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Standard Specification for Tolerances for Knitted Fabrics¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers test methods and tolerances applicable to the following properties of knitted fabrics: yield, mass (weight), width, length, fabric count, bursting strength, moisture regain, thickness, extractable matter, and fiber composition.

1.2 These tolerances are applicable to knitted fabrics of all types, such as warp knits, weft knits, flat bed knits, and so forth.

1.3 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

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 Standards:*²

[D123 Terminology Relating to Textiles](#)

[D629 Test Methods for Quantitative Analysis of Textiles](#)

[D2257 Test Method for Extractable Matter in Textiles](#)

[D2494 Test Method for Commercial Mass of a Shipment of Yarn or Manufactured Staple Fiber or Tow](#)

[D2654 Test Method for Moisture in Textiles \(Withdrawn 1998\)](#)³

[D2720 Practice for Calculation of Commercial Weight and Yield of Scoured Wool, Top, and Noil for Various Commercial Compositions](#)

[D3773 Test Methods for Length of Woven Fabric](#)

[D3774 Test Method for Width of Textile Fabric](#)

[D3776 Test Methods for Mass Per Unit Area \(Weight\) of Fabric](#)

[D3786 Test Method for Bursting Strength of Textile Fabrics—Diaphragm Bursting Strength Tester Method](#)

[D3787 Test Method for Bursting Strength of Textiles—Constant-Rate-of-Traversal \(CRT\) Ball Burst Test](#)

2.2 *Other Documents:*

[Textile Fiber Products Identification Act](#)⁴

[Wool Products Labeling Act of 1939](#)⁵

2.3 *Military Standard:*⁶

[MIL-STD-105D Sampling Procedures and Tables for Inspection by Attributes](#)

NOTE 1—Reference to test methods in this specification give only the permanent part of the ASTM designation. The current editions of each test method cited shall prevail.

3. Terminology

3.1 *Definitions:*

3.1.1 *bursting strength, n*—the force or pressure required to rupture a fabric by distending it, when applied at right angles to the plane of the fabric, under specified conditions.

3.1.2 *commercial mass, n*—billed weight (mass) as determined by a generally accepted method or as agreed upon between the purchaser and the seller.

3.1.2.1 *Discussion*—The basis for determining the commercial weight (mass) of a shipment of textile product is generally one of the following:

(1) *Man-Made Fibers:*

(a) *CMRU Basis* (commercial moisture regain with unscoured material)—the weight (mass) of unscoured, moisture-free textile product plus the weight (mass) corresponding to its commercial moisture regain.

(b) *CMRS Basis* (commercial moisture regain with scoured material)—the weight (mass) of moisture-free textile product after scouring by definite prescribed methods

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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 The last approved version of this historical standard is referenced on www.astm.org.

⁴ Act of Congress, "Textile Fiber Products Identification Act," 85th Congress, Second Session, approved Sept. 2, 1958.

⁵ Act of Congress, "Wool Products Labelling Act of 1939," 76th Congress, Third Session, approved Oct. 14, 1939.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

plus the weight corresponding to its commercial moisture regain.

(c) *CAS Basis* (commercial allowance with scoured material)—the weight (mass) of moisture-free textile product after scouring by definite prescribed methods plus the weight corresponding to its commercial allowance.

(d) *UN Basis* (unadjusted net)—the weight (mass) of unscoured textile product with no adjustment for the amount of moisture or finish, or both.

(2) *Wool*:

(a) *CC Basis* (commercial composition)—the weight (mass) of wool base as determined by definite prescribed methods plus the weights (masses) of moisture and other components corresponding to the commercial composition of the commercially designated material (for explanation, see Practice **D2720**).

(b) *UN Basis* (unadjusted net)—the weight (mass) of unscoured textile product with no adjustment for the amount of moisture or finish, or other components.

3.1.3 *commercial moisture regain (CMR), n*—a formally adopted, arbitrary value, to be used with the oven-dried mass of textile fibers, when calculating the commercial mass of a shipment or delivery.

3.1.4 *course, n—in knitted fabrics*, a row of successive loops parallel to the width direction of the fabric.

3.1.5 *finished fabric weight, n*—mass per unit area expressed in grams per square metre (ounces per square yard), grams per linear metre (ounces per linear yard), or inversely as metres per kilogram (linear yards per pound), or square metres per kilogram (square yards per pound).

3.1.5.1 *Discussion*—When weight (mass) is based on metres or linear yards, the fabric width must be stated.

3.1.6 *finished yield, n—in knitted fabrics*, the number of finished square metres per kilogram (square yards per pound) of finished fabric.

3.1.7 *greige yield, n—in knitted fabrics*, the number of finished square metres per kilogram (square yards per pound) of greige fabric.

3.1.8 *knitted fabric, n*—a structure produced by interlooping one or more ends of yarn or comparable material.

3.1.9 *knitted fabric count, n*—the number (counted units) of wale and courses per 25 mm (1 in.).

3.1.10 *length, n—in fabric*, the distance from one end to the other, measured parallel to the selvage or flattened tube edge of fabric that is under zero tension and free of folds and wrinkles.

3.1.11 *tolerances, n—in mathematics*, prescribed limits of variation for specified properties of a particular material based on observed values obtained by specified test methods and on samples that are representative of the material.

3.1.12 *wale, n—in knitted fabrics*, a column of successive loops parallel to the length direction of the fabric.

3.1.13 *width, n—in open-width knit fabric*, the perpendicular distance between the selvages when the fabric is laid flat, under zero tension, and free from folds or wrinkles.

3.1.14 *width, n—in tubular knit fabric*, the perpendicular distance between the edges of a flattened tube of fabric that is under zero tension and free from folds or wrinkles.

3.2 For definitions of other textile terms used in this specification, refer to Terminology **D123**.

4. Tolerances

4.1 The following are the tolerances for each knitted fabric property:

Characteristic	Requirements	Section
Yield	±5.0 %	8
Weight (mass)	±5.0 %	9
Width	−0 to +25 mm (1 in.)	10
Length	±2.0 %	11
Fabric count	±5.0 %	12
Bursting strength (ball burst)	±10.0 %	13
Extractable matter	1.0 %, max	14
Fiber content	pass ⁴	15

⁴ Those products to which the Wool Products Labeling Act of 1939⁵ apply, shall conform to the requirements of that act. Other fabrics shall conform to the requirements of the Textile Fiber Products Identification Act of 1958.⁴

5. Significance and Use

5.1 Knitted fabrics are known to exhibit inherent variations in properties. This specification lists the tolerances for each property deemed acceptable in the trade.

5.1.1 These tolerances can be used to determine if knitted fabrics meet specifications for properties, and provide a guide in case of dispute.

5.2 Tolerances agreed upon between the purchaser and the seller shall take precedence over those listed in this specification.

6. Sampling

6.1 *Lot Sample*—As a lot sample for acceptance testing, take at random the number of rolls as directed in an applicable specification or other agreement between the purchaser and the supplier, such as an agreement to use MIL-STD-105D.

6.2 *Laboratory Sample*—From each roll or piece in the lot sample, cut two laboratory samples the full width of the fabric and at least 375 mm (15 in.) along the selvage.

7. Conditioning

7.1 For tests made on conditioned material, precondition the specimens by bringing them to approximate moisture equilibrium in the standard atmosphere for preconditioning, then bring the specimens to moisture equilibrium for testing in the standard atmosphere for testing. It shall be considered that moisture equilibrium for testing has been reached when, after free exposure to air in motion, the change in weight (mass) of the specimen at successive intervals of not less than 2 h does not exceed 0.1 % of the specimen weight (mass).

7.2 Properties not significantly affected by minor variations in atmospheric conditions may be tested in prevailing room atmospheres by agreement of all parties concerned.

7.3 If the samples comprise whole rolls or bolts of fabric that cannot be properly conditioned in a reasonable time with