



## Designation: D2060 – 14 (Reapproved 2022)

# Standard Test Methods for Measuring Zipper Dimensions<sup>1</sup>

This standard is issued under the fixed designation D2060; 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 These test methods cover the measurement of the dimensions of all types and sizes of zippers.

1.2 The test methods appear as follows:

	Sections
Chain Flatness	34 – 39
Chain Straightness	40 – 44
Chain Thickness	28 – 33
Chain Width	45 – 50
Length of Zipper or Parts	9 – 14
Longitudinal Dimensional Change	51 – 58
Slider Mouth Width	21 – 27
Tape Width	15 – 20

1.3 The values stated in either SI units or in other units shall be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently of the other, without combining values in any way.

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, health, and 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>

[D123 Terminology Relating to Textiles](#)

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

<sup>1</sup> These test methods are under the jurisdiction of ASTM Committee D13 on Textiles and are the direct responsibility of Subcommittee D13.54 on Subassemblies, Inc.

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

[D2050 Terminology Relating to Subassemblies Used in the Manufacture of Textiles](#)

[D2051 Test Method for Durability of Finish of Zippers to Laundering](#)

[D2052 Test Method for Colorfastness of Zippers to Dry-cleaning](#)

[D2053 Test Method for Colorfastness of Zippers to Light](#)

[D2054 Test Method for Colorfastness of Zipper Tapes to Crocking](#)

[D2057 Test Method for Colorfastness of Zippers to Laundering](#)

[D2058 Test Method for Durability of Finish of Zippers to Drycleaning](#)

[D2059 Test Method for Resistance of Zippers to Salt Spray \(Fog\)](#)

[D2061 Test Methods for Strength Tests for Zippers](#)

[D2062 Test Methods for Operability of Zippers](#)

[D2724 Test Method for Bond Strength of Bonded, Fused, and Laminated Apparel Fabrics](#)

[D2905 Practice for Statements on Number of Specimens for Textiles \(Withdrawn 2008\)](#)<sup>3</sup>

[D3657 Specification for Zipper Dimensions](#)

[E145 Specification for Gravity-Convection and Forced-Ventilation Ovens](#)

2.2 *AATCC Method:*

[AATCC 143 Appearance of Apparel and Other Textile End Products After Repeated Home Launderings](#)<sup>4</sup>

2.3 *ANSI Standard:*

[ANSI/ASQC Z1.4 Sampling Procedures for Inspection by Attributes](#)<sup>5</sup>

## 3. Terminology

3.1 For definitions of terms relating to Subassemblies, D13.54, refer to Terminology [D2050](#).

3.1.1 The following terms are relevant to this standard: dimension, zipper.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Technical Manual of the American Association of Textile Chemists and Colorists, P. O. Box 12215, Research Triangle Park, NC 27709.

<sup>5</sup> Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

3.2 For all other terminology related to textiles, refer to Terminology D123.

3.2.1 Optional key terms, not under the jurisdiction of this SC that must be used to understand this standard. If the optional term is necessary, a very exact and detailed discussion must also be included to indicate why this is so.

4. Significance and Use

4.1 The significance of specific tests is discussed in the appropriate sections.

4.2 These test methods are considered satisfactory for acceptance testing of commercial shipments because the test methods have been used extensively in the trade for this purpose, and because current estimates of between-laboratory precision are acceptable in most cases.

4.2.1 In case of a dispute arising from differences in reported test results when using Test Methods D2060 for acceptance testing of commercial shipments, the purchaser and the supplier should conduct comparative tests to determine if there is a statistical bias between their laboratories. Competent statistical assistance is recommended for the investigation of bias. As a minimum, the two parties should take a group of test specimens that are as homogeneous as possible and that are from a lot of material of the type in question. The test specimens should then be randomly assigned in equal numbers to each laboratory for testing. The average results from the two laboratories should be compared using Student’s *t*-test for unpaired data and an acceptable probability level chosen by the two parties before the testing is begun. If a bias is found, either its cause must be found and corrected or the purchaser and the supplier must agree to interpret future test results in the light of the known bias.

4.3 The test method(s) in these test methods, along with those in Test Methods D2051, D2052, D2053, D2054, D2057, D2058, D2059, D2061, and D2062, are a collection of proven test methods. They can be used as aids in the evaluation of zippers without the need for a thorough knowledge of zippers. The enumerated test methods do not provide for the evaluation of all zipper properties. Besides those properties measured by

means of the enumerated test methods there are other properties that may be important for the satisfactory performance of a zipper. Test methods for measuring those properties have not been published either because no practical methods have yet been developed or because a valid evaluation of the information resulting from existing unpublished methods requires an intimate and thorough knowledge of zippers.

5. Sampling

5.1 Lot Sample—As a lot sample for acceptance testing, take at random the number of individual containers from each shipping carton as directed in an applicable material specification or other agreement between the purchaser and the supplier. Consider individual containers from each shipping carton to be the primary sampling units.

NOTE 1—An adequate specification or other agreement between the purchaser and supplier requires taking into account the variability between shipping cartons and between zippers in a container to provide a sampling plan with a meaningful producer’s risk, consumer’s risk, acceptable quality level, and limiting quality level.

5.2 Laboratory Sample and Test Specimens—As a laboratory sample for acceptance testing, take the number of zippers specified in Section 7 at random from each container in the lot sample. Consider the zippers as both the laboratory sample and the test specimens.

6. Test Specimen

6.1 The test specimen shall consist of a completely assembled zipper or length of chain.

7. Number of Specimens

7.1 All Properties Except Slider Mouth Width and Chain Width—Take a number of zippers per individual container from each shipping carton such that the user may expect at the 90 % probability level that the test result for an individual container is no more than the amounts shown in Table 1, above or below the true average for the individual container. Determine the number of zippers per individual container as follows:

7.1.1 Reliable Estimate of *s* or *v*—When there is a reliable estimate of *s* or *v* based upon extensive past records for similar

TABLE 1 Specimens Required Under Conditions of Known and Unknown Variability in User’s Laboratory Units as Indicated

Property	Allowable Variation (Two-Sided)	Equation for <i>n</i> Using a Reliable Estimate of <i>s</i> or <i>v</i>	No Reliable Estimate of <i>s</i> or <i>v</i>	
			Number of Specimens	Basis <sup>A</sup>
Length, assembled zipper, % of the average	10.0	$n = 0.027 \times v^2$	1	0.70
Length, chain, % of the average	10.0	$n = 0.027 \times v^2$	1	0.39
Length, top tape end, % of the average	10.0	$n = 0.027 \times v^2$	1	4.56
Length, bottom tape end, % of the average	10.0	$n = 0.027 \times v^2$	3	9.09
Length, opening, % of the average	10.0	$n = 0.027 \times v^2$	1	0.87
Effective tape width, % of the average	10.0	$n = 0.027 \times v^2$	1	2.34
Full tape width, % of the average	10.0	$n = 0.027 \times v^2$	1	2.51
Chain thickness, % of the average	10.0	$n = 0.027 \times v^2$	1	0.64
Chain straightness, 1/32-in. increments	1.0	$n = 2.71 \times s^2$	1	0.59
Wet dimensional change, home laundry, percentage points	0.200	$n = 67.6 \times s^2$	17	0.49
Wet dimensional change, launder-ometer, percentage points	0.200	$n = 67.6 \times s^2$	12	0.41
Dimensional change in dry heat, percentage points	0.200	$n = 67.6 \times s^2$	10	0.38

<sup>A</sup> The values of *s* or *v* in Table 1 are somewhat larger than will usually be found in practice (see 7.1.2).

materials tested in the user's laboratory as directed in these test methods, calculate  $n$  using the equations in **Table 1** which are based on (Eq 1) or (Eq 2) as noted in Test Method **D2905**, Section 5:

$$n = \frac{t^2 \times s^2}{E^2} \quad (1)$$

$$n = \frac{t^2 \times v^2}{A^2} \quad (2)$$

where:

- $n$  = number of specimens (rounded upward to a whole number),
- $s$  = reliable estimate of the standard deviation of individual observations in the user's laboratory under conditions of single-operator precision,
- $v$  = reliable estimate of the coefficient of variation of individual observations in the user's laboratory under conditions of single-operator precision,
- $t$  = 1.645, the value of Student's  $t$  for infinite degrees of freedom, for two-sided limits, and a 90 % probability level ( $t^2 = 2.706$ ),  $E$  and  $A$  = values of the allowable variations listed in **Table 1**, and  $t^2/E^2$  and  $t^2/A^2$  = the basis for calculation of the constants in the equations in **Table 1**.

7.1.2 *No Reliable Estimate of  $s$  or  $v$* —When there is no reliable estimate of  $s$  or  $v$  for the user's laboratory, (Eq 1) or (Eq 2) should not be used directly. Instead, specify the number of specimens shown in **Table 1**. This number of specimens is calculated using values of  $s$  or  $v$ , which are listed in **Table 1**, and that are somewhat larger values of  $s$  or  $v$  than are usually found in practice. When a reliable estimate of  $s$  or  $v$  for dimensional change or length of bottom end in the user's laboratory becomes available, the equations in **Table 1**, which are based on (Eq 1) and (Eq 2), will usually specify fewer specimens than are listed in **Table 1** for the condition when there is no reliable estimate of  $s$  or  $v$ .

7.2 *Slider Mouth Width and Chain Width*—Unless otherwise agreed upon, as when specified in an applicable material specification, take one specimen per lot.

## 8. Conditioning

8.1 For tests made as directed in Sections **12**, **18**, **37**, **42**, and **55**, bring the specimens to moisture equilibrium for testing in the standard atmosphere for testing textiles as directed in Practice **D1776**. Preconditioning is not required.

8.2 For tests made as directed in Sections **25** and **31**, specimens need not be preconditioned nor conditioned.

## LENGTH OF ZIPPER OR PARTS

### 9. Summary of Test Method

9.1 The chain or zipper is placed on a flat surface and, with the aid of a suitable scale, the length of the zipper or desired zipper part is determined.

### 10. Significance and Use

10.1 These measurements are useful in determining conformance with a purchasing specification and suitability for end use products using zippers.

### 11. Apparatus

11.1 *Scale*, graduated in 0.5 mm or ( $1/64$  in.).

### 12. Procedure

12.1 *Length of Completely Assembled Zipper*—Place the closed zipper flat on a horizontal working surface without tension, aligning the chain over a straight reference line on the working surface. Make marks on the working surface corresponding to the zipper extremities. Remove the zipper and, using the scale, measure the distance between the marks to the nearest 1.0 mm or ( $1/32$  in.).

NOTE 2—For the bottom end, the zipper extremities are the bottom of the bottom stop or interlocking element for a nonseparable zipper. The bottom end of a separable zipper is the lowermost tape or reinforcing tape but not the overhang of the fixed retainer. For the top end, the zipper extremities are the top of the top stop, or top of the last element, whichever is the extreme for both nonseparable and separable zippers.

12.2 *Length of Chain*—Place the closed chain, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. Place the scale on one stringer flush alongside the outer edge of the interlockable elements or the outer edge of the bead if the bead extends beyond the elements. Measure the distance between the extreme ends of the chain to the nearest 1 mm or ( $1/32$  in.).

12.3 *Length of Tape End*—Place the closed zipper, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. Place the end of the scale against the outermost surface of the outermost stationary component. Measure to the nearest 1.0 mm or ( $1/32$  in.) the tape end length along the cord to the outermost point of the pinked or straight-cut edge. In a case where the lengths of the tape ends on the two stringers are different, measure the length of the shorter tape end. This test method is not applicable to tape ends that are cut or pinked on a diagonal in excess of  $5^\circ$  in either direction.

12.4 *Effective Length of Opening, Completely Assembled Zipper*—Place the closed zipper, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. With a sharp-pointed pencil, make a reference mark even with the top of the slider. Move the slider to the extreme open position and make another reference mark even with the top of the slider. Measure the distance between the marks to the nearest 1.0 mm or ( $1/32$  in.). This test method is not applicable to separable zippers.

### 13. Report

13.1 State that the specimens were tested as directed in Sections **9 – 14** of Test Methods **D2060**. Describe the material or product sampled and the method of sampling used.

13.2 Report the following information:

- 13.2.1 The specific property (or properties) measured,
- 13.2.2 Number and description, of specimens tested, and
- 13.2.3 Measured length of each specimen.

#### 14. Precision and Bias

14.1 *Precision*—See Section 59.

14.1.1 Precision of the test method is related to the care with which the operator reads the 1.0 mm ( $1/32$ -in.) increments on the scale. The test method, though employing measurement of a variable, is really descriptive rather than quantitative. The test method has been found satisfactory in commercial use for determining conformity to an established specification.

14.2 *Bias*—The procedure in Test Methods D2060 for measuring the length of zipper parts has no known bias.

#### TAPE WIDTH

#### 15. Summary of Test Method

15.1 The chain or zipper is placed on a flat horizontal surface and, with the aid of a scale, the tape width is measured.

#### 16. Significance and Use

16.1 These measurements are used in determining the width of tape available for attachment of the zipper.

#### 17. Apparatus

17.1 *Scale*, graduated in 0.5 mm or ( $1/64$  in.).

#### 18. Procedure

18.1 *Effective Width*—Place the specimen, without tension, flat on a horizontal working surface. With the end of the scale at a  $90^\circ$  angle to the outer edge of the tape, place the end of the scale against the outermost edges of the interlockable elements on the bead if the bead extends beyond the elements. Measure the distance beyond the outermost edges of the interlockable elements, or the bead if the bead extends beyond the elements to the outermost edge of the tape, to the nearest 0.5 mm or ( $1/64$  in.), using a magnifying glass for greater precision. Take five measurements not less than 25.4 mm (1 in.) apart on each specimen.

18.2 *Full Width*—Measure the total tape width including the bead on the tape end of the fastener. Measure the distance perpendicular to the chain with the scale to the nearest 0.5 mm or ( $1/64$  in.) If a tape end does not exist, remove interlockable elements to provide a measuring area.

#### 19. Report

19.1 State that the specimens were tested as directed in Sections 15 – 20 of Test Methods D2060. Describe the material or product sampled and the method of sampling used.

19.2 Report the following information:

- 19.2.1 The specific property (or properties) measured,
- 19.2.2 Number and description of specimens tested, and
- 19.2.3 Measured width of each specimen.

#### 20. Precision and Bias

20.1 *Precision*—See Section 59.

20.1.1 Precision of the test method is related to the care with which the operator reads the 0.5 mm ( $1/64$ -in.) increments on the scale. The test method, though employing measurement of a variable, is really descriptive rather than quantitative. The test method has been found satisfactory in commercial use for determining conformity to an established specification.

20.2 *Bias*—The procedure in Test Methods D2060 for measuring the width of zipper tapes has no known bias.

#### SLIDER MOUTH WIDTH

#### 21. Summary of Test Method

21.1 A slider is cut into its halves and the mouth is then measured.

#### 22. Significance and Use

22.1 The slider mouth width is used only to designate the size of the zipper.

#### 23. Apparatus

23.1 *Leaf-Type Taper Gauge*, graduated in 0.025 mm (0.001 in.).

#### 24. Preparation of Specimens

24.1 Use side-cutting pliers, a jeweler's saw, or other suitable instrument to sever the slider through the diamond and to separate it into its front and back sections.

#### 25. Procedure

25.1 When the slider has flanges on both the front and back sections, measure the mouth width on the front half. When the slider has flanges on only one half, the measurement is made on that half.

25.2 Measure the mouth width to the nearest 0.025 mm (0.001 in.) by inserting a leaf-type taper gauge through the mouth of the slider. Take the measurement between the vertical parallel sides of the flanges at their narrowest point between the slider mouth and the leading edge of the diamond.

#### 26. Report

26.1 State that the specimens were tested as directed in Sections 21 – 27 of Test Methods D2060. Describe the material or product sampled and the method of sampling used.

26.2 Report the following information:

- 26.2.1 Number and description of specimens tested,
- 26.2.2 Width of zipper slider mouth,
- 26.2.3 Acceptable range of nominal slider mouth widths for zippers of that size as specified in Specification D3657, and
- 26.2.4 A statement that the sample does or does not conform to the nominal slider mouth width.

#### 27. Precision and Bias

27.1 *Precision*—No statement on the precision of the procedure in Test Methods D2060 for measuring slider mouth

width is being made, since the test result is merely used to determine into which of several slider mouth width ranges the specimen falls.

27.2 *Bias*—The procedure in Test Methods D2060 for measuring slider mouth width has no known bias.

## CHAIN THICKNESS

### 28. Summary of Test Method

28.1 A special gauge is used to determine chain thickness under prescribed conditions.

### 29. Significance and Use

29.1 This test method is useful for determining chain thickness in conjunction with the design of sewing aids such as folders.

### 30. Apparatus

30.1 *Dial Thickness Gauge*.

### 31. Procedure

31.1 Hold the specimen manually in a vertical position such that the thickness direction of the chain is perpendicular to the anvils of the gauge. Close the jaws of the gauge firmly on the chain, taking care that the anvil faces span the chain from shoulder to shoulder and that there is no movement of the elements from their original plane. Make five measurements on each specimen not less than 25.4 mm (1 in.) apart, reading the dial of the gauge to the nearest 0.001 in. (0.025 mm).

NOTE 3—For the zipper construction where the interlocking elements are attached in such a way that the tape laps the interlocking elements and the slider encompasses the tape, include the tape in the measurement taken (see Fig. 3 of Terminology D2050).

### 32. Report

32.1 State that the specimens were tested as directed in Sections 28 – 32 of Test Methods D2060. Describe the material or product sampled and the method of sampling used.

32.2 Report the following information:

- 32.2.1 Number and descriptions of specimens tested, and
- 32.2.2 The thickness of each chain specimen.

### 33. Precision and Bias

33.1 *Precision*—See Section 59.

33.2 *Bias*—The procedure in Test Methods D2060 for measuring the chain thickness of zippers has no known bias.

## CHAIN FLATNESS

### 34. Summary of Test Method

34.1 Departure from flatness is determined by passing a vernier height gauge over the length of the zipper to determine if the number of contacts made exceeds the number agreed upon by the purchaser and the supplier.

### 35. Significance and Use

35.1 Flatness of the zipper chain is important in its application to and appearance of the end use product.

### 36. Apparatus

36.1 *Surface Plate*—A toolmaker's surface plate at least 300 mm by 300 mm (12 in. by 12 in.).

36.2 *Height Gauge*, 152 mm (6 in.) vernier, permitting zero measurement at the base surface. The indicating anvil should be square with and parallel to the chain surface and should extend the full width of the chain.

### 37. Procedure

37.1 Place the specimen upon the surface plate without tension or pressure, with one tape edge aligned with the edge of the plate. Expose the specimen in the state described to the standard atmosphere for testing textiles for 24 h. Set the vernier height gauge to the thickness of the chain plus the desired amplitude for the size chain being measured. Place the vernier height gauge on the surface plate so that the indicating bar is positioned over the chain surface. Move the vernier height gauge along the entire length of the specimen chain and note the number of contacts made with the chain. Do not make any measurements within 25.4 mm (1 in.) of the slider or extremities of the specimen.

NOTE 4—The amplitude of wave to which the gauge should be set is that previously agreed upon by the purchaser and the supplier.

### 38. Report

38.1 State that the specimens were tested as directed in Sections 34 – 39 of Test Methods D2060. Describe the material or product sampled and the method of sampling used.

38.2 Report the following information:

- 38.2.1 Number of specimens,
- 38.2.2 Level of inspection in ANSI/ASQC Z1.4 agreed upon by the purchaser and seller,
- 38.2.3 Number of contacts per inch for each specimen tested and the number of specimens failing to meet the acceptance criteria, and
- 38.2.4 Whether the lot was accepted or rejected.

### 39. Precision and Bias

39.1 *Precision*—See Section 59.

39.1.1 Precision of the test method is related to the care with which the operator notes the contacts made by the height gauge. The test method, though employing measurement of a variable, is really descriptive rather than quantitative. The test method has been found satisfactory in commercial use for determining conformity to an established specification.

39.2 *Bias*—The procedure in Test Methods D2060 for measuring the chain flatness of zippers has no known bias.

## CHAIN STRAIGHTNESS

### 40. Summary of Test Method

40.1 Departure from straightness is determined by means of the height of the arc above a chord of predetermined length which delineates the segment of chain to be evaluated.

### 41. Significance and Use

41.1 Straightness of the zipper chain is important in its application to and appearance of the end use product.