
INTERNATIONAL STANDARD



1530

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Fishing nets — Description and designation of knotted netting

First edition — 1973-07-01

ITeH STANDARD PREVIEW
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[ISO 1530:1973](https://standards.iteh.ai/catalog/standards/sist/0a1ce77e-6686-47b3-9bb0-4d0d044909cc/iso-1530-1973)

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UDC 677.66 : 639.2.081.11

Ref. No. ISO 1530-1973 (E)

Descriptors : textiles, nets, fishing nets, knots, designation, describing.

FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up has the right to be represented on that Committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

Prior to 1972, the results of the work of the Technical Committees were published as ISO Recommendations; these documents are now in the process of being transformed into International Standards. As part of this process, International Standard ISO 1530 replaces ISO Recommendation R 1530-1970 drawn up by Technical Committee ISO/TC 38, *Textiles*.

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The Member Bodies of the following countries approved the Recommendation:

Australia	Hungary	Romania
Belgium	India	South Africa, Rep. of
Brazil	Iran	Spain
Czechoslovakia	Israel	Sweden
Denmark	Japan	Switzerland
Egypt, Arab Rep. of	Netherlands	Thailand
France	Norway	Turkey
Germany	Poland	United Kingdom
Greece	Portugal	U.S.S.R.

No Member Body expressed disapproval of the Recommendation.

Fishing nets — Description and designation of knotted netting

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1 SCOPE AND FIELD OF APPLICATION

This International Standard describes the principal characteristics of knotted netting for fishing nets and specifies the items of information to be furnished when ordering the netting. It is intended to facilitate the exchange of information between purchasers and suppliers of knotted netting for fishing nets.

NOTE — It should be understood that a complete designation of knotted netting and its component yarns will not always form part of a contract. There will be occasions when an order is placed on the basis of a sample or some other basis that does not give a complete indication of the properties of the netting or its component yarns. Nevertheless, it is desirable that the complete range of information should be dealt with in this International Standard so that a standard method is available for use on those occasions when it is needed.

2 REFERENCES

ISO 858, *Fishing nets — Designation of netting yarns in the Tex System.*¹⁾

ISO 1107, *Fishing nets — Netting — Basic terms and definitions.*¹⁾

3 PRINCIPAL CHARACTERISTICS OF KNOTTED NETTING

3.1 Types of manufacture

Knotted netting may be manufactured in the two-yarn system or in the single-yarn system as described below.

3.1.1 Two-yarn system

Knotted netting consisting of two systems of yarns is mostly manufactured on a knotting machine. The yarn of one of the two systems runs like a weaving warp from bobbins, while the yarn of the other system is wound on shuttles that guide it towards a hook-shaped or needle-type knotting device. All the knots in one row are knotted simultaneously.

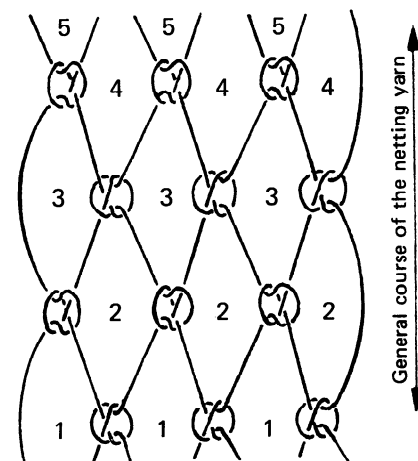


FIGURE 1 — Two-yarn system

1) At present at the stage of draft. (Revisions of ISO/R 858 and ISO/R 1107.)

3.1.2 Single-yarn system

Knotted netting consisting of a single-yarn system is mostly hand made. The yarn is wound on a netting needle and all the meshes in the same row are knotted individually one after another. A uniform mesh size may be achieved by the use of a mesh gauge during knotting. If the netting is made as a flat panel, then the netting yarn runs alternately from left to right and from right to left. If the netting is knotted round and round (as a "tube" or "cylinder"), then the yarn proceeds continuously in the same direction.

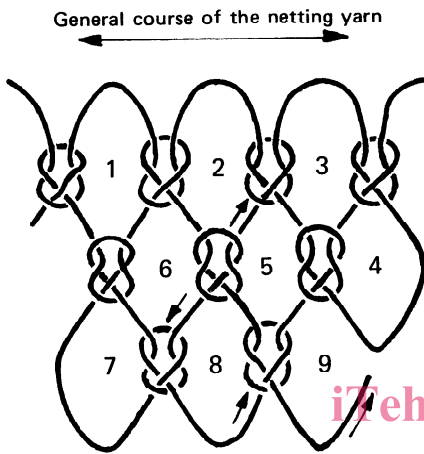


FIGURE 2 – Single-yarn system

3.2 Type of knot

The following illustrations show the principal types of knot with their customary designations :



FIGURE 3 – Weaver's knot – Z-type

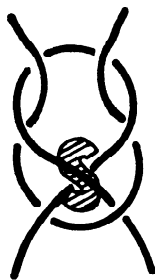


FIGURE 4 – Weaver's knot – S-type

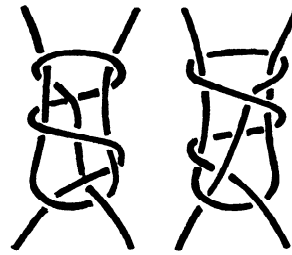


FIGURE 5 – Double weaver's knot

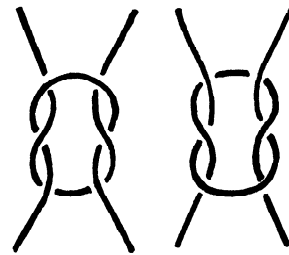


FIGURE 6 – Reef knot

3.3 Direction of stretch¹⁾

The directions in which netting may be stretched are designated as follows :

3.3.1 *N-stretch*. This relates to netting stretched at right angles (**N**ormal) to the general course of the netting yarn.

3.3.2 *T-stretch*. This relates to netting stretched parallel to the general course of the netting yarn (**T**winewise).

Netting may be stabilized after stretching, either by chemical or thermal means.

3.4 Size of netting and special features

The size of netting is specified by the following characteristics :

3.4.1 The number of meshes in both the T and N-directions marked by the letters T and N respectively following the figure in question and joined by the multiplication sign X or by the number of meshes in one direction and the length, indicated in a recognized unit, for example metres, of the other direction, the netting being fully extended whilst the measurement is made.

3.4.2 The size of mesh in millimetres (see ISO 1107).

Special features are sometimes required or may be provided as a matter of course : these include edge meshes for joining or mounting purposes; reinforcement of netting (for example, double or heavier yarn); width of reinforcement indicated by number of meshes, and any intermediate reinforcement that may be requested.

1) The term "stretch" in this context indicates either the operation of tightening of knots, or that of conferring a permanent shape by thermal or other means, or a combination of both processes.

For the general definition of the symbols N and T for direction in netting see ISO 1107.

4 DESCRIPTION OF NETTING YARNS

The features requiring descriptions are as follows :

4.1 Size

The designation shall follow the requirements laid down in ISO 858.

4.2 Material

The type of fibre shall be stated; descriptions of man-made fibre yarns shall indicate whether the yarn is composed, for example, of staple fibres; one more filaments; textured or bulked yarn or film.

5 INFORMATION TO BE EXCHANGED

5.1 Indication of use

In order to assist the netting manufacturer to offer the most suitable type of netting for a particular type of fishing net, the ultimate use of the netting shall be made known, for example, for gill-nets, trawl-nets, purse seine nets, etc.

5.2 Manufacture

The purchaser shall state which type of netting (see 3.1) is required.

5.3 Type of knot

If the purchaser has a preference for a particular type of knot (see 3.2), he shall state this in his enquiry or order.

5.4 Direction of stretch

The purchaser shall state the direction of stretch required (see 3.3) and whether or not the netting is to be stabilized after stretching.

5.5 Size of netting

The purchaser shall specify the relevant details in accordance with 3.4, noting that for size of mesh

(see 3.4.2) it is necessary to choose between length of mesh (to be preferred), length of mesh side or opening of mesh, for example "length of mesh 50 mm".

5.6 Netting yarns

If the purchaser requires specific yarns to be used, he shall give details in accordance with section 4. Failing this, the netting manufacturer may use his discretion but any particulars given relating to the yarns used shall be furnished in terms of section 4. Furthermore, the purchaser shall specify if any special treatment (for example, resin bonding) of the netting yarn is required.

5.7 Finish of netting

The purchaser shall specify what finishing process (if any) is required. The following are examples of possible processes :

5.7.1 White (natural), untreated.

5.7.2 White (natural), impregnated.

5.7.3 Dyed, without impregnation of other treatment.

5.7.4 Dyed and impregnated.

5.8 Packing of netting

The purchaser shall advise the supplier on the following points :

5.8.1 Whether netting should be extended in the N-direction or in the T-direction before packing, if this direction is other than the direction of stretch.

5.8.2 The method of making-up, for example, lapped or rolled.

5.8.3 Type of packaging required.

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