



Standard Test Method to Determine Melting Temperature of Synthetic Fibers¹

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1. Scope

1.1 Either of two test methods are used to determine the melting temperature of thermoplastic fibers, yarns, or threads.

1.2 Method 1 can be used to determine melting temperatures for blends of multiple fiber material types. Method 2 can only be used to determine the melting temperature of a single fiber material type.

1.3 The values stated in either SI units or other units are to be regarded separately. The values stated in each system are not exact equivalents; therefore, each system shall be used independently without combining values.

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

2. Referenced Documents

2.1 *ASTM Standard:*²

- D 123 Terminology Relating to Textiles
- D 276 Test Methods for Identification of Fibers in Textiles
- D 1776 Practice for Conditioning and Testing Textiles
- D 2257 Test Method for Extractable Matter in Textiles
- D 2258 Practice for Sampling Yarn for Testing
- D 3333 Practice for Sampling Manufactured Staple Fibers, Sliver, or Tow for Testing

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *melting temperature, n*— the temperature or range of temperatures at which a substance is observed to transition to a liquid-like state.

3.1.2 For all other terminology related to textiles, see Terminology D 123.

4. Summary of Test Method

4.1 *Method 1:*

4.1.1 A specimen of fiber and a reference sample are positioned into the designated heating blocks of a Differential Scanning Calorimetry (DSC) instrument.

4.1.2 Use the DSC data to determine the fiber specimen melting temperature.

4.2 *Method 2:*

4.2.1 A specimen of fiber is positioned in a melting temperature device.

4.2.2 The temperature of the device is raised until the fiber specimen reaches its melting temperature as determined by visual observation.

5. Significance and Use

5.1 Either of these two test methods is used to determine the temperature at which a synthetic fiber specimen changes from a solid to a liquid-like state.

5.1.1 Synthetic fibers may be either amorphous or semi-crystalline thermoplastics or thermosets. Synthetic fibers may change from the solid to a liquid-like state on heating because of the glass transition of amorphous polymers, the melting of crystalline regions of semi-crystalline polymers, or at the onset of degradation. Thermoplastic fibers consist of crystalline and amorphous regions and may be manufactured with a range of molecular weights. The amorphous and crystalline fiber structure and variable molecular weight can lead to a melting temperature range instead of a discrete melting point (see Table 1).

5.2 This test method is considered satisfactory for acceptance testing of commercial shipments.

5.2.1 If there are differences of practical significance between reported test results for two or more laboratories, perform comparative testing to determine if there is a statistical bias between them, using competent statistical assistance. As a minimum, use the samples for such a comparative test that are as homogeneous as possible, drawn from the same lot of material as the samples that resulted in disparate results during

¹ This test method is under the jurisdiction of ASTM Committee D13 on Textiles and is the direct responsibility of Subcommittee D13.51 on Conditioning and, Chemical and Thermal Properties.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

TABLE 1 List of Typical Fiber Melting Temperatures and Temperature Ranges^{A,B,C}

Fiber Type	Melting Temperature, °C
Vinyon HH	Softens at 85°
PVC	About 100°
Polyolefin	135° - 160°
Polypropylene	164° - 170°
Chlorofibre	162° - 167°
Saran®	166° and 170°
Nytril	176°
Modacrylic	184°
Polyamid(Nylon) 6	216° and 219°
Spandex	230°
Polyurethane	230-260°
Polyamide(Nylon)6-6	244° - 260°
Polyester	244° - 250°
Polyacrylonitrile	235-330°
Acetate	260°
Polycarbonate	294°
Triacetate	288° and 300°
Polytetrafluoroethylene	327°

^AIn some cases degradation takes place prior to or instead of melting.

^B, Alex and Rollo, Bruce (1973), *The WIRA Textile Data Book*, Wira, Leeds

^CPractice D 276 Standard Test Methods for Identification of Fibers in Textiles

initial testing and randomly assigned in equal numbers to each laboratory. Compare the test results from the laboratories involved using a statistical test for unpaired data, at a probability level chosen prior to the testing series. If bias is found, either its cause must be found and corrected, or future test results for that material must be adjusted in consideration of the known bias.

5.3 This test method is suitable for quality control testing of synthetic fibers and product comparisons of different fibers by manufacturers, retailers, and users.

6. Apparatus

6.1 *Apparatus for Method 1, using a DSC instrument :*

6.2 *Apparatus for Method 2:*

6.2.1 *Test Unit Configuration*—Apparatus used consists of an electrically heated stage which has a temperature range from 20°C (68°F) to 300°C (572°F) or at least 10°C (18°F) above the highest melting temperature to be measured. See Fig. X1.1 for a typical apparatus.

6.2.1.1 The adjustment mechanism shall be able to control the heat input into the stage.

6.2.1.2 Thermometer for measuring temperature shall be accurate to + 0.5°C (+1°F).

6.2.1.3 The device shall have a low powered magnifying glass to permit visual examination.

6.2.1.4 The device shall have a top and bottom microcover glass. The top glass shall fit directly over the bottom glass so that the fiber specimen rests between the microcovers.

6.2.2 Soxhlet extraction device. See Fig. X1.2.

7. Preparation of Apparatus

7.1 *Lot Sample:*

As a lot sample for acceptance testing, take at random the number of laboratory sampling units as directed in an applicable material specification or other agreement between the purchaser and the supplier. In the absence of a material specification or other agreement, use Practice D 2258 or

Practice D 3333, as applicable. Consider containers, such as cartons, bales or other shipping containers to be the primary sampling units.

7.2 *Laboratory Sample Unit:*

As a laboratory sampling unit for acceptance testing, take as directed in Practice D 2258 or Practice D 3333, as applicable. If the fiber sample requires cleaning using a Soxhlet extractor proceed to 7.2.1. If cleaning using a Soxhlet extractor is not required proceed to 7.3.

7.2.1 Place sample in a Soxhlet extractor (see Fig. 1) and perform twenty extractions using a chloroform, USP reagent. Follow extraction procedure in D 2257. Other solvents such as methanol, ethanol or isopropyl alcohol may be used if they are found to be effective in removing fiber finishes and coatings.

7.2.2 Dry samples and return to equilibrium in accordance with D 1776.

7.3 *Test Specimens:*

7.3.1 *Method 1:*

7.3.1.1 *DSC Sample Preparation*—Cut the samples into very small pieces with scissors and put a 5 to 7 mg specimen into the aluminum pan. Make a small hole on the lid with a needle and close the pan with the help of a sample crimper. Make another sample, which will be used as the reference sample by closing an empty pan with lid.

7.3.1.2 Prepare five specimens and five references to perform five replicates.

7.3.2 *Method 2:*

7.3.2.1 From each laboratory sampling unit, cut five fiber samples into specimens having a length of approximately 2mm (.0625 in).

7.3.2.2 Prepare the five specimens to perform five replicates.

8. Calibration

8.1 Follow the manufacturer's instructions to calibrate the melting temperature apparatus (See Appendix X1)

8.2 Verify the melting temperature apparatus performance by using fiber of a known melting temperature (see Table 1).

NOTE 1— Use a fiber having a melting temperature similar to the specimen to be tested (see Table 1).

NOTE 2—Avoid using a fiber with a wide melting temperature range as the verification fiber (see Table 1).

8.2.1 Verification is achieved when the melting temperature of the verification fiber used is within + 1°C (+2°F) of its known value.

9. Test Procedure

9.1 *Procedure for Method 1 :*

9.1.1 Put the specimen and the reference in the designated heating blocks (in accordance with the instrument manufacturer's manual) inside the heater chamber. Close the chamber, and start heating at the rate of 10°C/min to approximately 50°C above the melting point of the fiber being tested in accordance with Table 1.

9.1.2 Record the temperature. Cool the chamber, and repeat the measurement on a new specimen until five specimens are completed.

9.2 *Procedure for Method 2 :*