

Chainstitch or Lockstitch?
Tape Edge or Tack & Jump?
King Spools or Cocoons?

danfield®

THE WORLD LEADER IN
**MATTRESS
THREAD**

DANFIELD
PRECISION BOBBINS

COATS *danfield*®

Quality & Tradition You Can Rely On

COATS *danfield*[®] Mattress Threads

COATS *danfield*[®] offers a complete package of high performance threads, specially engineered for a variety of high-speed sewing operations in a mattress plant.

From the trusted P143A quilting thread, to the textured D30TA specially designed for tack and jump; from the workhorse Ultimax Bedding to bonded nylon threads for strong tape end closures; the wide range of deniers and styles in cocoon bobbins, and even the 8-point spring up twine, COATS *danfield*[®] brings to you a product range of unequalled productivity and unsurpassed reputation over years. Now available in 65 countries worldwide, with guaranteed quality and performance.



End Use Applications

- Quilted mattress pads
- Foundations
- Box springs
- Contract quilting and Schifflli embroidery

COATS *danfield*[®] Special Features

Needle Threads

- Continuous and knotless
- Designed for high speed mattress sewing operations
- Special silicone finish for minimal down time
- Large packages including 6 lb. put ups
- Complete range of substrates



Cocoon Bobbins

- Unique danfield pioneered technology
- Special dipping for consistent draw-out tensions
- Precision wind to prevent internal bobbin collapse
- Wide range of sizes and styles

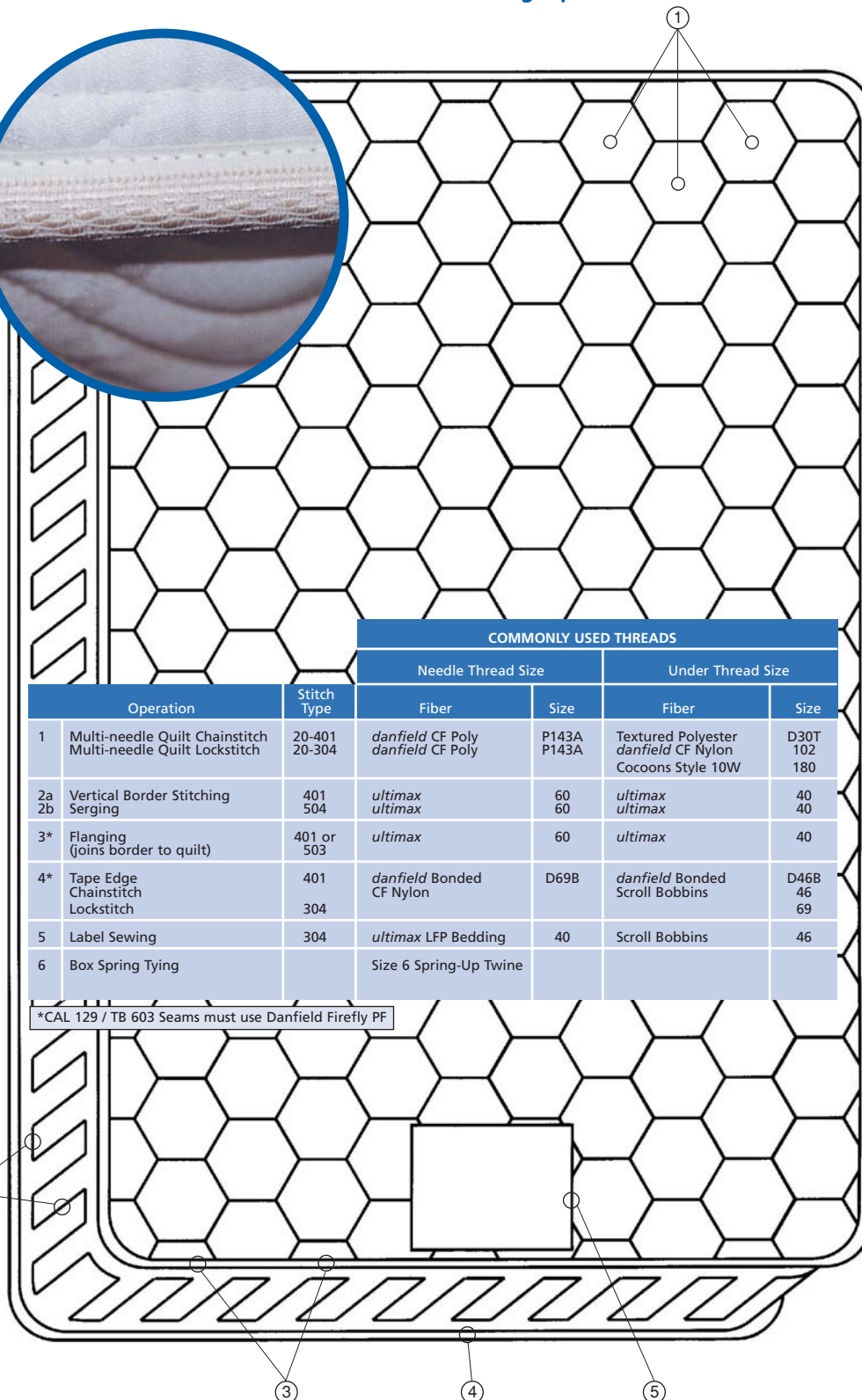
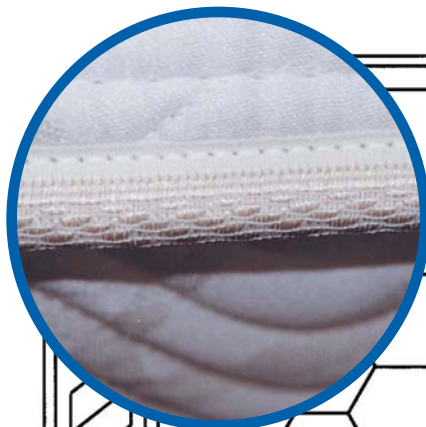
COATS *danfield*[®] Technical Data

Brand	Description	Size	Tex	Ply	Strength (lb)	Approx. Yield (Yrds/Lb.)	Applications
<i>danfield</i>	Lubricated Polyester	P-15	14	2	2.4	30000	Contract quilters Contract quilters Contract quilters
		P-23	21	3	3.6	19000	
		P-33	35	3	5.0	13500	
<i>danfield</i>	Lubricated Polyester	P-143A	45	3	6.2	9600	Mattress Mattress
		P-183A	60	3	7.5	8000	
<i>danfield firefly PF</i>	Bonded Para-Aramid Monocord	T-40	40	1	18.0	9550	CAL 129/TB603 Seams
<i>danfield</i>	Lubricated Nylon	D-15	14	2	2.0	28700	Contract quilters Contract quilters Contract quilters Mattress Mattress
		D-23	21	3	3.0	19200	
		D-33	35	3	4.7	13500	
		D-46	45	2	7.5	10000	
		D-69	70	3	11.4	6500	
<i>danfield</i>	Bonded Nylon	D-46B	45	2	7.5	9000	Tape edge
		D-69B	70	3	11.4	6600	
<i>ultimax</i>	Locked Filament Polyester	T-40	40	1	4.3	9900	Border stitching, serging, flanging, label sewing
		T-60	60	1	6.1	6800	
<i>danfield</i>	Textured Polyester	D-30T D-30TA	30 30	2	3.1	14500	Under thread for chainstitch multi-needle quilting
<i>nymo-ex</i>	Nylon Monocord Belbobs (Scroll Bobbins) Style 57	4	30	1	4.5	14400	Under thread for lockstitch sewing
		5	35	1	5.5	12750	

danfield P-143A put ups: 16 oz., 24 oz., 32 oz., 48 oz., 64 oz., 96 oz.
danfield put ups vary depending on the size and are available from 4 oz. to 96 oz.
 Ultimax put ups are available in 6000 yds., 12000 yds, 18000 yds, and 24000 yrd. cones.



Thread Recommendations for Mattress Sewing Operations



COMMONLY USED THREADS						
		Needle Thread Size		Under Thread Size		
Operation	Stitch Type	Fiber	Size	Fiber	Size	
1	Multi-needle Quilt Chainstitch Multi-needle Quilt Lockstitch	20-401 20-304	<i>danfield</i> CF Poly <i>danfield</i> CF Poly	P143A P143A	Textured Polyester <i>danfield</i> CF Nylon Cocoons Style 10W	D30T 102 180
2a 2b	Vertical Border Stitching Serging	401 504	<i>ultimax</i> <i>ultimax</i>	60 60	<i>ultimax</i> <i>ultimax</i>	40 40
3*	Flanging (joins border to quilt)	401 or 503	<i>ultimax</i>	60	<i>ultimax</i>	40
4*	Tape Edge Chainstitch Lockstitch	401 304	<i>danfield</i> Bonded CF Nylon	D69B	<i>danfield</i> Bonded Scroll Bobbins	D46B 46 69
5	Label Sewing	304	<i>ultimax</i> LFP Bedding	40	Scroll Bobbins	46
6	Box Spring Tying		Size 6 Spring-Up Twine			

*CAL 129 / TB 603 Seams must use Danfield Firefly PF

Machine Productivity & Thread Consumption

Chainstitch Machines

1 Gribetz = 225 mattress/8 hrs. (speed 1200 rpm)

Thread Consumption:

- Needle thread: 700-950 yds/mattress
- Looper thread: 400-500 yds/mattress

Note: All calculations based on queen size mattresses

Lockstitch Machines

1 Gribetz LS = 125 mattress/8 hrs. (speed 600 rpm)

Thread Consumption:

- Needle thread: 500 yds/mattress
- Cocoons: 500 yds/mattress

Based on normal 24 heads, cocoon bobbin set needs to be changed every 45 minutes - 1 hour.





COATS *danfield* Cocoon Bobbins Technical Data

Brand	Description	Size	Ply	Brand	Description	Size	Ply
<i>danfield</i>	Nylon Cocoons	0	1	<i>danfield</i>	Spun Poly Cocoons	240	2
		00	1			250	2
		42	2			250K	2
		62	2			260	2
		62TS*	2			L085A	2
		72	2			360D	3
		102	2				
180	3						
<i>danfield</i>	Poly Poly Cocoons	45/2	2				

* Taslanized

Main Cocoon Styles: 10W (mattress); 7B (quilting), and 4 & 6 (Schiffli)
 Nylon Size 102 Style 10W: 195 yds/cocoon
 Nylon Size 180 Style 10W: 220 yds/cocoon

Packing: 12 boxes/case. Pricing per LB.
 Special finishes: RFD and RFE

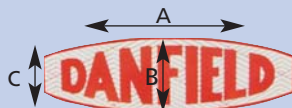


Dimensions and Average Yardages of *danfield*[®] Nylon Cocoon Bobbins

			COCOON STYLE													
			2	3	4	5	6	7	7B	8	9	10	10E	10S	10W	11
Thread Construction	Denier	Size	Average Yards per Cocoon Bobbin													
			70d/1	70	0	205	-	280	220	265	300	320	335	350	-	620
40d/2	80	42	175	160	240	190	230	260	275	285	-	-	570	475	490	-
100d/1	100	00	-	-	200	-	-	215	225	-	-	-	-	-	395	-
60d/2	120	62	100	113	165	130	-	175	185	200	205	-	-	315	340	385
70d/2	140	72	-	-	140	-	-	150	160	-	-	-	-	270	280	315
60d/3	180	180	-	-	-	-	-	115	130	-	-	-	-	205	220	245
100d/2	200	102	-	-	-	-	-	105	115	-	-	75	-	190	200	215
70d/3	210	73	-	-	-	-	-	90	100	-	-	-	-	-	180	-

Cocoon Style		2	3	4	5	6	7	7B	8	9	10	10E	10S	10W	11
A	Cocoon Length	30	30.5	32.5	31	32.5	32.5	33	33	34	37	40	41	40	42
B	Diameter at Center	10.1	10.4	11.5	10.5	11.7	11.8	12.0	12.2	15.0	15.6	14.5	15.2	15.6	-
C	Diameter at Ends	9.8	10.1	11.2	10.1	11.4	11.5	11.7	11.9	15.0	15.2	14.0	14.5	15.2	-

All dimensions in mm



COATS *danfield* cocoon bobbins are described by their "size" (thread construction and denier) and their "style" (physical dimensions of the cocoon bobbin).

E.g. A "0-10W" *danfield* cocoon is constructed with 1 ply of 70 denier nylon thread. The cocoon measures 40mm long, has a diameter at center of 15.6 mm and a diameter of 15.2mm at the ends of the cocoon.



The World of Coats

COATS *danfield*[®] comes to you from the World of Coats, the world's largest supplier of industrial thread products. We have the unique ability to service our customers anywhere in the world with our global product offering, innovative technical solutions, creative ideas and superior customer service. All Coats products are backed by Coats technical service, which gives you expert on-the-spot advice on your sewing problems, absolutely free of cost.



Pioneers in Mattress Threads

COATS NORTH AMERICA
www.coats.com

USA 800 631 0965 CANADA 519 848 3140
 MEXICO 011 525 227 1800 HONDURAS 011 604 669 0452
 DOMINICAN REPUBLIC 011 809 575 9065