

**Quality Assurance Handbook (Products)**  
**Product Category 2.1 Work Wear (WWS), Supporting Material,**  
**2.1\_5 Fabric Specific Requirements, Minimum Values for fabrics**  
**of 100% Cotton**  
**Revision 1.0 /19.11.2025**

|                                                                                                                            | 100 % CO                                                     |                                                              |
|----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------|--------------------------------------------------------------|
|                                                                                                                            | < 240 g/m <sup>2</sup>                                       | ≥240 g/m <sup>2</sup>                                        |
| <b>Fibre Content</b><br>ISO 1833:1977: 2017                                                                                | Max +/- 3.0 %                                                | Max +/- 3.0 %                                                |
| <b>Finished Weight</b><br>ISO 3801:1977                                                                                    | Max +/- 5.0 %                                                | Max +/- 5.0 %                                                |
| <b>yarn count</b><br>ISO 2060:1994                                                                                         | As Notified                                                  | As Notified                                                  |
| <b>Dimensional stability after wash</b><br>ISO 5077:2007 (after 5 washes)<br>Warp<br>Weft                                  | Max +/- 4.0 %<br>Max +/- 4.0 %                               | Max +/- 4.0 %<br>Max +/- 4.0 %                               |
| <b>Pilling</b><br>ISO 12945-2:2020 (7000 rev.)                                                                             | Grade 3/4                                                    | Grade 3/4                                                    |
| <b>Tensile Strength</b><br>ISO 13934-1:2013 (strip method)<br>Warp<br>Weft                                                 | 400 N<br>400 N                                               | 700 N<br>500 N                                               |
| <b>Tear Strength</b><br>EN ISO 13937-2: 2000<br>Warp<br>Weft                                                               | 20 N<br>18 N                                                 | 30 N<br>25 N                                                 |
| <b>Abrasion resistance</b><br>ISO 12947-2:2016                                                                             | min. 35 000 rubs                                             | min. 35 000 rubs                                             |
| <b>Colour fastness to Perspiration</b><br>ISO 105 E04 : 2013<br>Color Change<br>Colour Staining                            | Grade 4<br>Grade 3/4                                         | Grade 4<br>Grade 3/4                                         |
| <b>Colour fastness to Rubbing</b><br>ISO 105-X12:2016<br>Dry rubbing<br>Wet rubbing                                        | Grade 3–4<br>Grade 2–3                                       | Grade 3–4<br>Grade 2–3                                       |
| <b>Colour Fastness to Laundering</b><br>ISO 105-C06:2010 (E2S Multifibre)<br>Color Change<br>Staining Cotton and Polyester | Grade 3–4<br>Grade 3                                         | Grade 3–4<br>Grade 3                                         |
| <b>REACH regulations and SC and SVHC limitations</b><br>(Substances of Concern and Very High Concern)                      | Values according to latest regulations                       | Values according to latest regulations                       |
| <b>OEKO-TEX standard 100 requirements</b>                                                                                  | Values according to latest criteria of OEKO-TEX class 1 or 2 | Values according to latest criteria of OEKO-TEX class 1 or 2 |