



Coats American

# STAR ULTRA®

STAR ULTRA DEE AND STAR ULTRA MONOCORD

## FEATURES

- **100% polyester** — Excellent resistance to ultraviolet rays, microorganisms, and mildew and is ideal for canvas products and outdoor furniture; excellent resistance to acids and other chemicals
- **Controlled processing** — Excellent sewability with less pucker; provides optimum operator and sewing machine efficiencies
- **Bonded** — Excellent sewability in the tough to sew operations; resists abrasion from needles and also external forces better than nonbonded polyester
- **Specifically engineered** — Available in a wide range of sizes and finishes to suit numerous applications
- **Higher specific gravity** — More yardage per bobbin
- **Continuous filament construction** — No slubs or linting — clean sewing
- **Colorfast** — Excellent dry cleaning and laundering durability
- **High strength to size value** — Strong, neat seams
- **Low moisture regain** — Resists moisture absorption
- **Low conductivity of electrical charges** — Very good insulator



STAR ULTRA DEE and STAR ULTRA MONOCORD are Coats American's conventional continuous multifilament polyester sewing thread products. Applications for these products are numerous. From stitching outdoor furniture, canvas awnings, or grass catcher bags, to sewing flags, lingerie, and surgical apparel; Coats American can supply the polyester products needed in today's diversified sewing industries.



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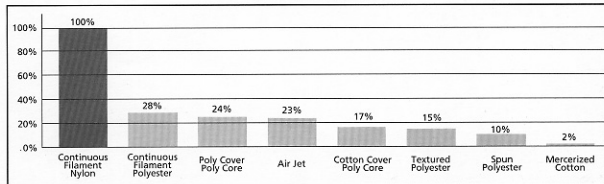
PHYSICAL CHARACTERISTICS  
STAR ULTRA DEE SOFT (D) AND BONDED (DB)

TKT SIZES	TEX SIZES	GOVERNMENT VT285 TYPES I & II	APPROX SINGLE-END STRENGTH (LBS)	APPROX YDS/LB SOFT	APPROX YDS/LB BONDED	RECOMMENDED NEEDLE SIZES		
						SINGER	UNION SPECIAL	METRIC
12	12	--	1.6	33,822	--	8-10	022-025	60-70
15	16	00	2.3	28,096	--	9-10	025-027	65-70
23	24	A/3	3.4	19,080	18,450	10-12	027-032	70-80
30	30	AA/2	4.5	13,910	13,430	12-16	036-040	80-100
46	45	B/2	7.1	9,257	8,911	14-18	036-044	90-110
69	70	E/3	10.6	5,930	5,637	16-19	040-048	100-120
92	90	F/4	14.2	4,590	4,330	19-22	048-054	120-140
138	135	FF/3	21.2	3,100	2,904	22-25	054-067	140-180
207	210	#3	31.9	2,020	1,938	25-27	067-100	180-250
277	270	#4	40.6	1,520	1,440	26-28	090-110	230-280

PHYSICAL CHARACTERISTICS  
STAR ULTRA MONOCORD (PM) POLYESTER MONOCORD

TKT SIZES	TEX SIZES	GOVERNMENT VT285 TYPE III	APPROX SINGLE-END BREAK (LBS)	APPROX YDS/LB BONDED	RECOMMENDED NEEDLE SIZES		
					SINGER	UNION SPECIAL	METRIC
46	45	B	7.1	8,800	14-18	036-044	90-110
69	70	E	10.6	5,700	16-19	040-048	100-120
92	90	F	14.2	4,275	19-22	048-054	120-140
110	120	--	20.2	3,340	22-25	054-067	140-180

ABRASION RESISTANCE





APPLICATIONS	TICKET SIZE	APPLICATIONS	TICKET SIZE
Embroidery bobbins	12, 15	Upholstered furniture	46, 69
Multineedle quilting	15, 23, 30	Automotive interiors	69, 92
Disposable garments	15, 23, 30	Flags	46
Ladies' and children's clothing	15, 23	Canvas goods	138, 207
Men's suits and coats	23, 30	Ladies' shoes	30, 46
Lingerie	15, 23	Men's boots and shoes	46, 69
Curtains and drapes	23, 30	Sporting goods	138, 207, 277
Mattresses	46, 69		

## PHYSICAL AND CHEMICAL PROPERTIES OF FIBERS

Hot head press and oven treatments	Shrinkage less than 2%
Heat/ironing	Melting point: 480°-500°F; sticks at 450°F
Organic acids	Unaffected
Mineral acids	Unaffected by most mineral acids; i.e., hydrochloric, nitric; dissolves in cold concentrated sulfuric acid
Alkalies	No effect when cold; good resistance to solutions of weak ammonia; moderate resistance to strong alkalies such as caustic lye at room temperature; disintegrates by strong alkalies at boil
Organic solvents	Generally unaffected; soluble in some phenolic compounds
Bleaching	Unaffected (chlorine, peroxide, etc.)
Insects and microorganisms (mildew, rot)	Unaffected; however, additives such as oils, waxes or finishes can lend to the support of fungi.
Moisture regain	Low (0.4%)
Laundering/dry cleaning	Excellent

## COLOR RANGE AND FASTNESS

Color range	Available in a broad range of standard and custom shades
Washing and laundering (commercial)	Color change rating is 4 (minimum), and color transfer rating is 3 (minimum) at #III-A test conditions per AATCC Method 61. <sup>1</sup>
Laundering (domestic)	Rating of 4 (minimum) at 140°F with chlorine bleach tested by ASTM D204-79a. <sup>1</sup>
Crocking	Rating of 3 (minimum) wet and dry, as tested by AATCC Method 8. <sup>1</sup>

<sup>1</sup> If thread is to be used for contrast stitching, check for suitability before sewing. Contact Coats American for advice regarding thread selection for specific fastness requirements.

<sup>2</sup> For heat exposures of thread colors beyond test conditions, fastness may vary. Therefore, it is recommended that the sewn product manufacturer check color under actual conditions before use.



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# STAR ULTRA®

STAR ULTRA DEE AND STAR ULTRA MONOCORD

## MAJOR TYPES

- D** Soft finish twisted construction
- DB** Stretched and bonded twisted construction
- PM** Bonded monocord
- VT285** Certified to meet U.S. Government specifications Types I, II, and III

## LUBRICANTS/SPECIAL TREATMENTS

**Silicone blends** Provide smooth uniform thread delivery for consistent stitch formation. Also provide good needle heat protection.

**Nonwick** Primarily used for military applications. This special treatment is intended to prevent the capillary action of water through a sewn seam.

**Heat resistant H. R.™** is a special finish which offers the highest degree of protection from needle heat.

In addition, special finishes may be formulated to individualized custom needs.

## COMPLETE YOUR SEWING THREAD REQUIREMENTS WITH STAR ULTRA DEE AND STAR ULTRA MONOCORD READY-WOUND BOBBINS

## FEATURES

- **Precision wind** — Predictable number of sewn seams versus the metal bobbin, neater seams
- **Superior quality** — More resistant to overspinning; uniform stitch formation; less waste
- **Replaces need for metal bobbins** — Faster bobbin changes
- **Broad selection of thread sizes and bobbin styles** — Readily available for most lockstitch machines; can be engineered for individualized special needs
- **Long yardage** — Increased production with fewer bobbin changes; more yards per bobbin than nylon or spun threads



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**Right Response™: Service that fits  
the way you do business.**