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Sirang Company  
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**SIRANG**coop  
colors Like the yarn's delicacy-1994

## About us

Yazd Sirang factories started their activity in 1994 in a land with an area of 150 thousand meters square. Aimed to create jobs in the province and improve the economic state of the people in Yazd, Eshkezar, and other towns, this production unit has now 1000 direct employees and provides 3000 indirect jobs. Its production capacity is 72100 tons per year and is now considered as one of the hubs of textile industries in the Middle East. The production lines of this company can produce various types of polyester and polypropylene yarns including POY microfilament, DTY microfilaments, ITY, POY, FDY, DTY, lycra, mélange, Schweitzer, TFO, BCF, and plastic, and paper spindles.

Depending on the applied chips, it can produce bright and semi-dull black, raw, or self-colored yarns with more than 3000 color diversities owing to being equipped with the dying system. In the year entitled “production, support, and resolving obstacles”, this complex employed the latest technologies and young experts to establish the production line of microfilament and ITY yarns which are highly used in the production of black chador to create jobs for more than 1000 people in addition to supplying the domestic market and prevent from currency exit from the country.

Quality control and laboratories of Sirang factory are equipped with various types of assessment instruments and can frequently measure different parameters such as weight uniformity, strength, elongation, shrinkage, and intermingles numbers. To have an effective presence in the global market, Sirang company managed to attain ISO 9001 (Iran-Germany Toufnavard, ISO 14001, OHSAS 18001 (LMS), 10004 standard of customer satisfaction system from Nobel Company, and product health standard from Acotex (Austria). To further develop and improve the quality, this complex established and implemented ISO/IEC 17025 standard in its labs and managed to attain the relevant certificates from the national qualification and standard organization of Iran.





## Honors



- ◆ Best Cooperative company of Yazd Province in 2010
- ◆ Best Cooperative company of Yazd Province in 2012
- ◆ Best Cooperative company of Yazd Province in 2015
- ◆ Best Cooperative company of Yazd Province in 2016
- ◆ Best Cooperative company of Yazd Province in 2018
- ◆ Best Cooperative company of Yazd Province in 2019,2021
- ◆ Customer right protection certificate in Yazd province, 2014
- ◆ Selected as distinguished complexes in economy and culture of the country 2014
- ◆ Selected industrial unit in 2011
- ◆ Selected industrial unit in 2015
- ◆ Selected industrial unit in 2016
- ◆ The best entrepreneur in 2015
- ◆ The best entrepreneur in 2019
- ◆ Certificate of commitment to enhancing cooperative management in 2015
- ◆ The best production unit of Yazd province in 2016
- ◆ Customer protection certificate in 2016
- ◆ The best exporter of Yazd province in 2019
- ◆ The best exporter of Yazd province in 2020,2021



## Our certificates and standards

- ◆ Health license of product from the national standard organization for POY yarn
- ◆ Health license of product from the national standard organization for FDY yarn
- ◆ Health license of product from the national standard organization for DTY yarn
- ◆ ISO/IEC 17025 laboratory systems standards
- ◆ Certificate of membership in the Research and Development and Innovation Association of Industries and Mines of Iran
- ◆ ISO9001:2015
- ◆ ISO14001
- ◆ ISO 45001
- ◆ ISO10668







**SIRANGcoop**

شرکت سیرنگ - ۱۳۷۳



Products

Products of Sirang production complex  
in terms of yarn count and filament

Denier / filament								
FDY	40/24	50/24	75/24	75/36	75/48	75/72	75/144	85/36
	100/36	100/48	100/72	100/96	100/144	150/48	150/72	200/48
	300/96	340/144	350/96	370/288	400/288	450/96	450/288	600/96
	600/192	800/192	900/192	1200/192				

Dtex / filament								
POY	75/36	85/24	85/36	130/36	180/36	180/48	180/72	225/48
	260/48	265/48	280/48	295/48	305/48	320/48	320/144	260/72
	370/96	400/96	420/96	420/144	450/96	500/96	500/144	550/96
	550/144	550/192	580/144	670/96	670/144	720/96	720/192	750/96
	830/192							

Dtex / filament								
POY -MICRO	40/36	50/36	65/36	65/72	75/72	85/72	130/72	130/144
	165/144	180/144	260/144	260/288	280/144	280/288	320/144	420/288
	500/288	550/288						

Dtex / filament					
ITY	85/72	130/108	135/108	165/108	200/108

Denier / filament								
DTY	75/36	100/36	100/48	150/48	150/72	170/48	200/72	200/92
	230/96	240/96	250/48	250/96	300/96	350/96	420/96	430/96
	450/96	300/144	430/144	450/144	300/192	430/192	500/192	900/192
	800/192	850/192	850/384	900/192	900/288	1000/192	1000/384	1050/384
	1200/384	1200/576	1800/384					

Denier / filament								
DTY -MICRO	30/36	40/36	45/36	50/36	40/72	45/72	50/72	75/72
	100/72	100/144	75/144	150/144	150/288	165/144	165/288	200/144
	200/288	200/384	250/288	255/144	300/144	300/288	330/144	350/288
	350/576	450/576	500/576	600/576	600/1152	900/864	1200/1152	

Denier / filament								
TFO	DTY	50/36	75/36	75/144	100/144	150/48	150/288	300/96
		900/288	1800/384	1200/384	1500/384			600/192
	FDY	75/36	100/36	150/48	300/96	450/96	1800/576	1350/288
	ITY	85/72	135/108					900/288

Denier / filament								
BCF	900/128	950/128	1000/128	1050/128	1100/128	1150/128	1200/128	1250/128
	1300/128	1350/128	1400/128	1450/128	1500/128	1550/128	1600/128	1650/128
	1700/128	1750/128	1800/128	1850/128	1900/128			

Denier/Filament * layer								
Multiply FDY	50/24*3	75/24*3	75/36*3	85/36*3	100/36*3	100/48*3	150/48*3	150/72*3
	300/96*3	340/144*3	350/96*3	370/288*3	400/288*3	450/96*3	450/288*3	600/96*3
	600/192*3	800/192*3	900/192*3	1200/192*3	50/24*2	75/24*2	75/36*2	85/36*2
	100/36*2	100/48*2	150/48*2	150/72*2	300/96*2	340/144*2	350/36*2	370/288*2
	400/288*2	450/96*2	450/288*2	600/96*2	600/192*2	800/192*2	900/192*2	1200/192*2

Denier / Filament * layer								
Multiply DTY	100/36*2	100/48*3	75/36*3	150/48*3	170/48*3	150/72*3	200/72*3	200/96*3
	230/96*3	240/96*3	350/96*3	250/96*3	300/96*3	350/96*3	420/96*3	430/96*3
	450/96*3	300/144*3	430/144*3	450/144*3	300/192*3	430/192*3	100/36*2	100/48*2
	75/36*2	150/48*2	170/48*2	150/72*2	200/72*2	200/96*2	230/96*2	240/96*2
	250/48*2	250/96*2	300/96*2	350/96*2	420/96*2	430/96*2	450/96*2	300/144*2

SIRANG's twisting machines are very flexible for producing multiply twisted yarns and have no limitation for denier, number of layers and twists for producing of final product. Please contact our sales experts for ordering yarn with especial twisting conditions

Danier+Stretch / filament							
LYCRA	25+20/48	30+20/36	35+20/48	50+20/36	50+20/72	50+40/72	75+20/36
	75+30/36	75+40/36	75+40/144	100+20/36	100+20/48	100+30/36	100+30/48
	100+40/36	100+40/48	100+40/144	150+20/48	150+20/72	150+30/48	150+30/72
	150+40/48	150+40/72	150+40/144	150+40/288	300+30/96	300+40/96	300+40/576
	300+70/96	450+40/96	450+40/144	450+70/96	450+70/144		

Denier / filament							
Schweitzer	75/36	100/36	100/48	150/48	150/72	300/96	450/96

Denier / filament							
Melange	150/72	150/96	200/72	300/96	300/144	400/192	500/192
	900/192	1200/384					600/192



## ◆ Polyester partially oriented yarn (POY) microfilament

The yarn count of normal polyester yarn is 3-6 Denier; while microfilament yarns have fine filaments whose yarn count is less than one Denier.

The presence of fine fibers in the yarns can lead to excellent properties such as high flexibility and a soft fabric handle. The drape of the fabrics will be excellent and they will exhibit proper thermal insulation. Sirang Company is capable of melt-spinning POY microfilament yarns in the yarn count range of 40-550 Dtex; the yarn count of each filament can reach 0.5 Denier.

### The table of producible yarn count

Sirang Company is capable of melt-spinning POY microfilament yarns in the yarn count range of 40-550 Dtex; the yarn count of each filament can reach 0.5 Denier.

POY -MICRO	Dtex / filament							
	40/36	50/36	65/36	65/72	75/72	85/72	130/72	130/144
	165/144	180/144	260/144	260/288	280/144	280/288	320/144	420/288
	500/288	550/288						

### Applications

- Women's wear
- Professional wears
- Fabrics used to clean microelectronic components
- Fabrics to polish lenses and sensitive optical devices
- Sportswear
- Filters



### ◆ Polyester drawn textured yarn microfilament

Compared to other textured yarns, DTY microfilament has a higher number of filaments and its filament yarn count is less than one Denier.

These filaments are finer than natural silk leading to the soft fabric handle.

#### Features

The small diameter of the microfilaments declined the flexural resistance of the yarn, hence incrementing the flexibility of the fabric leading to its proper drape. Its excellent water absorption is another feature of this yarn that will cause appropriate colorability of the yarn and fabrics, resulting in proper sweat absorption.

#### The table of producible yarn count

DTY -MICRO	Denier / filament							
	30/36	40/36	45/36	50/36	40/72	45/72	50/72	75/72
	100/72	100/144	75/144	150/144	150/288	165/144	165/288	200/144
	200/288	200/384	250/288	255/144	300/144	300/288	330/144	350/288
	350/576	450/576	500/576	600/576	600/1152	900/864	1200/1152	

#### Applications

- Women's wear
- Underwear
- Sportswear
- Black chador
- Outerwears
- Cleaning cloth

### ◆ Polyester Intermingled textured yarn (ITY)

Intermingled textured yarn (ITY) filaments which are also known as BSY or self-textured, refer to a group of filament yarns produced without texturizing process only by thermal treatment. Their handle is similar to the fabrics produced from textured yarns. These yarns have now found a significant share of the fabrics market, especially in women's wear.

Their production relies on merging two filament yarns with different shrinkage properties (e.g. FDY and POY). In the next steps, one of these yarns shrinks around the other giving rise to a soft handle similar to the textured fabrics.

The fabrics produced from these yarns can be classified into three classes:

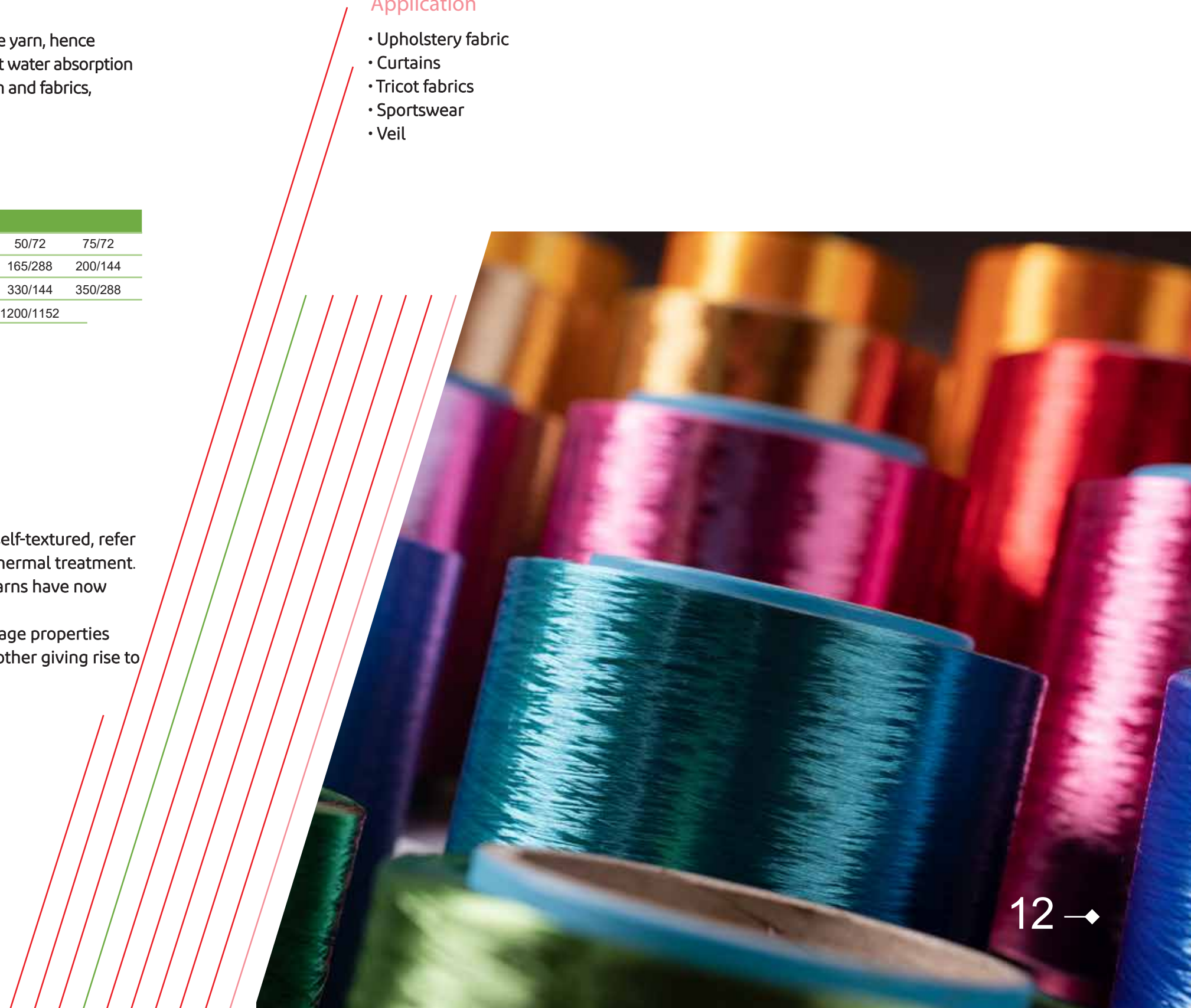
- 1- The soft handle of peach skin fabric
- 2- Silky handle (scroop fabric)
- 3- Santoon handle

#### Table of the producible yarn count

ITY	Dtex / filament				
	85/72	130/108	135/108	165/108	200/108

#### Application

- Upholstery fabric
- Curtains
- Tricot fabrics
- Sportswear
- Veil





## ◆ Polyester fully drawn yarn (FDY)

FDY refers to the yarns produced by melt-spinning of semi-dull and bright polyester chips along with drawing on POY followed by heat stabilization for full orientation

These yarns are produced in Sirang Company in both white and self-colored (using colored masterbatch and pigments) in the yarn count range of 50-1200 Denier. They can be used as a raw material for producing twisted yarns or directly applied to fabrics. These yarns are produced at high speeds (3800 m/min) and the main features of the yarn including strength, elongation, uniformity of stretch and boiling water shrinkage are closely controlled during polymerization and production procedures

FDYs of Sirang factory have high color diversity and can be found in various fluorescent types, high and low shrinkage, and filament

Table of producible yarn count

FDY	Dtex / filament							
	40/24	50/24	75/24	75/36	75/48	75/72	75/144	85/36
	100/36	100/48	100/72	100/96	100/144	150/48	150/72	200/48
	300/96	340/144	350/96	370/288	400/288	450/96	450/288	600/96
	600/192	800/192	900/192	1200/192				

To receive the color catalog of FDY products of Sirang Company refers to Sirang website on <https://Sirangcoop.com/en>

### Applications

- Raw material for the production of twisted yarns
- Curtain and Upholstery fabrics
- Scarf
- Chenille yarn
- Crepe
- Embroidery and sewing yarn
- Rachel blanket

## ◆ Polyester partially oriented yarn (POY)

POY is a type of yarn produced by melt-spinning using polyester semi-dull or super bright chips in white or self-colored pigments. Its filament yarns can be employed as the raw material in the texturizing units to produce textured DTY and ATY. POYs are produced at the rate of 2800-3600 m/min with low crystallinity. Its orientation and structure are suitable enough to be stored for several months with no brittleness or deformation.

### Production process

- Crystallization and drying
- Extrusion and spinning

Table of the producible yarn count

POY	Dtex / filament							
	75/36	85/24	85/36	130/36	180/36	180/48	180/72	225/48
	260/48	265/48	280/48	295/48	305/48	320/48	320/144	260/72
	370/96	400/96	420/96	420/144	450/96	500/96	500/144	550/96
	550/144	550/192	580/144	670/96	670/144	720/96	720/192	750/96

### Applications

- As a raw material for the production of textured DTY and ATY
- Curtain and Upholstery fabrics
- Sportswear (especially winter sports)
- Underwear
  - Socks and shirts
  - Knitted fabric



## ◆ Polyester drawn textured yarn

### (DTY) with a false twist

To approach the appearance and physical features of natural fibers, synthetic yarns (polyester, nylon, polypropylene, ...) are textured.

#### Texturizing process

The handle of the yarn can be improved by heat treatment, drawing, false twisting, and spin finish to give rise to softer and fluffier yarns with high elasticity. Their light reflection features could be also modified (i.e. duller yarns)

Intermingled yarns are often used as a wrap in woven fabrics while plain yarns serve as the weft. Plain yarns are, however, employed in circular knitting.

#### Types:

DTYs also known as trivera and filament, can be found in three types: plain, intermingled, and co-mingled in various colors and yarn count ranges (100-1200 Denier).

#### Table of the producible yarn count

DTY	Denier / filament							
	75/36	100/36	100/48	150/48	150/72	170/48	200/72	200/92
	230/96	240/96	250/48	250/96	300/96	350/96	420/96	430/96
	450/96	300/144	430/144	450/144	300/192	430/192	500/192	900/192
	800/192	850/192	850/384	900/192	900/288	1000/192	1000/384	1050/384
	1200/384	1200/576	1800/384					

To obtain the color catalog of FDY products of Sirang Company, refer to Sirang website on <https://Sirangcoop.com/en>

#### Applications

- Curtain, shirt, sheet, suit, tweed, and Upholstery
- Carpet and prayers carpet
- Industrial uses
- Rachel blanket
- Machine carpet
- Tricot, denim, and mantua
- Car seat Upholstery

## ◆ Polyester mélange yarn

Mélange yarns are produced by a combination of 2, 3, or 4 yarns with different colors in co-mingled or mingled forms. The color contrast will result in a new color with special effects.

In Sirang factories, fibers are precisely mixed at a proper ratio to obtain high-quality mélange yarns

The yarn count of the mélange yarns ranges in 150-1200 denier.

#### Table of producible yarn count

Melange	Denier / filament						
	150/72	150/96	200/72	300/96	300/144	400/192	500/192
	900/192	1200/384					600/192

#### Applications

- Tweed, and woven fabrics
- Single-faced, double-faced, and cotton jersey (circular knitted) fabrics
- Sportswear
- Sweater
- Homewear clothes
- T-shirts
- Hoody
- Car seat



## ◆ Polyester Lycra (Spandex or elastane)

Lycra yarn or spandex is a combination of DTY and a type of elastane yarn based on polyurethane. The elastane yarn is often in the yarn count range of 20, 30, 40, and 70 deniers leading to the final yarn count of 80-600 denier.

### Features

Thanks to its high elongation, fabrics made from spandex yarns have excellent elasticity and can elongate 3 to 4 times their initial length with no damage to the fabric. The size of the clothes will not change after washing even with hot water.

Spandex yarns are highly important in the production of clothes requiring high mobility as well as home clothes. They can be also employed in fashion designs by creating attractive styles.

## ◆ Table of the producible yarn count :

LYCRA	Danier+Stretch / filament						
	25+20/48	30+20/36	35+20/48	50+20/36	50+20/72	50+40/72	75+20/36
	75+30/36	75+40/36	75+40/144	100+20/36	100+20/48	100+30/36	100+30/48
	100+40/36	100+40/48	100+40/144	150+20/48	150+20/72	150+30/48	150+30/72
	150+40/48	150+40/72	150+40/144	150+40/288	300+30/96	300+40/96	300+40/576
	300+70/96	450+40/96	450+40/144	450+70/96	450+70/144		

### Applications

- Socks
- Gloves
- Swimming suite
- Elastic crepe and stretch fabrics
- Pantyhose
- Sportswear
- Shirt
- Elastic bandage

## ◆ Polyester Schweitzer yarn

This type of yarn, known as the sewing and locksnitch yarn in Iran, is produced on conic spindles with a length of 23 cm and a weight range of 800 to 1200 g.

The conic shape of the spindle combined with the zigzag twist of the yarn on the spindle facilitates the opening of the yarn with no falling. Depending on the state of the application, the spindle can be placed vertically or horizontally. Therefore, in addition to sewing, these yarns can be applied in knitting applications if necessary.

Schweitzer yarns can be found in plain, co-mingled, mingled, and twisted in a vast yarn count range (75-450 denier) and diverse colors.

In the final stage of its production, lubricant and antistatic oils are used to enhance its quality and facilitate its applications. This will decline the friction between the yarn and needle to avoid warming and breakage of the needle.

### Producible Yarn count

Schweitzer	Denier / filament						
	75/36	100/36	100/48	150/48	150/72	300/96	450/96

### Applications

- Sewing
- serging





## ◆ Multiply Polyester Yarn

Multiply yarns are obtained by twisting two or three DTY, ITY and FDY yarns. First, two or three yarns twist on the machine and while twisting it will become multiply. Then for yarn cohesion, the obtained thread will be twisted in an opposite direction and then twist fixing procedure will be done on it by steam. So, the final product is multiply twisted thread.

### Attributes

Multiply yarns are high strength and their most usage is for clothing industry, sewing clothes, bag and shoes. Another usage of them is for producing rope, sack weaving, curtain hanger, carpet string, etc.

### Yarn scores can be produced ◆

Multiply twisted yarns which produce in SIRANG coop., are in the range of 60-2700 denier and twisting number's range is 50 to 1000.

Denier/Filament * layer								
Multiply FDY	50/24*3	75/24*3	75/36*3	85/36*3	100/36*3	100/48*3	150/48*3	150/72*3
	300/96*3	340/144*3	350/96*3	370/288*3	400/288*3	450/96*3	450/288*3	600/96*3
	600/192*3	800/192*3	900/192*3	1200/192*3	50/24*2	75/24*2	75/36*2	85/36*2
	100/36*2	100/48*2	150/48*2	150/72*2	300/96*2	340/144*2	350/36*2	370/288*2
	400/288*2	450/96*2	450/288*2	600/96*2	600/192*2	800/192*2	900/192*2	1200/192*2

Denier / Filament * layer								
Multiply DTY	100/36*2	100/48*3	75/36*3	150/48*3	170/48*3	150/72*3	200/72*3	200/96*3
	230/96*3	240/96*3	350/96*3	250/96*3	300/96*3	350/96*3	420/96*3	430/96*3
	450/96*3	300/144*3	430/144*3	450/144*3	300/192*3	430/192*3	100/36*2	100/48*2
	75/36*2	150/48*2	170/48*2	150/72*2	200/72*2	200/96*2	230/96*2	240/96*2
	250/48*2	250/96*2	300/96*2	350/96*2	420/96*2	430/96*2	450/96*2	300/144*2
	430/144*2	450/144*2	300/192*2	430/192*2				



## ◆ Polyester two for one yarn

During twisting axial forces compress the filaments and enhance the integrity of the filaments, hence incrementing the yarn strength.  
By disturbing the parallel arrangement of the filaments, the twisting process can improve the handle of the yarn and decline the sliding properties of the yarn by increasing the surface friction.

### Features

The changes in the orientation of the filaments compared to the yarn axis can result in irregular light reflection from the yarn; hence decrementing its brightness.  
The twisting process can also alter the ribbon-like state of the yarn and lead to a rounder cross-section.  
The twisting machines of Sirang factories can twist DTY, FDY, ITY, and BCF yarns, single or multiple. They can produce products in the range of 50-2400 denier with the rate of 40-1600 twists per miter.  
TFO yarns are often used as wrap yarns.

Table of producible yarn count

		Denier / filament							
TFO	DTY	50/36	75/36	75/144	100/144	150/48	150/288	300/96	600/192
		900/288	1800/384	1200/384	1500/384				
	FDY	75/36	100/36	150/48	300/96	450/96	1800/576	1350/288	900/288
	ITY	85/72	135/108						

### Application

- Women's wear, curtain, shirt, chador, Termeh, crepe, tweed
- Shawl, scarf
- Machine-knitted carpet
- Upholstery
- Bedsheet
- Sewing yarn

## ◆ Polypropylene bulk textured filament (BCF) yarn

BCF yarns are produced from polypropylene by the melt-spinning process. The main superiority of this yarn is its integrity, bulkiness, and dull appearance. Therefore, this yarn could be a proper substitute for acrylic and wool yarns in the production of machine-made carpets.  
The carpets made from BFC yarns have no lints since the lints can not easily exit the carpet due to the integrity of the carpets.

Table of the producible yarn count

BCF	Denier / filament							
	900/128	950/128	1000/128	1050/128	1100/128	1150/128	1200/128	1250/128
	1300/128	1350/128	1400/128	1450/128	1500/128	1550/128	1600/128	1650/128
	1700/128	1750/128	1800/128	1850/128	1900/128			

### Applications

- Production of machine-knitted carpets
- Different types of mat
- rug
- Upholstery
- Moquette
- Kilim
- Carpet pile
- Woolen yarn





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◆ control plan

All products of the Sirang complex are continuously investigated in the quality control units using the latest and most precise equipment. At any working shifts, random samples are determined according to the instructions and all the physical properties of the yarn are measured. If even one of the cases fails in complying with the standards (international, national, or client demands) the defects will be immediately informed to the production unit. If the defects are not resolved, the production of the non-standard products will be prevented or even sometimes the production line will be stopped.

Quality properties tested in Sirang laboratories

- Linear density determination test
- Spin finish percentage determination or OPU
- Determination of twists in TFO or TFYs
- Determination of the evenness of yarn
- Determination of the shrinkage of yarn
- Determination of the yarn strength, rupture limit
- Yarn elongation at break test
- Determination of the number of mingles

In the continue, the principles based on which the compliance of the product or its grade is determined will be explained for FDY, POY, and DTY products.

Physical properties of FDY ◆

Shrinkage (%)		Mingle number (N/m)		Spin finish (%)		Elangation (%)		Strength (g/denier)		yarn count (denier)		yarn count (denier)
A	ISIRI 925	A	ISIRI 925	A	ISIRI 925	A	ISIRI 925	A	ISIRI 925	A	ISIRI 925	
5%-8%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	48-52	48/75-51/25	50
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	88-87 (3±83)	73/2-76/8	75
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	116-106 (5±111)	98-102	100
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	173-159 (7±166)	147-153	150
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	340-326 (7±333)	294-306	300
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	395-381 (7±388)	343-357	350
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	(490-510) (10±500)	441-459	450
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	676-656 (10±666)	588-612	600
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	1015-985 (15±1000)	888-918	900
5%-9%	≤15%	8 ≤	15 ≤	0/7-1 (0/85±0/15)	0/7-1/3 (1±0/3)	18-48 (33±15)	18-48 (33±15)	3.55 ≤	4 ≤	1348-1318 (15±1333)	1176-1224	1200



Physical properties of DTY

Residual twist		Stability of mangle points (%)			Texturizing oil (%)		Elongation (%)		Strength (denier/g)		yarn count denier		yarn count denier
ISIRI 927		ISIRI 927			A	ISIRI 927	A	ISIRI 927	A	ISIRI 927	A	ISIRI 927	
H.I.M Mingled	N.I.M simple	poor	moderate	strong									
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	19/4-20/6 (20±0/6)	19/48-20/52	20
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	48/5-51/5 (20±0/6)	48/7-51/3	50
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	72/75-77/25 (75±2/25)	73/05-76/95	75
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	97-103 (100±3)	97/4-102/6	100
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	144-156 (150±6)	145/5-154/5	150
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	240-280 (250±10)	242/5-257/5	250
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	288-312 (300±12)	291-309	300
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	432-4568 (450±18)	436/5-413/5	450
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	576-624 (600±24)	582-618	600
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	864-936 (900±36)	873-927	900
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	1152-1248 (1200±48)	1164-1236	1200
≥ 30	≥ 35	> 80	80 ≥	92≥	0/8-3/2 (2±1/2)	1-3 (2±1)	15-35 (25±10)	17-30 (23/5±6/5)	3/2≥	3/5≥	1728-1872 (1800±72)	1146-1854	1800

Physical properties of POY

Mingles (N/m)		Spin Finish (%)		Elongation		Strength (cN/Dtex)		yarn count (Dtex)		Dtex
Allowed number of mingles	ISIRI 6007	A	ISIRI 6007	A	ISIRI 6007	A	ISIRI 6007	A	ISIRI 6007	
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	53-57 (55±2)	53/7-56/3 (55±1/3)	55
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	82-88 (85±3)	82/9-87/1 (85±2/1)	85
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	135-125 (5±130)	127/4-132/6 (130±2/6)	130
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	185-175 (5±180)	176/4-183/6 (180±3/6)	180
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	267-253 (7±260)	254/8-265/2 (260±5/2)	260
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	287-273 (7±280)	254/8-265/2 (260±5/2)	280
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	510-490 (10±500)	490-510 (500±10)	500
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	762-738 (12±840)	735-765 (750±15)	750
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	852-828 (12±840)	823/2-858/8 (840±16/8)	840
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	1015-985 (15±1000)	980-1020 (1000±20)	1000
3≥	Unknown	0/25%-0/5%	0/25%-1%	130-148 (139±9)	100- 170 (135±35)	1/8≥	1/8≥	1267-1233 (17±1250)	1225-1275 (1250±25)	1250



◆ Packing Plan

Bag	Box pallet	Spindle pallet	Box	Range	Yarn type
\\\\\\\\\\	48 spindle	30 spindle	1 spindle	min	FDY
\\\\\\\\\\	60 spindle	72 spindle	2 spindle	max	
\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	30 spindle	1 spindle	min	POY
\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	84 spindle	2 spindle	max	
\\\\\\\\\\	Schweiter spindle (48 boxes) (686 spindles)	144 spindle	Full: 4 spindle	min	DTY
\\\\\\\\\\	Normal spindle (48 boxes) (168 spindles)		Moderate: 9 spindle Fine: 16 spindle	max	
\\\\\\\\\\	75-g spindle (36 boxes) (273 spindles)	\\\\\\\\\\\\\\\\\\	12 spindle	min	TFO
\\\\\\\\\\	50-g spindle (36 boxes) (436 spindles)	\\\\\\\\\\\\\\\\\\	13 spindle	max	
\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	9 spindle	\\\\\\\\\\\\\\\\\\	Lycra
\\\\\\\\\\	36 boxes (684 spindles 19 spindle/box)	\\\\\\\\\\\\\\\\\\	19 spindles per box	\\\\\\\\\\\\\\\\\\	Schweitzer yarn
6 spindle	\\\\\\\\\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	\\\\\\\\\\\\\\\\\\	min	BCF
9 spindle				max	

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