

Footwear Production Applications

Footwear Products Market - This end-use market can be divided into the following major sub-markets: 1) Athletic, 2) Boots & Heavy Shoes & 3) Dress/Casual Shoes.

Athletic - Uppers

Most athletic shoes uppers are sewn with nylon type 6.6 thread. The lasting thread is only used to hold a tape that is used attach the upper to a form so the shoe sole can be glued or vulcanized to the upper.

Seaming Thread

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (LBs)	Strength (KGs)	Comments
T-90	30	210d X 4	Anefil® Nylon	Twisted Multifilament - BT	RL	15.1	6.9	Seaming Thread
T-90	30	210d X 4	Anefil® Nylon	Twisted Multifilament - BT	HL	15.1	6.9	Heavy or Dense Fabrics
T-70	40	210d X 3	Anefil® Nylon	Twisted Multifilament - BT	RL	11.3	5.1	Seaming Thread
T-70	40	210d X 3	Anefil® Nylon	Twisted Multifilament - BT	HL	11.3	5.1	Heavy or Dense Fabrics

Lining Thread

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (LBs)	Strength (KGs)	Comments
T-45	60	210d X 2	Anefil® Nylon	Twisted Multifilament - BT	RL	7.4	3.4	Seaming Thread
T-60	50	20/2	Perma Spun®	100% Spun Polyester		5.2	2.4	Seaming Thread

Overedge – Lasting Thread

Size	Metric	Construction	Brand Name	Construction	Color	Strength (LBs)	Strength (KGs)	Comments
T-60	50	29/2	Perma Spun®	100% Spun Polyester	White	5.2	2.4	Serging Thread
T-45	60		Magic®	Air Entangled Polyester	White	5.2	2.4	Serging Thread
Cat #	Size	Construction	Brand Name	Construction	Color	Strength (LBs)	Strength (KGs)	Comments
DA70230	#11	1000dX10	10 Ply Polyester	100% CF Polyester - SST	White	100.0	45.4	String or Cord used for String Lasting - Ludlow LP1508
DA70205	#9	1000dX8	8 Ply Polyester	100% CF Polyester - SST	White	128.0	58.1	String or Cord used for String Lasting - Ludlow LP1508

Boots & Heavy Shoes

Most boot and heavy shoe uppers are sewn with nylon type 6.6 thread which has superior abrasion resistance properties as compared to polyester. Larger sizes of thread are used for bold topstitching on boots, etc..

Seaming Uppers - Nylon

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 135	M20	420d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	RL	23.8	10.8	Needle & Bobbin on Stress Seams & Needle Thread on Decorative Non-Stress Seams.
Tex 135	M20	420d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	HL	23.8	10.8	Needle & Bobbin on Stress Seams on Thick or Dense Fabrics
Tex 90	M30	280d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	RL	15.1	6.9	Bobbin Thread on Non-Stress Seams

Special Nylon Thread

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 210	M13	630d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	HL	34.8	15.8	Bold Topstitching
Tex 270	M10	840d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	HL	49.1	22.3	Extra Bold Topstitching
Tex 400	M8	1260d X 3	Anefil® Nylon	Twisted Multifilament - BT with Non-Wick	HL	74.6	33.8	Super Bold Topstitching

Seaming Uppers - Polyester

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 135	M20	420d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick	RL	20.0	9.1	Needle & Bobbin on Stress Seams & Needle Thread on Decorative Non-Stress Seams. Where Chemical Resistance Is Required.
Tex 135	M20	420d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick	HL	23.8	10.8	Needle & Bobbin on Stress Seams on Thick or Dense Fabrics. Where Chemical Resistance Is Required.
Tex 90	M30	280d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick	RL	15.1	6.9	Bobbin Thread on Non-Stress Seams

Special Polyester Thread

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 210	M13	630d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick		31.0	14.1	Bold Topstitching
Tex 270	M10	840d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick		41.1	18.6	Extra Bold Topstitching
Tex 400	M8	1300d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick		66.4	30.1	Super Bold Topstitching

Seaming Uppers - Kevlar®

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 135	M20	420d X 3	Anefil® Kevlar®	Twisted Multifilament - STX	RL	53.0	24.0	Needle & Bobbin on Stress Seams & Needle Thread on Decorative Non-Stress Seams.
Tex 90	M30	210d X 4	Anefil® Kevlar®	Twisted Multifilament - STX	RL	40.0	18.1	Bobbin Thread on Non-Stress Seams

Notes:

- A&E Prewound Bobbins available in ANEFIL® or ANECORD® (Common Styles = A, G, L, M, Y).
- DuPont™ and Kevlar® are registered Trademarks of E.I. du Pont de Nemours and Company and are used under license to A&E®.

Soles & Bottoming

Cat#	Size	Operation	Brand Name	Construction	Color	Strength (Lbs)	Strength (KGs)	Comments
DB70104	#554	Inseaming	#554 Monocord Polyester	Twisted Multifilament – BT with Non-Wick	White	90.0	48.0	Needle / Shuttle Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole
DB70106	#690	Inseaming	#690 Monocord Polyester	CF Monocord Polyester	White	100.0	45.4	Needle / Shuttle Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole
DA70103	#690	Lockstitch Seaming	#690 Polyester	Twisted Multifilament - SST	White	100.0	45.4	Needle Thread - Ludlow - DI1105 with - Polyester 3 Cord - Cabled Twist.
DB71116	#690	Shuttle	#690 Monocord Polyester	CF Monocord Polyester - STX	Black	90.0	40.8	Bobbin Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole

Special Bottoming Thread

Cat#	Size	Operation	Brand Name	Construction	Color	Strength (Lbs)	Strength (KGs)	Comments
2402200	#7	Lockstitch Seaming	#7 Apex Cotton Braid	Braided Cotton	White	NA	NA	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.
2404200	#7	Lockstitch Seaming	#7 Apex Cotton Braid	Braided Cotton	Colors	NA	NA	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.
D911110	#4	Lockstitch Seaming	#4 Apex Poly Braid	Braided Polyester	White	60	27.2	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.
D914110	#4	Lockstitch Seaming	#4 Apex Poly Braid	Braided Polyester	Colors	55	24.9	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.
D914130	#6	Lockstitch Seaming	#6 Apex Poly Braid	Braided Polyester	White	80	36.3	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.
D914135	#6	Lockstitch Seaming	#6 Apex Poly Braid	Braided Polyester	Colors	72	32.7	Used for Goodyear Welt Construction to Stitch the Upper, Lining, & Welt to the Insole.

Casual, Dress, & Light Weight Work Shoes

Casual, dress, and light weight work Shoes are sewn with both nylon and polyester threads. Generally, more colors are available in polyester than nylon threads.

Note: A&E Prewound Bobbins Available in Anefil® or Anecord® (Common Styles = A, G, L, M, Y).

Seaming Uppers - Nylon

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 70	M40	210d X 3	Anefil Nylon	Twisted Multifilament - BT	RL	11.3	5.1	Needle & Bobbin Threads
Tex 45	M60	210d X 2	Anefil Nylon	Twisted Multifilament - BT	RL	7.4	3.4	Bobbin Thread on Non-Stress Seams

Seaming Uppers - Polyester

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 70	M40	220d X 3	Anefil Polyester	Twisted Multifilament - BT	RL	10.0	4.6	Needle & Bobbin Threads. More Colors Available for Womens Wear.
Tex 45	M60	220d X 2	Anefil Polyester	Twisted Multifilament - BT	RL	6.6	3.0	Bobbin Thread on Non-Stress Seams & Stitching Linings

Special Polyester Threads

Size	Metric	Construction	Brand Name	Construction	Lube	Strength (Lbs)	Strength (KGs)	Comments
Tex 90	M30	220d X 4	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick	RL	15.1	6.9	For Bold Topstitching
Tex 135	M20	420d X 3	Anefil® Polyester	Twisted Multifilament - BT with Non-Wick	RL	20.0	9.1	For Extra Bold Topstitching

Waxed Hand Sewing - Polyester

Size	Operation	Brand Name	Construction	Color	Strength (Lbs)	Strength (KGs)	Comments
#4-3	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	35.0	15.9	Precut Lengths Available From 30" to 84"
#6-4	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	45.0	20.4	Precut Lengths Available From 30" to 84"
#8-5	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	57.0	25.9	Precut Lengths Available From 30" to 84"
#9-6	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	66.0	29.9	Precut Lengths Available From 30" to 84"
#11-7	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	77.0	34.9	Precut Lengths Available From 30" to 84"
#12-9	Hand Sewing	Ludlow® HMP Waxed Polyester	Monocord Polyester Construction	21	100.0	45.4	Precut Lengths Available From 30" to 84"

Soles / Bottoming

Cat#	Size	Operation	Brand Name	Construction	Color	Strength (Lbs)	Strength (KGs)	Comments
DB70102	#415	Inseaming	#415 Monocord Polyester	CT Monocord Polyester	White	70.0	31.8	Needle / Shuttle Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole
DB70104	#554	Inseaming	#554 Monocord Polyester	Twisted Multifilament - BT with Non-Wick	White	90.0	48.0	Needle / Shuttle Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole
DB70106	#690	Inseaming	#690 Monocord Polyester	CT Monocord Polyester	White	100.0	45.4	Needle / Shuttle Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole
DA70103	#690	Lockstitch Seaming	#690 Polyester	Twisted Multifilament - SST	White	100.0	45.4	Needle Thread - Ludlow - DI1105 with - Polyester 3 Cord - Cabled Twist.
DA71116	#690	Shuttle	#690 Monocord Polyester	CT Monocord Polyester - STX	Black	90.0	40.8	Bobbin Thread - Ludlow - Lp1548 with "T" Twist - Used for Seaming the Upper to the Welt & Mid-Sole

Note: * T-TWIST = Monocord Construction , Cable Twist = Twisted Multi-filament.

Littleway Construction

Cat#	Size	Operation	Brand Name	Construction	Color	Strength (Lbs)	Strength (KGs)	Comments
NA70206	346	Littleway Top Thread	346 Nylon Bt	Twisted Multi-Filament Nylon Bonded	White	55.0	24.9	Needle Thread
NA74230	346	Littleway Top Thread	346 Nylon Bt	Twisted Multi-Filament Nylon Bonded	Black	55.0	24.9	Needle Thread
NL11600	Tex 600	Littleway Prewound Bobbin	59 1/2 L Littleway Bobbin	Twisted Multi-Filament Nylon STX	White	84.0	38.1	Special Littleway Prewound Bobbin
NL14600	Tex 600	Littleway Prewound Bobbin	59 1/2 L Littleway Bobbin	Twisted Multi-Filament Nylon STX	Black	84.0	38.1	Special Littleway Prewound Bobbin