

Quality Assurance Handbook (Products)
Product Category 2.1 Work Wear (WWS), Supporting Material,
2.1_4 Fabric Specific Requirements, Minimum Values for Fabrics
that Contain Less than 50% of PES
Revision 1.0 /19.11.2025

	< 50 % PES	
	< 240 g/m ²	≥ 240 g/m ²
Fiber Content ISO 1833:7:2017	Max +/- 3.0 %	Max +/- 3.0 %
Finished Weight ISO 3801:1977	Max +/- 5.0 %	Max +/- 5.0 %
Yarn Count ISO 2060:1994	As Notified	As Notified
Dimensional Stability After Wash ISO 5077:2007 (after 5 washes) Warp Weft	Max +/- 4.0 % Max +/- 4.0 %	Max +/- 4.0 % Max +/- 4.0 %
Pilling ISO 12945-2:2020 (7000 rev.)	Grade 4	Grade 4
Tensile Strength ISO 13934-1:2013 (strip method) Warp Weft	500 N 400 N	700 N 500 N
Tear Strength EN ISO 13937-2: 2000 Warp Weft	22 N 30 N	30 N 25 N
Abrasion resistance ISO 12947-2: 2016	min. 35 000 rubs	min. 35 000 rubs
Colour Fastness to Perspiration ISO 105-E04: 2013 Color Change (Acid/ Alkalne) Color Staining	Grade 4 Grade 3/4	Grade 4 Grade 3/4
Color Fastness to Rubbing ISO 105-X12:2016 Dry rubbing Wet rubbing	Grade 4 Grade 3	Grade 4 Grade 3
Color Fastness to Laundering ISO 105-C06:2010 (E2S Multifibre) Staining Cotton and PES Colour change	Grade 3/4 Grade 3/4	Grade 3/4 Grade 3/4
Color fidelity of textiles ISO 105-A02:1993 Grey Scale CIELAB	Grade 4 Grade 1.7	Grade 4 Grade 1.7
REACH regulations and SC and SVHC limitations (Substances of Concern and Very High Concern)	values according to latest regulations	values according to latest regulations
OEKO-TEX standard 100 requirements	values according to latest criteria of OEKO-TEX class 1 or 2	values according to latest criteria of OEKO-TEX class 1 or 2