



Designation: D6770 – 21

Standard Test Method for Abrasion Resistance of Textile Webbing (Hex Bar Method)¹

This standard is issued under the fixed designation D6770; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This test method covers the determination of abrasion resistance of textile webbing using a hex bar abrasion tester.

1.1.1 The resistance is expressed as a percentage of retained breaking strength.

1.2 The values stated in SI units are to be regarded as standard. The values given in parentheses after SI units are provided for information only and are not considered standard.

1.3 *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 environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *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](#)

[D1776/D1776M Practice for Conditioning and Testing Textiles](#)

[D4850 Terminology Relating to Fabrics and Fabric Test Methods](#)

[D6775 Test Method for Breaking Strength and Elongation of Textile Webbing, Tape and Braided Material](#)

[E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods](#)

¹ This test method is under the jurisdiction of ASTM Committee D13 on Textiles and is the direct responsibility of Subcommittee D13.60 on Fabric Test Methods, Specific.

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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.

3. Terminology

3.1 For all terminology relating to Fabrics, refer to Terminology [D4850](#).

3.2 For all other terminology related to textiles, refer to Terminology [D123](#).

4. Summary of Test Method

4.1 Abrasion resistance is measured by subjecting the specimen to unidirectional reciprocal rubbing over a specific bar under specified conditions of tension, stroke length and time. Resistance to abrasion is evaluated by determining the percent retention of breaking force of an abraded specimen compared to an unabraded specimen.

5. Significance and Use

5.1 The measurement of the resistance to abrasion of textile webbing is very complex. The resistance to abrasion is affected by many factors that include the inherent mechanical properties of the fibers; the dimensions of the fibers; the structure of the yarns; the construction of the webbing; the type, kind, and amount of treatment added to the fibers, yarns, or webbing; the nature of the abradant; the variable action of the abradant over the specimen area abraded; the tension on the specimen; the pressure between the specimen and the abradant; and the dimensional changes in the specimen.

5.2 The resistance of textile webbing to abrasion as measured by this test method does not include all the factors which account for wear performance or durability in actual use. While the abrasion resistance stated in terms of the number of cycles and durability (defined as the ability to withstand deterioration or wearing out in use, including the effects of abrasion) are frequently related, the relationship varies with different end uses. Different factors may be necessary in any calculation of predicted durability from specific abrasion data.

5.3 Laboratory tests may be reliable as an indication of relative end use in cases where the difference in abrasion resistance of various materials is large, but they should not be relied upon where differences in laboratory test findings are small. In general, the results should not be relied upon for prediction of performance during actual wear life for specific end uses unless there are data showing the specific relationship between laboratory abrasion tests and actual wear in the intended end use.

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

5.4 These general observations apply to most webbings that are used in automotive, aerospace, industrial, and military applications.

5.5 This test method can be used for acceptance testing of commercial shipments but comparisons should be made with caution because estimates of between-laboratory precision are incomplete.

5.6 If there are differences of practical significance between reported test results for two laboratories (or more), comparative tests should be performed to determine if there is a statistical bias between them, using competent statistical assistance. As a minimum, use samples for such comparative tests that are as homogenous as possible, drawn from the same lot of material as the samples that resulted in disparate results during initial testing, and randomly assigned in equal numbers to each laboratory. The test results from the laboratories involved should be compared using a statistical test for unpaired data, at a probability level chosen prior to the testing series. If bias is found, either its cause must be found and corrected, or future test results must be adjusted in consideration of the known bias.

6. Apparatus

6.1 *Webbing Abrasion Tester*—The webbing abrasion tester consists of a suitable mechanism that will provide a reciprocating motion of the webbing over a standardized hex bar. One end of each specimen is attached to the mechanism and the other end passing over a hexagonal steel rod is attached to a weight. The hexagonal rod is so fixed as to subject the webbing specimen to abrasion on two adjacent edges as the drum moves the specimen across the rod. One example of such a mechanism is a reciprocating drum as illustrated in Fig. 1.

6.1.1 Mass “B” shall be 900 ± 60 g (2 lb \pm 2 oz) for webbing with breaking strengths up to 4500 N (1000 lb), 1800 ± 60 g (4 lb \pm 2 oz) for breaking strengths of 4500 to 13 500 N (1000 to 3000 lb) and 2400 ± 60 g (5.2 lb \pm 2 oz) for breaking strengths over 13 500 N (3000 lb).

6.1.2 Steel hexagonal rods “C” shall be 6.35 ± 0.03 mm (0.250 \pm 0.001 in.) when measured across opposite flat sides and the radius shall be 0.5 ± 0.2 mm (0.020 \pm 0.008 in.). The

steel shall have a cold drawn finish and a Rockwell Hardness of B-91 to B-101. The edges of the hexagonal rods shall not have any burrs, nicks or scale.

6.1.3 The mechanism “D” shall have a nominal outside diameter of 400 mm (16 in.) or be some mechanism able to produce a reciprocating motion of at least 300 mm (12 in.) over the hex rod with a suitable means for attaching the specimen to be tested without damage to the specimen.

6.1.4 The crank-arm “F” shall be attached to the mechanism “D” and to the driver disk “E” in such a manner that when the specimen is attached to the mechanism, the specimen during the test will oscillate over the hexagonal rod the required distance during each stroke and at the required rate (see 10.4).

6.1.5 The hexagonal rod shall be so placed that specimen “A” with the weight attached to one end and the other end passing over the hexagonal rod and attached to the drive mechanism will form an angle “H” of $85 \pm 2^\circ$.

6.2 *Tensile Testing Machine*³, CRE-Type equipped with split-drum webbing clamps as described in Test Method D6775.

7. Sampling and Test Specimens

7.1 *Lot Sample*—Take a lot sample as directed in the applicable material specification. In absence of such a specification randomly select five rolls or pieces to constitute the lot sample.

7.2 *Laboratory Sampling Unit*—As a laboratory sampling unit take from each roll or piece one piece of webbing that is 2.8 m (3.0 yd) in length.

7.3 *Test Specimens*—From each laboratory sampling unit, cut 2 test specimens 1.4 m (1.5 yd) in length. Mark one specimen “A” for abraded and the other “U” for unabraded.

7.3.1 When the lot or shipment consists of less than 5 rolls or pieces, randomly select 5 test specimens that represent all rolls or pieces in the lot or shipment.

³ Apparatus and accessories are commercially available.

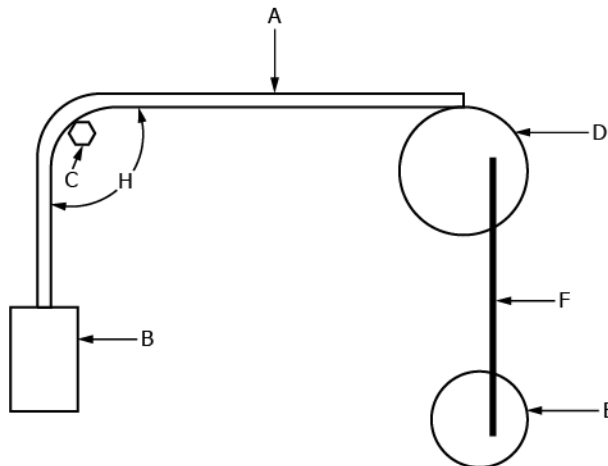


FIG. 1 Webbing Abrasion Tester

7.4 Ensure specimens are free of folds, creases, or wrinkles. Avoid getting oil, water, grease, and so forth, on the specimens when handling.

8. Conditioning

8.1 Condition the test specimens to moisture equilibrium for testing in the standard atmosphere for testing textiles in accordance with Practice **D1776/D1776M** or, if applicable, in the specified atmosphere in which the testing is to be performed.

8.2 In the event of dispute concerning the results of tests that may be affected by the moisture content, test specimens shall be preconditioned by bringing them to approximate moisture equilibrium in the standard atmosphere for preconditioning textiles in accordance with Practice **D1776/D1776M**.

9. Preparation and Calibration of Test Apparatus

9.1 Ensure the test machine is on a level, sturdy surface and free from vibration.

9.2 For hexagonal rods a manufacturer's certificate of compliance shall be acceptable as to the requirements as described in **6.1.2**.

10. Procedure

10.1 Condition the "A" test specimens in the standard atmosphere for testing textiles, in accordance with Section 8.

10.2 Attach the required mass (**6.1.1**) to one end of the test specimen, pass the other end over the hexagonal rod and attach to the drum. The length of the test specimens shall be adjusted, without altering the original length, so that the test specimens will oscillate across the hexagon rod and each end of the abraded area will be equidistant from the ends of the test specimens.

10.3 The edges of each new hexagonal rod shall be identified as 1 through 6, and rotated after each use so that no abrading edges are used more than once. Use edge 1 and 2 for one test specimen, edge 3 and 4 for a second test specimen, edges 5 and 6 for a third test specimen, and then discard the rod.

10.4 Oscillate the mechanism so that the test specimens are given a 300 ± 25 mm (12 ± 1 in.) traverse over the rod at the rate of $1 \pm .03$ strokes (0.5 cycles) per second for 5000 strokes (2500 cycles). One single stroke is 300 ± 25 mm (12 ± 1 in.) in one direction only.

10.5 After the machine has stopped at the predetermined number of cycles remove the test specimens from the abrading machine.

10.6 Continue as directed in **10.2 – 10.5** until all the required specimens have been abraded for each laboratory sampling unit.

10.7 Determine the breaking force of the abraded specimens (A) and the unabraded specimens (U) for each laboratory sampling unit in the lot to the nearest 1 % as directed in Test Method **D6775** set as follows:

10.7.1 Attach the split drum webbing clamps in the tensile tester and set the distance between them to 250 mm (10 in.) center to center.

10.7.2 Set the testing speed to 75 ± 25 mm/min (3 ± 1 in./min).

11. Calculation

11.1 Calculate the average breaking force for the lot of the abraded test specimens from the results of the laboratory sampling units.

11.2 Calculate the average breaking force for the lot of the unabraded test specimens from the results of the laboratory sampling units.

11.3 Calculate the percentage of retained breaking force to the nearest 1 % for the lot using Eq 1:

$$AR = \frac{100A}{U} \quad (1)$$

where:

AR = abrasion resistance, %,

A = average breaking force of the abraded specimens, N (lb), and

U = average breaking force of the unabraded specimens, N (lb).

12. Report

12.1 Report that the abrasion resistance was determined in accordance with Test Method D6770. Describe the material or product sampled.

12.2 Report the following information for the laboratory sampling unit and for the lot as applicable to a material specification or contract order:

12.2.1 Abrasion resistance, percent retained in breaking force.

12.2.2 Breaking force of abraded test specimens.

12.2.3 Breaking force of unabraded test specimens.

13. Precision and Bias⁴

13.1 The precision of this test method is based on an intralaboratory study, conducted to initiate the procedure now recognized as ASTM D6770, Test Method for Abrasion Resistance of Textile Webbing (Hex Bar Method). Each of six volunteer laboratories or operators were asked to test one material. Every "test result" represents the average of five individual determinations, and all participants were instructed to report five replicate test results for each material.

13.1.1 *Repeatability limit (r)*—The difference between repetitive results obtained by the same operator in a given laboratory applying the same test method with the same apparatus under constant operating conditions on identical test material within short intervals of time would in the long run, in the normal and correct operation of the test method, exceed the following values only in one case in 20.

⁴ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:D13-2001. Contact ASTM Customer Service at service@astm.org.