Product Catalogue

Embroidery Threads and Accessoires for the Industry



EMBROIDERY THREADS

E-ZEE

ACCESSOIRES

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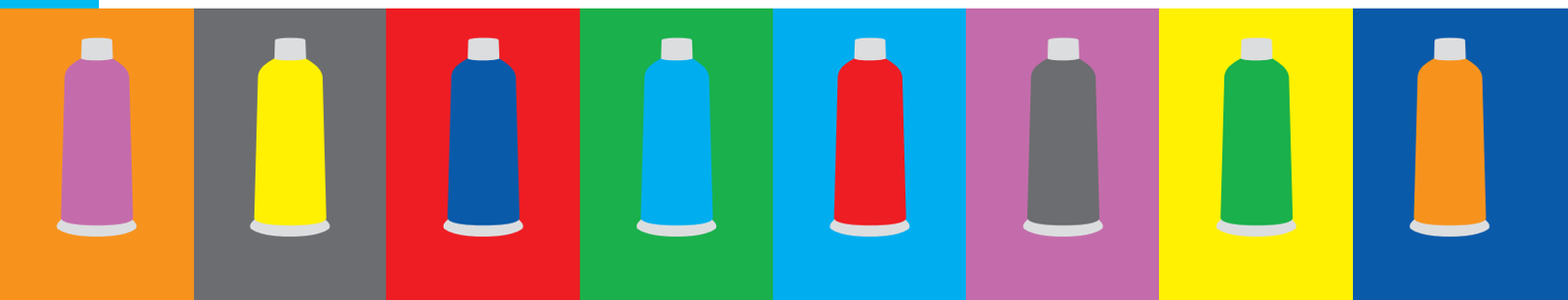
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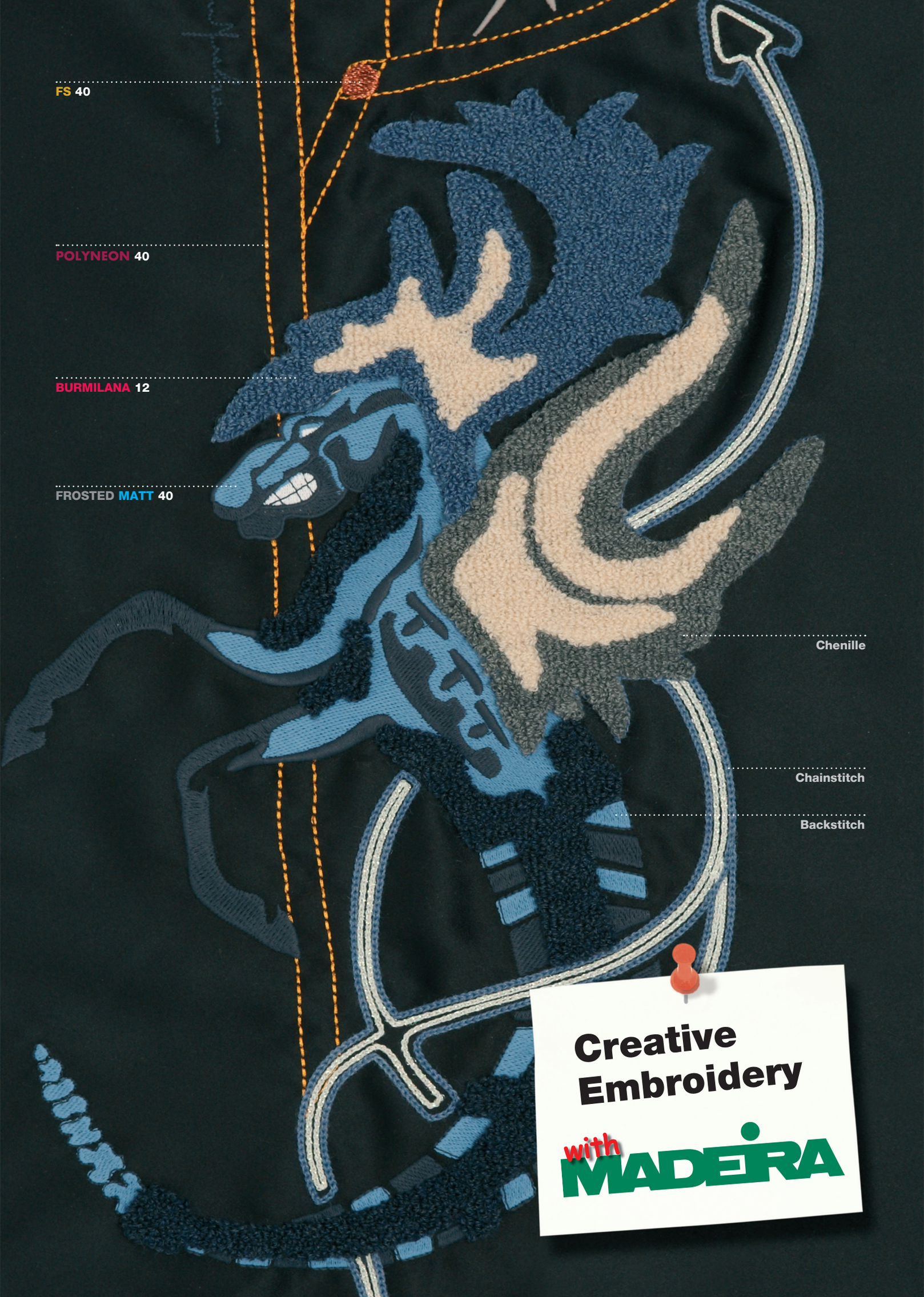
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Creative Embroidery
with MADEIRA

Viscose/Rayon Embroidery Thread



CLASSIC

CLASSIC viscose embroidery thread is made from the highest quality raw material rayon, giving a stunning yet subtle sheen finish to perfectly complement the embroidery.
CLASSIC viscose is literally the ideal embroidery thread. Four thicknesses (60, 40, 30 & 12) are available and in over 400 colours, including Ombre, Multi colour and Astro shades. The extreme softness and flexibility prevents loop formation and allows stitches in all directions.
CLASSIC viscose embroidery thread produces soft, elegant embroideries with a natural looking lustrous sheen.
Tests have shown that CLASSIC viscose thread can comfortably run at high speeds of 1200 stitches per minute. During testing, CLASSIC rayon averaged 400.000 stitches without a thread break. The super soft CLASSIC even protects needles and thread cutters from rapid wear and tear.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
DEKRA certified

CLASSIC No. 40

dtex 135 x 2
den 120 x 2

Art. No. 910
10 x 5000 m

Art. No. 911
10 x 1000 m

100 % viscose

65/#9 - 75/#11

387 single colours
19 ombré colours
6 multicolors
10 astro-color

CLASSIC No. 30

dtex 200 x 2
den 180 x 2

Art. No. 921
10 x 3000 m
black white

Art. No. 914
10 x 25 g

100 % viscose

75/#11

178 single colours

CLASSIC No. 60

dtex 84 x 2
den 75 x 2

Art. No. 915
10 x 1500 m

100 % viscose

60/#8 - 65/#9

85 single colours

CLASSIC No. 12

dtex 330 x 2
den 300 x 2

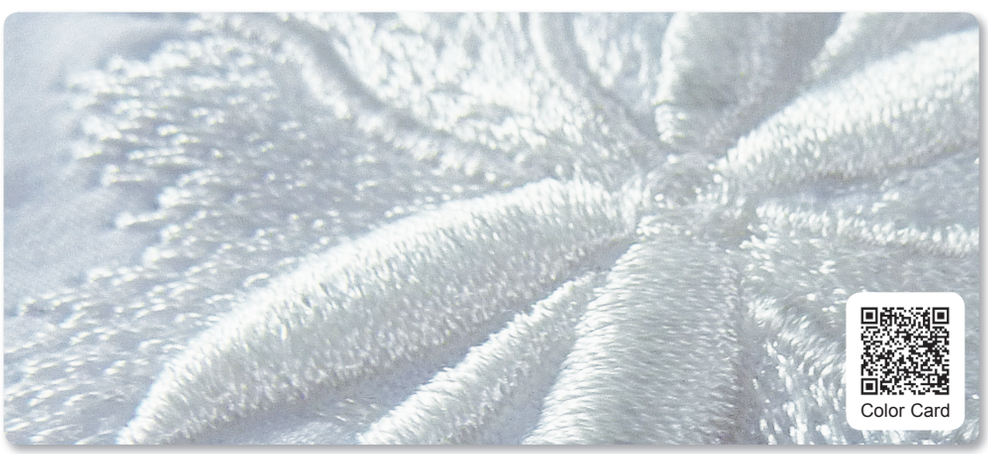
Art. No. 920
10 x 2000 m

100 % viscose

100/#16

57 single colours

CLASSIC No.12 is ideal for overlocking, festoon work and decorative stitching.





CLASSIC viscose embroidery thread produces soft, elegant embroideries with a natural looking lustrous sheen.

Embroider fine details and small lettering. MADEIRA's fine viscose thread **CLASSIC No. 60** and polyester threads **POLYNEON No. 60** and **POLYNEON No. 75** provide the opportunity to create the best small lettering and fine detailed embroidery.

1. The design should be digitised specifically for a 60/75s thickness thread, whether for a part or whole of the design. Always advise your digitiser if you will be using a fine 60 (50) thread for a part or entire design. The design should then be digitised accordingly.
2. The correct NEEDLE for 60s thickness embroidery thread is a size 60/8 - 65/9, for 75s thickness embroidery thread is a size 60/8.
3. The thread tension has to be adapted to the 60s/75s thread thickness. If you are embroidering lots of small lettering and fine details, we recommend to change the needle size.
4. If you are embroidering Piqué Shirts etc. it's a good idea to step stitch a base in a tone on tone thread to improve the quality of the fine designs.
5. The absolute minimum size lettering using standard 40 thickness thread is 6-7mm. With 60s thickness, this can be reduced to 3mm, without losing design clarity. With 75s thickness you can achieve lettering smaller than 3 mm!
6. The colours available in 60s thickness are marked with blue dots on the CLASSIC and POLYNEON shadecards. Yellow dots on the POLYNEON shadecard mark the 75s thickness.

MADEIRA also offers the metallic thread FS No. 50 which is also suitable for very fine lettering and details.

Small lettering on various materials



PolyNeon 60 on loose knit fabric
(see point 4 above)



PolyNeon 60 on fine twill fabric



Polyneon 75
fine details
(Original size)

Comparison strengths 40 and 60



Classic 40 (702 stitches)



Classic 60 (723 stitches)

Fine details in matte and metallic thread



Frosted Matt 40



FS

Advantages + benefits = extra added value

CLASSIC No. 30

When embroidering large areas of a design, it is recommended to work with the thicker thread, CLASSIC no. 30. Its voluminous characteristics reduce **stitches** and **embroidery times**.

Examples:



Illustration 1



Illustration 2

The design in illustration 1 has been embroidered with thread count No. 40. Total stitches: 5.942. The yellow area of the design in illustration 2 has been punched for thread count No. 30. Total stitch count in the embroidery is 4.805 (around 20% fewer stitches!).

Production time saved on each design is 1,5 minutes, calculated on the basis of a machine speed of 900 stitches/min. Due to its higher coverage, the count No. 30 allows stitches to be saved.

CLASSIC No. 30 is available in 178 single colours. These are marked with a red dot on the MADEIRA CLASSIC shade card. CLASSIC No. 30 can be easily embroidered using the standard needle size 75/11.

We would be delighted to send you samples of CLASSIC No. 30 on request.

Polyester Embroidery Thread



POLYNEON

95°C △ max. 20g/l active chlorine - max. 30°C - max. 30min

POLYNEON is resistant to chlorine and bleach so is therefore the perfect embroidery thread for stone wash items and frequent or heavy duty wash fabrics such as jeans, sportswear, children‘s wear, workwear, hotel and catering items.

POLYNEON No. 40 is the standard thickness for all types of embroidery and is available in 433 colours.

POLYNEON No. 40 FR is an innovative, flame retardant thread for embroidering logos or letters onto flame retardant textiles such as Workwear, Curtains, Car Seats and wherever effective flame retardant properties are required.
(Where extra fire resistant properties are necessary, for example on Fire Protection Clothing, MADEIRA’s FIRE FIGHTER, made from 100 % Aramid is essential and satisfies safety standards. Details see page 18)

POLYNEON No. 60 is finer than thread count 40. It creates perfect clarity in fine lettering and small details of text, monogram, emblems and badges. Available in 101 colours!

POLYNEON No. 75 is the finest polyester embroidery thread. It is perfect for attaching sequins and for producing the finest detailed letters and intricate filigree embroideries.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
www.dekra-seal.com
DEKRA certified

POLYNEON No. 40

dtex 135 x 2
den 120 x 2

Art. No. 918
10 x 5000 m

Art. No. 919
10 x 1000 m

100 % polyester filament

60/8 - 75/11

389 single colours
20 multi colours
24 fluorescent colours

POLYNEON FR

dtex 135 x 2
den 120 x 2

Art. No. 933
10 x 2500 m

100 % polyester filament

60/8 - 75/11

30 single colours
4 fluorescent colours

POLYNEON No. 60

dtex 84 x 2
den 75 x 2

Art. No. 924
10 x 1500 m

*Art. No. 926
10 x 5000 m
black white

100 % polyester filament

60/8 - 65/9

94 single colours
7 fluorescent colours
*** 2 colours (black & white)**

POLYNEON No. 75

dtex 55 x 2
den 50 x 2

Art. No. 936
10 x 2500 m

*Art. No. 935
10 x 10000 m
black white

100 % polyester filament

60/8

83 single colours
5 fluorescent colours
*** 2 colours (black & white)**





MADEIRA

Metallic Embroidery Threads



FS

FS No. 30

95°C △ max. 20g CL/l - max. 30°C - max. 30 min.
Peroxide: max. 10ml/L H_2O_2 35% - max. 50°C - max. 20 min.

FS No. 50, 45, 40, 20 and 15

60°C

Genuine metallic shine or metallic effects for selected clothes, bags, shoes, logos, badges and much more. In addition to classic golden or silver threads, MADEIRA offers the world's widest colour palette, count and texture range - which is perfect for all fashion trends. Highlights are ultra fine metallic thread, thick and textured appearances, metallic thread resistant to chlorine, two tone, antique-style, multicolours, metallic fashion colours and with metallic effects from subtle matt, fine and classic colours and right through to rich glitter.

FS No. 50

Art. No. 987
5 x 1000 m

Art. No. 988
10 x 5000 m

dtex 150 den 135

55 % metallised polyester
45 % polyamide

65/9 - 75/11

8 single colours

FS No. 45

Art. No. 997
10 x 5000 m

dtex 220 den 200

25 % metallised polyester
75 % polyester

90/14
80/12 (special needle with a size 90 eye)

26 single colours

FS No. 40

Art. No. 985
5 x 1000 m

Art. No. 986
10 x 5000 m

dtex 220 den 200

40 % metallised polyester
35 % polyamide, 25 % cellulose
Astro-Colours:
45 % viscose / 55 % met. polyester

65/9 - 75/11

20 single colours

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
95.0.5859 Hohenstein

Quality Management ISO 9001
DEKRA certified

FS No. 30

Art. No. 980
10 x 5000 m

Art. No. 979
10 x 2500 m

dtex 320 den 290

50 % metallised polyester
50 % polyester

90/14
80/12 (special needle with a size 90 eye)

DENIMWASH

13 single colours

FS No. 20

Art. No. 981
5 x 20 g

Art. No. 974
10 x 100 g

dtex 360 den 320

20 % metallised polyester
80 % viscose

100/16

32 single colours

Usage:

For optimum embroidery production, we recommend MADEIRA needles which are crafted for use with our threads. If a different needle system is used, please select a larger size than shown on the list.

FS No. 15

Art. No. 989
5 x 20 g

Art. No. 990
10 x 100 g

dtex 660 den 590

35 % metallised polyester
65 % polyester

100/16

16 single colours

FS No. 12

Art. No. 999
10 x 1200 m

dtex 830 den 750

50 % metallised polyester
50 % polyester

100/16 - 110/18

6 single colours

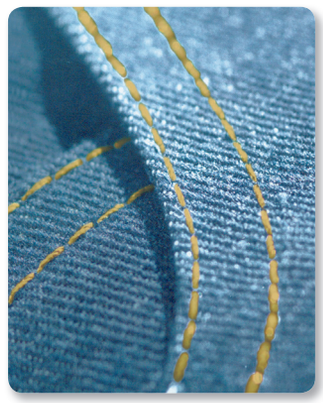
DENIMWASH

Color Card



MADEIRA

Metallic Sewing Threads



FS

FS No. 12 and 8



△ max. 20 g CL/l - max. 30 °C - max. 30 min.
Peroxide: max. 10 ml/L H_2O_2 35 % - max. 50 °C - max. 20 min.

FS No. 15 and 10



Metallic look and sensational appearance - 4 metallic effect threads specially designed for use on sewing and special machines. These threads of 3 or 5 ply, show an extreme tensile strength and offer a completely new look. The stylish colours range from bright white diamond to mysterious graphite.

FS No. 15

Art. No. 989
5 x 20 g

Art. No. 990
10 x 100 g

dtex 660 den 590

35 % metallised polyester
65 % polyester

100/16

16 single colours

FS No. 12

Art. No. 999
10 x 1200 m

dtex 830 den 750

50 % metallised polyester
50 % polyester

100/16 - 110/18

6 single colours

DENIMWASH

FS No. 10

Art. No. 993
5 x 20 g

Art. No. 994
10 x 100 g

dtex 1050 den 950

35 % metallised polyester
65 % polyester

110/18 - 130/22

10 single colours

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
95.0.5859 Hohenstein

Quality Management ISO 9001
www.dekra-seal.com
DEKRA certified

FS No. 8

Art. No. 998
10 x 800 m

dtex 1400 den 1250

50 % metallised polyester
50 % polyester

120/20 - 130/22

7 single colours

DENIMWASH





MADEIRA

FS 40 Metallic thread will perform perfectly, just like CLASSIC 40 or POLYNEON 40, if you follow these few guidelines for trouble free embroidery and for professional results.

1. Machine:

as for any thread, check thread guides are free from rough spots, bobbin cases are clean

2. Machine speed:

with FS40 – normal speed up to **900** stitches per minute

3. Position:

1000m spools must be placed so the thread runs in a **CLOCKWISE** direction

4. Tensions:

no change for cones, loosen bobbin tension slightly for small spools

5. Needle:

ideally fresh and new, to prevent any burrs catching the thread

6. Needle size:

your standard needle for 40s thread dependent on fabric & embroidery application

7. Fabric:

any & all

8. Embroidery design:

same as for CLASSIC 40 or POLYNEON 40

9. Digitising:

punching parameters for standard 40 weight thread, select 'metallic' option if available

10. Stitch lenght:

3mm – 8mm

11. Density:

0.4mm

12. Backings:

choose backing to suit fabric but remember – **less is more!!**



Follow these easy hints for other MADEIRA metallic threads:

Due to their complex structure, metallic threads may not unwind as softly as standard rayon or polyester embroidery threads. **MADEIRA can provide useful hints:** The practical cone nets (fig. 1) ensure steady unwinding from the reel. The spool tops (fig. 2+3) provide a larger unwinding diameter for spools.

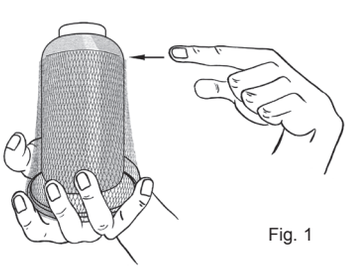


Fig. 1

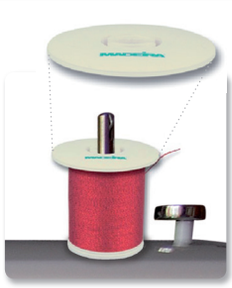
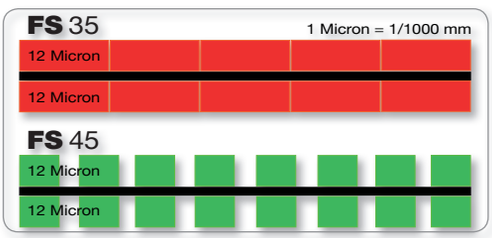


Fig. 2

Fig. 3

Tips for Punching and Embroidering with FS 45

Some customers are confused with the “45” thread count, especially if they compare the dtex of FS 40, FS 35 and FS 45. The weight of FS 45 (and this is what the dtex tells) is the same as FS 40 but the volume of the thread can be compared with FS 35. This means the thickness/volume of the FS 45 thread is very similar to the FS 35 but the FS 45 has less metallic than its other family members FS 40 and FS 35.



The following pictures display in theory how the thread would look when cut lengthwise in half.

The micron thickness of the metallic wrapping on the FS 35 and FS 45 is the same, but the distance between the wraps on the FS 45 is larger. The FS 45 shows more of the core thread than all the other MADEIRA FS metallic series.

How to Punch for FS 45

You can use the same stitch distance as for FS 40 which is 4.0 - 0.4, based on one tenth of a millimeter. The problems begin when the stitch distance of the underlay stitches is too dense or too many layers of underlay are used. Short stitches are also a problem - stitches < 2 mm for FS 45 are a problem and this shows up when being sewn on larger machines with multiple heads. The stitch length for FS 45 is best when set at 3 mm in length for fillings or for running stitches. If you are having problems even when the stitch length is at 3 mm then you must check to see if in the underlay or on the border of the fillings, there are small stitches which are 1 mm or under. This happens with most automatic stitch programs - the underlay or the stitches on the border of fillings can become too short in some areas. If this is the case, you must edit them out but only in the places of the design where the thread on the machine is breaking.

FS 45 is not recommended for small lettering or designs with thin elements which are 1 mm wide because of the threads thickness.

Embroidering with FS 45

The needle size used must be a number 90 because FS 45 is as thick/voluminous as the FS 35. Smaller needle sizes do not have a large enough eye needed for the thread to be pulled up and down through the different types of fabrics. Alternatively, you can use the MADEIRA special needle strength 80 with a size 90 eye.
Thread Tension should be less than for standard thread types. Thick stiff backing can in some cases cause problems, because the metallic foil can be caught on the fibers of the backing and pull the foil away from the core thread. The machine speed should be slowed down to 700 - 850 per minute.



If you would like to try the FS 45 thread, please feel free to ask for thread samples and free test programmes (in .dst format) from MADEIRA!

Metallic Embroidery Threads



Her comes the chunky glitter!

SUPERTWIST

MADEIRA‘s unique metallic effect thread with amazingly deep structured colour shades and textures, glittering reflections, metallic effects... Whether embroidered solely or in combination with the wool style BURMILANA embroidery thread or the CLASSIC rayon embroidery thread, SUPERTWIST will make your embroidery even more attractive.
The colour range extends from bright plain colours to multicolour variations right through to the soft shades of opal colours.
Opal and Crystal colours are now suitable for denim wash! DENIMWASH

SUPERTWIST 30 - 125 individual colour shades enable the implementation of brilliant designs and, by means of their amazing surface effects, the creation of selected variations meeting the highest requirements. Make your statement with MADEIRA Metallic threads!

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
95.0.5859 Hohenstein

Quality Management ISO 9001 www.dekra-seal.com DEKRA certified

SUPERTWIST
No. 30

Art. No. 983 multicolour opal crystal
5 x 1000 m

Art. No. 982 multicolour opal
10 x 5000 m

dtex 180 den 160

30 % metallised polyester
70 % polyamide

90/14
80/12 (special needle with a size 90 eye)

68 single colours
11 multicolours
16 opal colours
26 crystal colours





Wool Effect Embroidery Thread



BURMILANA 12

BURMILANA is a speciality embroidery thread which has the characteristics and appearance of wool, giving a hand-crafted look. It is particularly suitable for stitching onto knitwear and looks beautiful as chenille, loop pile or chain stitch embroideries.

For fashion, knitted goods, ethnic, country style or traditional folk costumes, embroidery with BURMILANA completes the ‚wool on wool' natural effect.

Special Considerations:

Please ensure the design is specially digitised taking into consideration the additional coverage and reduction in stitch count generated by the thickness and texture of BURMILANA.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
95.0.4921 Hohenstein

Quality Management ISO 9001
DEKRA certified

BURMILANA

No. 12 dtex 330 x 2
den 300 x 2

Art. No. 813
10 x 1000 m

50 % wool / 50 % acrylic

100/16

135 single colours
12 mélangé colours



Wool characteristics of Burmilana.



Special effects with Burmilana.



Wool Effect Embroidery Thread



BURMILANA CO

BURMILANA CO is available in the same thread count as BURMILANA 12, but it is a cotton acrylic blend - this makes it the perfect complement to the famous wool blend. Very soft and cool due to the high cotton content, the perfect alternative for a fresh and summery look.

All 72 colours are certified according to Oeko-Tex Standard 100 Class 1 (Baby-Standard!). BURMILANA CO is, of course, also ideal for decorative seams, Chenille embroidery and chain stitch.

Special Considerations:

Please ensure the design is specially digitised taking into consideration the additional coverage and reduction in stitch count generated by the thickness and texture of BURMILANA.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
DEKRA certified

BURMILANA CO

No. 12 dtex 330 x 2 / den 300 x 2

Art. No. 816
10 x 1000 m

50 % Cotton / 50 % acrylic

100/16

65 single colours
7 mélangé colours





MADEIRA

...stitch with BURMILANA 12/CO

The special effect wool mix BURMILANA 12/CO thread enables you to produce beautiful designs with an almost handstitched appearance. If you have never used BURMILANA 12/CO before, you will be pleasantly surprised by the results!

Because it is thicker, and of a different texture to most threads in every day use, there are several points we would like to advise you of, to ensure optimum results when stitching with BURMILANA12/CO:

1. **DIGITISING**
   BURMILANA is a number 12 thickness thread. Most designs are digitised for a standard No 40 thickness of thread, unless you advise the digitiser otherwise! Therefore, please ensure your design has been correctly digitised for BURMILANA 12/CO.
2. **NEEDLES**
   Recommended needles are MADEIRA No 100. MADEIRA needles are specially produced for embroidery machines and have an elongated eye. This means thicker threads can pass through this elongated eye easier than through standard needle eyes. Since BURMILANA 12/CO is often used on knitwear, sweats, etc, our light ballpoint system R-SUK/-FG is the ideal needlepoint.
3. **CARE**
   BURMILANA 12/CO can be washed up to 40°C.
4. **MACHINE SETTINGS**
   BURMILANA 12/CO is so much thicker than a standard 40 rayon or polyester thread, therefore machine speeds need to be slightly reduced. And of course tensions should be adjusted to accommodate the difference in thickness and texture.



Design with MADEIRA CLASSIC No. 40 rayon embroidery thread.



Design with BURMILANA No. 12 ‚wool mix' heavier weight embroidery thread.

Polyester Embroidery Thread - Totally matt!



FROSTED MATT No.40

FROSTED MATT - the world's first truly matt and light-fast embroidery thread brings a new sensation to the perception of colours and new highs to fastness to light. Due to the unique construction and the special finish this embroidery thread reflects the true colours intensively with enormous coloring power.
Due to highest possible dyeing methods **FROSTED MATT** has an unmatched overall rating to fastness to light. Colours remain and don't fade easily, as others do.
FROSTED MATT is easy to wash and care for and has high fastness to light. So, it can be used in all sectors. Due to the absence of a shiny effect, the embroideries realised with **FROSTED MATT** show an unmatched clarity.
FROSTED MATT allows even more creativity in the development of embroidery designs, as now it is possible to combine matt and shiny threads, achieving amazing contrasts.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
www.dekra-seal.com
DEKRA certified

60°C
△ max. 20g/l active chlorine - max. 30°C - max. 30min

FROSTED MATT
No. 40 dtex 90 x 2 / den 80 x 2
Art. No. 940
10 x 2500 m

96 % PES / 4 % ceramic

60/8 - 75/11

176 single colours
13 fluorescent colours

Special features:
The thread is defined with regard to punching technology as count No. 40.
However, due to its unique structure, it might be necessary in certain cases to increase the stitch density for optimum results.

Washing instructions:
Do not tumble dry unless the item has been thoroughly rinsed. Never leave damp embroidered items folded or pressed together.

Storage:
High temperatures, direct heat, humidity and sunlight must be avoided when embroidery threads are stored.

Remove stains:
only with solvents that do not contain bleaching or discolouring agents. Wash embroidered items immediately after using any stain remover.

Iron:
On the reverse side or place the item between two cloths.





MADEIRA

Glow in the dark thread



LUNA

Makes embroideries glow in the dark, as **LUNA** stores the light, emitting it in the dark. The luminous power of the thread depends on the intensity of the light. A new technology makes **LUNA** glow in the dark, time after time and much longer than other glow in the dark threads. Thanks to its composition, **LUNA** is soft and kind to the skin and it can be used as a 40 weight thread.
To emphasize single parts of the embroidery: from outdoor, children´s wear, Halloween and carnival costumes. Washing resistant. Works with all embroidery designs. **LUNA is now suitable for Denim-Wash!**

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
www.dekra-seal.com
DEKRA certified

LUNA dtex 150 x 2
den 135 x 2

60°C △ ⊡ P

△ max. 20g/l active chlorine - max. 30°C - max. 30min

Art. No. 996
10 x 750 m

approx. 60% polybutylene terephthalate (PBT)
approx. 40% polypropylene (PP)

75/11 - 80/12

DENIMWASH

1 single colour: off white (glows in the dark greenish)







MADEIRA

Flame & heat resistant embroidery thread



FIRE FIGHTER

MADEIRA's new FIRE FIGHTER thread does not catch fire but sparks trends! FIRE FIGHTER No. 40 is a flame and heat resistant embroidery thread which is indispensable to motor sport clothing, workwear and protective clothing. FIRE FIGHTER No. 40 is also used to embroider seat cushions of airplanes and wherever special safety aspects are essential.
FIRE FIGHTER No. 40 is made from 100 % aramid, the fibre used for NOMEX®. It is normally difficult to dye 100 % aramid efficiently but through our Research & Development, MADEIRA has succeeded in producing a range of 24 rich and popular colours. MADEIRA's quality ensures good running properties and FIRE FIGHTER complies with ISO standards ISO-6941 / ISO 15025. Resulting in confidence and power for the sponsors.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
95.0.4921 Hohenstein

FIRE FIGHTER contains NOMEX® branded fibres from Du Pont®. NOMEX® is a registered trade mark of Du Pont®.

Quality Management ISO 9001
www.dekra-seal.com
DEKRA certified

Special features:
Due to the particular thread texture, the make-up is 950 m per spool - it would not be possible to wind up 1000 m of this thread onto one spool.

Color Card

FIRE FIGHTER No. 40

dtex 130 x 2
den 120 x 2

60°C △ max. 20g/l active chlorine - max. 30°C - max. 30min

Art. No. 922
10 x 950 m
100 % aramid
75/11 - 80/12
24 single colours

Art. No. 929
10 x 2500 m
100 % aramid
75/11 - 80/12
24 single colours

When using FIRE FIGHTER, don't forget to ensure the bobbin thread is also suitably flame resistant. MADEIRA's special 100 % aramid bobbin thread is available on 5000 m cones and it is recommended for use with FIRE FIGHTER.



FIRE FIGHTER Bobbin Thread

Art. No. 923
10 x 5000 m
100 % aramid
Colour: black & white

E-ZEE FIRE FIGHTER

Highly flame-resistant embroidery backing for flame retardant protective clothing. A light, breathable, form-stable and tear-resistant special fabric made from 100 % aramid. Available in two types in natural yellow material.

Weight: 55 g/m²
Rolls of 20 cm x 50 m / Art.No. 051FF525
Rolls of 100 cm x 50 m / Art.No. 051FF515

MADEIRA

Be transparent!



MONOLON

MONOLON is a transparent monofilament for amazing embroidering ideas, great for creating extraordinary highlights within a thread mix. Filigree designs will have a translucent effect, sometimes difficult to master with dense colours.

Developed originally to fix cord threads and sequins, MADEIRA's MONOLON offers the possibility to realize even more unique embroidery designs.

CONFIDENCE IN TEXTILES
Tested for harmful substances
according to Oeko-Tex® Standard 100
94.0.6007 Hohenstein

Quality Management ISO 9001
DEKRA certified

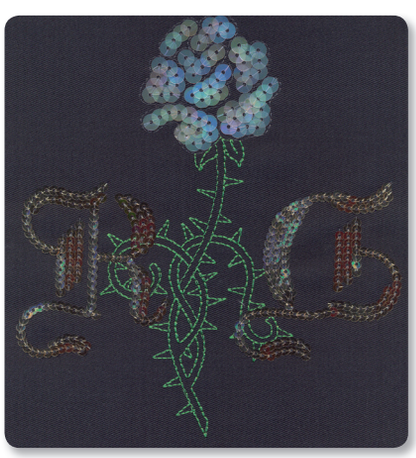
MONOLON dtex 66 den 60

Art. No. 801
10 x 15000 m
100 % polyamide

65/9

2 single colours: transparent and smoke







High Quality Underthreads

BURMILON



95°C △ max. 20g/l active chlorine - max. 30°C - max. 30min

BURMILON No. 200

Art. No. 305
7500 m
dtex 150 / den135

100 % polyester

Black & White

BURMILON No. 120/2

Art. No. 301
7500 m
dtex 80 x 2 / den 72 x 2

100 % polyester

Black & White

Bobbin Thread No. 150

Art. No. 315
15000 m
dtex 110 x 2 den 100 x 2

100 % polyester

Black & White

Quality Management ISO 9001 www.dekra-seal.com DEKRA certified

BURMILON 200: An extremely fine underthread which means minimum spool changes are required. Please note, for optimum performance, adjustments to the machine may be necessary!

BURMILON 120/2: The absolute classic! The top seller in MADEIRA‘s underthread range.

Bobbin Thread 150: This underthread is available on cones of 15000 m.

PREWOUND BOBBINS

ROYAL

papersided

Art. No. 307
120 m/spool
dtex 75 x 2 / den 68 x 2

100 % polyester

Black & White

144 spools per box

MAGNETIC SIDED BOBBINS

with magnetic side window

Art. No. 308
about 125 m/spool
dtex 70 x 2 den 65 x 2

100 % polyester

Black & White

144 spools per box

MAGNA GLIDE

with magnetic core, not papersided

Art. No. 310
about 120 m/spool
dtex 75 x 2 / den 68 x 2

100 % polyester

Black & White

100 spools per box

ROYAL: No winding from large cones! Prewound bobbins are practical, always ready to use and have the same amount of thread on each bobbin, which means all bobbins can be changed at the same time without wastage.

MAGNETIC SIDED BOBBINS: With magnetised side window, which causes a larger running rest and prevents possible loops.

MAGNA GLIDE: Like ROYAL, but with magnetic core and not papersided.

Guidelines for Underthread use:
For standard length stitches the general rule for underthread requirement is around 3 m per 1000 stitches. Upper thread: You can expect approximately 5 m per 1000 stitches.

Correct thread tension:
A perfectly tensioned embroidery with standard length stitches should have around one third of the underthread visible on the stitches underneath!

MADEIRA

For your embroidery sampling

ASSORTMENT BOXES



CLASSIC



POLYNEON



FROSTED MATT



BURMILANA

Five reasons why we recommend you select the Madeira Assortment Boxes:

1. There‘s always the perfect choice and combination of colours for sampling!
2. The colour assortments contain full size 1000 m MSC (Mini-Snap-Cone)#. Sampling is therefore adaptable and immediate, even with colours you do not normally hold in stock!
3. Colour matching from an actual spool is even easier than from the shadecard!
4. A spool can be laid directly onto the fabric and the colour match will not be compromised by surrounding colours, as in shadecard matching!
5. Each colour is stored in its own numbered compartment within the drawer unit. Corresponding shade numbers are printed on the top of the unit, in drawer and section order providing a complete overview of all colours within and any to be replaced are easily identified!

A practical working tool for every day use, clean and well organised!
The complete range of CLASSIC consists of box A, B and C.
The complete range of POLYNEON consists of box A, B and C;
for FROSTED MATT of box A and X and for BURMILANA just Box A.

We offer sample kits for the following qualities of embroidery thread:

Viscose thread **	CLASSIC No. 40 387 colours (1000 m)	Box A 005CL4A 42,8 x 17 x 53,6 cm (BxHxT)	Box B 005CL4B 42,8 x 17 x 53,6 cm (BxHxT)	Box C 005CL4C 42,8 x 6,8 x 53,6 cm (BxHxT)
Polyester thread **	POLYNEON No. 40 413 colours (1000 m)	Box A 005PO40A 42,8 x 17 x 53,6 cm (BxHxT)	Box B 005PO40B 42,8 x 17 x 53,6 cm (BxHxT)	Box C 005PO40C 42,8 x 6,8 x 53,6 cm (BxHxT)
Extra matt polyester thread *	FROSTED MATT 189 colours (1000 m) (Special Make-Up for Assortment Boxes)	Box A 005FM40A 42,8 x 17 x 53,6 cm (BxHxT)	Box X 005FM40X 42,8 x 6,8 x 53,6 cm (BxHxT)	
Wool Effect Embroidery Thread	BURMILANA No. 12 147 colours (300 m) (Special Make-Up for Assortment Boxes)	Box A 005BURA 42,8 x 17 x 53,6 cm (BxHxT)		

* The assortments consist of **2** stackable cases.
** The assortments consist of **3** stackable cases..

except Burmilana; Special Make-Up on 300 m spool.

Colour family Sets

Beautiful - Practical - Affordable: These sets provide a wide range of colours that will help you and your customers to make decisions easily, safely and quickly.

CLASSIC 40

10 Colours x 1.000m

YELLOW
Colours: 1022, 1023, 1061, 1080, 1024, 1064, 1171, 1359, 1025, 1192
Art. No. 00610000

ORANGE
Colours: 1017, 1152, 1065, 1021, 1221, 1026, 1155, 1278, 1078, 1039
Art. No. 00610001

RED
Colours: 1146, 1281, 1385, 1174, 1037, 1147, 1081, 1182, 1035, 1374
Art. No. 00610002

PINK
Colours: 1116, 1148, 1309, 1383, 1107, 1307, 1121, 1117, 1110, 1186
Art. No. 00610003

PURPLE
Colours: 1232, 1188, 1080, 1122, 1366, 1119, 1310, 1389, 1032, 1330
Art. No. 00610004

AQUA
Colours: 1045, 1093, 1246, 1299, 1292, 1091, 1088, 1295, 1095, 1297
Art. No. 00610005

BLUE
Colours: 1074, 1176, 1076, 1242, 1244, 1028, 1133, 1166, 1042, 1044
Art. No. 00610006

GREEN
Colours: 1150, 1248, 1049, 1048, 1170, 1051, 1250, 1369, 1189, 1103
Art. No. 00610007

BROWN
Colours: 1082, 1055, 1070, 1173, 1230, 1054, 1058, 1374, 1229, 1059
Art. No. 00610008

GREY
Colours: 1000, 1011, 1003, 1040, 1041, 1286, 1118, 1086, 1288, 1361
Art. No. 00610009

MULTICOLOR
10 Multicolor x 1.000m
Colours: 2011, 2007, 2033, 2008, 2022, 2055, 2050, 2148, 2038, 2017
Art. No. 00610010

POLYNEON 40

10 Colours x 1.000m

YELLOW
Colours: 1666, 1727, 1723, 1735, 1624, 1980, 1771, 1724, 1772, 1792
Art. No. 00610300

ORANGE
Colours: 1653, 1952, 1869, 1621, 1899, 1927, 1870, 1965, 1678, 1639
Art. No. 00610301

RED
Colours: 1878, 1781, 1835, 1638, 1637, 1986, 1782, 1635, 1784, 1747
Art. No. 00610302

PINK
Colours: 1921, 1917, 1990, 1984, 1994, 1754, 1815, 1721, 1787, 1986
Art. No. 00610303

PURPLE
Colours: 1711, 1788, 1712, 1633, 1743, 1919, 1710, 1635, 1834, 1943
Art. No. 00610304

AQUA
Colours: 1645, 1694, 1879, 1799, 1692, 1991, 1888, 1695, 1895, 1977
Art. No. 00610305

BLUE
Colours: 1761, 1676, 1775, 1642, 1844, 1671, 1733, 1843, 1975, 1944
Art. No. 00610306

GREEN
Colours: 1940, 1649, 1848, 1648, 1770, 1851, 1750, 1650, 1769, 1903
Art. No. 00610307

BROWN
Colours: 1938, 1855, 1684, 1791, 1872, 1854, 1658, 1784, 1929, 1895
Art. No. 00610308

GREY
Colours: 1804, 1611, 1803, 1740, 1840, 1686, 1718, 1810, 1741, 1664
Art. No. 00610309

MULTICOLOR
10 Multicolor x 1.000m
Colours: 1515, 1518, 1519, 1517, 1516, 1514, 1510, 1513, 1512, 1511
Art. No. 006MIPLM

FROSTED MATT 40

10 Colours x 1.000m

YELLOW
Colours: 7670, 7725, 7735, 7771, 7792, 7809, 7866, 7969, 7971, 7980
Art. No. 00610600

ORANGE
Colours: 7364, 7598, 7621, 7753, 7755, 7778, 7820, 7821, 7837, 7965
Art. No. 00610601

RED
Colours: 7165, 7255, 7635, 7639, 7747, 7781, 7838, 7899, 7982, 7986
Art. No. 00610602

PINK
Colours: 7310, 7710, 7721, 7786, 7787, 7816, 7917, 7919, 7948, 7984
Art. No. 00610603

PURPLE
Colours: 7109, 7170, 7710, 7630, 7680, 7711, 7832, 7834, 7921, 7922
Art. No. 00610604

AQUA
Colours: 7547, 7645, 7695, 7746, 7828, 7857, 7868, 7892, 7934, 7977
Art. No. 00610605

BLUE
Colours: 7643, 7733, 7742, 7757, 7842, 7843, 7844, 7874, 7871, 7976
Art. No. 00610606

GREEN
Colours: 7027, 7058, 7649, 7650, 7804, 7833, 7851, 7903, 7950, 7970
Art. No. 00610607

BROWN
Colours: 7657, 7658, 7729, 7745, 7773, 7855, 7859, 7884, 7885, 7957
Art. No. 00610608

GREY
Colours: 7640, 7664, 7718, 7739, 7741, 7801, 7803, 7811, 7841, 7886
Art. No. 00610609



Assortments

For fine details and small embroidery pattern, you can achieve more precision of your embroidery with these finer yarns.



Example image

CLASSIC 60

Assortment of fine yarns
85 Colours x 1.500m
in 2 plastic boxes

Art. No. 005CL60

POLYNEON 60

Assortment of fine yarns
101 Colours x 1.500m
in 3 plastic boxes

Art. No. 005POL60+61

POLYNEON 75

Assortment of fine yarns
90 Colours x 2.500m
in 2 plasticboxes

Art. No. 005PO75+76

Sets

The most important embroidery yarns and the most beautiful colors for getting to know each other. Depending on the starter set, there is a matching bobbin thread and the matching needles. This makes it even easier to get started.

Mini Starter



Example image

CLASSIC 40

10 diff. colours x 1.000m

Colours: 1051, 1134, 1074, 1121, 1068, 1041, 1147, 1084, 1001, 1000

Art. No. 006MICL4

POLYNEON 40

10 diff. colours x 1.000m

Colours: 1843, 1988, 1874, 1921, 1971, 1918, 1747, 1800, 1682,1801

Art. No. 006MIPL4

FROSTED MATT 40

10 diff. colours x *1.000m

Colours: 7800, 7843, 7747, 7058, 7364, 7984, 7041, 7801, 7937, 7950

Art. No. 006MIFM4

Big Starter



Example image

CLASSIC 40

12 diff. colours x *2.500m

Colours: 1147, 1041, 1001, 1000, 1084, 1068, 1121, 1051, 1074, 1134, 1065, 1070
+ Colour Card CLASSIC

POLYNEON 40

12 diff. colours x *2.500m

Colours: 1971, 1918, 1747, 1823, 1843, 1874, 1988, 1765, 1801, 1921, 1800, 1682
+ Colour Card POLYNEON

Both sets also include:

Burmilon: 120/2, 1 x *1500m, white
Needles: 10 St. x 65/9, 10 St. x 75/11
Royal Prewound Bobbins: 6 x 120m

Art. No. 006BICL4

Art. No. 006BIPL4

Maxi Starter



Example image

CLASSIC 40

25 x 1.000m

Colours: 1137, 1192, 1070, 1223, 1068, 1041, 1086, 1001, 1074, 1058, 1384, 1147, 1122, 1080, 1121, 1173, 1000, 1241, 1044, 1134, 1370, 1051, 1048, 1246
Multicolor: 2060

Polyneon 40 3 x 1.000m
Colours: 1800, 1801
Multicolor: 1606

POLYNEON 40

25 x 1.000m

Colours: 1670, 1951, 1971, 1924, 1823, 1918, 1811, 1801, 1758, 1784, 1747, 1922, 1831, 1921, 1946, 1792, 1800, 1643, 1841, 1843, 1851, 1988, 1846, 1874
Multicolor: 1606

Classic 40 3 x 1.000m
Colours: 1000, 1001
Multicolor: 2060

Both sets also include:

Needles:
10 St. x 65/9
10 St. x 75/11
10 St. x 90/14
Royal Prewound Bobbins:
6 x 120m

FS Metallic 20 / 30 / 40 / 50
Nr. 20 - 1 x 20g; Col. 1442
Nr. 30 - 1 x *500m; Col. 3031
Nr. 40 - 2 x 1000m; Col. 4006, 4010
Nr. 50 - 1 x 1000m; Col. 5003
Supertwist 30 - 1 x 1.000m; Fb. 25

Classic 30 - 2 x 25g; Col. 1000, 1001
Classic 60 - 2 x 1.500m; Col. 1000, 1001
Polyneon 60 - 2 x 1.500m; Col. 1800, 1801
Polyneon 75 - 2 x 2.500m; Col. 1800, 1801
Frosted Matt 40 - 4 x *1.000m;
Col. 7801, 7908, 7823, 7800

Art. No. 006MACL4

Art. No. 006MAPL4

***Special Make-Up for Assortments and Sets**

Tips on the use of E-ZEE backings

E-ZEE®

To achieve high-quality embroideries, the background fabric should be stabilized with a backing material. It is customary to frame fabric and backing as tight as a drum. The decision about which backing to select is very individual and should depend both on the fabric and on the design to embroider.



Front side



Back side



Back side with partial removed backing

Here are a few basic tips on the use of backings:

- Backing materials in black should only be used to stabilize dark fabrics, otherwise it might show through light coloured or flimsy fabrics. MADEIRA offers backings in both black and white.
- The weight of the backing should match/fit the quality of the fabric. For fine fabrics light-weight backings should generally be chosen, whilst for heavy fabrics, thicker backings or a couple of layers of a thinner backing are both acceptable. A backing which is too heavy can cause unsightly puckering.
- After embroidering the backing materials can be cut away or torn away from the back of the embroidery. Whether to use a cut-away or a tear-away backing, the choice always depends on the embroidery work to be done (i.e. caps, badges, shirts, etc.). Stretchy fabrics will mostly require the use of a cut-away backing.
- To better stabilize stretchy knitwear it is recommended to use fusible (Cotton Soft), cut away (Weblon or Web) or self adhesive (Stick on) backings.

The following overview shows which backings from the E-ZEE range are suitable for which fabrics and usages. These tips are only rough guidelines:

Fabrics to be embroidered	CMX	SMX	Squares	Squares/ Rolls Caps	Cotton Soft	WEB/ WEBLON	PES
Blouses / shirts Light fabrics (i.e. fine cotton and viscose, etc.)	35 g	35 g				44 g	40 g soft
Medium fabrics (i.e. cotton) [2) 4)]	40 g, 50 g	42 g, 50 g	40 g		50 g	50 g, 44 g	
Heavy fabrics (i.e. denim) [4)]	75 g, 80 g	80 g	40 g		60 g, 80 g		80 g soft
Polo-Shirts / stretchy knitwear (i.e. pullover) [1)]					50 g (fusible)	50 g, 44 g	80 g soft
T-Shirts [2)]	35 g, 40 g	35 g, 42 g	40 g		50 g	50 g, 44 g	40 g soft
Sweatshirts [4)]	75 g, 80 g	80 g	40 g		50 g (fusible)	50 g, 44 g	
Coats / trousers [4)]	50 g, 75 g, 80 g	80 g	40 g		60 g, 80 g		80 g soft
Caps [3) 4)]	80 g	80 g	40 g	76 g			80 g hard
Badges [4)]	80 g	80 g	40 g		80 g		80 g soft

[1)] Self adhesive Stick On can also be used (see details in How to „E-ZEE Stick On“ page 27).
[2)] E-ZEE Squares can also be used.
[3)] E-ZEE Squares/Rolls Caps can be used as an alternative.
[4)] If necessary, use 2 layers of E-ZEE Squares.

Best performance with E-ZEE - either in pre-cuts or in rolls!

E-ZEE CMX & SMX



High quality and very stable wet-laid backings. The production process of these materials allows a regular alignment and distribution of the fibers. This is why these all-round backings are resistant and soft at the same time.

Material: cellulose, polyester, PVA, viscose – proportion varies depending on weight class
Weight/Make-Up: 35 to 80 g/m² / Rolls (see “Overview E-ZEE Backings” on page 29)
Colour: Black & White

E-ZEE Squares



All-round, light-weight tear-away backing. Available in pre-cut size 20 cm x 20 cm. Quick and easy to remove. Can also be used in two layers for stronger stabilization and can be easily removed layer after layer.

Material: 100 % viscose
Weight: 40 g/m²
Make-Up: 250 pre-cuts à 20 cm x 20 cm
Colour: Black & White

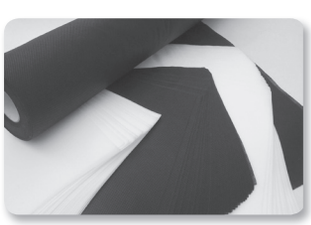
E-ZEE Squares Caps / Rolls Caps



E-ZEE Squares Caps / Rolls Caps are stable Tear-away backings, ideal for caps and made from 100 % polyester. Squares Caps are pre-cuts that come in size 10 cm x 30 cm – Rolls Caps comes in rolls of 10 cm x 100 m. The use of pre-cut backing means time saving and higher productivity.

Material: 100 % polyester
Weight: 76 g/m²
Make-Up Squares Caps: 250 pre-cuts à 10 cm x 30 cm
Make-Up Rolls Caps: Rolls of 10 cm x 100 m
Colour: White

E-ZEE Cotton Soft



Well established in the market due to its good value for money and the excellent tear-away characteristics, Cotton Soft is designed to be less stretchy than most classic backings, therefore it will tear easily if it is hold too tight in the frame. Cotton Soft is made of 100 % recycled cotton and will leave very soft remnants right after the first washing. Variations in the quality of the fiber structure can´t be totally excluded.

Material: 100 % cotton
Weight: 50 to 80 g/m²
Make-Up: Rolls + Package of 6 small rolls (see “Overview E-ZEE Backings” on page 29)
Colour: Black & White

Best performance with E-ZEE - either in pre-cuts or in rolls!

E-ZEE WEB



A stable, light-weight cut-away backing, ideal to stabilize knitwear and piqué. It comes in pre-cuts and in rolls. **Special feature:** only iron at low heat (110 °C).

Material: 100 % polypropylene
Weight: 50 g/m²
Make-Up: 250 pre-cuts à 38 cm x 38 cm / 250 pre-cuts à 23 cm x 23 cm / Rolls of 200 m x 90 cm
Colour: Black & White

E-ZEE WEBLON



A stable, light-weight cut-away backing. Due to its special structure it almost does not show through. Ideal to stabilize knitwear and piqué, as well as fine shirting. Best suitable for embroideries that need to go through the heat press for further finishing steps. **Special feature:** heat-resistant up to 260 °C.

Material: 100 % polyamide
Weight: 44 g/m² (white) / 34 g/m² (black)
Make-Up: 250 pre-cuts à 20 cm x 20 cm / Rolls of 45 m x 50 cm / Rolls of 200 m x 94 cm
Colour: Black & White

E-ZEE Stick On light / Stick On



This self adhesive backing is the best solution for fabrics and cuts that need to be stabilized but can´t be framed (for ex. velvet, velour-like fabrics, etc.). Stick On Light has a slightly lower adhesive power – Stick On can be used to fix products that can´t be placed on a frame, such as bags, tiny cuts, etc. (see details on page 27).

Material: 100 % viscose
Weight: 50 g/m²
Make-Up: Rolls (see “Overview E-ZEE Backings” on page 27)
Colour: Stick On light: White / Stick On: Black & White

E-ZEE PES soft / PES hard



This polyester backing is available in a hard and a soft version – the hard version is particularly suitable for caps.

Material: 100 % polyester
Weight: 40 to 80 g/m²
Make-Up: Rolls (see “Overview E-ZEE Backings” on page 29)
Colour: Black & White

E-ZEE Fire Fighter



Flame resistant backing for fireproof clothing. Light, breathable, stable and tear-proof fabric made of 100 % aramid.

Material: 100 % aramid / melamine resin – proportion varies depending on make-up
Weight: 55 g/m²
Make-Up: Rolls (see “Overview E-ZEE Backings” on page 29)
Colour: Yellow (natural colour)

Stick On / Stick On light (Self adhesive backing)

E-ZEE®

Cut a piece of E-ZEE Stick On larger than the frame. Place the entire piece, including the protective paper, into the frame, with the protective paper on top, as in figure one.



Fig. 1

Before placing the frame on the machine, cut out a small piece of backing from the centre where the stitch plate would be. This should be at least as big as the embroidery design (see figure 2).

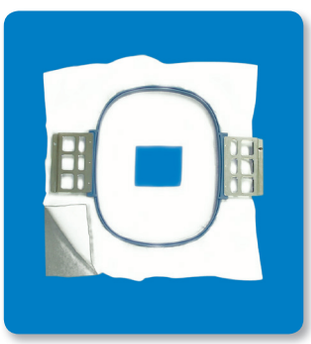


Fig. 2

Using a fine blade, cut a 2 cm wide border from the protective paper only around the resulting hole, and then pull this off, as in figure 3. The Sticky border can be used several times.

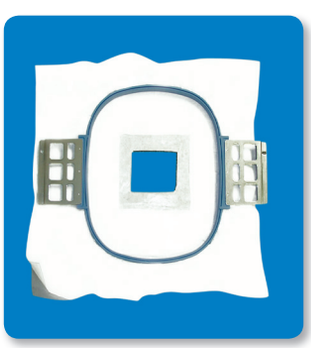


Fig. 3

Stable base material:

On Stick On it is possible to stick several layers of backing material. The garment or the background fabric is then placed on top and embroidered.

Open Weave/knitwear/stretch fabric:

a) Iron on a piece of fusible backing, larger than the embroidery design, onto the reverse of the fabric and then fix this onto the glue side of the E-ZEE Stick On border in the frame, or

b) Place a piece of E-ZEE Stick On onto the open weave fabric, then stick onto the glue side of the E-ZEE Stick On border in the frame (see figures 4+5).



Fig. 4



Fig. 5

The MADEIRA E-ZEE collection contains backings and toppings for all your needs – please ask for details.

E-ZEE Comfort-Wear



Comfort-Wear is a fusible, bi-elastic jersey interlining to cover the reverse of embroideries, to protect the skin from potential scratching or irritation. The bi-elasticity and softness of Comfort-Wear provides excellent wearing comfort, allowing maximum freedom of movement. Comfort-Wear is a very light fabric and thus will not show through the clothing.
Comfort-Wear is fixed onto the reverse of the embroidery by using a heat press or iron. The adhesive agent of Comfort-Wear will be activated again each time it is ironed and hence will stick much longer than comparable products. Comfort-Wear is available in black and white.

Material: 100 % polyester
Weight: 51 g/m²
Make-Up: Rolls of 50 cm x 100 m
Colour: Black & White



Art. No.: 051CW50W (White)
Art. No.: 051CW50S (Black)

Processing:

Due to the spherical adhesive agent the coated side is rougher and therefore clearly visible. Lay the coated side of Comfort-Wear onto the reverse of the embroidery and fix it using a heat press or iron. To protect the embroidery and the fabric/garment, we strongly recommend placing a separate cloth under the main embroidery face. After ironing Comfort-Wear has to cool for min. 2 hours.

Optimal fixing conditions:

Heat press:
Temperature: 130 - 140 °C
Pressure: 4-6 bar
Duration: approx. 15 sec.

Iron:
Temperature: 2 points with maximum steam
Pressure: as strong as possible
Duration: approx. 30 sec.

Due to the variety of temperature resistance and finish of different fabrics, it is essential to run tests before starting production.

OEKO-TEX®
CONFIDENCE IN TEXTILES
STANDARD 100
08.0.62534 HOHENSTEIN HTTI
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Quality Management
ISO 9001
www.dekra-seal.com
DEKRA
certified

E-ZEE Heat Seal



Heat Seal is a permanent adhesive foil for affixing all types of patches and badges. Made from 100 % copolyamide. Available in two versions. One version can be affixed using an iron, and the other requires an ironing press. Depending on the version, washing temperatures can be either 40 °C or up to 95 °C.

Heat Seal's adhesive strength is fully activated after 48 hours!

Iron version:

Material: 100 % copolyamide
Weight: 100 g/m²
Make-Up:
Rolls of 20 cm x 50 m (Art.No.: 035HI125)
Rolls of 50 cm x 50 m (Art.No.: 035HI155)

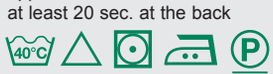
How to use it:

Step 1: Glue Heat Seal to the back of the embroidery (if necessary, cover top of embroidery in order to prevent surplus glue on the iron).

Temperature: 2 points, no steam
Pressure: light
Duration: approx. 5 sec. on both sides

Step 2: Cut out embroidery and glue onto item of clothing.

Temperature: 2 points, no steam
Pressure: as hard as possible
Duration: approx. 10 sec. on front
at least 20 sec. at the back



Ironing press version:

Material: 100 % copolyamide
Weight: 80 g/m²
Make-Up:
Rolls of 105 cm x 100 m (Art.No.: 035HP811)

How to use it:

Step 1: Glue Heat Seal to the back of the embroidery (if necessary, cover top of embroidery in order to prevent surplus glue on the ironing press).

Temperature: 170 °C
Pressure: 0-1 bar
Duration: approx. 5 sec.

Step 2: Cut out embroidery and glue onto item of clothing.

Temperature: 170 °C
Pressure: 3 - 4 bar
Duration: approx. 15 sec.



MADEIRA

Produktübersicht Vliese

Product	Weight	Colour	Material	Tear	Cut	Öko Tex	Make-Up	Art.-No.
CMX	**35 g/m²**	White	Cellulose, polyester, viscose in different percentage depending on the weight	‘		✓	200 m x 90 cm	051CMX3W
CMX	**35 g/m²**	Black		‘			200 m x 90 cm	051CMX3S
CMX	**40 g/m²**	White			‘		100 m x 90 cm	051CMX4W
CMX	**40 g/m²**	Black			‘		100 m x 90 cm	051CMX4S
CMX	**50 g/m²**	White		‘			200 m x 90 cm	051CMX5W
CMX	**50 g/m²**	Black		‘			200 m x 90 cm	051CMX5S
CMX	**50 g/m²**	White			‘		100 m x 90 cm	051CMX51
CMX	**50 g/m²**	Black			‘		100 m x 90 cm	051CMX50
CMX	**65 g/m²**	White			‘		100 m x 90 cm	051CMX6W
CMX	**65 g/m²**	Black			‘		100 m x 90 cm	051CMX6S
CMX	**75 g/m²**	White		‘	‘		100 m x 90 cm	051CMX7W
CMX	**75 g/m²**	Black		‘	‘		100 m x 90 cm	051CMX7S
CMX	**80 g/m²**	White			‘		100 m x 90 cm	051CMX8W
CMX	**80 g/m²**	Black			‘		100 m x 90 cm	051CMX8S
SMX	**35 g/m²**	White	55% polyester, 15% PVA, 30% viscose	‘			200 m x 90 cm	051SMX3W
SMX	**42 g/m²**	White		‘			200 m x 90 cm	051SMX4W
SMX	**50 g/m²**	White		‘			200 m x 90 cm	051SMX5W
SMX	**80 g/m²**	White		‘	‘		100 m x 90 cm	051SMX8W
SQUARES	**40 g/m²**	White	100% viscose	‘			* 20 cm x 20 cm	051QV42W
SQUARES	**40 g/m²**	Black		‘			* 20 cm x 20 cm	051QV42S
SQUARES Caps	**76 g/m²**	White	100% polyester	‘			* 10 cm x 30 cm	051QC71W
ROLLS Caps	**76 g/m²**	White		‘			100 m x 10 cm	051RC71W
Cotton Soft	**50 g/m²**	White	100% cotton	‘			200 m x 90 cm	051CS59W
Cotton Soft	**50 g/m²**	Black		‘			200 m x 90 cm	051CS59S
Cotton Soft bügelbeschichtet	**50 g/m²**	White		‘			200 m x 90 cm	051CB59W
Cotton Soft bügelbeschichtet	**50 g/m²**	Black		‘			200 m x 90 cm	051CB59S
Cotton Soft	**60 g/m²**	White		‘			200 m x 90 cm	051CS69W
Cotton Soft	**60 g/m²**	Black		‘			200 m x 90 cm	051CS69S
Cotton Soft	**80 g/m²**	White		‘			100 m x 90 cm	051CS89W
Cotton Soft	**80 g/m²**	Black		‘			100 m x 90 cm	051CS89S
Cotton Soft Sixpack	**50 g/m²**	White		‘			6 x 50 m x 30 cm	051CS53W
Cotton Soft Sixpack	**50 g/m²**	Black		‘			6 x 50 m x 30 cm	051CS53S
WEB	**50 g/m²**	White	100% polypropylene ironing max.:		‘	✓	* 23 cm x 23 cm	051WB52W
WEB	**50 g/m²**	Black			‘		* 23 cm x 23 cm	051WB52S
WEB	**50 g/m²**	White			‘		* 38 cm x 38 cm	051WB54W
WEB	**50 g/m²**	Black			‘		* 38 cm x 38 cm	051WB54S
WEB	**50 g/m²**	White			‘		200 m x 90 cm	051WB59W
WEB	**50 g/m²**	Black			‘		200 m x 90 cm	051WB59S
WEBLON	**44 g/m²**	White	100% polyamide heat-resistant, melting point: 260 °C		‘	✓	* 20 cm x 20 cm	051WL20W
WEBLON	**34 g/m²**	Black			‘		* 20 cm x 20 cm	051WL20S
WEBLON	**44 g/m²**	White			‘		45 m x 50 cm	051WL50W
WEBLON	**34 g/m²**	Black			‘		45 m x 50 cm	051WL50S
WEBLON	**44 g/m²**	White			‘		45 m x 75 cm	051WL75W
WEBLON	**34 g/m²**	Black			‘		45 m x 75 cm	051WL75S
WEBLON	**34 g/m²**	White			‘		200 m x 94 cm	051WL92W
WEBLON	**34 g/m²**	Black			‘		200 m x 94 cm	051WL92S
Stick On light	**50 g/m²**	White	100% viscose	‘			50 m x 75 cm	051SL75W
Stick On light	**50 g/m²**	White		‘			100 m x 75 cm	051SL71W
Stick On	**50 g/m²**	White		‘			50 m x 75 cm	051SV75W
Stick On	**50 g/m²**	White		‘			100 m x 75 cm	051SV57W
Stick On	**50 g/m²**	Black		‘			50 m x 75 cm	051SV75S
Stick On	**50 g/m²**	Black		‘			100 m x 75 cm	051SV71S
PES soft	**40 g/m²**	White	100% polyester		‘		200 m x 90 cm	051PS49W
PES soft	**80 g/m²**	White			‘		100 m x 90 cm	051PS89W
PES soft	**80 g/m²**	Black			‘		100 m x 90 cm	051PS89S
PES hard	**80 g/m²**	White			‘		100 m x 90 cm	051PH89W
PES hard	**80 g/m²**	Black			‘		100 m x 90 cm	051PH89S
E-ZEE FireFighter	**55 g/m²**	Yellow	100% Aramid 50% Aramid / 50% melamine resin		‘		50 m x 20 cm	051FF525
E-ZEE FireFighter	**55 g/m²**	Yellow			‘		50 m x 100 cm	051FF515

* 250 pre-cuts

OEKO-TEX® CONFIDENCE IN TEXTILES STANDARD 100 08.0.62534 HOHENSTEIN HTTI

Water soluble film



AVALON

Some fabrics and fabric textures, such as knitwear and terry towels, are not easy to embroider. Knitwear is very stretchy and therefore requires stabilizing when embroidering. On very coarse knitted fabrics the stitches tend to sink into the pile, as with terry towels. The embroidered stitches get lost among the loops which diminishes the quality of the embroidery and is considered a defect by the buyers.

There is a way to avoid this inconvenience. AVALON from MADEIRA, a water soluble film which has to be hooped on the top of the fabric. Since it lays between the fabric and the embroidery, it holds down the loops of terry fabrics and the pile of knitwear. As a result the embroidery can be done almost without any additional underlay stitches.

How to remove AVALON:

AVALON is a water soluble film which dissolves during the first washing.

- First tear away the excess of AVALON all around the embroidery.
- If the embroidered garment is not to be washed so soon, put a clean moistened cloth on top of the embroidery. Iron shortly until it is dry. AVALON dissolves and gets absorbed into the cloth.
- Repeat if AVALON has not been entirely removed.
- All residues will get removed during the first washing.

Whatever method you choose for the removal of AVALON, it is very important to let the embroidered garments dry completely before piling them up.



Fig. 1



Fig. 2



Fig. 3

Fig. 1: Typical problems happening with knitwear and terry towels: jagged outlines, distorted details.

Fig. 2: MADEIRA AVALON – hooped together with the fabric – guarantees high quality embroideries.

Fig. 3: No compromise on quality – Embroidery with AVALON: clear outlines, clear details.

AVALON (20 microns)

Rolls of 100 m x 20 cm, Art. No. 035AVA20
Rolls of 100 m x 50 cm, Art. No. 035AVA50
Rolls of 100 m x 100 cm, Art. No. 035AVA

AVALON STRONG (35 microns)

Rolls of 100 m x 20 cm, Art. No. 035AVS21
Rolls of 100 m x 50 cm, Art. No. 035AVS51
Rolls of 100 m x 100 cm, Art. No. 035AVS11

Storage:

To keep the film in optimum condition, store in waterproof packaging away from extreme temperature and humidity fluctuations and sunlight. To prevent part used rolls from drying up, it is recommended to pack into plastic and seal.

...and everything goes smoothly



AVALON Plus

AVALON PLUS is a water soluble film with a structure similar to a backing. AVALON PLUS should be used under the fabric – just like backing. It stabilizes the embroidery during the production process and is completely removed when washed for the first time, leaving the back of the embroidery perfectly clean and comfortable to wear.

AVALON Plus (300 microns)

Roll of 100 m x 20 cm, Art. No. 035PLUS2
Roll of 100 m x 50 cm, Art. No. 035PLUS5
Roll of 100 m x 100 cm, Art. No. 035PLUS1

Storage:

To keep the film in optimum condition, store in waterproof packaging away from extreme temperature and humidity fluctuations and sunlight. To prevent part used rolls from drying up, it is recommended to pack into plastic and seal.





AVALON Ultra

AVALON ULTRA is a water soluble material that can be ideally used as a support for lace embroidery, if the design has been digitized for that purpose. AVALON ULTRA dissolves entirely when washed and leaves a light and airy embroidery constructed only of embroidery and bobbin thread.

AVALON ULTRA (90 microns)

Roll of 50 m x 50 cm, Art. No. 035AVU55
Roll of 50 m x 100 cm, Art. No. 035AVU15



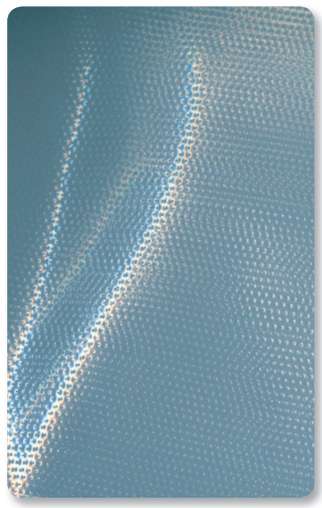
Storage:

To keep the film in optimum condition, store in waterproof packaging away from extreme temperature and humidity fluctuations and sunlight. To prevent part used rolls from drying up, it is recommended to pack into plastic and seal.





Heat dissolvable film



How many times have you been asked to produce embroidery without residual non-woven fabrics on the reverse? Or painstakingly picked away at non-woven backings to ensure nothing was left behind? Or had such difficult fabric or designs to embroiderer that you have layered up the backing and/or been left with puckering or needle damage?

With MadeirAS Film, and Avalon, this could all be a thing of the past...

MadeirAS Film is a heat sensitive film made from **100 micron** or **30 micron Polyolefin - 100 % environmentally friendly and does not contain formaldehyde.**

MadeirAS film has unique advantages.
It is removed completely by heat. Due to its composition, MadeirAS Film is a useful and versatile embroidery aid for everything from fine and stretchy fabrics to standard cotton ones. With MadeirAS film, even problem fabrics can be embroidered without puckering and its use can eliminate the necessity to use adhesive spray.

Instructions for use:

MadeirAS film is straightforward and simple to use. It can be used for the MadeirAS Technique or as a normal backing or topping fabric.

MadeirAS film is removed quickly by heat applied by a heatpress, transfer press or hand held iron at temperatures of 120 ºC - 140 ºC, for only a few seconds, leaving no residue behind.

Make-Up 100 Mikron:

Rolls of 100 m x 50 cm	Art. No. 035AS51B
Rolls of 100 m x 100 cm	Art. No. 035AS11B

Make-Up 30 Mikron:

Rolls of 100 m x 50 cm	Art. No. 035AS513
Rolls of 200 m x 100 cm	Art. No. 035AS123

A simple method for embroidering badges

Avoid the necessity of cutting out the finished badge!

MADEIRAS®

1. Fix the MadeirAS film in the frame of your embroidery machine. Depending on the structure of your embroidery program, it might be necessary to use several layers of MadeirAS film.

To fix the MadeirAS film:
If you use one layer the smooth side should be on the top.
If you use 2 layers the rough sides should be one on top the other.
If you use 3 layers the rough side should be on top of the smooth of layer 2.

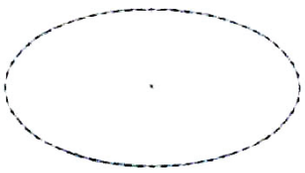


Fig. 1

2. After fixing the layers of film, embroider the outline of the badge with fixing stitches (Fig. 1).

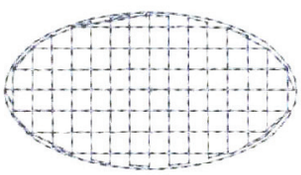


Fig. 2

3. Within the outline, embroider a grid support of running stitches, to stabilise the field for the filling stitches (Fig. 2).

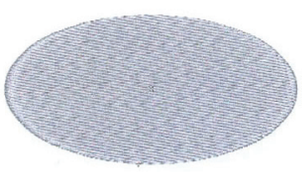


Fig. 3

4. Embroider the filling stitches (Fig. 3).



Fig. 4

5. Embroider the motif or characters of your badge (Fig. 4).

6. Embroider a 2,5 - 3 mm edging around the outline (see point 2) with satin stitches. The stitches should be as close together as possible. This will perforate the film and the badge can easily be removed (Fig. 5).



Fig. 5

7. If the stitches are not close enough, the badge can not be torn away from the film. Any residue of film can be removed by ironing or hot pressing.

MADEIRA

Removal of the MADEIRAS®-Films

Standard iron:

1. First very **carefully** tear away the excess film from around the embroidery, without putting pressure onto the stitching or fabric. It is then easier to iron away the residue of the MadeirAS film on the embroidery instead of the whole film.
2. Ideal **temperature: 140 °C** (= level 2 = **).
3. Iron the embroidery for **5-10 seconds with circular movements**. In this way the MadeirAS film will be melted away by the temperature and rubbed away through the circular movements.
4. Should some residue still remain on the embroidery, the temperature should be slightly increased when ironing the next embroidery. A better result can possibly be achieved ironing at 200 °C (= level 3 = ***). In this case, at a temperature of 200 °C, 3-5 seconds should be enough to remove the MadeirAS film completely.
5. **Heat-tests** run with all MADEIRA threads including polyester thread, have shown no problem when ironing for 10-30 seconds at a temperature of 140 °C, nor when ironing at 200 °C for 10 seconds. However, please test that the fabric itself will withstand the temperature.

With the heat press:

1. First **very carefully** tear away the MadeirAS film from the embroidery **(only so far as possible)**.
2. Then leave the embroidery under the heat press for around **10-20 seconds**. NB: MADEIRA is working successfully with a heat press from INSTA. This type of heat press has only one heat plate on the top (on the market you can also find heat presses with an additional heat plate at the bottom). MADEIRA uses the machine settings as follows:

   Temperature: ca. 120 °C
   Pressure = 0 = no pressure
3. The MadeirAS film will be melted away and the remains will be stuck on the heat plate of the heat press. No residue should remain on the embroidery. If it is not the case then it might be that the temperature of the heat press was too low or that the embroidery has not been left under the press for long enough.
4. At the end (but not necessarily every time) the MadeirAS film can be scraped off with a spatula, whilst still warm.
5. **Heat tests** run with all MADEIRA threads, including polyester thread, have shown no problem at a temperature of 120 °C for 1, 2, 3, 5 and even 10 minutes. However, please test that the fabric itself will withstand the temperature.

Produktübersicht Folien

Product	Weight	Colour	Material	heat soluble	water soluble	Make-Up	Art.-No.
AVALON **AVALON** **AVALON**	**20 µ** **20 µ** **20 µ**		100% polyvinyl alcohol		‘ ‘ ‘	100 m x 20 cm 100 m x 50 cm 100 m x 100 cm	035AVA20 035AVA50 035AVA
AVALON Strong **AVALON Strong** **AVALON Strong**	**35 µ** **35 µ** **35 µ**		100% polyvinyl alcohol		‘ ‘ ‘	100 m x 20 cm 100 m x 50 cm 100 m x 100 cm	035AVS21 035AVS51 035AVS11
AVALON Plus **AVALON Plus** **AVALON Plus**	**300 µ** **300 µ** **300 µ**		100% polyvinyl alcohol		‘ ‘ ‘	100 m x 20 cm 100 m x 50 cm 100 m x 100 cm	035PLUS2 035PLUS5 035PLUS1
AVALON Ultra **AVALON Ultra**	**90 µ** **90 µ**		100% polyvinyl alcohol		‘ ‘	50 m x 50 cm 50 m x 100 cm	035AVU55 035AVU15
MadeirAS-Film **MadeirAS-Film** **MadeirAS-Film** **MadeirAS-Film**	**100 µ** **100 µ** **30 µ** **30 µ**		100% polyolefin	‘ ‘ ‘ ‘		100 m x 50 cm 100 m x 100 cm 100 m x 50 cm 200 m x 100 cm	035AS51B 035AS11B 035AS513 035AS123
Bodybuilder **Bodybuilder** **Bodybuilder hard** **Bodybuilder hard**	**3 mm** **3 mm** **3 mm** **3 mm**	White Black White Black	100% ethylene vinyl acetate			* 30 cm x 40 cm * 30 cm x 40 cm * 30 cm x 40 cm * 30 cm x 40 cm	035B010W 035B010B 035BH10W 035BH10B
Heat Seal Iron version **Heat Seal** Iron version **Heat Seal** Ironing press version	**100 g/m²** **100 g/m²** **80 g/m²**		100% copolyamid			20 cm x 50 m 50 cm x 50 m 105 cm x 100 m	035HI125 035HI155 035HP811
Comfort-Wear[1] **Comfort-Wear**[1]	**51 g/m²** **51 g/m²**	White Black	100% polyester			100 m x 50 cm 100 m x 50 cm	051CW50W 051CW50S

* 10 pre-cuts

(1) OEKO-TEX® CONFIDENCE IN TEXTILES STANDARD 100 08.0.62534 HOHENSTEIN HTTI Geprüft auf Schadstoffe. www.oeko-tex.com/standard100

Bulk up with Bodybuilder!

BODYBUILDER

MADEIRA´s 3-D foam material.
The perfect solution to create raised embroideries.

How to use it:

Fig. 1: Pre-embroider help lines to assist placement of the BODYBUILDER cut pieces.

Fig. 2: Lay BODYBUILDER on top. If necessary, for example on caps, use the temporary spray MSA1100 to fix it.

Fig. 3: Embroider the full design.

Fig. 4: Take off the BODYBUILDER material. The excellent perforation of BODYBUILDER ensures easy removal of the remains, even from the letters.

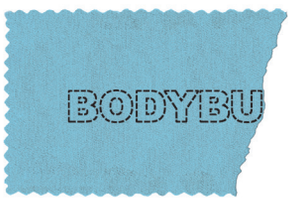


Fig. 1


Fig. 2

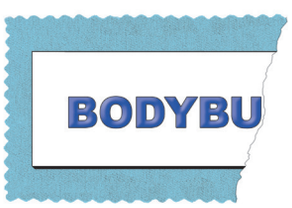


Fig. 3

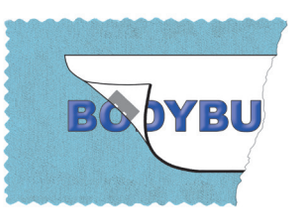


Fig. 4

Important information:

- To fully cover the material, it is necessary to increase the stitch density for the 3D embroidery. After embroidering the help lines (Fig. 1), a “STOP” should be programmed, so that the BODYBUILDER cut piece can be laid.
- The embroidery program of the BODYBUILDER logo (dst. format) is available free of charge from MADEIRA, for your own embroidery tests!

BODYBUILDER

- Available in black & white
- Thickness: 3 mm
- Make-up: 10 pre-cuts à 30 cm x 40 cm
- Art.-No.: 035B010W (white) / 035B010B (black)

NEW BODYBUILDER hard

- Available in black & white
- Thickness: 3 mm
- Make-up: 10 pre-cuts à 30 cm x 40 cm
- Art.-No.: 035BH10W (white) / 035BH10B (black)



Needles



MADEIRA Embroidery Thread		Recommended Needle	Art.-No.	Needlesystem: DB x K5					Brother PR	
				R	RG	FFG	FG/SUK	RG/SAN®1	RG Brother PR Serie	FG Brother PR Serie
CLASSIC **POLYNEON** **FROSTED MATT**	**No. 60** **No. 75, 60, 40** **No. 40**	DB x K5 Nm **60/8 R** DB x K5 Nm **60/8 RG** DB x K5 Nm **60/8 FFG**	021060R 021060RG 021060HR	●	●	●				
CLASSIC **POLYNEON** **FROSTED MATT** **FS** **MONOLON**	**No. 60, 40** **No. 60, 40** **No. 40** **No. 50, 40**	DB x K5 Nm **65/9 R** DB x K5 Nm **65/9 RG/SAN®1** DB x K5 Nm **65/9 FFG** **Brother** 130/705H **RG 65/9**	021065R 022065RG 021065HR 024065RG	●		●		●	●	
CLASSIC **POLYNEON** **FS**	**No. 40** **No. 40** **No. 50, 40**	DB x K5 Nm **70/10 FFG** DB x K5 Nm **70/10 RG**	021070HR 021070RG		●	●				
CLASSIC **POLYNEON** **FROSTED MATT** **FS** **FIRE FIGHTER** **LUNA**	**No. 40, 30** **No. 40** **No. 40** **No. 50, 40** **No. 40** **No. 40**	DB x K5 Nm **75/11 R** DB x K5 Nm **75/11 RG** DB x K5 Nm **75/11 RG/SAN®1** DB x K5 Nm **75/11 FFG** **Brother** 130/705H **FG 75/11**	021075R 021075RG 022075RG 021075HR 024075FG	●	●	●		●		●
FIRE FIGHTER **LUNA**	**No. 40** **No. 40**	DB x K5 Nm **80/12 RG** DB x K5 Nm **80/11 RG/SAN®1** DB x K5 Nm **80/12 FFG**	021080RG 022080RG 021080HR		●	●		●		
FS **SUPERTWIST**	**No. 30, 45** **No. 30**	DB x K5 Nm **90/14 R** DB x K5 Nm **90/14 RG** DB x K5 Nm **90/14 FFG** **Brother** 130/705H **FG 90/14**	021090R 021090RG 021090HR 024090FG	●	●	●				●
As an alternative to using DBxK5 Nm 90/14 needle, try the size 80. A thinner needle with a bigger needle eye to use for fine fabrics.		DB x K5 **SAN®8 FFG 80/12**	023080HR			●				
BURMILANA **CLASSIC** **FS**	**No. 12/CO** **No. 12** **No. 20, 15, 12**	DB x K5 Nm **100/16 RG** DB x K5 Nm **100/16 FG** **Brother** 130/705H **FG 100/16**	021100RG 021100FG 024100FG		●		●			●

The **75/11/RG** or **FFG** are the standard needles, e.g. for standard thread. Always note the desired needle tip: **R** = normal round tip | **RG** = round tip with small ball point | **FFG** = slight ball point | **FG** = medium ball point.
Brother PR embroidery machines require a different needle system. For this purpose, MADEIRA offers needles in sizes 65, 75, 90 and 100, with which all MADEIRA threads can be processed (see table top right).

Tips for cap embroidery: Needle size choice for various threads and thread thicknesses may differ in cap embroidery - if necessary, do not use the finest needle version proposed in each case, but select the next size up or even the next biggest one. Where necessary, speak to your machine supplier for more detailed information. Here we also recommend **SAN®1 version** (see table above). **SAN®1** with RG tip - these needles have an extremely hard **GEBEDUR®** surface coating - the titanium nitride coating provides higher wear and tip protection. **SAN®1** stands for a special needle shaft geometry, which ensures greater stability!

For 3-D embroidery with foam materials (see BODYBUILDER page 36) the **SAN®1 version** is also a good alternative. For embroidery on leather / faux leather, we recommend needle versions with **R-tips**.

Different thread counts – different requirements

Due to the different thread counts, the stitch density needs to be adjusted while digitising. Also, it might be that on the embroidery machine different needle sizes have to be used.
The following overview shows which stitch density and which needle sizes are suitable for which embroidery thread. Only the right combination of both stitch density and needle size will lead to a satisfactory embroidery result.

Thread type	Satin stitch per cm / Back stitch per cm	Density based on 1/10 mm	Dennsity based on 1mm	Needle size
CLASSIC 60	57	3.5	0.35	60/8 - 65/9
CLASSIC 40	51	4.0	0.40	65/9 - 75/11
CLASSIC 30	41	5.0	0.50	75/11
CLASSIC 12	25	8.0	0.80	100/16
POLYNEON 75	94	2.0	0.20	60/8
POLYNEON 60	57	3.5	0.35	60/8 - 65/9
POLYNEON 40 / FR	51	4.0	0.40	60/8 - 75/11
FS 50	57	3.5	0.35	65/9 - 75/11
FS 45	51	4.0	0.40	80/12 - 90/14
FS 40	51	4.0	0.40	65/9 - 75/11
FS 30	41	5.0	0.50	80/12 - 90/14
FS 20	27	8.0	0.80	100/16
FS 15	23	9.0	0.90	100/16
FS 12	23	9.0	0.90	100/16 - 110/18
SUPERTWIST 30	30	6.0	0.60	80/12 - 90/14
BURMILANA 12/CO	23	9.0	0.90	100/16
FROSTED MATT 40	51	3.0 or 4.0	0.30 or 0.40	60/8 - 75/11
LUNA 40	51	4.0 or 5.0	0.40 or 0.50	75/11 - 80/12
FIRE FIGHTER 40	51	4.0	0.40	75/11 - 80/12
MONOLON	66	3.5	0.35	65/9

All a.m. tips are only to be considered as rough guidelines and may vary depending on the fabric to be used and on the effect to achieve.

Guidelines for Underthread use:
For standard length stitches the general rule for underthread requirement is around 3 m per 1000 stitches. Upper thread: You can expect approximately 5 m per 1000 stitches.

Correct thread tension:
A perfectly tensioned embroidery with standard length stitches should have around one third of the underthread visible on the stitches underneath!

Embroidery Scissors

MADEIRA offers embroidery scissors in different shapes & sizes. Their common links are the high precision cut right up to the point and the use of best materials which fulfills even the highest requirements and ensures lengthy durability.

High quality embroidery scissors, 22 carat gold-plated, free from nickel and thus kind to the skin.

Curved Embroidery Scissors



The curved point allows a precise and safe cut without damaging the fabric. Ideal for removing connecting stitches.

Art-No.: 020N9476 (length: 10,5 cm)

Double Curved Embroidery Scissors



Allow reach to areas not easily accessible, such as the presser foot. The double curve shape holds the fingers away from the fabric.

Art-No.: 020N9478 (length: 9 cm)

Stork Shaped Embroidery Scissors



Attractive embroidery scissors combining a comfortable cut with a modern design.

Art-No.: 020N9479 (length: 9,5 cm)

Straight Embroidery Scissors



The standard scissors for all cutting works at the embroidery machine.

Art-No.: 020N9477 (length: 10,5 cm)

Special-Scissors (E-ZEE FireFighter)



To ensure smooth cutting, we recommend our special scissors. Normal scissors do not cut the backing very well and soon become blunt.

Art-No.: 020N9495 (length: 24 cm)

The professional chromium-plated steel embroidery scissors.

Curved Precision Embroidery Scissors



The particular shape at the top of the scissors ensures trouble free work on the frame. The curved points prevent fabric and embroidery damage.

Art-No.: 020N9491 (length: 14 cm)

Thumb Grip Snips



Indispensable for all fabric work, where precision is a must. Automatic spring-back to the initial position, ergonomic shape.

Art-No.: 020N9492 (length: 11 cm)

Appliqué Scissors



Precision scissors for appliqué, trimming and quilt work. The shaped 'bill' prevents fabric or appliqué damage.

Art-No.: 020N9493 (length: 15 cm)

Snipper



For a quick and clean cutting. Automatic spring back to starting position and blade made of hardened steel.

Art-No.: 020N9494 (length: 10,5 cm)

Temporary adhesive spray

MSA 1100



An essential spray for temporary positioning of appliqués and cut pieces.

The advantages:

> High Volume contents - 350g per can - more than most 500ml cans
> Adhesive action sustained for a whole hour
> **New:** higher strength adhesive
> **New:** light citrus odour
> Excellent price & very economical to use

Order **MSA 1100 Temporary Adhesive Spray** today and see the benefits.

Please Note:
Minimum Order Quantity: 1 box of 12 cans
Article No: 025MSAN
Special prices for high quantities available on request.

Due to transport regulations, the spray may be delivered separately from thread orders.

Use MSA 1100 temporary spray adhesive:

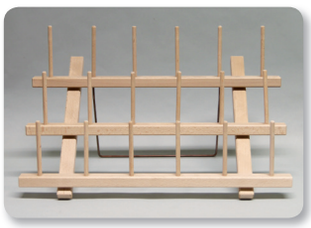
1. Shake the can well before use.
2. Where possible, use adhesive sprays in a separate area, away from all machinery. Even though it is unseen by the naked eye, fine mist from adhesive spray could adversely affect machine parts, needles, hoops and table surfaces. If using close to the machine, clean the machine and both sides of the hoops regularly. This helps to prevent a build up especially around the hoop screws.
3. Where possible, spray the appliqué or cut piece and not the base material.
4. Spray from the recommended distance, around 20cm, in short bursts.
5. Wipe away any excess immediately with spirit cleaner!
6. If any stains remain, do not attempt to wash or dry clean, as this will ‚fix' the stains in place. Should this occur, please contact MADEIRA and/or your fabric supplier for advice!
7. Again - always test ALL fabrics for suitability! Nowadays there are many different types of materials, with a variety of finishes and some extremely delicate fabrics. Even if the spray is used correctly, certain fabrics could react badly and possible staining could occur. The list below shows fabrics most likely to cause trouble: **silk, velour, imitation leather, technical textiles etc.** Please pay special attention to testing these fabrics!
8. There is always a certain risk of staining. Due to the fact we have no control over its use, MADEIRA cannot be held responsible for MSA 1100 causing or resulting in staining, other problems or disputes.
10. MADEIRA temporary adhesive spray **MSA 1100** is used widely worldwide. With the correct testing and application, you should enjoy trouble free production!

Support from the very beginning

Accessoires

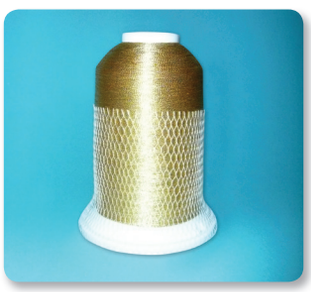
Cone Holder

The wooden cone holder has space for 18 cones. The ideal design and size allows additional holders to be stacked either vertically or horizontally for optimum space utilisation.



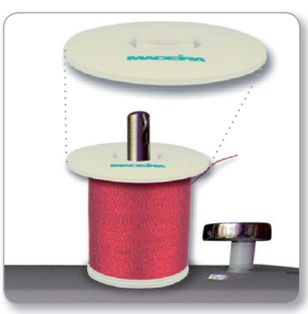
Cone Net

Cone stockings or nets prevent thread falling down the cone either on the machine or in storage. Furthermore they reduce stati charging. MADEIRA cone nets are available, on request, free of charge.



Spool-Tops

Spool tops are especially suited for spooling to enable longer run time.



Sortimentskasten & StarterKits leer

The Assortment Boxes with 1 or 3 drawers (page 21) and Starter Set plastic boxes (page 40) are also available as empty units, allowing you to expertly store your choice of MSCs (Mini Snap Cones) CLASSIC, POLYNEON or flanged bobbins – from the FS/SUPERTWIST thread range.
The starter kit plastic boxes (see p.23), are also available as empty boxes for storage of MSC or disc coils.

(1) Art. No. 005NEUT (3 unit Box)

(2) Art. No. 050PLBOX

(1) Art. No. 005NEUT1 (1 unit Box)

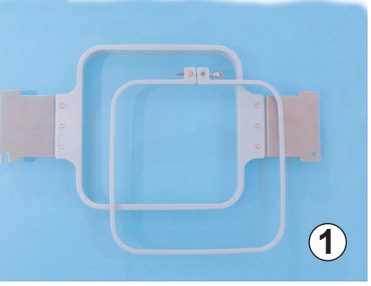


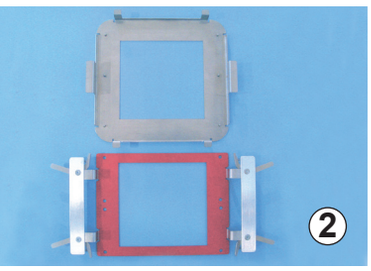
Combination spool and cone stands

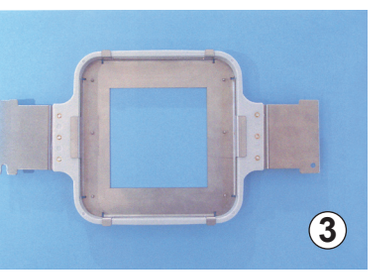
Using MADEIRA combi spool/cone stands, you can easily change from spools to cones as the combi stand fits all.

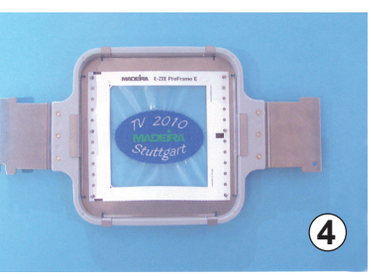


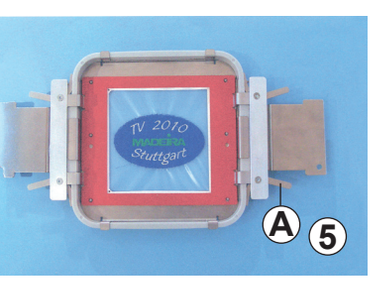
MADEIRA
Leidenschaft für Stickerei seit 1919

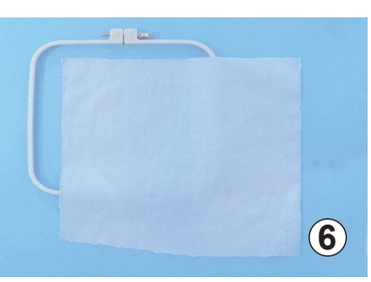


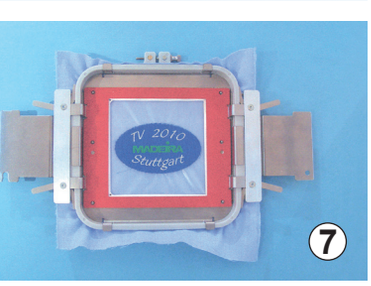














MFS from MADEIRA! An absolute must!

MFS is an affordable frame that was originally engineered for Brother PR machines.

It is made of a standard embroidery frame (Fig. 1) and a removable frame consisting of two parts and meant to hold and fix the E-ZEE PreFrames (Fig. 2)

After positioning the E-ZEE PreFrame on the **MFS** frame, you can start embroidering your logo or badge. Customization of name patches is easy: remove the E-ZEE Preframe from the MFS frame and put it aside. At this stage the embroidery is almost finished, all that is missing is a name. No problem! You can add it later once you know it!

In a further step the badge will need to be fixed onto the garment. A satin stitch border will do it. Then no cutting necessary, just tear away the E-ZEE-PreFrame foil around the badge. It can´t be easier!

How to work with the **MFS**:

- Insert the metal inlay into the plastic base (Fig. 3).
- Snap an E-ZEE PreFrame in place – take one that is already embroidered (Fig. 4).
- Snap the upper part of the metal inlay in place and lock the whole frame (Fig. 5 – A = locking devices).
- Hoop the garment in the plastic frame (Fig. 6) and assemble the whole frame (Fig. 7).
- Now you can embroider some satin stitches around the pre-embroidered badge in order to fix it to the garment.
- The badge is finished, cleanly affixed to the fabric (Fig. 8).

MFS – an affordable embroidery tool for clean and precise results!

Scan to see the MFS-Video...

The embroidery design process

From the basics to advanced creative embroidery techniques



The book explains in depth all aspects of the embroidery design process from the basics to advanced creative embroidery techniques. It is full of practical information and important tips about how to create good quality designs for industrial embroidery machines. Regardless of punching skill level and for anyone just interested in learning about the process of embroidery design, this book is a valuable source of inspiration and technical advice.

Bonnie Nielsen is an internationally known embroidery designer with more than 25 years of experience in the embroidery industry. She is recognized worldwide for her creative punching skills and is well known for her technical embroidery digitizing articles.

Bonnie Nielsen
“PUNCH - Digitizing for Embroidery Design”

TVP Edition
VERLAGSHAUS GRUBER, Eppertshausen 2010

ISBN: 978-3-00-030071-4
Euro 52,-

Now available for order directly at MADEIRA!
Fax +49 761 50 84 56 or eMail info@madeira.de

MADEIRA

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- The new shop version in **responsive design** - your orders can now be clearly arranged on your cell phone.

Clearly defined priorities for your user benefit, convince yourself. Do not hesitate, register now!



MADEIRA

Washing

 Washing temperature max. 95°C (normal program)	 Washing temperature max. 95°C (delicates program)	 Washing temperature max. 60°C (normal program)	 Washing temperature max. 60°C (delicates program)	 Washing temperature max. 50°C (normal program)	 Washing temperature max. 50°C (delicates program)	 Washing temperature max. 40°C (normal program)

Washing

 Washing temperature max. 40°C (delicates program)	 Washing temperature max. 40°C (extra delicates program)	 Washing temperature max. 30°C (normal program)	 Washing temperature max. 30°C (delicates program)	 Washing temperature max. 30°C (extra delicates program)	 Washing temperature max. 40°C (Hand wash)	 Do not wash

Bleaching

 Any bleach possible!	 Only oxygen bleach possible! No chlorine bleach!	 Do not bleach!

Drying

 Drying in dryer possible. Normal temperature, initial temperature max. 80°C	 Drying in dryer possible. Low temperature, initial temperature max. 60°C	 Do not dry in dryer!

Ironing

 Ironing with maximum temperature of the iron is 200°C	 Ironing with maximum temperature of the iron is 150°C	 Ironing with maximum temperature of the iron is 110°C without steam! Steam ironing can cause irreparable damage!	 Do not iron!

Professional Textiles care

 Professional chemical cleaning with tetrachloroethene and all solvents specified with the symbol „F“, (normal program)	 Professional chemical cleaning with tetrachloroethene and all solvents specified with the symbol „F“, (delicates program)	 Professional chemical cleaning with carbon hydrates. Distillation temperature between 150°C and 210°C, burning point between 38°C and 70°C (normal program)	 Professional chemical cleaning with carbon hydrates. Distillation temperature between 150°C and 210°C, burning point between 38°C and 70°C (delicates program)	 No chemical cleaning possible!

The letters in the circle are primarily intended for the chemical cleaner's. They most of all provide information about the solvents coming into consideration. The bars below the circle mean that the mechanical strain during cleaning, the added moisture, soaking and/or drying temperatures must be reduced.

Professional Textiles care

 Professional wet cleaning! (normal program)	 Professional wet cleaning! (delicates program)	 Professional wet cleaning! (extra delicates program)	 No wet cleaning possible!

The symbol for wet cleaning is used for items that can be treated in a wet cleaning procedure in water. The requirements for the machine equipment, the used means and finish methods cannot be achieved by the parameters of a household washing machine.

Thread Description	Thickness DTEX	Appearence	Colours	Make-Up Spools/MSC	Make-Up Cones	Care
Viscose Embroidery Thread, 100% viscose						
CLASSIC No.40 single colours	135x2	brilliant, natural sheen	387	1000m	5000m	95°C
CLASSIC No.40 ombré	135x2	brilliant, natural sheen	19	1000m	5000m	95°C
CLASSIC No.40 multicolour	135x2	brillant, natural sheen/shaded light to dark	6	1000m	5000m	95°C
CLASSIC No.40 astro-colour	135x2	brillant, random shaded colours	10	1000m	5000m	95°C
CLASSIC No.30	200x2	brillant, natural sheen	178(2)	25g	(3000m)	95°C
CLASSIC No.60	84x2	brillant, natural sheen	85	1500m	---	95°C
CLASSIC No.12	330x2	brillant, natural sheen	57	---	2000m	95°C
Polyester Embroidery Thread, 100% polyester						
POLYNEON No.40 single colours	135x2	brilliant sheen	389	1000m	5000m	95°C △
POLYNEON No.40 fluorescent	135x2	brilliant sheen, fluorescent	24	1000m	5000m	95°C △
POLYNEON No.40 multicolour	135x2	brilliant sheen, random shaded colours	20	1000m	5000m	95°C △
POLYNEON No.40 FR	135x2	brilliant sheen, flame retardant	34	---	2500m	95°C △
POLYNEON No.60	84x2	brilliant sheen	101(2)	1500m	(5000m)	95°C △
POLYNEON No.75	55x2	brilliant sheen	40(2)	2500m	(10000m)	95°C △
Metallic Embroidery Thread, metallised polyester/polyamide/viscose						
FS No.50	150	smooth metallic	8	1000m	5000m	60°C
FS No.45	220	smooth metallic	26	---	5000m	60°C
FS No.40	220	smooth metallic	20	1000m	5000m	60°C
FS No.40 astro	220	smooth metallic, random shaded colours	5	1500m	---	60°C
FS No.30	320	smooth metallic	13	---	5000m	95°C △
FS No.30	320	smooth metallic	13	---	2500m	95°C △
FS No.20	360	smooth twisted metallic	32	20g	---	60°C
FS No.15	660	smooth metallic	16	20g	100g	60°C
SUPERTWIST No.30	180	textured metallic glitter	68	1000m	5000m	60°C
SUPERTWIST No.30 crystal	180	textured crystal shine	30	1000m	---	60°C △
SUPERTWIST No.30 opal	180	textured iridescent, glittering	16	1000m	5000m	60°C △
SUPERTWIST No.30 multicolour	180	textured multicolour, metallic glitter	11	1000m	5000m	60°C
Metallic Sewing Thread, metallised polyester/polyamide/viscose						
FS No.15	660	smooth metallic	16	20g	100g	60°C
FS No.12	830	smooth metallic	6	---	1200m	60°C △
FS No.10	1050	smooth metallic	10	20g	100g	60°C
FS No.8	1400	smooth metallic	7	---	800m	60°C △
Wool Effect Embroidery Thread, 50% wool / 50% acrylic						
BURMILANA No.12 single colours	330x2	woollen & warm	135	1000m	---	40°C
BURMILANA No.12 mélangé	330x2	woollen & warm, mélangé effect	12	1000m	---	40°C
Wool Effect Embroidery Thread, 50% cotton / 50% acrylic						
BURMILANA No.12 single colours	330x2	fresh & summery	65	1000m	---	40°C
BURMILANA No.12 mélangé	330x2	fresh & summery, mélangé effect	7	1000m	---	40°C
FROSTED MATT - Extra Matt Polyester Embroidery Thread, 96% polyester / 4% ceramic						
FROSTED MATT No.40	90x2	extra matt	189	---	2500m	60°C △
LUNA Glow in the Dark Embroidery Thread, 60% PBT / 40% PP						
LUNA No.40	150x2	glows in the dark greenish	1	750m	---	60°C △
FIRE FIGHTER - Flame Resistant Embroidery Thread, 100% aramid						
FIRE FIGHTER No.40 Embr. Thread	130x2		24	950m	2500m	95°C △
FIRE FIGHTER No.40 Bobbin Thread	130x2		Black & White	---	5000m	95°C △
MONOLON Embroidery Thread, 100% polyamide						
MONOLON	66		2	---	15000m	60°C
Bobbin Thread, 100% polyester						
BURMILON No.200	150		Black & White	---	7500m	
BURMILON No.120/2	80x2		Black & White	---	7500m	
Bobbin Thread No.150	110x2		Black & White	---	15000m	
ROYAL Prewound	75x2		L-Style, Black & White	144 x 132 yds		
MAGENTIC SIDED BOBBINS	75x2		L-Style, White	144 x 123m		
MAGENTIC SIDED BOBBINS	75x2		L-Style, Black	144 x 113m		
MAGNA-GLIDE Prewound	75x2		L-Style, White	100 x 123m		
MAGNA-GLIDE Prewound	75x2		L-Style, Black	100 x 118m		

Product	Weight	Colour	Make-Up
E-ZEE CMX			
E-ZEE CMX 80% cellulose / 20% PES	35g	Black & White	Rolls of 200 m x 90 cm
E-ZEE CMX 40% cellulose / 60% PES (Cut)	40g	Black & White	Rolls of 100 m x 90 cm
E-ZEE CMX 80% cellulose / 20% PES	50g	Black & White	Rolls of 200 m x 90 cm
E-ZEE CMX 20% cellulose / 60% PES / 20% viscose (Cut)	50g	Black & White	Rolls of 100 m x 90 cm
E-ZEE CMX 40% cellulose / 60% PES (Cut)	65g	Black & White	Rolls of 100 m x 90 cm
E-ZEE CMX 70% cellulose / 30% viscose	75g	Black & White	Rolls of 100 m x 90 cm
E-ZEE CMX 40% cellulose / 60% PES (Cut)	80g	Black & White	Rolls of 100 m x 90 cm
E-ZEE SMX			
E-ZEE SMX 55% PES / 15% PVA / 30% viscose	35g	White	Rolls of 200 m x 90 cm
E-ZEE SMX 55% PES / 15% PVA / 30% viscose	42g	White	Rolls of 200 m x 90 cm
E-ZEE SMX 55% PES / 15% PVA / 30% viscose	50g	White	Rolls of 200 m x 90 cm
E-ZEE SMX 55% PES / 15% PVA / 30% viscose	80g	White	Rolls of 100 m x 90 cm
E-ZEE SQUARES & SQUARES / ROLLS Caps			
E-ZEE SQUARES 100% viscose	40g	Black & White	Pre-cuts à 20 cm x 20 cm
E-ZEE SQUARES Caps 100% PES	76g	White	Pre-cuts à 10 cm x 30 cm
E-ZEE ROLLS Caps 100% PES	76g	White	Rolls of 100 m x 10 cm
E-ZEE Cotton Soft			
E-ZEE Cotton Soft 100% cotton	50g	Black & White	Rolls of 200 m x 90 cm
E-ZEE Cotton Soft 100% cotton, fusible	50g	Black & White	Rolls of 200 m x 90 cm
E-ZEE Cotton Soft 100% cotton	60g	Black & White	Rolls of 200 m x 90 cm
E-ZEE Cotton Soft 100% cotton	80g	Black & White	Rolls of 100 m x 90 cm
E-ZEE Cotton Soft 100% cotton, sixpack	50g	Black & White	Rolls of 6 x 50 m x 30 cm
E-ZEE WEB			
E-ZEE WEB 100% polypropylene	50g	Black & White	Pre-cuts à 23 cm x 23 cm
E-ZEE WEB 100% polypropylene	50g	Black & White	Pre-cuts à 38 cm x 38 cm
E-ZEE WEB 100% polypropylene	50g	Black & White	Rolls of 200 m x 90 cm
E-ZEE WEBLON			
E-ZEE WEBLON 100% polyamide	44g	White	Pre-cuts à 20 cm x 20 cm
E-ZEE WEBLON 100% polyamide	34g	Black	Pre-cuts à 20 cm x 20 cm
E-ZEE WEBLON 100% polyamide	44g	White	Rolls of 45 m x 50 cm
E-ZEE WEBLON 100% polyamide	34g	Black	Rolls of 45 m x 50 cm
E-ZEE WEBLON 100% polyamide	44g	White	Rolls of 45 m x 75 cm
E-ZEE WEBLON 100% polyamide	34g	Black	Rolls of 45 m x 75 cm
E-ZEE WEBLON 100% polyamide	34g	White	Rolls of 200 m x 94 cm
E-ZEE WEBLON 100% polyamide	34g	Black	Rolls of 200 m x 94 cm
E-ZEE Stick On / Stick On light			
E-ZEE Stick On 100% viscose	50g	Black & White	Rolls of 100 m x 75 cm
E-ZEE Stick On 100% viscose	50g	Black & White	Rolls of 50 m x 75 cm
E-ZEE Stick On light 100% viscose	50g	White	Rolls of 100 m x 75 cm
E-ZEE Stick On light 100% viscose	50g	White	Rolls of 50 m x 75 cm
E-ZEE PES soft / hard			
E-ZEE PES 100% PES soft	40g	White	Rolls of 200 m x 90 cm
E-ZEE PES 100% PES soft	80g	Black & White	Rolls of 100 m x 90 cm
E-ZEE PES 100% PES hard	80g	Black & White	Rolls of 100 m x 90 cm
E-ZEE Heat Seal			
E-ZEE Heat Seal (Iron version) 100% copolyamide	100g	Transparent	Rolls of 50 m x 20 cm
E-ZEE Heat Seal (Iron version) 100% copolyamide	100g	Transparent	Rolls of 50 m x 50 cm
E-ZEE Heat Seal (Ironing press version) 100% copolyamide	80g	Transparent	Rolls of 100 m x 105 cm
E-ZEE Comfort-Wear			
E-ZEE Comfort-Wear 100% polyester	51g	Black & White	Rolls of 100 m x 50 cm
E-ZEE FIRE FIGHTER			
E-ZEE FIRE FIGHTER 100% aramid	55g	Yellow	Rolls of 50 m x 20 cm
E-ZEE FIRE FIGHTER 50% aramid / 50% melamine resin	55g	Yellow	Rolls of 50 m x 100 cm

Films	Product Description	Make-Up
AVALON	Water soluble film to use on knitwear, terry towelling etc.	Rolls of 100 m x 100 cm Rolls of 100 m x 50 cm Rolls of 100 m x 20 cm
AVALON Plus cm	Water soluble fabric with a textile/non-woven structure.	Rolls of 100 m x 20 Rolls of 100 m x 50 cm Rolls of 100 m x 100 cm
AVALON STRONG	Water soluble film in a thicker version.	Rolls of 100 m x 20 cm Rolls of 100 m x 50 cm Rolls of 100 m x 100 cm
AVALON ULTRA	Water soluble film, i.e. for lace embroideries.	Rolls of 50 m x 50 cm Rolls of 50 m x 100 cm
MadeirAS 100 Micron	Heat soluble film for embroidery solutions.	Rolls of 100 m x 100 cm Rolls of 100 m x 50 cm
MadeirAS 30 Micron	Heat soluble film for embroidery solutions.	Rolls of 100 m x 50 cm Rolls of 200 m x 100 cm
Bodybuilder Bodybuilder hard	3-D foam material (3 mm) / Black & White. 3-D foam material (3 mm) / Black & White.	Pre-cuts à 30 cm x 40 cm Pre-cuts à 30 cm x 40 cm

Accessoires	Product Description
MADEIRA Needles	Needles for embroidery machines in different thicknesses and points. Boxes of 100 needles.
Cone Holder	18 cones
Scissors	Embroidery scissors in different shapes for all usages.
Adhes. Spray MSA 1100	Temporary adhesive spray for fixing appliqués or pre-cuts. Cans of 500 ml / 350 g.
Assortment Boxes	CLASSIC 40, POLYNEON 40, FROSTED MATT 40, BURMILANA 12. One spool of each single colour. (Assortment also available for POLYNEON 60 and 75 - delivered in a plastic box!)
Starter Set	Available for CLASSIC 40, POLYNEON 40 and FROSTED MATT in different make-up's. (page23)

General Terms and Conditions of Delivery and Payment of Madeira Garnfabrik Rudolf Schmidt KG 09/2010

I. Application, Scope of Validity:
The present Terms and Conditions shall apply exclusively and are legally binding now and in future for all business transacted between us and the Buyer, even if explicit mention is not made thereof in subsequent contracts.
Auxiliary arrangements and/or special agreements, including those of our sales force, representatives or authorized parties, shall always require the explicit written conformation of our Management. Where contracts materialise through intermediaries or representatives, these shall only become legally operative if confirmed by us in written form.
The present General Terms and Conditions of Delivery and Payment shall always have priority over any terms and conditions of the Buyer, which shall be explicitly excluded, unless we expressly recognise said different terms and conditions in written form. The terms and conditions of the Buyer shall also not apply if upon receiving them we fail to voice our objection thereto.

II. Contract
Our offers shall be subject to change in terms of price and delivery period. Acceptance of orders shall always be subject to our order confirmation. If we fail to confirm the order placement and if the ordered goods are delivered, acceptance of the order placement is constituted by the delivery together with the invoice and/or delivery note. Subject of contract shall be exclusively the product sold with all attributes and features and the product description on which the intended purpose is based as negotiated for the contract. Any other or farther-reaching attributes and/or features or any intended purpose in excess hereof shall only be deemed contracted if they have been explicitly confirmed by us in written form. All information relating to product colours, running metres, piece/metre data, illustrations, price lists shall not be binding, unless the order confirmation features said information as explicitly binding. Discrepancies of this nature shall not constitute any entitlement to file complaints, providing the item delivered has not been significantly altered and the Buyer can be reasonably expected to accept the alteration.

III. Delivery Time, Transfer of Risk
1. Delivery Dates
Delivery dates shall be subject to our own possibilities for delivery, unless they have been explicitly contracted in written form as binding. The delivery shall be ex-warehouse at the risk and expense of the Buyer. The hazard of incidental deterioration/ accidental loss shall pass to the Buyer as soon as the consignment has left our warehouse or as from readiness for despatch of the goods, providing despatch is not delayed for reasons for which we are responsible, irrespective of whether the despatch is made from the place of fulfilment and irrespective of who bears the freight costs.

2. Delivery Time/Force Majeure
The delivery deadline is deemed met if the goods have left our warehouse by the time the deadline lapses or we have notified readiness for despatch. If advance payment or the payment of a deposit was contracted, the delivery deadline shall only commence after payment has been received.
Incidents of force majeure or industrial disputes, particularly strike and lock-out situations for which we are not responsible shall entitle us to postpone delivery for the duration of the difficulties or for an appropriate lead time or to withdraw from the contract in whole or in part for that part, which has not yet been fulfilled, without the Buyer being able to derive any right to claim compensation as a result.
If the delivery period we specify proves fruitless for more than two weeks, the Buyer shall be entitled to set us a two-week period for delivery. If we fail to deliver by the lapse of this delivery period for reasons for which we are responsible, the Buyer shall be entitled to withdraw from the contract.

IV. Prices, Payment
Unless otherwise contracted in written form, our prices shall be ex-works in Euro. Without any specific price agreement, the price lists shall apply that are valid on the day the order placement is received. Value added tax to the amount required by law shall be added to the prices. New accounts will have to pay the purchase price in advance.

V. Retention of Title
We shall retain title to all our deliveries subject to Section 440 BGB [German Civil Code] until the Buyer has effected full payment of all claims owed to us or generating in the future. For running accounts, the retained title to the goods shall be deemed security for our claim to payment. The Buyer shall only be entitled to dispose of our property in the course of regular business transactions. The Buyer shall not be allowed to pledge or transfer our property by way of security, even in subordinate ranking. In the event of the resale of the goods to which we retain title, the Buyer shall now assign to us, as security, all claims to payment due to him from his customers until all our claims to payment have been satisfied. The Buyer shall be authorised to collect the assigned payments for as long as the Buyer satisfies his duty to pay us. In the event of resale on credit, the Buyer undertakes to retain title to the goods until payment has been made in full. The claims in rem thus generated shall already now be deemed assigned to us. We shall be informed immediately of any third-party access to our property and of any pledges in respect of the claims assigned to us. In the case of default of the debtor and non-compliance on the part of the Buyer in respect of the aforementioned ancillary duties, the authorisation of the Buyer to recover payments shall extinguish, even without any explicit revocation. The Buyer shall inform us of the assigned claims to payment and the debtors thereof, provide us with all the information required to recover payment, hand over the relevant documentation and inform the third-party debtors of the assignment. Our claim to retention shall be conditional in that upon the full payment of all claims from business relations, the title to the goods shall pass to the Buyer who shall be unrestrictedly entitled to the assigned claims to payment. If the value of the security exceeds our claims against the Buyer by more than 20%, we shall, at the request of the Buyer and at our own discretion, release the securities to which we are entitled to an appropriate extent. Any compounding, mixing and processing of our delivered goods shall be in our name, so that co-ownership thereto directly passes to us in accordance with Sections 947 ff BGB [German Civil Code].
The above provision shall apply appropriately to all items of which we have co-ownership.

VI. Notice of Defects and Quality Defects
1. Defects or complaints about incomplete or inaccurate deliveries shall be notified in writing immediately they have been established so as to be verifiable. Otherwise the item delivered shall be deemed approved, providing we or our legal representatives or vicarious agents cannot be accused of malicious intent.
2. If the defect has been notified on time, unless the sale of consumer goods is involved, we shall be entitled to choose between providing a remedy or a substitute delivery and/or can refund the reduced value for the parts, which inside the statutory limitation period can be proven to have become unusable as a result of circumstances prior to the transfer of risk or have become significantly impaired in usability.
3. If the remedy provided proves to be a failure, the Buyer shall only be entitled to withdraw from the contract subject to Sections 440, 323, 326 I 3 BGB, to the exclusion of any further claims, or to reduce the purchase price as defined in Section 441 BGB.
4. The Buyer shall not be entitled to claim guarantee if he failed to store the goods properly or if the goods were exposed to third-party access.
5. All claims to defects shall cease to apply if the Buyer does not concede us an appropriate period of time or an opportunity to check the defect goods and to provide the remedy that might be required as defined in Section 439 BGB.
6. The point in time when the risk was transferred shall be determinant for establishing the contractual condition of the goods.
7. Claims to defects shall become statute-barred twelve months after the transfer of risk. If a remedy or new delivery is provided subject to guarantee, the period of limitation shall not recommence running.
8. If the Buyer sells the goods to third parties, the Buyer shall only be entitled to have recourse to us, in so far as compliance with the deadlines defined in Section 479 BGB can be checked by way of a printed sales voucher registered in the accounting system of the Buyer. Claims of the Buyer against us shall be subject to evidence that the Buyer had to take the item back again owing to a justified claim on the part of the consumer or third party or had to pay back part of the purchase price as reduction. Claims to guarantee satisfied out of good will, i.e. without legal obligation, shall not substantiate any claims against us. Claims defined in Section 478 BGB shall become statute-barred subject to Section 479 BGB.

VII. Restriction of Liability
1. Unless otherwise described in the following other and farther-reaching claims of the Buyer against us shall be ruled out. This shall particularly apply for claims to compensation from default, from the impossibility to deliver, from a culpable breach of contractual auxiliary duties, from negligence upon entering into the contract and from unlawful action. We shall not, therefore, be liable for damages that do not occur on the delivered goods themselves. Above all we shall not be liable for lost profits or other financial loss of the Buyer. The aforementioned restrictions of liability shall not apply if we have caused damages by wilful intent or gross negligence or if we have breached major contractual duties. In so far as we give advice on the processing possibilities of our yarn and other products whilst negotiating sales, we shall not be liable for damages incurred during said processing. If we breach a major contractual duty, we shall only be liable for the damages that can be reasonably foreseen as typical for the contract. For each claim to damages we shall only be liable up to the amount of double the purchase price of goods purchased from us.
2. The restriction of liability shall not apply in those cases in which we bear liability subject to the Product Liability Act for persons or damages to privately used items when the delivered goods feature errors. It shall also not apply for injury to life or limb, for the lack of assured attributes, if said assurance aimed to cover the Buyer for damages that did not occur on the delivered goods themselves. Claims of the Buyer to recourse against us shall only exist in so far as the Buyer has not made any arrangement with his customer that goes beyond the legal claims to defects.
Where our liability is ruled out or restricted, this shall likewise apply for the personal liability of our legal representatives, auxiliaries and vicarious agents.

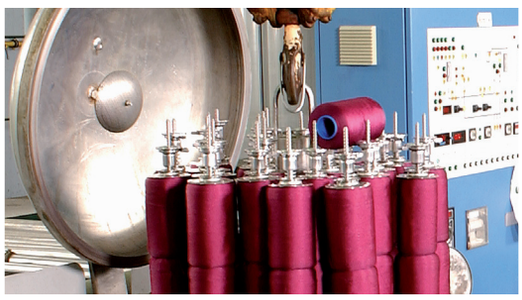
VIII. Offset and Retention
Notwithstanding his rights after giving notification of defects, the Buyer shall not be entitled to assert any right of refusal to pay the claims due to us or any right of retention, in so far as these are not based on the same contract. The Buyer shall also not be entitled to offset payment against a disputed claim or claim that has not been established by declaratory judgment.

IX. Data Protection
Pursuant to Section 26 Bundesdatenschutzgesetz [Federal Data Protection Act] the Buyer is notified that for the purposes of billing and other order confirmation, data is processed and saved electronically.

X. Safeguarding Clause, Place of Fulfilment, Place of Jurisdiction, Choice of Law
The invalidity of single provisions shall be without influence on the validity of the remaining provisions. The Parties shall replace the invalid provision by one that comes the closest to the business objective.
Amendments and/or additions shall require the written form to the exclusion of the electronic form. This requirement for the written form shall also apply to any cancellation of the written form.
Place of fulfilment for our deliveries and services and for customer payments shall be Freiburg in Breisgau, when the customer is a business person. The exclusive place of jurisdiction for disputes shall be Freiburg in Breisgau, providing the customer is a business person not subject to Section 4 HGB [German Commercial Code] or a business person who has no general place of jurisdiction in Germany.
If the Buyer has his registered seat of business in another country, the law of the Federal Republic of Germany shall apply exclusively, to the exclusion of the Uniform Law for the International Sale of Goods. The place of jurisdiction Freiburg shall also be deemed contracted if the Buyer against whom legal action is taken relocates his place of residence or regular whereabouts to another country after entering into the contract with us or if his place of residence or regular whereabouts are unknown at the time legal action is filed.

NOTES

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Presented by:

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