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Standard Specification for Tensile Testing Machines for Textiles¹

This standard is issued under the fixed designation D76/D76M; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the operating characteristics of three types of tensile testing machines used for the determination of the force-elongation properties of textile materials. These types of tensile testing machines are:

1.1.1 Constant-rate-of-extension, CRE.

1.1.2 Constant-rate-of-traverse, CRT.

1.1.3 Constant-rate-of-loading (force), CRL.

1.2 Specifications for tensile testing machines to measure other tensile-related properties of textile materials not covered by this standard are given in the ASTM standards using those machines.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system ~~may~~ are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other. ~~Combining other, and~~ values from the two systems ~~may result in non-conformance with the standard; shall not be combined.~~

1.4 The following safety hazards caveat pertains only to the test methods described in this specification: *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, 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:²

[D123 Terminology Relating to Textiles](#)

[D2256 Test Method for Tensile Properties of Yarns by the Single-Strand Method](#)

[D4849 Terminology Related to Yarns and Fibers](#)

[E4 Practices for Force Verification of Testing Machines](#)

¹ This specification is under the jurisdiction of ASTM Committee D13 on Textiles and is the direct responsibility of Subcommittee D13.58 on Yarns and Fibers. Current edition approved July 1, 2016; July 1, 2021. Published July 2016; August 2021. Originally approved in 1920. Last previous edition approved in 2014 as D76—11; D76—11(2016). DOI: 10.1520/D0076—D0076M-11R16; 10.1520/D0076_D0076M-21.

² 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.

E74 Practices for Calibration and Verification for Force-Measuring Instruments

3. Terminology

3.1 For terminology related to tensile testing, see Terminology **D4849**.

3.1.1 The following terms are relevant for this standard: bench marks, calibrate, capacity, clamp, constant-rate-of extension type tensile testing machine (CRE), constant-rate-of-load tensile testing machine (CRL), constant-rate-of-traverse tensile testing machine (CRT), effective carriage mass, effective gauge length, grip, jaw face, jaw liner, jaws, least count, nominal gauge length, response time, sensitivity, *in electronic systems*, sensitivity, stress, tensile testing machine, test skein, time-to-break, true gauge length.

3.1.2 For all other terminology related to textiles, see Terminology **D123**.

4. Performance Requirements

4.1 Individual ASTM methods for tensile testing of textile materials that prescribe apparatus which conforms to this specification shall also include such other detailed specifications as may be necessary to describe the testing machine and its operation completely.

4.1.1 This specification shall not be construed as being intended to preclude the evolution of improved methods of testing or testing apparatus, which is recognized as being vital in an advancing technology.

4.2 Comparison of results from tensile testing machines operating on different principles is not recommended. When these machines are used for comparison testing however, constant time-to-break at 20 ± 3 s is the established way of producing data, but even then the data may differ significantly.

4.2.1 Comparison of test data from machines of the same type, especially two or more CRT-type or two or more CRL-type machines, requires consideration of the effect of individual machine characteristics; for example, inertia effects, capacity, sensitivity, type of loadcell, etc., which may cause significant differences in results even though uniform procedures are employed. Data from different CRE-type testing machines, however, should not be significantly different.

4.2.2 In any case, all types of tensile testing machines must satisfy the accuracy requirements as given in Section 7.

4.3 While changes in humidity affect the tensile properties of many textile materials, changes in humidity normally do not affect the testing machines themselves.

4.4 When machines are moved to different locations, their calibration shall be verified to make sure that they still meet the specified tolerances.

4.5 When each of the sub-systems (force, extension, clamping) has been individually calibrated, verified, or checked, it is recommended that the total system be verified using a standard material appropriate for the type testing to be carried out.³ This testing of the total system is the established way of ensuring that the clamping system is operating properly.

5. Apparatus

5.1 *Tensile Testing Machines*—Tensile testing machines for textile materials are classified according to their operating principle as follows:

Type	Principle of Operation
CRE	Constant rate-of-extension
CRT	Constant rate-of-traverse (pendulum type)
CRL	Constant rate-of-load (inclined plane type)

³ Two styles of standard break fabrics obtained from Testfabrics, Inc., P.O. Drawer O, Middlesex, NJ 08846 have been found satisfactory for this purpose. See also **A1.3** of this specification.

5.1.1 *CRE-Type*—A testing machine in which the pulling clamp moves at a uniform rate, and when loaded at the maximum allowable force, the force-measuring mechanism (load cell) moves a negligible distance of less than 0.130_2 mm $\{0.005[0.008]$ in.].

5.1.2 *CRT-Type*—A testing machine in which the pulling clamp moves at a uniform rate and the force is applied through the other clamp, which moves appreciably to actuate a force-measuring mechanism, producing a rate of increase of force or extension which is usually not constant and is dependent on the extension characteristics of the specimen.

5.1.3 *CRL-Type*—A testing machine in which the rate of increase of the force is uniform with time after the first 3 s and the specimen is free to elongate, this elongation being dependent upon the extension characteristics of the specimen at any applied force.

5.1.4 *Multiple-Purpose Type*—Machines capable of being operated as both a CRE-type and a CRL-type may be used.

5.2 *Measuring Devices*—Machines shall be equipped with a suitable device for measuring the force and, when needed, a device to measure extension. Preferably, the data must be electronically stored using a data-acquisition system, or at least the curve shall be recorded graphically, or the force and extension data may be indicated on appropriate scales or displays.

5.2.1 Most testing machines record only force-extension data. When the capacity of a testing machine is adjusted to fit the predetermined linear density or cross-sectional area of the specimen, instead of force the stress will be recorded. When the machine is adjusted to record extension in terms of unit specimen length, the chart can be read directly in percent elongation or strain. When these conditions do not exist, the force-extension curve must be converted to obtain stress-strain characteristics.

5.2.2 The force-indicating and force-recording devices shall be in conformance with the requirements of this specification as to accuracy, sensitivity, and response time, and shall permit calibration or verification by appropriate methods described or referenced herein.

5.3 *Clamping or Holding Devices*—Specimen clamping or holding devices shall be prescribed in the individual test methods in sufficient detail for all users to employ the same or comparable devices.

5.3.1 The prescribed specimen clamping or holding devices shall be designed to ensure that the pulling axis of the testing machine and the central axis of a properly mounted specimen coincide.

5.3.2 The clamping or holding device may be designed for manual or automatic mounting of specimens.

5.3.3 The required clamping force can be obtained with the clamping or holding devices by any suitable mechanism; for example, screw, cam action, pneumatic, or toggle.

5.3.4 Clamping surfaces in contact with a test specimen shall be of any suitable material and configuration which provides the required restraint, preclude slippage, and minimize specimen failure in the clamped areas. Clamp liners may be used, provided the above conditions are met.

5.3.5 When the flat-faced type clamp proves unsatisfactory because of slippage or excessive breakage in the clamp, snubbing type devices (capstan, drum, split-drum, etc.) may be used.

5.4 *Calibrating Devices*—Calibrating weights or other calibrating devices conforming to Practice E74 are required for verification of calibration. Calipers, a steel rule that can be read to 0.25 mm [0.01 in.], or a suitable cathetometer, and a stop watch are required for verification of recorded elongation, and crosshead and chart speed.

6. Machine Operational Design

6.1 The use of motor-driven machines is preferred over manually driven machines because of improved control of testing.

6.2 Testing machines of the CRT-type shall not be used for measuring forces below fifty times their resolution. For example, if the minimum force that can be read is 0.5 cN [0.5 gf], the testing machine may not be used for materials which test at 25.0 cN [25 gf] or less.

6.2.1 Choose the full scale force such that the expected maximum force falls within:

6.2.1.1 10 to 90% full scale for the CRE-type testing machines,

6.2.1.2 15 to 85% full scale for the CRT-type testing machines,

6.2.1.3 15 to 85% full scale for the CRL-type testing machines,

6.3 Machines shall operate at a uniform rate of pulling clamp (CRE), and (CRT), or loading (CRL) as specified in 6.4, 6.5, and 6.6.

6.3.1 Machines may be built for operating at various rates of operation or at a single constant rate.

6.3.2 When machines are intended for operation at a specified or required average time to break as specified in individual standards (for example, 20 s to break as in Test Method D2256 and Test Methods D1682) then their rate of operation must be adjustable. The adjustment may be continuous or in steps not exceeding 125:100. Machines with a continuously adjustable rate of operation shall be equipped with a device indicating the rate of operation.

6.3.3 The machine rate of operation shall be within the tolerances prescribed in the individual standards.

6.4 CRE-Type:

6.4.1 Machines shall be designed for operation at such uniform rates of pulling clamp as are specified in individual standards.

6.4.2 Using a data-acquisition system, the sampling rate should be set to approximately 500/(time-to-break). Using a graphical recording system, the force-measuring system, including the recording mechanism, shall have a full-scale pen response time less than 2 s in either direction. In addition, the response time for pen deflections of less than full scale shall be proportional to the fraction of full-scale time represented by those deflections within a tolerance of $\pm 10\%$ of the nominal full-scale response time.

NOTE 1—The response time of the recording mechanism is the limiting factor affecting the choice of a rate for testing. The rate chosen shall give the maximum slope of the recorded curve which does not exceed one half of the slope of the maximum pen speed. See Fig. 1.

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6.5 CRT-Type—Machines shall be designed for operation of the pulling clamp at a uniform rate as specified in individual standards.

6.6 CRL-Type—Machines shall be designed to apply forces at a uniform rate, or at a uniform rate of loading per unit of specimen linear density, as specified in individual standards.

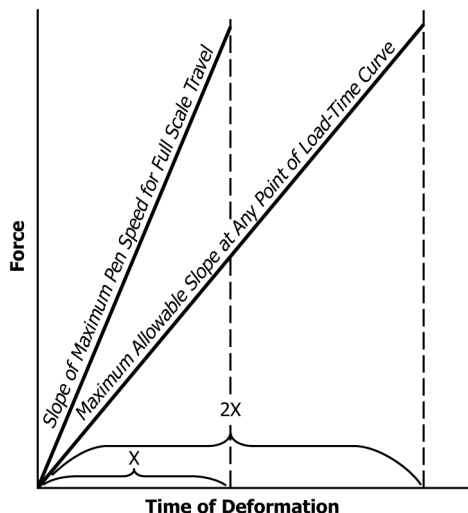


FIG. 1 Limitations on Response Speed of Recorder Pen

6.7 Machines may be built for either manual or automatic mounting of the specimen into the clamp or holding devices.

7. Tolerance on Indicated Force, Recorded Elongation, Nominal Gauge Length, and Speed of Moving Clamp

7.1 On instruments where the capacity of the force measuring mechanism (load cell) is used for digital analysis without regard to the full scale force displayed on the recorder, the maximum allowable error in force indication shall be $\pm 0.5\%$ of the reading for CRE-type machines and $\pm 1.0\%$ for CRT- and CRL-type machines (see Section 8).

7.2 The maximum allowable error in recorded grip displacement shall be $\pm 1\%$ of the recorded values for CRE-type machines and ± 2.5 mm [0.5 in.] for CRT- and CRL-type machines (see Section 9 for CRE-type machines and Section 10 for CRT- and CRL-type machines).

7.3 The maximum allowable variation in nominal gauge length on repeated return of the clamps to their starting position shall be less than 0.25 mm [0.01 in.].

7.4 The maximum allowable variation of crosshead speed of the CRE-type tester or moving clamp of the CRT-type tester from the required testing speed shall be less than 4%.

7.5 The maximum allowable variation of the loading rate for the CRL-type of tester from the required rate shall be less than 5%.

8. Verification of Indicated Force

8.1 This section provides a general procedure for the verification of the force calibration of tensile testing machines for textiles. No attempt is made to give detailed instructions applicable to any particular case. The verification should be performed or supervised by a qualified person competent to exercise scientific judgment in matters not covered herein. Detailed instructions are given in Annex A1 covering verification of one variety of testing machine of the CRL-type.

8.2 Verify tensile testing machines as directed in the applicable procedure and at the suggested time intervals listed in Practices E4, except as otherwise provided in the following paragraphs.

8.3 Verify the machine in the condition under which it is used, with all attachments and recording mechanisms in operation if they are to be used in actual testing; but with any pawls or other detent device in the force-measuring mechanism rendered inoperative. Following the application of each test force, eliminate the effect of friction by gently oscillating the force-measuring mechanism or by tapping the machine to ensure that the applied force is in equilibrium with the force registered by the measuring mechanism.

8.4 Examine the measuring, indicating, and recording mechanisms for friction or slack. Estimate, in terms of the units in which the machine is calibrated, the magnitude of such factors and, if excessive, reduce the error at the source to conform to the tolerance as stated in 7.1.

8.5 If other than vertical test forces must be applied, suitable apparatus must be devised subject to the general requirements for accuracy of calibration devices prescribed in Practice E74. If cords and pulleys are used, any errors due to axle friction, pulley eccentricities, cord friction, and uncertainty of cord center line shall be within the required limits of Practice E74. If an elastic calibration device is used, take due account of possible variations in its readings resulting from its inclined or horizontal position.

9. Verification of Recorded Clamp Displacement of CRE-Type Machines

9.1 This procedure is applicable to machines with synchronous drives between the crosshead and the chart, and to machines with independent crosshead and independent chart drives.

9.2 Bring the clamps to their normal position for the start of the test. Measure the distance between the clamps from nip to nip to the nearest 0.25 mm [0.01 in.]. Designate this distance as the nominal gauge length.

9.3 Set the speed of the crosshead and the speed of the chart drive (when the chart is equipped with an independent drive) at the actual speeds to be used in testing.

9.4 Adjust the chart with the pen resting exactly on a division line. Mark this line as zero. Without a specimen in the machine, start the crosshead and the chart simultaneously and permit them to run until the clamp separation has increased some convenient amount, such as nominal gauge length plus 200 or 500 mm [8 or 20 in.]. Stop the machine and the recorder simultaneously.

9.5 Measure the distance between the clamps as directed in 9.2 and designate this distance as “total clamp separation.” Count the chart divisions traversed by the recorder pen. The percent elongation per chart division may then be calculated using Eq 1:

$$\varepsilon = 100 \cdot \frac{T - G}{C \cdot G} \quad (1)$$

where:

- ε = percent elongation per chart division,
- T = total clamp separation,
- G = nominal gauge length,
- C = chart divisions traversed, and
- 100 = ratio to percent conversion constant.

NOTE 2—The speeds of both the crosshead and the chart drive of most CRE-type machines are easily altered either by changing gear ratios or by continuous speed change devices. It is of particular importance, therefore, that careful attention be given to the exact ratio of chart divisions traversed by the pen in the elongation direction to unit distance traveled by the crosshead.

NOTE 3—The deflection of the weighing force-measuring clamp with respect to the weighing headload cell in CRE-type testing machines shall not exceed 0.1302 mm [0.00510008 in.] for forces within the rated capacity of the machine. The deflection may be measured with a cathetometer or other similar equipment having a precision of 0.03 mm [0.001 in.]. Testing at short gauge lengths of high modulus materials may require corrections or stiffer measuring systems.

10. Verification of Recorded Elongation for CRT- and CRL-Type Machines

10.1 Bring the clamps of the testing machine to their normal positions for the start of a test. Place a chart in the holder and adjust its position with the pen at the zero force and zero elongation points. (On machines having a specific location for the chart as determined by supports, adjust the pen to record zero force and zero elongation.) Measure the distance between the inner edges of the clamping surfaces of the clamps to the nearest 0.25 mm [0.01 in.]. Designate this distance as the nominal gauge length. The distance can be measured conveniently by means of a pair of calipers and a steel rule graduated to 0.25 mm [0.01 in.]. A cathetometer of equal precision may be used.

10.2 Operate the machine without a specimen to register increasing clamp separation at zero force. If the chart is properly positioned in the holder, the pen line drawn will be superimposed on the axis of the chart showing zero force and variable elongation. Adjust the chart to obtain this condition, if necessary.

10.2.1 If the pen is set slightly to one side of the zero force axis, any deviation of the pen line from parallelism with the ruled line can be detected more readily.

10.2.2 For inclined plane testing machines, set the plane in the starting position and traverse the carriage by hand to ascertain parallelism of pen line and zero force axis on the chart.

10.3 Operate the machine as directed in 10.2 until the pen indicates a known separation; for example, 25 mm [1.0 in.]. Measure the distance between the clamps to the nearest 0.25 mm [0.01 in.] as directed in 10.1. This distance should equal the nominal gauge length, plus the separation recorded on the chart.

10.3.1 For inclined plane testing machines, with the plane in the starting position, traverse the carriage by hand until the pen indicates a known or specified separation; for example, 25 mm [1.0 in.]. Block the carriage to prevent any movement of the pen, and measure the actual distance between clamps.

10.4 Repeat this operation as directed in 10.3 with greater separations; for example, 50 and 75 mm [2.0 and 3.0 in.].

10.5 Any discrepancy between the recorded separation and the actual increase in distance between the clamps is an error in the recorded elongation and may be caused by one or more factors, such as faulty spacing of chart elongation graduations, faulty pen mechanism, or error in the multiplying lever train. Other causes of error in indicated elongation are discussed in **Annex A2**.

10.6 To establish the presence of other errors in the recorded elongation, place a chart in the testing machine and adjust it as directed in **10.1**. Clamp a suitable specimen, such as a steel strip having negligible elongation under the forces used, in both clamps. Operate the machine to draw a line on the chart. This line should be superimposed on the chart axis indicating variable force and zero elongation. Deviation of the pen line from the printed axis on the chart indicates an error in recorded elongation due to the geometry of the testing machine, to the use of an incorrect chart, or to slippage in the clamps.

10.6.1 The base line indicating zero elongation and increasing force is not necessarily a straight line. On pendulum type testing machines, it is frequently somewhat curved at higher forces. On many testing machines, it forms an angle other than 90° with the base line indicating zero force and increasing elongation. The angle depends upon the design of the machine.

11. Verification of Nominal Gauge Length

11.1 Determine the accuracy of the pulling clamp return by first establishing the nominal gauge length as directed in **10.1**. With no specimen in place, operate the machine (at actual testing rates) through start-and-return cycles, measuring the distance between clamps as directed in **10.1** after each return. Variations in the gauge length shall not exceed ± 0.25 mm [0.01 in.] at any testing rate.

12. Keywords

12.1 elongation; tension (tensile) properties/tests; testing machines

iteh Standards
(<https://standards.iteh.ai>)
ANNEXES
Document Preview
(Mandatory Information)

A1. FORCE CALIBRATION OF CRL-TYPE MACHINES, INCLINED PLANE TYPE

[ASTM D76/D76M-21](https://standards.iteh.ai/catalog/standards/sist/9739b1b3-5359-4791-849b-a2d7d08abb98/astm-d76-d76m-21)

<https://standards.iteh.ai/catalog/standards/sist/9739b1b3-5359-4791-849b-a2d7d08abb98/astm-d76-d76m-21>

A1.1 Calibrate the force of CRL-type machines which employ or use the inclined plane principle as follows:

A1.1.1 The apparatus required includes: (1) a balance or scale, (2) calibration weights which cover twice the normal capacity range of the tester and are accurate to 0.1 %, and (3) a steel measuring tape.

A1.1.2 Weigh the carriage plus accessory weights, jaws, pen holder, pen, and any other item which travels with the carriage. When different capacities are secured by the use of supplementary weights, weigh these separately.

A1.1.3 Determine the maximum angle of inclination from the dimensions of the plane and the vertical displacement during operation as directed below.

A1.1.3.1 Insert a chart in its holder. Move the carriage and draw a penline. If the penline does not coincide with the base line of the chart when the plane is in the horizontal position, make appropriate adjustments.

A1.1.3.2 With the carriage in its normal starting position (horizontal), measure to the nearest 1.0 mm [0.03 in.] the distance, *A*, from the center of the fulcrum to some point, *X*, at the right end of the track or plane. Measure the vertical distance, *B*, of point *X* from some reference line such as the base or floor.