

**Quality Assurance Handbook (Products)**  
**Product Category 2.1 Work Wear (WWS), 1.11.2018/31.8.2015**  
**Supporting Material 2.1 - 3.1.2\_2**  
**Minimum Values for Fabrics that Contain Less than 50% of PES**

	<b>&lt; 50 % PES</b>	
	<b>&lt; 240 g/m<sup>2</sup></b>	<b>≥ 240 g/m<sup>2</sup></b>
<b>fibre content</b> ISO 1833:1977	max +/- 3.0 %	max +/- 3.0 %
<b>finished weight</b> ISO 3801:1977	max +/- 5.0 %	max +/- 5.0 %
<b>yarn count</b> ISO 2060:1994	as notified	as notified
<b>dimensional stability after wash</b> ISO 5077:2007 (after 5 washes)		
warp	max +/- 4.0 %	max +/- 4.0 %
weft	max +/- 3.0 %	max +/- 3.0 %
<b>pilling</b> ISO 12945-2:2000 (5000 rev.)	grade 3 – 4	grade 3 – 4
<b>tensile strength</b> ISO 13934-1:1999 (strip method)		
warp	500 N	700 N
weft	400 N	500 N
<b>tear strength</b> EN ISO 13937-2		
warp	22 N	30 N
weft	30 N	25 N
<b>color fastness to rubbing</b> ISO 105-X12:1995		
dry rubbing	grade 4.0	grade 4.0
wet rubbing	grade 3.0	grade 3.0
<b>color fastness to laundering</b> ISO 105-C06:1994 (E2S Multifibre)		
staining cotton and PES	grade 3.0	grade 3.0
colour change	grade 3.0	grade 3.0
<b>color fidelity of textiles</b> ISO 105-A02:1993		
grey scale	grade 4.0	grade 4.0
CIELAB	grade 1.7	grade 1.7