

Processing Guide

Durafil Heat Soluble Thread

Best Practice for Temporary Stitching and Controlled Heat Removal

1. Purpose

Durafil Heat Soluble Thread is designed for temporary stitching applications where stitches are later removed by controlled heat.

This product is intended for use as a bobbin thread only and must never be used as a needle thread.

This guide outlines practical processing steps to help achieve efficient stitch removal, good garment appearance, and consistent production results.

2. Recommended Process Flow

1. Select suitable heat soluble thread specification.
2. Conduct sewing trial on target fabric.
3. Load Durafil Heat Soluble Thread in the **bobbin position only**.
4. Use conventional permanent thread in the needle position.
5. Apply temporary stitching only where required.
6. Complete garment assembly operations.

7. Apply controlled heat process to remove thread.

8. Inspect result.

9. Approve for bulk production.

3. Sewing Stage Guidelines

Best Practice

- Use Durafil Heat Soluble Thread in the **bobbin only**.
- Use standard sewing thread as needle thread.
- Never use heat soluble thread as needle thread due to needle heat and friction risk.
- Maintain balanced thread tension.
- Use only the amount of temporary stitching necessary.
- Avoid excessive stitch density where removal speed is critical.
- Keep thread path clean and smooth.

Operator Objective

Use the thread as a temporary holding tool, not as a permanent seam thread.

4. Garment Construction Guidance

Apply thread only in areas where temporary holding is needed, such as:

- Lapels
- Pleats
- Pocket positioning
- Hem folds
- Collar positioning
- Temporary alignment areas

Use as **bobbin thread only** in suitable stitch constructions.

Minimise unnecessary usage to improve processing efficiency.

5. Heat Removal Stage

Heat activates melting of the bobbin thread.

Typical heat sources:

- Steam press
- Flat press
- Ironing station
- Tunnel finisher
- Other controlled thermal systems

6. Critical Process Variables

Variable	Effect
Temperature	Primary factor in thread melting
Exposure Time	Longer exposure improves removal
Fabric Thickness	More layers may require more heat
Moisture / Steam	May improve heat transfer
Pressure	Can improve heat contact
Garment Construction	Dense areas may require adjustment

7. Trial Procedure (Strongly Recommended)

Before bulk production:

1. Sew sample garment using heat soluble thread in bobbin only.
2. Use normal needle thread.
3. Apply planned finishing heat process.
4. Check thread disappearance.
5. Check residue level.
6. Check fabric appearance.

7. Adjust settings if required.

8. Record approved conditions.

8. Common Processing Problems

Problem	Likely Cause	Corrective Action
Thread remains visible	Insufficient heat	Increase temperature or dwell time
Partial removal	Uneven heat exposure	Improve contact or repeat process
Needle thread breakage of soluble thread	Incorrect use as needle thread	Use only in bobbin position
Fabric marking	Excessive heat	Reduce temperature or protect fabric
Slow removal	Too many stitch layers	Reduce stitch density
Residue concern	Process not optimised	Review settings and application method

9. Productivity Guidance

For best efficiency:

- Use thread only where needed
 - Use in bobbin position only
 - Standardise approved settings
 - Train operators
 - Run sample checks each shift
 - Avoid over-processing garments
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10. Fabric Compatibility

Always trial first, especially on:

- Heat-sensitive synthetics
- Delicate fabrics
- Coated fabrics
- Dark shade shine-sensitive fabrics
- Multi-layer structured garments

11. Important Note

Durafil Heat Soluble Thread is designed for **bobbin thread use only** and must never be used as a needle thread.

Final performance depends on thread type, garment construction, fabric type, heat method, operator discipline, and process control.

Users are responsible for testing, process adjustment, and validation before production.

12. Contact for Technical Support

Email: info@durafil-group.com