



Designation: D 4389 – 99

Standard Specification for Finished Glass Fabrics Woven From Rovings¹

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1. Scope*

1.1 This specification primarily covers glass fabrics woven from “E” electrical continuous glass fiber rovings that are intended primarily as a reinforcing material in laminated plastics for structural use.

1.2 This specification specifies the terminology, definitions, general requirements, and physical requirements for woven roving glass fiber fabrics. This specification permits the application of sizing materials to the glass fiber roving during manufacture that helps facilitate weaving. When used as permitted in this specification, such materials are compatible with the resin matrix as specified in the contracting instrument.

NOTE 1—Sizing materials on glass fiber yarns, in most cases, are removed by various cleaning procedures as a first stage in preparing a finished fabric. When these yarn sizing materials are removed during a cleaning procedure, they need not be compatible with the subsequent resin matrix.

1.3 The values stated in either SI units or inch-pound units are to be regarded as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the standard.

NOTE 2—This specification is one of a series to provide a substitute for the following Military Specifications:

- MIL-Y-1140H Yarn, Cord, Sleaving, Cloth, and Tape-Glass
- MIL-C-9084C Cloth, Glass Finished for Resin Laminates
- MIL-C-19663C Cloth, Glass, Woven Roving for Plastic Laminates

2. Referenced Documents

2.1 ASTM Standards:²

- D 123 Terminology Relating to Textiles
- D 578 Specification for Glass Fiber Strands
- D 1776 Practice for Conditioning Textiles for Testing
- D 2408 Test Method for Finish Content of Woven Glass Fabric, Cleaned and After-Finished with Amino-Silane

Type Finishes for Plastic Laminates³

- D 2409 Test Method for Finish Content of Woven Glass Fabric, Cleaned and After-Finished with Vinyl-Silane Type Finishes for Plastic Laminates³
- D 2410 Test Method for Finish Content of Woven Glass Fabric, Cleaned and After-Finished with Chrome Complexes, for Plastic Laminates³
- D 2660 Test Method for Finish Content of Woven Glass Fabric, Cleaned and After-Finished with Acrylic-Silane Type Finishes, for Plastic Laminates³
- D 3098 Test Method for Finish Content of Woven Glass Fabric, Cleaned and After Finished with Epoxy-Functional Silane-Type Finishes for Plastic Laminates³
- D 3773 Test Methods for Length of Woven Fabric
- D 3774 Test Methods for Width of Woven Fabric
- D 3775 Test Method for Fabric Count of Woven Fabric
- D 3776 Test Methods for Mass per Unit Area (Weight) of Woven Fabric
- D 4029 Specification for Finished Woven Glass Fabrics
- D 4963 Test Method for Ignition Loss of Glass Strands and Fabrics

2.2 ANSI Standard:

- ANSI/ASQC Z1.4 Sampling Procedures for Inspection by Attributes⁴

3. Terminology

3.1 Definitions:

- 3.1.1 *continuous filament yarn, n*—a yarn made of filaments that extend substantially throughout the length of the yarn.
- 3.1.2 *roving, n—in glass textiles*, a multiplicity of filaments or yarns gathered together into an approximately parallel arrangement without twist.
- 3.1.3 For definitions of other textile terms used in this specification, refer to Terminology D 123.

CLASSIFICATION

4. Classification

4.1 *Designation of Woven Roving Fabric*—The basic designations for glass woven roving fabric is by mass per unit area and is given in grams per square metre (ounces per square

¹ This specification is under the jurisdiction of ASTM Committee D-13 on Textiles and is the direct responsibility of Subcommittee D13.18 on Glass Fiber and Its Products.

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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.

³ Discontinued 1990; see *Annual Book of ASTM Standards*, Vol 08.02.

⁴ Available from American National Standards Institute 11 W. 42nd St., 13th Floor, New York, NY 10036.

*A Summary of Changes section appears at the end of this standard.

yard). Historically, an ASTM type number has been used by the industry. These numbers have been sequentially assigned as new woven roving constructions as they were added to this specification. Numbers, 1 through 10, are shown in Table 1 with the relationship to mass per unit area and fabric count.

REQUIREMENTS

5. Material

5.1 The roving shall be continuous filament fiber, free of any free alkali, such as sodium or potassium metal salts and foreign particles, dirt, and other impurities. It shall be “E” electrical grade.

5.1.1 The fabric shall be uniformly woven, have uniform color, overall cleanness, and no objectionable odor.

6. Fabric Count

6.1 For woven roving fabrics listed in Table 1, the average fabric count shall conform to the requirements of Table 1. For woven roving fabrics not listed in Table 1, the average fabric count shall be agreed upon between the purchaser and the supplier.

7. Yarn Designations

7.1 For woven roving fabrics, the roving designations shall be as agreed upon between the purchaser and the supplier. The requirements of the individual elements of the designation are specified in Sections 8-10.

8. Yarn Number

8.1 For woven roving fabrics listed in Table 1, the average size-free yarn numbers of the yarns designated shall conform to the requirements of Table 1. For woven roving fabrics not listed in Table 1, the average size-free yarn numbers shall be agreed upon between the purchaser and the supplier.

9. Filament Diameter

9.1 The range of values for the filament diameters are listed in Table 2. The average filament diameter for the rovings in the woven roving fabric shall be within the interval listed in Table 2.

TABLE 2 Letter Designation for Average Fiber Diameter Range of Glass Roving Used in Woven Roving Fabrics

Letter Designation	SI Units		US Customary Units	
	Diameter in Micrometres		Diameter in Inches	
	At Least	Below	At Least	Below
G	8.9	10.2	0.00035	0.00040
H	10.2	11.4	0.00040	0.00045
J	11.4	12.7	0.00045	0.00050
K	12.7	14.0	0.00050	0.00055
L	14.0	15.2	0.00055	0.00060
M	15.2	16.5	0.00060	0.00065
N	16.5	17.8	0.00065	0.00070
P	17.8	19.0	0.00070	0.00075

10. Strand Construction

10.1 The construction of the component strands shall be agreed upon between the purchaser and the supplier.

11. Weave Type

11.1 For woven roving fabrics listed in Table 1, the weave type shall be plain weave. For woven roving fabrics not listed in Table 1, the weave type shall be agreed upon between the purchaser and the supplier.

12. Mass per Unit Area

12.1 For woven roving fabrics listed in Table 1, the average mass per unit area shall conform to the requirements of Table 1. For woven roving fabrics not listed in Table 1, the average mass per unit area shall be agreed upon between the purchaser and the supplier. The average mass per unit area for the lot shall be within the interval: specified mass per unit area \pm 10 % of the specified mass per unit area.

13. Width

13.1 Fabric width shall be agreed upon between the purchaser and the supplier. The fabric width, including both selvages but excluding any feathered edges, shall not be less than the specified width and no more than 13 mm (0.5 in.) wider than the specified width.

NOTE 3—During the processing of glass fabrics, the selvages may be slit to minimize tension influences. This slit distance is excluded when

TABLE 1 Physical Properties of Generally Available “E” Glass Finished Woven Roving Fabrics

ASTM Type	Weave	Nominal Mass Per Unit Area		Roving Count 25.4 mm (1 in.) min		Construction ^A Nominal Roving Length Per Unit Mass				Standard Roll Length	
						Tex		yd/lb			
		g/m ²	oz/yd ²	Warp	Fill	Warp	Fill	Warp	Fill	m	yd
1	Plain	441	13.0	10	4	840 to 755	1065 to 925	590 to 655	465 to 535	91.5	100
2	Plain	542	16.0	10	4	840 to 755	1680 to 1505	590 to 655	295 to 330	91.5	100
3	Plain	831	24.5	5	4	2360 to 2065	2680 to 2255	210 to 240	185 to 220	68.5	75
4	Plain	831	24.5	5	3	2360 to 2065	3545 to 3105	210 to 240	140 to 160	68.5	75
5	Plain	915	27.0	5	2.5	2360 to 2065	4960 to 4725	210 to 240	100 to 105	59.5	65
6	Plain	610	18.0	7	6	1210 to 1835	1340 to 1155	410 to 270	370 to 430	68.5	75
7	Plain	745	22.0	5	4	2360 to 2065	2155 to 1910	210 to 240	230 to 260	68.5	75
8	Plain	610	18.0	4	4	2360 to 2065	1655 to 1505	210 to 240	300 to 330	68.5	75
9	Plain	559	16.5	5	4	1710 to 1525	1710 to 1525	290 to 325	290 to 325	91.5	100
10	Plain	711	21.0	4	4	2420 to 2155	2420 to 2155	205 to 230	205 to 230	82.5	90

^A In some cases, the fill yarn may be woven as 2 picks per shed and as 1 fill yarn. The basic roving length per unit area used to produce the above fill yarns should be doubled.