

Quality Assurance Handbook (Products)
Product Category 2.1 Work Wear (WWS), Supporting Material,
2.1_2 Fabric Specific Requirements, Minimum Values for Knitted
materials and garments,
Revision 1.0 /19.11.2025

	Knitted Materials	
	>50 % PES	< 50 % PES
Fibre 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	Max +/- 5.0 %	Max +/- 6.0 %
Weft	Max +/- 5.0 %	Max +/- 6.0 %
Pilling Washing 25 times according to ISO 15797, and check visually afterwards	Grade 3/4	Grade 3/4
Color fastness to artificial light: xenon arc fading lamp test ISO 105 B02:2014 Color Change	Grade 4–5	Grade 4–5
Color Fastness to Rubbing ISO 105-X12:2016 Dry rubbing Wet rubbing	Grade 4 Grade 3	Grade 4 Grade 3
Colour fastness to laundering ISO 105-C06:2010 (E2S Multifibre) staining cotton and PES color change	Grade 4 Grade 4	Grade 3/4 Grade 3/4
Colorfastness to Perspiration ISO 105-E04: 2013 Color Change (Acid/ Alkaline) Color Staining	Grade 4 Grade 3/4	Grade 4 Grade 3/4
Colour fidelity of textiles ISO 105-A02:1993 Grey scale CIELAB	Grade 4 Grade 1.7	Grade 4 Grade 1.7
The torsion/twisting angle	< 5 % deviation	< 5 % deviation
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