



Designation: **E11–17 E11 – 20**

## Standard Specification for Woven Wire Test Sieve Cloth and Test Sieves<sup>1</sup>

This standard is issued under the fixed designation E11; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the U.S. Department of Defense.*

### 1. Scope\*

1.1 This document specifies the technical requirements for; the woven wire test sieve cloth (sieve cloth) used in test sieves, the construction of test sieves, standard and non-standard test sieve frame sizes, and test procedures used to inspect sieve cloth and the test sieves. This specification applies to test sieves manufactured with sieve cloth having a nominal aperture size ranging from 125 millimetres (mm) down to 20 micrometres ( $\mu\text{m}$ ).

1.2 Additional reference information can be found in Specifications **E161**, **E323**, **E2016**, and in Test Methods **C430** and **E2427**.

1.3 The values stated in SI units shall be considered standard for the dimensions of the sieve cloth openings and the wire diameters used in the sieve cloth. The values stated in inch-pound units shall be considered standard with regard to the sieve frames, pans, and covers.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate ~~safety~~ safety, health, and ~~health~~ environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

### 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

**C430** Test Method for Fineness of Hydraulic Cement by the 45- $\mu\text{m}$  (No. 325) Sieve

**E161** Specification for Electroformed Material and Test Sieves

**E323** Specification for Perforated-Plate Sieves for Testing Purposes

**E1638** Terminology Relating to Sieves, Sieving Methods, and Screening Media

**E2016** Specification for Industrial Woven Wire Cloth

**E2427** Test Method for Acceptance by Performance Testing for Sieves

2.2 *ASTM Manual:*<sup>2</sup>

**Manual 32** Test Sieving Methods: Guidelines for Establishing Sieve Analysis Procedures; 5<sup>th</sup> Edition

2.3 *Federal Standard:*<sup>3</sup>

**Fed. Std. No. 123** Marking for Shipment (Civil Agencies)

2.4 *Military Standard:*<sup>3</sup>

**MIL-STD-129** Marking for Shipment and Storage

2.5 *ISO Standard:*<sup>4</sup>

**ISO 3310-1** Test Sieves—Technical Requirements and Testing – Part 1: Test Sieves of Metal Wire Cloth

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee **E29** on Particle and Spray Characterization and is the direct responsibility of Subcommittee **E29.01** on Sieves, Sieving Methods, and Screening Media.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://www.dodssp.daps.mil.

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, http://www.ansi.org.

\*A Summary of Changes section appears at the end of this standard

### 3. Terminology

3.1 *Definitions*—Additional terms can be found in Terminology E1638.

3.1.1 *aperture*—*aperture, n*—the dimension defining an opening in a screening surface.

3.1.2 *backing cloth*—~~a wire mesh support layer used directly under the sieve cloth with an opening coarser than the sieve designation.~~

3.1.2 *crimp*—~~*backing cloth, n*—the corrugation in the warp and shute wire, or both. The crimp in the wires is formed either during the weaving process, or with a crimping machine prior to weaving. If formed during the weaving process, the tension existing between the warp and shute wires fundamentally determines the respective amount or depth of crimp, which locks the wires in place, and in part establishes the firmness of the sieve cloth.~~ a wire mesh support layer used directly under the sieve cloth with an opening coarser than the sieve designation.

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**TABLE 1 Nominal Dimensions and Permissible Variations for Sieve Cloth and Compliance, Inspection and Calibration Test Sieves**

(1)	(2a)	(2b)	(3) <sup>A</sup>	(4)	(5)	(6)	(7)	(8)	(9) <sup>B, C</sup>	(10)	(11) <sup>B, C</sup>	(12)	(13)	(14)	(15)
Standard	Sieve Designation		Nominal Sieve Opening	±Y Variation for Average Opening	+X Maximum Variation for Opening	Resulting Maximum Individual Opening	Compliance Sieves		Inspection Sieves		Calibration Sieves		Typical Wire Diameter	Permissible Average Wire Diameter	
	U.S. Alternative	Supplementary Size					Sample Openings per 100 ft <sup>2</sup>	Maximum Standard Deviation	Sample Openings per Sieve	Maximum Standard Deviation	Sample Openings per Sieve	Maximum Standard Deviation		Min	Max
	mm	mm	in.	mm	mm	mm							mm		
125	5 in.		5.00	3.30	4.06	129.06	20	—	all	—	all	—	8.00	6.8	9.2
		112	4.41	2.96	3.74	115.74	20	—	all	—	all	—	8.00	6.8	9.2
106	4.24 in.		4.24	2.80	3.59	109.59	20	—	all	—	all	—	6.30	5.4	7.2
100	4 in.		4.00	2.65	3.44	103.44	20	—	all	—	all	—	6.30	5.4	7.2
90	3½ in.		3.50	2.39	3.18	93.18	20	—	all	—	all	—	6.30	5.4	7.2
		80	3.15	2.13	2.91	82.91	20	—	all	—	all	—	6.30	5.4	7.2
75	3 in.		3.00	2.00	2.78	77.78	20	—	all	—	all	—	6.30	5.4	7.2
		71	2.80	1.89	2.67	73.67	20	—	all	—	all	—	5.60	4.8	6.4
63	2½ in.		2.50	1.69	2.44	65.44	20	—	all	—	all	—	5.60	4.8	6.4
		56	2.20	1.50	2.24	58.24	20	—	all	—	all	—	5.00	4.3	5.8
53	2.12 in.		2.12	1.42	2.15	55.15	20	—	all	—	all	—	5.00	4.3	5.8
50	2 in.		2.00	1.34	2.06	52.06	20	—	all	—	all	—	5.00	4.3	5.8
45	1¾ in.		1.75	1.21	1.91	46.91	20	—	all	—	all	—	4.50	3.8	5.2
		40	1.57	1.08	1.75	41.75	20	—	all	—	all	—	4.50	3.8	5.2
37.5	1½ in.		1.50	1.01	1.67	39.17	20	1.103	all	—	all	—	4.50	3.8	5.2
		35.5	1.40	0.961	1.60	37.10	20	1.035	all	—	all	—	4.00	3.4	4.6
31.5	1¼ in.		1.25	0.855	1.47	32.97	20	0.907	all	—	all	—	4.00	3.4	4.6
		28	1.10	0.762	1.35	29.35	20	0.802	all	—	all	—	3.55	3.0	4.1
26.5	1.06 in.		1.06	0.722	1.29	27.79	20	0.758	all	—	all	—	3.55	3.0	4.1
25	1.00 in.		1.00	0.682	1.24	26.24	20	0.715	all	—	all	—	3.55	3.0	4.1
22.4	¾ in.		0.875	0.613	1.14	23.54	150	0.641	15	0.431	30	0.460	3.55	3.0	4.1
		20	0.787	0.548	1.05	21.05	150	0.575	15	0.387	30	0.413	3.15	2.7	3.6
19	¾ in.		0.750	0.522	1.01	20.01	150	0.548	15	0.368	30	0.393	3.15	2.7	3.6
		18	0.709	0.495	0.97	18.97	150	0.521	15	0.350	30	0.374	3.15	2.7	3.6
16	⅝ in.		0.625	0.441	0.89	16.89	150	0.467	15	0.314	30	0.335	3.15	2.7	3.6
		14	0.551	0.387	0.81	14.81	150	0.414	15	0.278	30	0.297	2.80	2.4	3.2
13.2	0.530 in.		0.530	0.365	0.78	13.98	150	0.393	15	0.264	30	0.282	2.80	2.4	3.2
12.5	½ in.		0.500	0.346	0.75	13.25	150	0.374	15	0.251	30	0.268	2.50	2.1	2.9
11.2	⅞ in.		0.438	0.311	0.69	11.89	150	0.340	15	0.229	30	0.244	2.50	2.1	2.9
		10	0.394	0.279	0.64	10.64	150	0.308	15	0.207	30	0.221	2.50	2.1	2.9
9.5	⅝ in.		0.375	0.265	0.61	10.11	150	0.294	15	0.198	30	0.211	2.24	1.9	2.6
		9	0.354	0.251	0.59	9.59	150	0.281	15	0.189	30	0.202	2.24	1.9	2.6
8	⅝ in.		0.312	0.224	0.54	8.54	150	0.254	15	0.171	30	0.182	2.00	1.7	2.3
		7.1	0.280	0.200	0.50	7.60	150	0.230	15	0.155	30	0.165	1.80	1.5	2.1
6.7	0.265 in.		0.265	0.189	0.48	7.18	150	0.219	15	0.147	30	0.157	1.80	1.5	2.1
6.3	¼ in.		0.250	0.178	0.46	6.76	150	0.208	15	0.140	30	0.149	1.80	1.5	2.1
5.6	No. 3½		0.223	0.159	0.42	6.02	150	0.189	15	0.127	30	0.136	1.60	1.3	1.9
		5	0.197	0.142	0.39	5.39	150	0.172	15	0.116	30	0.123	1.60	1.3	1.9
4.75	No. 4		0.187	0.135	0.37	5.12	150	0.165	15	0.111	30	0.118	1.60	1.3	1.9
		4.5	0.177	0.128	0.36	4.86	150	0.158	15	0.106	30	0.113	1.40	1.2	1.7
4	No. 5		0.157	0.114	0.33	4.33	150	0.143	15	0.096	30	0.103	1.40	1.2	1.7
		3.55	0.140	0.102	0.30	3.85	200	0.130	20	0.092	40	0.097	1.25	1.06	1.50
3.35	No. 6		0.132	0.096	0.29	3.64	200	0.125	20	0.088	40	0.093	1.25	1.06	1.50
		3.15	0.124	0.091	0.28	3.43	200	0.119	20	0.084	40	0.089	1.25	1.06	1.50
2.8	No. 7		0.110	0.081	0.26	3.06	200	0.108	20	0.076	40	0.081	1.12	0.95	1.30
		2.5	0.0984	0.073	0.24	2.74	200	0.099	20	0.070	40	0.074	1.00	0.85	1.15
2.36	No. 8		0.0937	0.069	0.23	2.59	200	0.095	20	0.067	40	0.071	1.00	0.85	1.15
		2.24	0.0882	0.065	0.22	2.46	200	0.091	20	0.064	40	0.068	0.90	0.77	1.04
2	No. 10		0.0787	0.059	0.20	2.20	250	0.083	25	0.060	50	0.064	0.90	0.77	1.04
		1.8	0.0709	0.053	0.19	1.99	250	0.077	25	0.056	50	0.059	0.80	0.68	0.92
1.7	No. 12		0.0661	0.050	0.18	1.88	250	0.074	25	0.054	50	0.057	0.80	0.68	0.92

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TABLE 1 Continued

(1) Standard	(2a)		(2b)	(3) <sup>A</sup>	(4)	(5)	(6)	(7)		(8)	(9) <sup>B, C</sup>		(10)	(11) <sup>B, C</sup>		(12)	(13)	(14)		(15)
	Sieve Designation			Nominal Sieve Opening	±Y Variation for Average Opening	+X Maximum Variation for Opening	Resulting Maximum Individual Opening	Compliance Sieves		Inspection Sieves		Calibration Sieves		Typical Wire Diameter	Permissible Average Wire Diameter		Min	Max		
	U.S. Alternative	Supplementary Size						Sample Openings per 100 ft <sup>2</sup>	Maximum Standard Deviation	Sample Openings per Sieve	Maximum Standard Deviation	Sample Openings per Sieve	Maximum Standard Deviation							
1.4	No. 14		1.6	0.0630 0.0555	0.047 0.042	0.17 0.16	1.77 1.56	250 400	0.070 0.064	25 40	0.051 0.050	50 80	0.054 0.052	0.80 0.71	0.68 0.60	0.92 0.82				
1.18	No. 16		1.25	0.0492 0.0469	0.038 0.036	0.15 0.14	1.40 1.32	400 400	0.058 0.056	40 40	0.045 0.043	80 80	0.047 0.045	0.63 0.63	0.54 0.54	0.72 0.72				
1	No. 18		1.12	0.0441 0.0394	0.034 0.030	0.14 0.13	1.26 1.13	400 400	0.054 0.050	40 40	0.042 0.039	80 80	0.044 0.040	0.56 0.56	0.48 0.48	0.64 0.64				
			µm	in.	µm	µm	µm							mm						
850	No. 20		900	0.0354 0.0331	27.6 26.2	118 114	1018 964	400 400	45.51 43.66	40 40	35.22 33.79	80 80	36.74 35.25	0.500 0.500	0.43 0.43	0.58 0.58				
710	No. 25		800	0.0315 0.0278	24.8 22.2	109 101	909 811	400 500	41.79 38.36	40 50	32.34 30.43	80 100	33.74 31.62	0.450 0.450	0.38 0.38	0.52 0.52				
600	No. 30		630	0.0248 0.0234	19.9 19.0	93 91	723 691	500 500	35.23 34.04	50 50	27.95 27.00	100 100	29.04 28.06	0.400 0.400	0.34 0.34	0.46 0.46				
500	No. 35		560	0.0220 0.0197	17.9 16.2	87 80	647 580	500 600	32.43 29.96	50 60	25.73 24.21	100 120	26.73 25.09	0.355 0.315	0.30 0.27	0.41 0.36				
425	No. 40		450	0.0177 0.0165	14.7 14.0	75 73	525 498	600 600	27.86 26.79	60 60	22.51 21.65	120 120	23.32 22.43	0.280 0.280	0.24 0.24	0.32 0.32				
355	No. 45		400	0.0157 0.0139	13.3 12.0	70 65	470 420	600 800	25.71 23.72	60 80	20.78 19.68	120 160	21.52 20.30	0.250 0.224	0.21 0.19	0.29 0.26				
300	No. 50		315	0.0124 0.0117	10.8 10.4	60 58	375 358	800 800	21.90 21.20	80 80	18.17 17.59	160 160	18.75 18.15	0.200 0.200	0.17 0.17	0.23 0.23				
250	No. 60		280	0.0110 0.0098	9.8 8.9	56 52	336 302	800 800	20.26 18.82	80 80	16.81 15.61	160 160	17.34 16.11	0.180 0.160	0.15 0.13	0.21 0.19				
212	No. 70		224	0.0088 0.0083	8.1 7.8	49 47	273 259	800 800	17.53 16.93	80 80	14.54 14.05	160 160	15.01 14.49	0.160 0.140	0.13 0.12	0.19 0.17				
180	No. 80		200	0.0079 0.0070	7.4 6.8	45 43	245 223	800 1000	16.32 15.27	80 100	13.54 12.91	160 200	13.97 13.28	0.140 0.125	0.12 0.106	0.17 0.150				
150	No. 100		160	0.0063 0.0059	6.3 6.0	40 38	200 188	1000 1000	14.20 13.65	100 100	12.00 11.53	200 200	12.34 11.86	0.112 0.100	0.095 0.085	0.130 0.115				
125	No. 120		140	0.0055 0.0049	5.7 5.2	37 34	177 159	1000 1000	13.09 12.23	100 100	10.55 10.33	200 200	11.06 10.63	0.100 0.090	0.085 0.077	0.115 0.104				
106	No. 140		112	0.0044 0.0041	4.8 4.7	32 31	144 137	1000 1000	11.46 11.10	100 100	9.68 9.38	200 200	9.96 9.65	0.080 0.071	0.068 0.060	0.092 0.082				
90	No. 170		100	0.0039 0.0035	4.5 4.2	30 29	130 119	1000 1000	10.73 10.10	100 100	9.07 8.53	200 200	9.33 8.78	0.071 0.063	0.060 0.054	0.082 0.072				
75	No. 200		80	<del>0.0031</del> 0.0031	<del>3.9</del> 3.9	<del>27</del> 27	<del>107</del> 107	<del>1000</del> 1000	<del>9.45</del> 9.45	<del>100</del> 100	<del>7.99</del> 7.99	<del>250</del> 250	<del>8.33</del> 8.33	<del>0.560</del> 0.056	<del>0.048</del> 0.048	<del>0.064</del> 0.064				
63	No. 230		71	0.0029 0.0028	3.7 3.6	26 25	101 96	1000 1000	9.12 8.85	100 100	7.70 7.48	250 250	8.04 7.80	0.050 0.050	0.043 0.043	0.058 0.058				
53	No. 270		56	0.0025 0.0022	3.4 3.2	24 22	87 78	1000 1000	8.29 7.79	100 100	7.01 6.58	250 250	7.31 6.87	0.045 0.040	0.038 0.034	0.052 0.046				
45	No. 325		50	0.0021 0.0020	3.1 3.0	21 21	74 71	1000 1000	7.56 7.34	100 100	6.39 6.20	250 250	6.67 6.47	0.036 0.036	0.031 0.031	0.041 0.041				
38	No. 400		40	0.0017 0.0016	2.8 2.7	20 19	65 59	1000 1000	6.95 6.55	100 100	5.87 5.54	250 300	6.13 5.83	0.032 0.032	0.027 0.027	0.037 0.037				
32	No. 450		36	0.0015 0.0014	2.6 2.6	18 18	56 54	1000 1000	6.38 6.22	100 100	5.39 5.26	300 300	5.69 5.54	0.030 0.030	0.024 0.024	0.035 0.035				
25	No. 500			0.0012 0.0010	2.4 2.2	17 15	49 40	1000 1000	5.87 5.23	100 100	4.96 4.42	300 300	5.23 4.66	0.028 0.025	0.023 0.021	0.033 0.029				
20	No. 635			0.0008 0.0008	2.1 2.1	13 13	33 33	1000 1000	4.73 4.73	100 100	4.00 4.00	300 300	4.22 4.22	0.020 0.020	0.017 0.017	0.023 0.023				

<sup>A</sup> Column 3—These numbers are only approximate but are in use for reference; the sieve shall be identified by the standard designation in millimetres or micrometres.

<sup>B</sup> Columns 9 and 11—See Annex A1, which specifies that all openings will be inspected for test sieves having 15 openings or less.

<sup>C</sup> Columns 9 and 11—These number of sample openings are based on an 8-in. diameter test sieve.

**TABLE 2 Dimensions of Standard Frames**

Nominal Diameter, in.	Diameter Tolerance, in. (mm)	Typical Frame <sup>A</sup>
	Inside at Top <sup>B</sup>	Nominal Height, in. (mm)
3	3.000 + 0.030/-0.000	1¼ (31.8) FH <sup>C</sup>
	(76.2 + 0.76/-0.00)	⅝ (15.9) HH
6	6.000 + 0.030/-0.000	1¾ (44.5) FH
	(152.4 + 0.76/-0.00)	1 (25.4) HH
8	8.000 + 0.030/-0.000	2 (50.8) FH
	(203.2 + 0.76/-0.00)	1 (25.4) HH
10	10.000 + 0.030/-0.000	3 (76.2) FH
	(254 + 0.76/-0.00)	1½ (38.1) HH
12	12.000 + 0.030/-0.000	3¼ (82.6) FH
	(304.8 + 0.76/-0.00)	2 (50.8) IH
		1⅝ (41.3) HH

<sup>A</sup> Frame height measured from top of frame to top of sieve cloth.

<sup>B</sup> Measured 0.2 in. (5 mm) below the top of the frame.

<sup>C</sup> FH = full height; HH = half height; IH = intermediate height.

3.1.3 *crimp*, *n*—the corrugation in the warp and shute wire, or both. The crimp in the wires is formed either during the weaving process, or with a crimping machine prior to weaving. If formed during the weaving process, the tension existing between the warp and shute wires fundamentally determines the respective amount or depth of crimp, which locks the wires in place, and in part establishes the firmness of the sieve cloth.

3.1.4 ~~*firmness*~~—*firmness*, *n*—a subjective term referring to the planar rigidity of sieve cloth (as a roll good, not mounted in a test sieve frame), established by the tensile strength of the material, the relationship of the mesh to wire diameters, the type of weave, and amount of crimp in the wires. The absence of firmness in sieve cloth is termed *sleaziness*.

3.1.5 *matched test sieve*—*sieve*, *n*—a test sieve that reproduces the performance results of another test sieve within user defined limits for a designated material (for information only and may not be in compliance with this specification).

3.1.6 *mesh*—*mesh*, *n*—the number of wires or openings per linear inch (25.4 mm) counted from the center of any wire to a point exactly 1 in. (25.4 mm) distant, including the fractional distance between either thereof.

3.1.7 ~~*plain weave*~~—*weave*, *n*—sieve cloth in which the warp wires and shute wires pass over one and under one in both directions.

3.1.8 ~~*shute wires*~~—*wires*, *n*—the wires running the short way of, or across the cloth as woven (also referred to as the shoot, fill, or weft wires).

3.1.9 *sieve*—*sieve*, *n*—an apparatus for the purpose of sieving, consisting of a separating media mounted in a frame.

3.1.10 *sieve cloth*—*cloth*, *n*—woven wire cloth conforming to this specification.

3.1.11 *test sieve (wire cloth)*—*cloth*, *n*—a sieve manufactured by mounting sieve cloth in a frame, designed for use in particle size analysis by sieving.

3.1.11.1 *compliance test sieve*—*sieve*, *n*—a test sieve manufactured using sieve cloth which has been inspected prior to being mounted in the sieve frame; and that meets the requirements of **Table 1** in part based on the standard deviation of the required number of sample openings per 100 square feet of sieve cloth (Column 7) not exceeding the maximum allowable for a confidence level of 66 % (Column 8).

3.1.11.2 *inspection test sieve*—*sieve*, *n*—a test sieve manufactured using sieve cloth which has been inspected after being mounted in the sieve frame; and that meets the requirements of **Table 1** in part based on the standard deviation of the required number of sample openings in the test sieve (Column 9) not exceeding the maximum allowable for a confidence level of 99 % (Column 10).

3.1.11.3 *calibration test sieve*—*sieve*, *n*—a test sieve manufactured using sieve cloth which has been inspected after being mounted in the sieve frame; and that meets the requirements of **Table 1** in part based on the standard deviation of the required number of sample openings in the test sieve (Column 11) not exceeding the maximum allowable for a confidence level of 99.73 % (Column 12).

3.1.11.3.1 *Discussion*—Calibration sieves have had at least twice as many openings measured as Inspection sieves.

3.1.12 ~~*twill weave*~~—*weave*, *n*—sieve cloth in which the warp wires and shute wires pass over two and under two wires in both directions.

3.1.13 ~~*warp wires*~~—*wires*, *n*—the wires running the long way of the cloth as woven.

#### 4. Ordering Information

4.1 Orders for items under this specification should include the following information as required:

4.1.1 Description of item(s) (Test Sieve or Sieve Cloth),

4.1.2 ASTM E11 designation and year of issue,

4.1.3 Quantity of each item, and

4.1.4 Sieve designation (**Table 1**, Standard Column 1, Alternate Column 2).

4.1.4.1 Test sieves can be supplied based on different levels of confidence as Compliance Sieves, Inspection Sieves, and Calibration Sieves.

4.2 Test sieves in standard circular or nonstandard frame:

4.2.1 Nominal sieve frame diameter (see **Table 2**), and

4.2.2 Nominal sieve frame height (see **Table 2**).

4.3 Description of nonstandard sieve.

#### 5. Sieve Cloth Requirements

5.1 The sieve cloth used in test sieves shall meet the requirements of **Table 1** and shall be designated Specification E11 Sieve Cloth. The number of inspected apertures shall be in accordance with **Table 1** (Column 7). Sieve cloth conforming to this specification shall be woven from stainless steel, brass, or bronze. Sieve cloth with openings greater than or equal to 75 micrometres shall be woven using a plain weave. For sieve cloth with openings equal to or less than 71 micrometres the sieve cloth may be supplied using a twill weave. The sieve cloth shall not be coated or plated.