2	Tensile Strength after Aging (ISO 2062, Method A, B or C)	
3.7.2.1	After Heat Age (7 days at 100 +/- 2 °C, AATCC Evaluation Procedure 1)	70% of original data
3.7.2.2	After Ultraviolet (FLTM BO 116-01, 225.6 kJ/m ²)	Report Only
3.7.3	Elongation (ISO 2062, Method A, B or C)	See Table 1
3.7.4	Resistance to Fade (FLTM BO 116-01, ISO 105 A-02/ AATCC Evaluation Procedure 1)	Rating 4 min
	All Applications (excluding IP Polyester Thread)	225.6 kJ/m ²
	IP Decorative Polyester Thread	451.2 kJ/m ²
3.7.5	Heat Aging (7 days at 90 +/- 2 °C, AATCC Evaluation Procedure 1)	Rating 4 min
3.7.6	Resistance to Crocking (FLTM BN 107-01, AATCC Evaluation Procedure 2)	
	Dry	Rating 4 min
	Wet	Rating 4 min