



Standard Test Method for Linear Density of Yarn (Yarn Number) by the Skein Method¹

This standard is issued under the fixed designation D 1907; 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 test method covers the determination of the linear density of all types of yarn in package form, subject to the limitations of size and stretch given in 1.2 and 1.3. Provision is made for expressing yarn linear density in all the traditional yarn numbering systems.

1.2 This method is applicable to yarns that stretch less than 5 % when tension on the yarn is increased from 0.25 to 0.75 cN/tex (0.25 to 0.75 gf/tex). By mutual agreement, and use of a lower than specified reeling tension, this method may also be adapted to measure the linear density of yarns that stretch more than 5 %, under the above force.

1.3 This method is applicable to yarns finer than 2000 tex. However, it may be also adapted to coarser yarns by the use of skeins of shorter than specified lengths, and alternate reeling conditions, agreeable to the interested parties.

1.4 Depending on the procedure used to calculate the moisture content of the yarn being tested, and its actual moisture content, or finish content, or both, one or more of the following options may be utilized.

1.4.1 *Unscoured Yarn:*

Option 1—Yarn at equilibrium with the standard atmosphere for testing textiles.

Option 2—Oven-dried yarn.

Option 3—Oven-dried yarn, plus commercial moisture regain.

1.4.2 *Scoured Yarn:*

Option 4—Scoured yarn at equilibrium with the standard atmosphere for testing textiles.

Option 5—Oven-dried, scoured yarn.

Option 6—Oven-dried, scoured yarn, plus commercial moisture regain.

Option 7—Oven-dried, scoured yarn, plus commercial allowance (commercial moisture regain, plus an allowance for finish).

1.5 Specimens used to determine yarn linear density may also be used to determine the skein breaking strength of the yarn. Hence, this method provides the sequence of steps to be followed, to determine both these yarn properties.

NOTE 1—The linear density of yarns produced with jute, or glass, may

also be determined by the following approved methods: Specifications D 541, D 578, and D 681. The linear density of short yarn segments, raveled from fabrics, may be determined by Test Method D 1059.

1.6 The values stated in SI units are to be regarded as standard. The values shown in parentheses are approximate conversions to U.S. customary unit equivalents.

1.7 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*

D 123 Terminology Relating to Textiles²

D 541 Specification for Single Jute Yarn²

D 578 Specification for Glass Fiber Strands²

D 681 Specification for Jute Rove and Plied Yarn for Electrical and Packing Purposes²

D 1059 Test Method for Yarn Number Based on Short-Length Specimens²

D 1578 Test Method for Breaking Strength of Skeins²

D 1776 Practice for Conditioning Textiles for Testing²

D 1909 Table of Commercial Moisture Regains for Textile Fibers²

D 2257 Test Method for Extractable Matter in Textiles²

D 2258 Practice for Sampling Yarn for Testing²

D 2494 Test Method for Commercial Mass of a Shipment of Yarn or Man-Made Staple Fiber, or Tow²

2.2 *ISO Standards:*

2060 Textiles—Yarn from Packages—Determination of linear density (mass per unit length) by the skein method.

3. Terminology

3.1 *Definitions:*

3.1.1 *commercial allowance, (CA) n*—an arbitrary value, equal to the commercial moisture regain, plus a specific allowance for finish, used with the mass of scoured, oven-dried yarn, to compute (1) yarn linear density, (2) the commercial or legal mass of a shipment or delivery of any specific textile material (see also *commercial moisture regain*), or (3) the mass of a specific component in the analysis of fiber blends.

3.1.2 *commercial moisture regain, (CMR) n*—a formally adopted, arbitrary value, to be used with the oven-dried mass of

² Annual Book of ASTM Standards, Vol. 07.01.

¹ This test method is under the jurisdiction of ASTM Committee D-13 on Textiles, and is the direct responsibility of Subcommittee D13.58 on Yarn Test Methods, General.

Current edition approved Jan. 10, 1997. Published August 1997. Originally published as D 1907 – 61 T. Last previous edition D 1907 – 96.

textile fibers, when calculating the commercial mass of a shipment or delivery.

3.1.3 *direct yarn numbering system, n*—a system that expresses yarn linear density (number) in mass per unit length. (See also *denier*, *spynle number*, and *tex*.)

3.1.4 *indirect yarn numbering system, n*—a system that expresses yarn linear density (number) in length per unit mass. (See also *cotton count*, *metric count*, *worsted count*, *cut*, and *run*.)

3.1.5 *skein, n*—a continuous strand of yarn, wound on a hand or motorized reel.

3.1.6 *yarn linear density, n*—the mass per unit length of a yarn. (See also *yarn number*.)

3.1.7 *yarn number, n*—a measure of the linear density of a yarn, expressed as “mass per unit length”, or “length per unit mass”, depending on the yarn numbering system used. (See also *yarn linear density*.)

3.1.8 *yarn numbering system, n*—a system expressing the size of a yarn as a relationship between its length and associated mass. (See also *yarn linear density*, *yarn number*, *direct yarn numbering system*, *indirect yarn numbering system*, and Appendix X1.)

3.2 For definitions of other textile terms used in this method, refer to Terminology D 123.

4. Summary of Test Method

4.1 Specified lengths of yarn are wound on reels as skeins, and weighed. The linear density of the yarn is computed from the mass and length of the skein. In some options, the skein is scoured before weighing, and, depending on the option chosen, the mass of the skein may be determined after oven drying, or after conditioning.

5. Significance and Use

5.1 Test Method D 1907 is considered satisfactory for acceptance testing of commercial shipments, since it has been used extensively in the trade for that purpose.

5.1.1 In case of dispute arising from differences in reported test results when using Test Method D 1907 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.

5.1.2 Competent statistical assistance is recommended for the determination of such a bias. As a minimum, the two parties should take a group of test specimens that are as homogeneous as possible, and that are from the same lot of the material 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 statistical analysis for unpaired data, and an acceptable probability level chosen by the parties before testing begins. If a bias is found, either its cause must be identified and corrected, or the purchaser and supplier must agree to interpret future test results with consideration to the known bias.

5.2 This test method is intended primarily for the determination of the average linear density of yarns. However, the variations identified by the results may also provide useful information. If the coefficient of variation is to be calculated, each skein must be weighed separately, and a larger number of

skeins will need to be tested (as compared to the number of skeins to be tested for the determination of the average yarn linear density alone).

5.3 This test method includes seven options, depending on whether the yarn is scoured before weighing, weighed in the conditioned or oven-dried state, or whether or not the results obtained are adjusted for commercial moisture regain, or a commercial allowance. Option 1 (unscoured, conditioned yarn) is generally used for yarns spun on the cotton system, while Options 6 and 7 (scoured, oven dried yarn, plus commercial moisture regain, or allowance are generally used for filament yarns, or yarns containing wool fibers. The specific options to be used in any instance shall be agreed upon by the parties, or as prescribed in test methods or tolerances, for filament yarns, or for yarns spun from specific fibers.

5.4 In Options 2, 3, 5, 6, and 7, an oven-dried sample is obtained by exposing the yarn in an oven with a supply of air at standard textile testing conditions, as described in 6.3.

6. Apparatus and Reagents

6.1 Reel:

6.1.1 *General*—A hand reel or motor driven reel having a perimeter of 1.000 m or 1.500 yd. with a tolerance of $\pm 0.25\%$ is recommended. By prior agreement, reels having a perimeter of between 1.0 and 2.5 m (1.5 and 3.0 yd) may be used. The reel shall be fitted with a traversing mechanism that will avoid bunching successive wraps of yarn, and with an indicator of the length wound. A warning bell that rings at a specified length, is also recommended. And, it is advisable that one arm of the reel be collapsible, to allow for easy removal of the wound skeins.

6.1.2 *Reel Perimeter*—Determine the actual perimeter of the reel by winding a 0.6 cm. (0.25 in.) wide steel measuring tape around the reel. Tension the tape prior to directly reading the circumference of the reel, by attaching a 0.5 kg (1.0 lb) weight to the end of the tape. Repeat this measurement near each end of the bars of the reel, and in the center. If the circumference at any of these areas is outside the limits of 1.000 ± 2.5 mm (1.500 + 0.1 in.), adjust the fly wheel to bring the measurement(s) within the limits.

6.1.3 *Yarn Tensioning*—The reel shall be fitted with either a positive fee system at a controlled tension of 0.5 cN/tex (0.05 gf/ tex) or with an adjustable tension device. The length of the skeins should be checked, and variations in length not be allowed to exceed $\pm 0.25\%$ (See Annex A1).

6.2 *Balance*—For the determination of average yarn linear density, a balance of suitable capacity, graduated in grams or grains, with a sensitivity of 1 part in 1000 should be used. If single skeins are weighed, a balance graduated directly in yarn linear density may be used.

NOTE 2—The 1:1000 balance sensitivity is needed to ascertain the completion of conditioning, or oven drying. For subsequent weighings of skeins, a 1:500 sensitivity has been found to be sufficient.

NOTE 3—For the calculation of the variation of yarn linear density, a 1:100 balance sensitivity is sufficient to weigh individual skeins, after the skeins are conditioned, or oven-dried.

6.3 *Drying Oven*—An oven, ventilated and capable of being controlled in a temperature range of $105 \pm 3^\circ\text{C}$ ($221 \pm 5^\circ\text{F}$), is required to dry the skeins. The oven should be of sufficient

design to facilitate the free passage of air through the specimens, and should be supplied with a current of air sufficient to change the air in the oven once every 4 min. The specimens shall be protected from any direct heat, radiating from the heating units of the oven. Air supplied to the oven shall be at the standard atmosphere for testing textiles. The oven may be provided with facilities to shut off the air current and weigh the specimens, without removing them from the oven.

6.4 *Facilities for Scouring* (Options 4, 5, 6, and 7), as indicated in X2.2, or in Sections 6.1 and 6.3 of Test Method D 2494.

6.5 *Weighing Cans*, with tight fitting lids, and of sufficient size to hold all skeins, or groups of skeins (Options 2, 3, 5, 6, and 7), if the weighing is to be done outside the oven. Weighing bottles with ground-glass stoppers may also be used.

6.6 *Auxiliary Facilities*, suited to the specimens and options used, such as sample supports, tared wire gauze baskets of corrosion resistant metal, dessicators of sufficient size to hold the weighing cans or bottles, and an efficient dessicant.

7. Sampling

7.1 *Lot Sample*—As a lot sample for acceptance testing, take at random the number of shipping units directed in an applicable material specification, or other agreement between the purchaser and supplier, such as an agreement to use Practice D 2258. Consider cartons or other shipping units to be the primary sampling units.

NOTE 4—An adequate specification or other agreement between the purchaser and the supplier requires taking into account the variability between shipping units, between packages or ends within a shipping unit, and between specimens from a single package, to provide a sampling plan with a meaningful producer’s risk, user’s risk, acceptable quality level, and limiting quality level.

7.2 *Laboratory Sample*—As a laboratory sample for acceptance testing, take at random from each shipping unit in the lot sample the number of packages or ends directed in an applicable material specification, or as agreed to between purchaser and supplier (such as an agreement to use Practice D 2258). Preferably, the same number of packages should be taken from each shipping unit in the lot sample.

7.2.1 *Average of Yarn Linear Density*—When only the average of the yarn linear density is to be determined, take a laboratory sample as follows:

- Filament yarns — 5 packages
- Yarns spun on Worsted or Cotton systems — 10 packages
- Yarns spun on Bast, or Woollen systems — 20 packages

7.2.2 *Average and Variability of Yarn Linear Density*—When both the average and variability of the linear density of yarn are to be determined, take a laboratory sample of 30 packages. If possible, take an equal number of randomly selected packages from each case in the lot sample.

7.3 *Test Specimens*—Test one skein from each package in the laboratory sample.

NOTE 5—Since the variation in yarn linear density is usually higher between packages than within packages, no appreciable improvement in precision can be expected by testing more than one skein from each package.

7.3.1 An exception to the information provided in Note 5 may occur in packages of filament yarns; consistent differences in yarn linear density are sometimes present between yarn on the outside of the package, as compared to yarn on the inside. If such differences are suspected, test more than one skein from each package, without reducing the number of packages sampled for testing, taking skeins at intervals throughout the packages.

8. Conditioning

8.1 Before reeling test skeins, condition yarn in skein form in the standard atmosphere for testing textiles for a minimum of 1 h, and yarn on packages for a minimum of 3 h. Additionally, prior to testing, preconditioning of the test skeins may be required for Option 1, but is not necessary for Options 2 through 7.

NOTE 6—For Options 2 through 7, where the yarn is scoured or oven-dried after reeling, the conditioning prior to reeling is required to ensure a correct skein length.

9. Procedure

9.1 *General*:

9.1.1 The procedure used depends on the options selected; Table 1 shows the steps to be followed for each option.

9.1.2 If both the breaking load and linear density are to be determined, test conditioned skeins for breaking strength before scouring, as directed in Test Method D 1578.

For Option 1, condition the yarn prior to reeling test skeins. Pre-condition, then condition the test skeins; perform skein

TABLE 1 General Procedures

	Referenced Sections
Step 1	
<i>All Options:</i>	
Selection of lot sample, and packages	7
Conditioning prior to reeling	8.1
Setting of skein gage, and reeling of skeins	9.3 to 9.6
Step 2	
<i>Option 1—Unscoured yarn in standard atmosphere for testing textiles:</i>	
Preconditioning and conditioning	9.7, and 9.8
Weighing of skeins, and calculation of yarn linear density	9.10, 10.1, and 10.2
<i>Option 2—Unscoured, moisture free yarn, and, Option 3—Unscoured, moisture free yarn, with commercial moisture regain:</i>	
Oven drying	9.9
Weighing of skeins, and calculation of yarn linear density	9.10, and 10
<i>Option 4—Scoured yarn, in standard atmosphere for testing textiles:</i>	
Scouring	9.6, and X2
Preconditioning, and conditioning	9.7, and 9.8
Weighing of skeins, and calculation of yarn linear density	9.10, 10.1, and 10.2
<i>Option 5—Scoured, oven-dried yarn</i>	
<i>Option 6—Scoured, oven-dried yarn, with commercial moisture regain:</i>	
<i>Option 7—Scoured, oven-dried yarn, with commercial allowance:</i>	
Scouring	9.6, and X2
Oven drying	9.9
Weighing of skeins, and calculation of yarn linear density	9.10, 10.1, and 10.2

breaking load tests prior to weighing the skeins. For all the other Options, condition the yarn prior to reeling test skeins. Precondition, then condition the test skeins, break them, then proceed with oven drying or scouring, or both, and the subsequent steps shown in Table 1.

9.2 Tension for Reeling:

9.2.1 To establish the required tension for reeling, reel a skein from each of two packages, and immediately check their lengths, as prescribed in Appendix. If the length of either skein departs from the set length by more than 0.25 %, adjust the reeling tension and repeat the reeling measurement until both skeins fall within the ± 0.25 % tolerance. If yarn is supplied on more than one type of package, check two skeins from each type of package as above. It may be necessary to use different reeling tensions for each package type.

9.2.2 If, when reeled under the least possible tension, skeins are more than 0.25 % shorter than the nominal length, reel skeins longer than specified in Table 2, and allow them to relax in the standard atmosphere for testing textiles for at least 3 h. Then reel test skeins from the relaxed skeins, for the determination of yarn linear density.

9.2.3 Once the correct tension for reeling has been established for a specific type of yarn and package, subsequent testing of that yarn on the same reel does not require rechecking of skein lengths.

9.3 Length of Test Skein:

9.3.1 For reels with perimeters of 1 m or 1.5 yd, select the number of wraps and skein length from Table 2. If a reel with a different perimeter is used by agreement, select the number of wraps based on a whole number of turns of the reel, that will give approximately one of the skein lengths shown in Table 2.

NOTE 7—If both the skein breaking force and yarn linear density are to be determined, note that in certain cases, skein lengths shorter than those shown in Table 2 are permitted. For example, Option 1 of Test Method D 1578 specifies a skein length of 110 m (120 yd), but permits the use of shorter skeins, to allow the breaking force to remain within the capacity of the tensile testing machine. In such cases, reel an additional skein from each package in the laboratory sample so that the total length of the skeins (additional skein plus skein used to determine the skein breaking force), reeled from each package, equals the values listed in Table 2. Weigh the two skeins from each package together, to determine the linear density of the yarn.

9.3.2 When reeling very coarse yarns, wind a single layer, to avoid a build up on the reel. Specifically, use no more than 25 wraps for yarns between 500 and 1000 tex, and no more than 10 wraps for yarns between 1000 and 2000 tex. Obtain the required length of skeins (approximately 50 m, or 60 yd) either by reeling two or more contiguous short skeins, or by using a reel with a perimeter larger than 1 m (1.5 yd).

9.4 Reeling—Since the speed of reeling can affect reeling tension, reel all skeins at the speed used in reeling preliminary

skeins (see Annex A1). Avoid jerks and undue acceleration or deceleration.

9.5 Scouring (Options 4, 5, 6, and 7 only)—Scour the skeins as directed in Appendix X2. Alternatively, the scouring procedures listed in Sections 7.8, 7.9, and 7.12 of Test Method D 2494 may also be used.

9.6 Preconditioning (Options 1 and 4 only)—Precondition skeins of the as received yarn, reeled for Option 1, or scoured and air-dried skeins for Option 4, for at least 3 h in an atmosphere that does not exceed a temperature of 50°C (122°F), and with a relative humidity between 10 and 25 %.

9.6.1 If preconditioning is carried out in an oven, ensure that the yarn does not become too dry.

NOTE 8—In Option 1, preconditioning and conditioning of yarn may be done before reeling. However, it is usually not convenient to precondition large packages in an oven or a cabinet. Therefore, it may be preferable to precondition the yarn in skein form.

9.7 Conditioning (Options 1 and 4 only)—Condition skeins that have been preconditioned as directed in Section 9.6 in a standard atmosphere for testing textiles, $21 \pm 1^\circ\text{C}$ ($70 \pm 2^\circ\text{F}$) and 65 ± 2 % relative humidity, until moisture equilibrium is reached, that is, until the mass of the specimen increases by no more than 0.1 % after 2 h in that atmosphere.

9.8 Oven Drying (Options 2, 3, 5, 6, and 7)

9.8.1 Place the skeins as reeled, or after scouring, in an oven, maintained at $105 \pm 3^\circ\text{C}$ ($221 \pm 5^\circ\text{F}$). Arrange the skeins to permit free air access.

9.8.2 Dry the skeins to constant mass, that is, until they lose no more than 0.1 % of their mass at 15 min. intervals if weighed in the oven, or at 30 min. intervals if weighed outside the oven.

9.8.2.1 Cooling in hot, closed containers in a dessicator frequently creates a vacuum in the container. For metal containers, quickly remove and replace the cover to release the vacuum before weighing. For glass bottles, cool the container with the cover resting sideways on the container, to prevent development of vacuum, and put covers in place upon opening the dessicator, before weighing.

9.9 Weighing:

9.9.1 If the variation in yarn linear density is to be determined or if the mass of individual skeins is needed, weigh each skein separately.

9.9.2 To determine average yarn linear density, weigh all skeins together at each step, even if weighed separately earlier.

NOTE 9—A higher degree of accuracy is obtained when all skeins are weighed together as compared to when each skein is weighed separately. Hence, this method provides for the determination of the average yarn linear density by weighing all the skeins together.

9.9.3 If the pan of the balance is too small to accommodate all the skeins at one time, weigh them separately in groups, and add the results of each weighing.

9.9.4 If weighing dried skeins in an oven, shut off the current of air in the oven. If the weighing is done outside the oven, transfer the skein or skeins to a weighing can or bottle, close and place in a dessicator to cool. Weigh when cool. If weighing bottles are used, loosen their covers from time to time, while cooling.

TABLE 2 Number of Wraps and Lengths of Skeins

	1 m Reel Perimeter	1.5 yd Reel Perimeter
All yarns finer than 100 tex	100 wraps = 100 m	80 wraps = 120 yd
Spun yarns coarser than 100 tex ^A	50 wraps = 50 m	40 wraps = 60 yd
Filament yarns coarser than 100 tex	10 wraps = 10 m	8 wraps = 12 yd

^ASee 9.3.2.