



Designation: D6321/D6321M – 22

# Standard Practice for the Evaluation of Machine Washable T-Shirts<sup>1</sup>

This standard is issued under the fixed designation D6321/D6321M; 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.

## 1. Scope

1.1 This practice covers test methods and procedures used to evaluate important characteristics of machine washable T-shirts. T-shirts may be made of knitted fabric composed of any textile fiber(s) or blend of fibers and intended to be used as underwear or as an outer garment.

1.2 T-shirts' characteristics may be assessed either as a final product or at any intermediate processing stage.

1.3 This practice excludes T-shirts intended for hand washing or dry cleaning care.

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

1.5 *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.*

1.6 *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](#)

[D3786 Test Method for Bursting Strength of Textile Fabrics—Diaphragm Bursting Strength Tester Method](#)

[D3787 Test Method for Bursting Strength of Textiles—Constant-Rate-of-Traversal \(CRT\) Ball Burst Test](#)

[D3887 Specification for Tolerance for Knitted Fabrics \(Withdrawn 2017\)](#)<sup>3</sup>

[D3940 Test Method for Bursting Strength \(Load\) and Elongation of Sewn Seams of Knit or Woven Stretch Textile Fabrics \(Withdrawn 1995\)](#)<sup>3</sup>

[D4154 Performance Specification for Men's and Boys' Knitted and Woven Beachwear and Sports Shirt Fabrics](#)

[D4156 Performance Specification for Women's and Girls' Knitted Sportswear Fabrics](#)

[D7022 Terminology Relating to Apparel](#)

2.2 *AATCC Test Methods:*<sup>4</sup>

[EP1, Gray Scale for Color Change](#)

[EP2, Gray Scale for Staining](#)

[EP7, Instrumental Assessment of the Change in Color of a Textile Specimen](#)

[TM7, Colorfastness to Water](#)

[TM150, Dimensional Changes of Garments after Home Laundering](#)

[TM172, Colorfastness to Powered Non-Chlorine Bleach in Home Laundering](#)

[TM179, Skew Change in Fabrics After Home Laundering](#)

2.3 *Other AATCC Documents:*

[M11 Glossary of AATCC Standard Terminology](#)<sup>4</sup>

[LP1 Home Laundering: Machine Washing](#)

## 3. Terminology

3.1 For all terminology relating to D13.61, Apparel, refer to Terminology [D7022](#).

3.1.1 The following terms are relevant to this standard: T-shirt.

3.1.2 For definitions of other textile terms used in this standard, refer to terminology in Terminology [D123](#) and Glossary of AATCC Standard Terminology.

## 4. Significance and Use

4.1 This practice may be used to evaluate pertinent characteristics of washable T-shirts.

<sup>1</sup> This practice is under the jurisdiction of ASTM Committee [D13](#) on Textiles, and is the direct responsibility of Subcommittee [D13.61](#) on Apparel.

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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.

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

<sup>4</sup> Available from AATCC, PO Box 12215, Research Triangle Park, NC 27709.

4.2 T-shirts may be subject to extra processes such as garment dyeing, garment washing, printing, application of embroidery or trims. An individual process or combination of processes may affect the performance of the final product.

4.3 This practice may be used by mutual agreement between the purchaser and the supplier to establish purchasing specifications.

## 5. Sampling, Selection, and Number of Specimens

5.1 *Lot Sample*—Take a lot sample as directed in an applicable material specification or as agreed between purchaser and supplier, such as an agreement to take at random some fixed number of shipping containers or garments from each lot.

5.2 *Laboratory Sample*—From each lot sampling unit, take five T-shirts to be used as the laboratory sample.

5.3 *Test Specimen*—From each laboratory sample, two T-shirts are to be tested as-received and two T-shirts that are to be laundered. The fifth T-shirt is to be retained as a control specimen and not tested.

## 6. Fabric Performance Characteristics

6.1 Evaluate fabric designated for T-shirt manufacture using Specification **D3887**, **D3787**, Performance Specification **D4154**, or Performance Specification **D4156** as appropriate.

## 7. Garment Performance Characteristics

7.1 *Assessments Prior to Machine Laundering (As-Received State)*:

7.1.1 Condition T-shirts in standard atmospheres for testing  $20\text{ }^{\circ}\text{C} \pm 3\text{ }^{\circ}\text{C}$  [ $70\text{ }^{\circ}\text{F} \pm 2\text{ }^{\circ}\text{F}$ ] and  $65\% \pm 2\%$  RH according to Practice **D1776** for 4 hrs.

7.1.2 *Shade Difference*—Examine each of the four T-shirts for shade difference, garment panel-to-panel, using AATCC EP1 or EP7.

NOTE 1—Difference results may be obtained when using the subjecting assessment in EP1 when using the instrumental assessment in EP7.

7.1.3 *Defects*—Examine the four T-shirts for needle cutting, seam appearance, surface irregularities, or any other defect and record the information.

7.1.4 *Seam Performance*—Determine seam performance for the two as-received T-shirts as directed in Test Method **D3940**.

7.1.5 *Bursting Force*—If the fabric is not available for 6.1, determine bursting strength on the as-received T-shirts using **D3787** or **D3786**.

7.2 *Specimen Preparation Prior to Laundering*:

7.2.1 Condition T-shirts to the standard atmospheres of  $20\text{ }^{\circ}\text{C} \pm 3\text{ }^{\circ}\text{C}$  [ $70\text{ }^{\circ}\text{F} \pm 2\text{ }^{\circ}\text{F}$ ] and  $65\%$  RH as specified in Practice **D1776** for at least 4 h.

7.2.2 Lay the two T-shirts designated for laundering on a flat surface without tension, aligning sides and sleeves and smoothing to minimize folds and wrinkles.

7.2.3 Mark the dimensions to be measured with an indelible marking pen.

7.2.3.1 For garment dimensional change, mark the locations according to AATCC TM-150 and as shown in Fig. 1 using a plastic or metal tape graduated in increments of millimetres [ $1/16$  in.]:

7.2.3.2 *Chest Width*—Place marks “A1” and “A2” 125 mm [5.0 in.] below each armhole seam. This is Distance “A”. Measure and record the distance across the chest to the nearest mm [ $1/16$  in.].

7.2.3.3 *Front Length*—Fold the T-shirts in half lengthwise, back-to-back, matching shoulder and neck band seams. Lay the folded T-shirts flat on a smooth surface. Place marks “B1” and “B2” 25 mm [1 in.] below the center neck band and 25 mm [1 in.] above the bottom hem. This is Distance “B”. Measure and record the distance between the upper and lower marks to the nearest mm [ $1/16$  in.].

7.2.3.4 *Sleeve Length*—Place two T-shirts flat on a smooth surface. Mark the distance between the upper shoulder joining to the lower edge of the sleeve hem. This is Distance “C”. Measure and record the distance between the marked shoulder seam and the hem edge to the nearest mm [ $1/16$  in.].

7.2.3.5 *Sleeve Seam*—Place T-shirts flat on a smooth surface. Measure and record the distance between the upper shoulder joining and the underarm seam intersection to the nearest mm [ $1/16$  in.]. This measurement is Distance “D”.

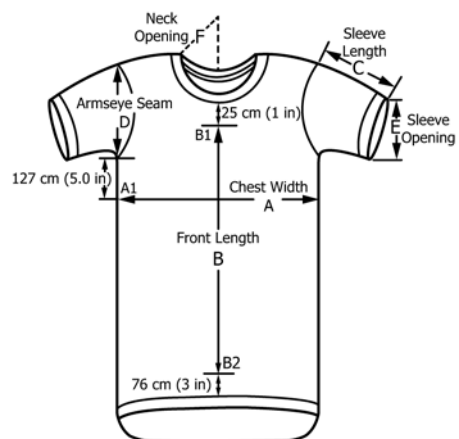
7.2.3.6 *Sleeve Opening*—Place T-shirts flat with the sleeves folded. Measure and record the distance between the upper edge of the sleeve hem to the lower edge of the sleeve on the outer edge to the nearest mm [ $1/16$  in.]. This is Distance “E”. The measured distance should be doubled and recorded.

7.2.3.7 *Neck Opening*—Grasp the neck band at the center back and the center front, forming a folded edge. Measure across the folded band. This is Distance “F”. The measured distance should be doubled and recorded.

7.2.4 *Skewness Change*—Mark the T-shirts according to AATCC TM179, marking Method 2. See Fig. 2.

7.2.5 *Colorfastness to Water*—For dyed or printed T-shirts, prepare specimens for colorfastness to water according to AATCC TM107.

NOTE 2—It has been reported that the results for staining, obtained by standard AATCC Test Methods, on fabrics dyed to dark shades that contain a combination of polyester and spandex, or their blends, may not



NOTE 1—Refer to AATCC Test Method 150.  
**FIG. 1 Dimensional Change Marking Location**