



# Denim Shirts

## Thread and zip recommendations for denim shirts

Coats is the world's largest sewing thread manufacturer. Over the past 250 years Coats has built a reputation as a company that delivers high quality sewing threads in a huge range of substrates, sizes and colours to meet all of your sewing requirements.

Alternative thread types may be used depending on required final quality. The thread size will determine the choice of needle size.






### Coats threads & zips

Coats offer an extensive variety of threads and zips for denim shirts. Please see our [thread recommendations](#) and [zip recommendations](#) below.








## Premium Woven Casual Soft Wash

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty	24	120	Dual Duty	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Dual Duty	40	75	Dual Duty	40	75	90 - 110
3		Five thread overlock	516	10 - 12	Dual Duty	24	120	Dual Duty	24	120	70 - 90
4		Bartack	304-5	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90





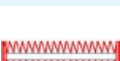
## Premium Woven Special Finishes

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty True Indigo	24	120	Dual Duty True Indigo	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Dual Duty True Indigo	40	75	Dual Duty True Indigo	40	75	90 - 110
3		Five thread overlock	516	10 - 12	Dual Duty True Indigo	24	120	Dual Duty True Indigo	24	120	70 - 90
4		Bartack	304-5	-	Dual Duty True Indigo	24	120	Dual Duty True Indigo	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty True Indigo	24	120	Dual Duty True Indigo	24	120	70 - 90





## Premium Woven Bleach Resistant Shades

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty Rugged	24	120	Dual Duty Rugged	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Dual Duty Rugged	40	75	Dual Duty Rugged	40	75	90 - 110
3		Five thread overlock	516	10 - 12	Dual Duty Rugged	24	120	Dual Duty Rugged	24	120	70 - 90
4		Bartack	304-5	-	Dual Duty Rugged	24	120	Dual Duty Rugged	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty Rugged	24	120	Dual Duty Rugged	24	120	70 - 90






## Premium Woven Bleach resistant

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100
2		Top stitch	301x2	10 - 12	Epic Rugged	40	80	Epic Rugged	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100
4		Bartack	304-5	-	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100
5		Buttonhole	304-3	-	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100






## Premium Woven Fine Seams

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty	24	120	Dual Duty	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Gral	60	40	Dual Duty	40	75	100 - 110
3		Five thread overlock	516	10 - 12	Gral	60	40	Dual Duty	24	120	100 - 110
4		Bartack	304-5	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90

## Premium Woven Post Dyed Cotton Garments



Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty Supercotton	24	120	Dual Duty Supercotton	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Dual Duty Supercotton	40	75	Dual Duty Supercotton	40	75	90 - 110
3		Five thread overlock	516	10 - 12	Dual Duty Supercotton	24	120	Dual Duty Supercotton	24	120	70 - 90
4		Bartack	304-5	-	Dual Duty Supercotton	24	120	Dual Duty Supercotton	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty Supercotton	24	120	Dual Duty Supercotton	24	120	70 - 90

## Premium Woven Premium Quality Polyester





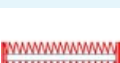
### Corespun

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Epic	30	100	Epic	30	100	80 - 100
2		Top stitch	301x2	10 - 12	Epic	40	80	Epic	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Epic	30	100	Epic	30	100	80 - 100
4		Bartack	304-5	-	Epic	30	100	Epic	30	100	80 - 100
5		Buttonhole	304-3	-	Epic	30	100	Epic	30	100	80 - 100






## Premium Woven Decorative

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Epic Multicolour	30	100	Epic	30	100	80 - 100
2		Top stitch	301x2	10 - 12	Epic Multicolour	40	80	Epic	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Epic Multicolour	30	100	Epic	30	100	80 - 100
4		Bartack	304-5	-	Epic Multicolour	30	100	Epic	30	100	80 - 100
5		Buttonhole	304-3	-	Epic Multicolour	30	100	Epic	30	100	80 - 100



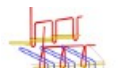

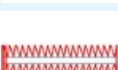
## Premium Woven Highly Extensible

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Eloflex	105	30	Eloflex	60	50	125 - 140
2		Top stitch	301x2	10 - 12	Eloflex	105	30	Eloflex	60	50	125 - 140
3		Five thread overlock	516	10 - 12	Eloflex	105	30	Eloflex	60	50	125 - 140
4		Bartack	304-5	-	Eloflex	105	30	Eloflex	60	50	125 - 140
5		Buttonhole	304-3	-	Eloflex	105	30	Eloflex	60	50	125 - 140






## Premium Woven Metallic / Polyester

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Metallic	48	80	Epic	30	100	100 - 110
2		Top stitch	301x2	10 - 12	Metallic	72	50	Epic	40	80	110 - 125
3		Five thread overlock	516	10 - 12	Metallic	48	80	Epic	30	100	100 - 110
4		Bartack	304-5	-	Metallic	48	80	Epic	30	100	100 - 110
5		Buttonhole	304-3	-	Metallic	48	80	Epic	30	100	100 - 110



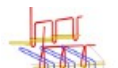

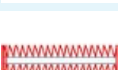
## Premium Woven Metallic / Polyester / Rayon Braid

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	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Brio Metallic	350	0.8mm	Epic	30	100	180 - 200
2		Top stitch	301x2	10 - 12	Brio Metallic	350	0.8mm	Epic	40	80	180 - 200
3		Five thread overlock	516	10 - 12	Brio Metallic	350	0.8mm	Epic	30	100	180 - 200
4		Bartack	304-5	-	Brio Metallic	350	0.8mm	Epic	30	100	180 - 200
5		Buttonhole	304-3	-	Brio Metallic	350	0.8mm	Epic	30	100	180 - 200

## Premium Woven Metallic / Polyester Corespun

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	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Epic Metallic	30	100	Epic	30	100	80 - 100
2		Top stitch	301x2	10 - 12	Epic Metallic	40	80	Epic	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Epic Metallic	30	100	Epic	30	100	80 - 100
4		Bartack	304-5	-	Epic Metallic	30	100	Epic	30	100	80 - 100
5		Buttonhole	304-3	-	Epic Metallic	30	100	Epic	30	100	80 - 100






## Premium Woven Embroidery

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
-	-	-	-	12 - 14	Sylko	27	120	Epic	18	180	75 - 90
-	-	-	-	12 - 14	Sylko Art	18	180	Epic	18	180	70 - 90
-	-	-	-	12 - 14	Sylko Metallic	27	120	Epic	18	180	75 - 90
-	-	-	-	12 - 14	EcoVerde Recycled Trilobal Polyester	30	100	Epic	18	180	80 - 100

## Premium Knitted Casual Soft Wash




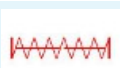

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	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Dual Duty	24	120	Dual Duty	24	120	70 - 90
2		Top stitch	301x2	10 - 12	Dual Duty	40	75	Dual Duty	40	75	90 - 110
3		Five thread overlock	516	10 - 12	Dual Duty	24	120	Gramax	35	80	70 - 90
4		Bartack	304-5	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90
5		Buttonhole	304-3	-	Dual Duty	24	120	Dual Duty	24	120	70 - 90



## Premium Knitted Bleach resistant

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100
2		Top stitch	301x2	10 - 12	Epic Rugged	40	80	Epic Rugged	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Epic Rugged	30	100	Gramax	35	80	80 - 100
4		Bartack	304-5	-	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100
5		Buttonhole	304-3	-	Epic Rugged	30	100	Epic Rugged	30	100	80 - 100

## Premium Knitted Embroidery




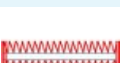
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	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
-	-	-	-	12 - 14	Sylko	27	120	Epic	18	180	75 - 90
-	-	-	-	12 - 14	Sylko Art	18	180	Epic	18	180	70 - 90
-	-	-	-	12 - 14	Sylko Metallic	27	120	Epic	18	180	75 - 90
-	-	-	-	12 - 14	EcoVerde Recycled Trilobal Polyester	30	100	Epic	18	180	80 - 100

## Standard Woven Premium Quality Staple Spun





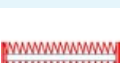
### Polyester

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Astra	27	120	Astra	27	120	75 - 90
2		Top stitch	301x2	10 - 12	Astra	40	80	Astra	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Astra	27	120	Astra	27	120	75 - 90
4		Bartack	304-5	-	Astra	27	120	Astra	27	120	75 - 90
5		Buttonhole	304-3	-	Astra	27	120	Astra	27	120	75 - 90

## Standard Woven Bleach Resistant Shades

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90
2		Top stitch	301x2	10 - 12	Astra Rugged	40	80	Astra Rugged	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90
4		Bartack	304-5	-	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90
5		Buttonhole	304-3	-	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90

## Standard Woven Embroidery






Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
-	-	-	-	12 - 14	Sylko	27	120	Astra	18	180	75 - 90
-	-	-	-	12 - 14	Sylko Art	18	180	Astra	18	180	70 - 90
-	-	-	-	12 - 14	Sylko Metallic	27	120	Astra	18	180	75 - 90
-	-	-	-	12 - 14	EcoVerde Recycled Trilobal Polyester	30	100	Astra	18	180	80 - 100

## Standard Knitted Premium Quality Staple Spun





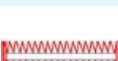
### Polyester

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	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Astra	27	120	Astra	27	120	75 - 90
2		Top stitch	301x2	10 - 12	Astra	40	80	Astra	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Astra	27	120	Gramax	35	80	75 - 90
4		Bartack	304-5	-	Astra	27	120	Astra	27	120	75 - 90
5		Buttonhole	304-3	-	Astra	27	120	Astra	27	120	75 - 90

## Standard Knitted Bleach Resistant Shades

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
1		Lockstitch	301	10 - 12	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90
2		Top stitch	301x2	10 - 12	Astra Rugged	40	80	Astra Rugged	40	80	90 - 110
3		Five thread overlock	516	10 - 12	Astra Rugged	27	120	Gramax	35	80	75 - 90
4		Bartack	304-5	-	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90
5		Buttonhole	304-3	-	Astra Rugged	27	120	Astra Rugged	27	120	75 - 90

## Standard Knitted Embroidery

Coats industrial sewing threads are available in a range of fibre types and finishes, each designed to meet particular customer needs. Please see this comprehensive range below or, if there are further thread options available, please select an option from the dropdown menu.

	Image of stitch	Machine type	Stitch type	Stitch rating per 3cm	Needle thread			Under thread			Needle size Nm
					Brand	Tex	Ticket	Brand	Tex	Ticket	
-	-	-	-	12 - 14	Sylko	27	120	Astra	18	180	75 - 90
-	-	-	-	12 - 14	Sylko Art	18	180	Astra	18	180	70 - 90
-	-	-	-	12 - 14	Sylko Metallic	27	120	Astra	18	180	75 - 90
-	-	-	-	12 - 14	EcoVerde Recycled Trilobal Polyester	30	100	Astra	18	180	80 - 100

### Zips: Opti offer

Key: CE = Closed End; OE = Open End; 2WOE = 2 Way Open End; 2WCE = 2 Way Closed End; X-Form / O-Form

Application	Opti LUX		Opti M		Opti S Invisible		Opti S	
		Specials		Specials		Specials		Specials
Fly	LUX6 CE	-	M45 CE	Cotton Tape, Contrast	S43 CE	Cotton Tape	S40 CE	-
	LUX4 CE	-	M40 CE	Cotton Tape, Contrast	S44 CE	Cotton Tape	S60 CE	-
	-	-	M60 CE	Cotton Tape, Contrast	S54 CE	Cotton Tape	-	-
Opening	LUX4 2W	-	M40 CE	Cotton Tape, Contrast	S54 CE	Cotton Tape	S40 CE	Reversed
	LUX6 2W	-	M60 CE	Cotton Tape, Contrast	S44 CE	Cotton Tape	-	-
	LUX4 CE	-	-	-	S43 CE	Cotton Tape	-	-
Pockets	LUX6 CE	-	M40 CE	Cotton Tape, Contrast	-	-	S40 CE	Lace tape
	LUX4 CE	-	M60 CE	Cotton Tape, Contrast	-	-	S60 CE	-

## Additional Information

The sewing thread recommendations laid out above are intended as a guide to aid the construction of garments with good quality seams. As garments of the same generic type differ in terms of fabric substrate and construction, and both making up methods and post make up processing can greatly vary, these recommendations should be viewed as a good starting point for thread selection.

Garment specific recommendations for thread and needle selection as well as accurate thread consumption figures and onsite technical support can be obtained by contacting your local Coats' office.

These recommendations and consumption figures are intended as a guide only and are given in good faith but without warranty or liability on the company or its employees.