Designation: D 5735 – 95

Standard Test Method for Tearing Strength on Nonwoven Fabrics by the Tongue (Single Rip) Procedure (Constant-Rate-of-Extension Tensile Testing Machine)[1]

This standard is issued under the fixed designation D 5735; 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 measurement of the tearing strength of nonwoven fabrics by the tongue (single rip) procedure using a recording constant-rate-of-extension (CRE) tensile testing machine.

1.1.1 The CRE-type tensile testing machine has become the preferred test apparatus for determining tongue tearing strength. It is recognized that some constant-rate-of-traverse (CRT) tensile testing machines continue to be used. As a consequence, these test instruments may be used when agreed upon between the purchaser and the supplier. The conditions for the CRT-type tensile tester as used with this test are included in Appendix X1.

1.2 This test method applies to most nonwoven fabrics including those that are treated or untreated, including those heavily sized, coated or resin treated, provided that during the test, the fabric does not tear in the direction crosswise to the direction of the force applied. This test method may not be useful for highloft nonwoven fabrics. If the tear is not substantially lengthwise, the fabric shall be described as untearable in that direction by this test.

1.3 Tongue tear strength as measured in this method is the maximum single-peak force required to continue or propagate a tear started previously in the specimen. The reported value includes the simultaneous force required to shift fibers, break fibers, break fiber bonds and break fiber interlocks in nonwoven fabric. The reported value is not directly related to the force required to initiate or start a tear.

1.4 The values stated in SI units are to be regarded as the standard. The inch-pound units given in parentheses may be approximate.

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

2. Referenced Documents

2.1 *ASTM Standards:*

D 76 Specification for Tensile Testing Machines for Textiles[2]

D 123 Terminology Relating to Textile Materials[2]

D 1776 Practice for Conditioning Textiles for Testing[2]

D 4848 Terminology Relating to Force and Deformation and Properties Textiles[3]

3. Terminology

3.1 *Definitions:*

3.1.1 *lengthwise direction*, *n*—in textiles, the direction in a machine-made fabric parallel to the direction of movement the fabric followed in the manufacturing machine.

3.1.1.1 *Discussion*—For nonwovens, an easily distinguishable pattern for orientation may not be apparent, especially if removed from the roll. Care should be taken to maintain the directionality by clearly marking the direction.

3.1.2 *nonwoven fabric*, *n*—a textile structure produced by bonding or interlocking of fibers, or both, accomplished by mechanical, chemical, thermal, or solvent means and combination thereof.

3.1.3 *tearing force*, *n*—the average force required to continue a tear previously started in a fabric.

3.1.3.1 *Discussion*—For nonwovens, the tearing force is recorded as the maximum force required to continue a tear previously started in a fabric. The tearing force may appear as a single peak or a series of peaks on a force-extension curve, depending on the nature of the material. Typically for nonwoven fabrics, if a small decrease in force occurs at a time when the applied force is increasing, it is not considered as a peak unless the indicated force exceeds the force required to break, individually or collectively, the fibers, fiber bonds, or fiber interlocks. Lower shifts corresponding to fiber movement do not qualify as peaks since the fibers, fiber bonds, or fiber interlocks are not broken. The tongue tearing force may be calculated from a single-peak or multiple-peak force-extension curve.

3.1.4 *tearing strength*, *n*—the force required either to start or to continue or propagate a tear in a fabric under specified conditions.

3.1.5 *widthwise direction*, *n*—in textiles, the direction in a

[1] This test method is under the jurisdiction of ASTM Committee D-13 on Textiles and is the direct responsibility of Subcommittee D13.64 on Non-Woven Fabric.

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[2] *Annual Book of ASTM Standards*, Vol 07.01.

[3] *Annual Book of ASTM Standards*, Vol 07.02.

machine-made fabric perpendicular to the direction of movement the fabric followed in the manufacturing machine.

3.1.6 For other definitions of other textile terms used in this test method, refer to Terminology D 123 and Terminology D 4848.

4. Summary of Test Method

4.1 A rectangular specimen, cut in the center of the shorter edge to form a two-tongue (trouser type) specimen. One tongue of the specimen is gripped in the upper jaw and the other tongue is gripped in the lower jaw of a tensile testing machine. The separation of the jaws is continuously increased to apply a force to propagate the tear in a ripping action. At the same time, the force developed is recorded. The maximum force to continue the tear is calculated from autographic chart recorders, or microprocessor data collection systems.

5. Significance and Use

5.1 This test method is used in the trade for acceptance testing of commercial shipments of nonwoven fabrics, however, caution is advised since information about between-laboratory precision is incomplete. Comparative test as directed in 5.1.1 may be advisable.

5.1.1 In case of a dispute arising from differences in reported test results when using this test method 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. 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 the appropriate Student's t-test and an acceptable probability level chosen by the two parties before 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 view of the known bias.

5.2 The force registered in a tear test is irregular, and as a consequence empirical methods have had to be developed to obtain usable values related to tear strength. In spite of the empirical nature of the reported values, they are considered to reflect comparative performance of similar nonwoven fabrics tested and measured in the same way. No procedure is available that can be used with all fabrics to determine the minimum tearing strength.

5.3 For nonwoven fabrics, because the individual fibers are more or less randomly oriented and capable of some reorientation in the direction of the applied force, the maximum tongue tearing strength is reached when the resistance to further reorientation is greater than the force required to shift and rupture one or more fibers, or the fiber interlocking, simultaneously. The tearing strength is determined primarily by the bonding or interlocking of fibers in this structure.

5.4 Depending on the nature of the specimen, the data recording devices usually will show the tearing force in the form of a single-peak. The highest peak appears to reflect the strength of the fibers, fiber bonds, or fiber interlocks, individually or in combination, needed to stop a tear in a fabric of the same construction.

5.5 Most nonwoven fabrics can be tested by this test method. Some modification of clamping techniques may be necessary for a given fabric, depending upon its structure. Special adaptation may be necessary with strong fabrics, or fabrics made from glass fibers, to prevent them from slipping in the clamps or being damaged as a result of being gripped in the clamps.

5.6 The CRE-type is the preferred tensile testing machine. This test method allows the use of the CRT-type tensile machine when agreed upon between the purchaser and supplier. However, there may be no overall correlation between the results obtained with the CRT machine and the CRE machine. Consequently, these two tensile testers cannot be used interchangeably unless the degree of quantitative correlation has been established between the purchaser and supplier. In any event, the CRE machine shall prevail.

6. Apparatus

6.1 *Tensile Testing Machine*, of the constant-rate-of-extension (CRE) type conforming to the requirements of Specification D 76 with autographic recorder, or automatic microprocessor data gathering systems.

6.2 *Clamps*, having all jaw surfaces parallel, flat, and capable of preventing slippage of the specimen during a test, and measuring at least 25 by 75 mm (1 by 3 in.) with the longer dimension perpendicular to the direction of application of the force.

6.2.1 The use of hydraulic pneumatic clamping systems with a minimum of 50 by 75 mm (2 by 3 in.) serrated or rubber jaw faces having a clamping force at the grip faces of 13 to 14 kN (2900 to 3111 lbf) is recommended. Manual clamping is permitted providing no slippage of the specimen is observed.

6.2.2 For some materials, to prevent slippage when using jaw faces other than serrated, such as rubber faced jaws, they may be covered with a No. 80 to 120 medium grip emery cloth. Secure the emery cloth to the jaw faces with pressure sensitive tape.

6.3 *Cutting Die or Template*, having essentially the shape and dimensions with tolerances of 0.5 % shown in Fig. 1.

7. Sampling and Test Specimens

7.1 *Lot Sample*—As a lot sample for acceptance testing, take at random the number of rolls, or pieces, of nonwoven fabric directed in an applicable material specification or other agreement between the purchaser and the supplier. Consider the rolls, or pieces, of nonwoven fabric to be the primary sampling units. In the absence of such an agreement, take the number of nonwoven fabric rolls specified in Table 1.

NOTE 1—An adequate specification or other agreement between the purchaser and supplier requires taking into account the variability between rolls or pieces of fabric and between specimens from a swatch from a roll or pieces of fabric to provide a sampling plan with a meaningful producer's risk, consumer's risk, acceptable quality level, and limiting quality level.

7.2 *Laboratory Sample*—For the laboratory sample, take a swatch extending the width of the fabric and approximately 1