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Standard Terminology Relating to Yarns and Fibers¹

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1. Scope

1.1 This standard is a compilation of terminology developed by Committee D-13.58 on Yarns and Fibers.

1.1.1 This terminology, mostly definitions, is unique to fibers and yarns used in the textile industry. Terms that are generally understood or adequately defined in other readily available sources are not included.

1.1.2 Subcommittee D13.58 has jurisdictional responsibility for every item in this standard. The standards in which the terms and definitions are used are listed by number after the definition. The wording of an entry cannot be changed without the approval of 13.58 subcommittee. Any changes approved by the subcommittee and main committee are then directed to subcommittee D13.92 on Terminology for subsequent changes or additions to Terminology D123.

1.1.3 This terminology standard is not all inclusive of the terms under the jurisdiction of subcommittee D13.58. Other terminology standards under the jurisdiction of subcommittee D13.58 are D 3888², D 4466, and D 4466D 4848.

2. Referenced Documents

2.1 *ASTM Standards:*

- D 123 Terminology Relating to Textiles²
- D 3888 Terminology Relating to Open-End Spinning³
- D 4466 Terminology for Multicomponent Textile Fibers³
- D 4848 Force, Deformation and Related Properties of Textiles³

3. Terminology

3.1 Alphabetical listings of terms with subcommittee 13.58 jurisdiction and attribution for each term.

American grain count, *n*—a direct yarn numbering system for expressing linear density, equal to the mass in grains per 120 yards of sliver or roving. **D 2260**

beam, *n*—*in textiles*, a large spool containing many ends of

yarn wound parallel, and used for such purposes as weaving or warp knitting. **D 2258**

beam set, *n*—*in textiles*, one or more beams of yarn in a single shipment to be further processed together for a specific end use. **D 2258**

bench marks, *n*—marks placed on a specimen to define gage length, that is, the portion of the specimen that will be evaluated in a specific test. **D 76**

boundary friction, *n*—friction at low sliding speeds (0.02 m/min or less) where lubrication occurs under thin-film lubricant conditions. **D 3412**

broken filament, *n*—*in multifilament yarn*, breaks in one or more filaments. **D 3990**

bulk shrinkage, *n*—a measure of potential stretch and power of stretch yarns or a measure of bulk of textured-set yarns. **D 4031**

bunch, *n*—a defect in a yarn characterized by a segment not over 6 mm ($\frac{1}{4}$ in.) in length that shows an abrupt increase in diameter caused by more fibers matted in this particular place. (See **slug**, **slub**.) **D 2255**

cable twist, *n*—the construction of cabled yarn, cord, or rope in which each successive twist is in the opposite direction to the preceding twist; an S/Z/S or Z/S/Z construction. **D 1423**

calibrate, *v*—to determine and record the relationship between a set of standard units of measure and the output of an instrument or test procedure. **D 76**

DISCUSSION—This term is also commonly used to describe the checking of previously marked instruments, an operation more properly described as a description of verification. **D 76**

capacity, *n*—*for tensile testing machines*, the maximum force for which the machine is designed. **D 76**

DISCUSSION—Capacity is the maximum force the tester-frame and the drive system can exercise on the specimen without inadmissible deformations of the tester-frame, etc. Within its capacity, there are available load-cells with different full-scale ranges which may be chosen to select an appropriate full-scale range for a special test. **D 76**

case, *n*—*in textiles*, a shipping unit, usually a carton, box, bale, or other container holding a number of yarn packages. **D 2258**

clamp, *n*—that part of a testing machine used to grip the specimen by means of suitable jaws. **D 76**

¹ This terminology is under the jurisdiction of ASTM Committee D13 on Textiles and is the direct responsibility of Subcommittee D13.58 on Yarns and Fibers.

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² *Annual Book of ASTM Standards*, Vol 07.01

³ *Annual Book of ASTM Standards*, Vol 07.02

cockles, *n*—*in yarns*, irregular, thick, uneven lumps. **D 2255**

coefficient of friction, *n*—the ratio of the tangential force that is needed to maintain uniform relative motion between two contacting surfaces to the perpendicular force holding them in contact. **D 3108, D 3412**

coefficient of variation unevenness, *n*—*in textiles*, the standard deviation of the linear densities over which unevenness is measured expressed as a percentage of the average linear density for the total length within which unevenness is measured. (See also **unevenness** and **mean deviation unevenness**.) **D 1425**

cohesive force, *n*—*in a textile strand*, the force required to overcome fiber cohesion as the strand is being reduced in linear density.

DISCUSSION—In dynamic tests, cohesive force is the force required to maintain drafting in a roving, silver, or top. In static tests, cohesive force is measured while a test specimen is held in a fixed position between two slowly separating clamps. **D 2612, D 4120**

colorfastness, *n*—the resistance of a material to change in any of its color characteristics, to transfer its colorant(s) to adjacent materials, or both, as the result of exposure of the material to any real or simulated environment that might be encountered during processing, storage, use or testing of the material. **D 204**

commercial allowance, *n*—an arbitrary value equal to the commercial moisture regain plus a specified 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 **D 1907, D 2494**

commercial mass, *n*—billed mass as determined by a generally accepted method or as agreed upon between the purchaser and supplier.

DISCUSSION—The basis for determining the commercial mass of a shipment of yarn or manufactured fibers is generally one of the following: (1) *CAS Basis (commercial allowance with scoured material)*—the mass of oven-dry fiber or yarn after scouring by definite prescribed methods plus the mass corresponding to its *commercial allowance*, (2) *CMRS Basis (commercial moisture regain with scoured material)*—the mass of oven-dry fiber or yarn after scouring by definite prescribed methods plus the mass corresponding to its *commercial moisture regain*, (3) *CMRU Basis (commercial regain with unscoured material)*—the mass of unscoured oven-dry fiber or yarn plus the mass corresponding to its *commercial regain*, (4) *UN Basis (unadjusted net)*—the mass of the unscoured fiber or yarn with no adjustment for the amount of moisture or finish, or both. **D 2494**

cone, *n*—*in textiles*, (1) a yarn holder or bobbin of conical shape used as a core for a yarn package of conical form, also called a cone core. (2) the yarn package obtained when yarn is wound upon a cone core. **D 2258**

constant-rate-of-extension type tensile testing machine (CRE), *n*—*in tensile testing*, an apparatus in which the pulling clamp moves at a uniform rate, and the force-measuring mechanism moves a negligible distance with increasing force, less than 0.13 mm (0.005 in.) **D 76**

constant-rate-of-load tensile testing machine (CRL), *n*—*in tensile testing*, an apparatus in which the rate of increase of the force is uniform with time after the first 3 s and the specimen is free to elongate, this elongation dependent on the extension characteristics of the specimen at any applied force. **D 76**

constant-rate-of-traverse tensile testing machine (CR), *n*—a testing machine in which the pulling clamp moves at a uniform rate and the force is applied through the other clamp which moves appreciably to actuate a force-measuring mechanism, producing a rate of increase of force or extension that is usually not constant and is dependent upon the extension characteristics of the specimen. **D 76**

container, *n*—a receptacle designed to hold a material, or to give integrity to the material.

DISCUSSION—The term container in textiles may include bales, cartons and other shipping containers. **D 3333**

core-spun yarn, *n*—a compound structure in which a filament or strand serves as an axis around which a cover of either loose fiber or a yarn is wound.

DISCUSSION—(1) *General*—in yarn testing, when the core and cover in this type of compound structure need to be separated, for testing of either component, the methods used should not compromise the physical properties of the component to be evaluated: and (2) *Specific*—as a sewing thread, the means by which this compound structure is made will not allow the core and cover to be readily separated without compromising the physical attributes of each component. Hence, the sewing thread should be evaluated as a compound structure. **D 204**

cotton count, *n*—an indirect yarn numbering system generally used in the cotton system equal to the number of 840-yd lengths of yarn per pound. **D 1059, D 2260**

cotton system, *n*—a spinning system adapted to fibers less than 65 mm (2.5 in.) in length.

DISCUSSION—This system usually employs flat-top cards and may use roll and other drafting assemblies on intermediate processes and spinning machines. **D 2645**

cover, *n*—*in yarns*, the outside layer of fibers that form the surface of a yarn. **D 2255**

covered yarn, *n*—a compound structure which contains distinguishable inner and outer fibrous elements which can be different. **D 204**

CRE—abbreviation for constant-rate-of-extension. **D 76**

crimp, *n*—*in a textile strand*, the undulations, waviness, or succession of bend, curls, or waves in the strand induced either naturally, mechanically, or chemically.

DISCUSSION—Crimp has many characteristics, among which are its amplitude, frequency, index, and type. In test method D 3937, crimp is characterized by a change in the directional rotation of a line tangent to the fiber as the point of tangent progresses along the fiber. Two changes in rotation constitutes one unit of crimp. **D 3937**

crimp, *n*—*in a yarn*, the undulations, waviness, or succession of bends, curls, or waves in the yarn induced either naturally, mechanically, thermally, or chemically. **D 6774**

crimp contraction, *n*—an indicator of crimp capacity or a characterization of a yarn’s ability to contract under tension.

D 4031, D 6774

crimp development medium, *n*—for testing of textured yarn, an environment that allows the temporary set of fiber crimp to be overcome and that allows the filaments to assume their permanently set configuration.

D 4031

crimp frequency, *n*—in manufactured staple fibers, the number of crimps or waves per unit length of extended or straightened fiber.

D 3937

crimp index, *n*—an indirect measure of the amplitude of the crimp.

DISCUSSION—Crimp index is calculated as the difference in distance between two points on the fiber as it lies in an unstretched condition in one plane and the distance between the same two points when the fiber is straightened under a specified tension expressed as a percentage of the unstretched distance. To improve reproducibility, the unstretched distance may be measured under a specified, very low tension to align the fiber in one plane.

D 3937

crimp recovery, *n*—a measure of the ability of a yarn to return to its original crimped state after being subjected to tension.

D 4031

CRL—abbreviation for constant-rate-of-loading.

D 76

CRT—abbreviation for constant-rate-of-traverse.

D 76

cut, *n*—in asbestos and glass yarns, the number of 100-yd lengths of yarn per pound; an indirect yarn numbering system.

D 1059, D 2260

cut, *n*—in wool yarns, the number of 300-yd lengths of yarn per pound; an indirect yarn numbering system.

D 1059,

D 2260

denier, *n*—the unit of linear density, equal to the mass in grams of 9000 m of fiber, yarn, or other textile strand that is used in a direct yarn numbering system. (See also **linear density**)

D 1059, D 2260

direct cabling technology, *n*—a single-step manufacturing systems that produces a twist-balanced cabled yarn (2 fold) from twistless single yarns.

DISCUSSION—Direct cabling of yarn is carried out in a one-step twisting operation as compared to conventional cabling of yarn that is carried out in multiple twist operations.

(D13.59) D 1423

direct yarn numbering system, *n*—a system that expresses the linear density of yarn in mass per unit length.

DISCUSSION—The preferred units of measurements for the direct yarn measuring system are grams and meters. Tex (weight in grams for 1000 metres) and Denier (weight in grams for 9000 metres) are recommended to show linear density in the direct numbering system. These can be calculated by dividing the mass of a yarn by its length. Conversion factors to convert between direct and indirect numbering systems can be found in Standard Tables D 2260.

D 1059,

D 1907, D 2260

direction of twist, *n*—the right or left direction of the helix formed in a twisted strand as indicated by superimposition of the capital letter “S” or “Z.”

DISCUSSION—Yarn has an S twist, when the yarn is held in a vertical position, the visible spirals or helices around the central axis conform in direction of slope to the central portion of the letter “S”, and Z twist if the invisible spirals or helices conform in direction of slope to the

central portion of the letter “Z”. When two or more yarns, either single or plied are twisted together, the letters “S” and “Z” are used in a similar manner to indicate the direction of the last twist inserted.

D 1422, D 1423

draw ratio (DR), *n*—the relation of the final length per unit mass to original length per unit mass of a material resulting from drawing.

D 3218, D 5344

draw texturing, *n*—for processing thermoplastic fibers, the simultaneous or sequential process of drawing and imparting crimp, thus producing increased molecular orientation and increased bulk.

DISCUSSION—The drawing and texturing stages may occur in separate, usually consecutive, zones of a machine (sequential draw texturing) or together in the same zone (simultaneous draw texturing).

D 5344

drawing, *n*—in textile processing, the process of stretching or attenuating a material to increase the length per unit mass.

DISCUSSION—This process orients the molecular chains in the length direction of a monofilament or partially oriented yarn.

D 3218,

D 5344

effective carriage mass, *n*—in CRL-type tensile testing machine, the force actually applied to a specimen by the mass of the carriage, plus any added masses.

D 76

effective fiber length, *n*—in vibroscope test for linear density, that portion of the fiber free to vibrate between fixed supports or holders.

D 1577

effective gage length, *n*—in tensile testing, the estimated length of the specimen subjected to a strain equal to that observed for the true gage length.

DISCUSSION—The effective gage length can be calculated using the following equation:

$$G_E = G_N \times E_N/E_T \quad (1)$$

where:

G_E = effective gage length

G_N = nominal gage length

E_N = percent elongation based on the nominal gage length, and

E_T = percent elongation based on the true gage length.

D 76

elastomeric yarn, *n*—a nontextured yarn which can be stretched repeatedly at room temperature to at least twice its original length and which after removal of the tensile force will immediately and forcibly return to approximately its original length.

DISCUSSION—The elastic properties of yarn are produced by the use of filaments, or a core, made from polymers having a special chemical composition or molecular structure, for example, filaments made from spandex or from cut or extruded rubber.

D 3106

electrostatic decay half-life, *n*—in textiles, the time in minutes for the maximum voltage induced on the textile to be reduced to one half of the maximum voltage by the various decay mechanisms: conduction and ionization of the air.

D 4238

electrostatic propensity, *n*—the capacity of a nonconducting

material to acquire and hold an electrical charge by induction (by means of corona discharge) or by triboelectric means (rubbing with another material). **D 4238**

end, n—an individual silver, roving, yarn, or cord.

DISCUSSION—For yarns, one or more continuous, multiple parallel lengths of yarn which may be wound on a yarn package or beam. For example, two lengths of yarn wrapped parallel on a single bobbin constitute two yarn ends, likewise, one thousand lengths of yarn wrapped parallel on a single beam constitutes one thousand yarn ends.

D 2258

entanglement, n—the extent or degree to which the filaments in a yarn are interlocked and cannot be readily separated.

DISCUSSION—There are two kinds of entanglements, intermediary (loose) node and hard (tight) node. Intermediary nodes are pulled out easily under tension or separated by a needle. Test method D 4724 measures the presence of hard nodes in which the interlocking or interlacing is compact pulling the yarn bundle together. **D 4724**

evaluator, n—a part of, or an attachment to, an unevenness testing instrument, which automatically gives an estimate of R_u . **D 1425**

fabric package, n—a length of fabric in a form suitable for handling, storing, or shipping.

DISCUSSION—Fabric packages may be unsupported, such as when folded in cases, or supported, such as on tubes, bolts, or creels. Fabric packages are frequently referred to as rolls or pieces. **D 2258**

fiber beard, n—*in length testing of fibers*, fibers caught randomly on a comb which are subsequently straightened and parallelized without stretching or damaging. **D 3513**

fiber chip, n—*in manufactured textiles*, staple fibers that are massed together as a unit and that maintain a single geometry or alignment. **D 3937**

fiber cohesion, n—in textiles, the resistance to separation of fibers in contact with one another.

DISCUSSION—This resistance is due to the combined effects of the surface characteristic, length, crimp, finish, and linear density of the fibers. Cohesion should not be confused with adhesion or sticking together as in a glutinous substance. **D 2612, D 4120**

filament yarn, n—a yarn composed of (continuous) filaments assembled with or without twist. **D 3822, D 4724**

final twist, n—the number of turns per unit length in a single yarn component of a plied yarn or the plied yarn component of a cabled yarn as the component lies in the more complex structure. (syn. “as-is” twist) **D 1423**

frayed, adj—*in textiles*, a worn condition characterized by damaged yarn surfaces, projecting yarn ends, hairiness, etc. **D 5647**

friction, n—the resistance to the relative motion of one body sliding, rolling, or flowing over another body with which it is in contact.

DISCUSSION—There are two frictional properties exhibited between any pair of surfaces: static friction and kinetic friction. Test Methods D 3108 and D 3412 both measure the coefficient of friction for kinetic friction. **D 3108, D 3412**

fundamental resonant frequency, n—*in linear density testing*, the lowest frequency at which free oscillations can exist

in a fiber tensioned between two fixed points. **D 1577**
fuzz, n—untangled fiber ends that protrude from the surface of a yarn or fabric.

DISCUSSION—Fuzz should not be confused with “cover”. **D 2255**

fuzzy, adj—characterized by a hairy appearance due to broken fibers or filaments. (Syn. hairiness) **D 5647**

grain, n—*in yarn spinning*, a direct yarn numbering system for sliver, top or roving, equal to the mass in grains of 120 yds. (See **American grain count**) **D 2260**

grain, n—*in measuring mass*, 1/7000 lb avoirdupois **D 2260**

greige thread, n—undyed or unfinished sewing thread in the state following final plying or equivalent step in a processing sequence, such as extruding, texurizing or braiding. **D 204, D 3823**

grex, n—an obsolete direct numbering system for fiber yarn or other textile strand equal to the mass in grams per 10 000 m **D 1059, D 2260**

grip, v—*in tensile testing*, to hold, grasp, or secure, for example, to grip the specimen by the jaws of the clamps. **D 76**

growth, n—an increase in one or more dimensions of an object or a material. **D 204**

hairiness, n—*or yarns*, an overall condition characterized by filaments or fibers protruding from the yarn surface and uniformly distributed along the yarn length. (Compare wild fibers.) **D 5647**

hawser twist, n—the construction of cabled yarn, cord, or rope in which the single and first-ply twist are in the same direction and the second-ply twist is in the opposite direction, and S/S/Z or Z/Z/S construction. **D 1423**

heat shrinkage, n—a decrease in one or more dimensions of an object or material exposed to heat. **D 3128**

heatset yarn, n—*in a textured yarn*, a yarn that is subjected to secondary heat during the texturing process, which is designed to reduce the torque and bulk shrinkage.

DISCUSSION—The characteristics of heatset yarns are a function of the temperature, time, and length of exposure to the heat source.

indirect yarn numbering system, n—a system that expresses the linear density of yarn in length per unit mass.

DISCUSSION—The preferred units of measurements for the indirect yarn measuring system are yards and pounds. Cotton count (number of 840 yard lengths per pound), worsted count (number of 560 yard lengths per pound), metric count (number of 1000 metre lengths per kilogram), woolen run (number of 1600 yard lengths per pound) and number of yards per pound are commonly used in the indirect numbering system. These can be calculated by dividing the number of specified lengths of a yarn by its unit of mass. Conversion factors to convert between indirect and direct numbering systems can be found in Standard Tables D 2260 **D 1059, D 1907, D 2260**

integrator, n—*in textile unevenness testing*, a device that calculates the coefficient of variation unevenness or the mean deviation unevenness.

DISCUSSION—The terms “integrator” and “integration” as applied to textile unevenness testing do not imply integration in the strict mathematical sense. The type integrator, linear or quadratic, must be carefully selected depending upon a known irregularity of the material; that is, purely random or purely periodic. **D 1425**