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Standard Terminology Relating to Fabrics and Fabric Test Methods¹

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ϵ ¹ NOTE—This terminology was updated editorially in September 2011.

1. Scope

1.1 This terminology covers definitions of technical terms used in the industry related to textile fabrics. Terms that are generally understood or adequately defined in other readily available sources are not included. Other terminology standards that have terms related to textile fabrics are shown in 2.1

2. Referenced Documents

2.1 ASTM Standards:²

- D737 Test Method for Air Permeability of Textile Fabrics
- D1117 Guide for Evaluating Nonwoven Fabrics³
- D1336 Test Method for Distortion of Yarn in Woven Fabrics
- D1388 Test Method for Stiffness of Fabrics
- D1424 Test Method for Tearing Strength of Fabrics by Falling-Pendulum (Elmendorf-Type) Apparatus
- D1775 Test Method for Tension and Elongation of Wide Elastic Fabrics⁴
- D1777 Test Method for Thickness of Textile Materials
- D2261 Test Method for Tearing Strength of Fabrics by the Tongue (Single Rip) Procedure (Constant-Rate-of-Extension Tensile Testing Machine)
- D2594 Test Method for Stretch Properties of Knitted Fabrics Having Low Power
- D2646 Test Methods for Backing Fabric Characteristics of Pile Yarn Floor Coverings
- D2724 Test Methods for Bonded, Fused, and Laminated Apparel Fabrics
- D2906 Practice for Statements on Precision and Bias for Textiles³

- D3107 Test Methods for Stretch Properties of Fabrics Woven from Stretch Yarns
- D3511 Test Method for Pilling Resistance and Other Related Surface Changes of Textile Fabrics: Brush Pilling Tester
- D3512 Test Method for Pilling Resistance and Other Related Surface Changes of Textile Fabrics: Random Tumble Pilling Tester
- D3514 Test Method for Pilling Resistance and Other Related Surface Changes of Textile Fabrics: Elastomeric Pad
- D3773 Test Methods for Length of Woven Fabric
- D3774 Test Method for Width of Textile Fabric
- D3775 Test Method for Warp (End) and Filling (Pick) Count of Woven Fabrics
- 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-Traverse (CRT) Ball Burst Test
- D3789 Practice for Labeling Cans of Consumer Spray Paint⁴
- D3882 Test Method for Bow and Skew in Woven and Knitted Fabrics
- D3883 Test Method for Yarn Crimp and Yarn Take-up in Woven Fabrics
- D3884 Test Method for Abrasion Resistance of Textile Fabrics (Rotary Platform, Double-Head Method)
- D3885 Test Method for Abrasion Resistance of Textile Fabrics (Flexing and Abrasion Method)
- D3886 Test Method for Abrasion Resistance of Textile Fabrics (Inflated Diaphragm Apparatus)
- D3887 Specification for Tolerances for Knitted Fabrics
- D3939 Test Method for Snagging Resistance of Fabrics (Mace)
- D3990 Terminology Relating to Fabric Defects
- D4032 Test Method for Stiffness of Fabric by the Circular Bend Procedure

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

⁴ Withdrawn. The last approved version of this historical standard is referenced on www.astm.org.

D4033 Test Method for Resistance to Yarn Slippage at the Sewn Seam in Upholstery Fabrics (Dynamic Fatigue Method) (Discontinued 2001)³

D4034 Test Method for Resistance to Yarn Slippage at the Sewn Seam in Woven Upholstery Fabrics (Discontinued 2001)³

D4157 Test Method for Abrasion Resistance of Textile Fabrics (Oscillatory Cylinder Method)

D4158 Guide for Abrasion Resistance of Textile Fabrics (Uniform Abrasion)

D4390 Practice for the Evaluation of the Performance of Terry Bathroom Products for Home Use⁴

D4772 Test Method for Surface Water Absorption of Terry Fabrics (Water Flow)

D4350 Test Method for Corrosivity Index of Plastics and Fillers

D4685 Test Method for Pile Fabric Abrasion

D4848 Terminology Related to Force, Deformation and Related Properties of Textiles

D4850 Terminology Relating to Fabrics and Fabric Test Methods

D4851 Test Methods for Coated and Laminated Fabrics for Architectural Use

D4964 Test Method for Tension and Elongation of Elastic Fabrics (Constant-Rate-of-Extension Type Tensile Testing Machine)

D4966 Test Method for Abrasion Resistance of Textile Fabrics (Martindale Abrasion Tester Method)

D4970 Test Method for Pilling Resistance and Other Related Surface Changes of Textile Fabrics: Martindale Tester

D5034 Test Method for Breaking Strength and Elongation of Textile Fabrics (Grab Test)

D5035 Test Method for Breaking Force and Elongation of Textile Fabrics (Strip Method)

D5103 Test Method for Length and Length Distribution of Manufactured Staple Fibers (Single-Fiber Test)

D5278 Test Method for Elongation of Narrow Elastic Fabrics (Static-Load Testing)

D5362 Test Method for Snagging Resistance of Fabrics (Bean Bag)

D5378 Performance Specification for Woven and Knitted Shower Curtains for Institutional and Household Use³

D5426 Practices for Visual Inspection and Grading of Fabrics Used for Inflatable Restraints

D5430 Test Methods for Visually Inspecting and Grading Fabrics

D5446 Practice for Determining Physical Properties of Fabrics, Yarns, and Sewing Thread Used in Inflatable Restraints

D5587 Test Method for Tearing Strength of Fabrics by Trapezoid Procedure

D5684 Terminology Relating to Pile Floor Coverings

D5793 Test Method for Binding Sites per Unit Length or Width of Pile Yarn Floor Coverings

D6207 Test Method for Dimensional Stability of Fabrics to Changes in Humidity and Temperature

D6614 Test Method for Stretch Properties of Textile Fabrics – CRE Method

D6674 Guide for Proficiency Test Program for Fabrics

D6770 Test Method for Abrasion Resistance of Textile Webbing (Hex Bar Method)

D6797 Test Method for Bursting Strength of Fabrics Constant-Rate-of-Extension (CRE) Ball Burst Test

3. Terminology

3.1 Definitions:

abrasion, *n*—the wearing away of any part of a material by rubbing against another surface. **D3884, D3885, D3886, D4157, D4158, D4685, D4966**

abrasion cycle, *n*—one complete movement across the surface of a material.

DISCUSSION—The complete movement for an abrasion cycle is dependent on the action of the abrasion machine and the test method used. It may consist of one back-and-forth unidirectional movement or one circular movement, or a combination of both. **D3885**

abrasion cycle, *n*—for the Martindale Abrasion Tester, 16 rubs required to complete a geometric shape, known as a Lissajous. **D4966**

abrasion cycle, *n*—in abrasion testing, one or more movements of the abradant across a material surface, or the material surface across the abradant, that permits a return to its starting position.

DISCUSSION—The abrasion cycle is dependent on the programmed motions of the abrasion machine and the test standard used. It may consist of one back-and-forth unidirectional movement such as for the flexing and abrasion test method; a circular movement such as for the rotary platform test method, or a combination of both such as for the inflated diaphragm test method. For the oscillatory cylinder abrasion method, an abrasion cycle consists of one double-rub. **See double-rub.**

[D13.60] D4157, D6770

absorption, *n*—a process in which one material (the absorbent) takes in or absorbs another (the absorbate); as the absorption of moisture by fibers. **[D13.59] D4772**

accuracy, *n*—of a test method, the degree of agreement between the true value of the property being tested (or accepted standard value) and the average of many observations made according to the test method, preferably by many observers. **[D13.60] D2906, D6674**

air permeability, *n*—the rate of air flow passing perpendicular through a known area under a prescribed air pressure differential between the two surfaces of a material.

DISCUSSION—Air permeability of fabric at a stated pressure differential between two surfaces of the fabric is generally expressed in SI units as cm³/s/cm² and in inch-pound units as ft³/min/ft² calculated in operating conditions. (See **permeability, porosity.**) **D737**

air-supported roof, *n*—a fabric roof-system that is properly secured and primarily supported and held in place by air pressure. **D4851**

architectural-use, *n*—in the building trade, a descriptive term for fabrics used in fabric roof-systems or similar industrial applications. (See also **fabric roof-system.**) **D4851**

bagging, *n*—any material, such as fabric or other suitable material used to protect commodities during shipment and/or storage.

DISCUSSION—Fabrics may be of the woven, knitted, or non-woven type, and are typically produced with cotton, jute, polyethylene, or polypropylene fibers. **D4850**

batch sample, *n*—the material(s) used for the proficiency test study taken from a common roll or garment lot and distributed to the participants. **[D13.60] D6674**

bending length, *n*—(1) *general*—a measure of the interaction between fabric weight and fabric stiffness as shown by the way in which a fabric bends under its own weight. It reflects the stiffness of a fabric when bent in one plane under the force of gravity, and is one component of drape; (2) *specific*—the cube root of the ratio of the flexural rigidity to the weight per unit area. **D1388**

bias, *n*—*in statistics*, a constant or systematic error in test results. **[D13.60] D6674**

blister, *n*—*in bonded, fused, or laminated fabrics*, a bulge, swelling, or similar surface condition on either the face fabric or the backing fabric characterized by the fabric being raised from the plane of the underlying component over a limited area to give a puffy appearance. **D2724**

bond strength, *n*—*of bonded, fused, or laminated fabrics*, the tensile force expressed in ounces per 25 mm (1 in.) of width, required to separate the component layers under specified conditions. **D2724**

bonded fabric, *n*—a layered fabric structure wherein a face or shell fabric is joined to a backing fabric, such as tricot, with an adhesive that does not significantly add to the thickness of the combined fabrics. (See also **laminated fabric, coated fabric**.) **D2724**

book fold, *n*—a fabric doubled selvage to selvage, then folded back and forth upon itself in predetermined lengths. (See also **shoe fold**.)

DISCUSSION—When the piece is completed, the fold-edges on each side are folded once more upon themselves so that the fold-edges are inside, forming a compact package as long as one half the width of the fabric. **D4850**

bow, *n*—a fabric condition resulting when filling yarns or knitted courses are displaced from a line perpendicular to the selvages and form one or more arcs across the width of the fabric. (See also **double bow**.) **D3882, D3990**

braided fabric, *n*—a structure produced by interlacing three or more ends of yarns in a manner such that the paths of the yarns are diagonal to the vertical axis of the fabric. **D4850**

breaking force, *n*—the maximum force applied to a material carried to rupture (compare *breaking point, breaking strength*). **[D13.60] D3884, D3885, D4157, D4848, D5034, D5035, D6770**

breaking load, *n*—deprecated term. Use *breaking force*. **[D13.60] D4848, D5034**

broken end, *n*—*in woven fabrics*, a void in the warp direction due to yarn breakage. **D3990**

bubble—See preferred term *blister*. **[D13.59] D2724**

burlap, *n*—a coarse, heavy, plain weave fabric of yarns, such as bast or cotton fiber yarn. **D4850**

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

DISCUSSION—The angle of application of force, and the area of the fabric upon which the force is applied varies continuously as the fabric stretches when it is tested as directed in this method. **D6797**

bursting strength, *n*—the force or pressure required to rupture a fabric by distending it with a force, applied at right angles to the plane of the fabric, under specified conditions. **D3786, D3787, D3887**

calibrate, *n*—to determine and record the relationship between a set of standard units of measure and the output of an instrument or test procedure. **[D13.60] D6674**

circular bend, *n*—simultaneous, multidirectional deformation of a fabric in which one face of a flat specimen becomes concave and the other becomes convex. **D4032**

coated fabric, *n*—a flexible material composed of a fabric and any adherent polymeric material applied to one or both surfaces. (See also **laminated fabric**.) **D4850, D4851, D5446**

color contrast, *n*—*in textiles*, a general term for a visible color difference between two adjacent areas.

DISCUSSION—For the purpose of Test Methods **D3939** and **D5362**, a color contrast is a visible color difference between a snag and the immediate surrounding area of the fabric that has no defects. Color contrasts often occur when printed fabrics are snagged. **D3939, D5362**

constant-rate-of-extension tensile testing machine (CRE), *n*—a testing machine in which the rate of increase of the specimen length is uniform with time. **D6797**

constant-rate-of-extension (CRE) tensile testing machine—a testing machine in which the rate of increase of specimen length is uniform with time. **[D13.60] D5035**

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.). **D3787**

constant-rate-of-load (CRL) tensile testing machine—a testing machine in which the rate of increase of the load being applied to the specimen is uniform with time after the first 3 s. **[D13.60] D4964, D5035, D5034**

constant-rate-of-traverse (CRT) tensile testing machine—a testing machine in which the pulling clamp moves at a uniform rate and the load is applied through the other clamp which moves appreciably to actuate a weighing mechanism, so that the rate of increase of load or elongation is dependent upon the extension characteristics of the specimen. **[D13.60] D3787, D5035, D5034**

corduroy, *n*—a filling cut-pile fabric in which the cut fibers form a surface of wales (rounded cords or ribs) which usually run warpwise. **D4685, D4850**

count, *n*—*in woven fabric*, the number of warp yarns (ends) and filling yarns (picks) per unit distance as counted while the fabric is held under zero tension, and is free of folds and wrinkles. **D3775**

count, *n*—*in knitted fabrics*, the number (counted units) of wale loops and course loops per 25 mm (1 in.). **D3787**

course, *n*—*in knitted fabrics*, a row of successive loops in the width direction of the fabric. **D2594**

crack mark, *n*—*in bonded, fused, or laminated fabrics*, a sharp break or crease in the surface contour of either the face fabric or the backing fabric that becomes evident when the bonded, fused, or laminated composite is rolled, bent, draped, or folded. **[D13.54] D2724**

crease retention, *n*—that property of a fabric which enables it to maintain an inserted crease. **D4850**

critical defect, *n*—a serious defect that judgment and experience indicate is likely to prevent the usability or proper performance of a product from its intended purpose. **D5430**

cross-machine direction, CD, *n*—the direction in the plane of the fabric perpendicular to the direction of manufacture.

DISCUSSION—This term is used to refer to the direction analogous to coursewise or filling direction in knitted or woven fabrics, respectively.

[D13.59, D13.60] D737, D1388, D1424, D1777, D2261

cut, *n*—*as applied to woven fabric*, a length approximately 60 yard in the greige. **D4850**

cut strip test, *n*—*in fabric testing*, a strip test in which the specimen is cut to the specified testing width. **D5035**

cycle, *n*—16 movements required for the completion of one Lissajous figure on a Martindale tester. **[D13.60] D4970**

cycle, *n*—in the Martindale tester, the sixteen movements required to complete one Lissajous figure. **[D13.60] D4966**

defect, *n*—*in inspection and grading*, the departure or non-conformance of some characteristic from its intended level or state.

DISCUSSION—In inspection and grading the characteristic is usually a visual one. However, defects such as heat damage or poorly finished textiles grading by hand may be required. **D5430**

dimensional change, *n*—a generic term for changes in length or width of a specimen subjected to specified conditions.

DISCUSSION—Dimensional change is usually expressed as a percent of the original dimension of the specimen. When a dimension increases it is often referred to as growth. When a dimension decreases it is often referred to as shrinkage. **D1117, D2646**

dimensional stability, *n*—the ability of a material to retain its length and width dimensions under specified conditions.

DISCUSSION—The dimensions are length and width and the specified conditions are those of cycled humidity and temperature. **D6207**

denim, *n*—a durable woven twill fabric, usually of all cotton or a blend of cotton and manufactured fibers, made from a variety of yarn numbers, and in various fabric weights, colors, designs, and finishes. **D4850**

direction of slippage, *n*—*at the seam*, the line of movement parallel to either the filling or the warp on a woven fabric in which minimum force is required to produce yarn slippage.

DISCUSSION—The fabric may be pulled in both directions in many cases. **D4034**

distortion, *n*—*in fabrics*, a general term for a visible defect in the texture of a fabric.

DISCUSSION—For the purpose of Test Methods **D3939** and **D5362**, snags are composed of different combinations of protrusions and distortions. A distortion is characterized by a group of fibers, yarn, or a yarn segment that is displaced from its normal pattern so that there is a visible change in the texture of the fabric; however, the displaced group of fibers, yarn, or yarn segment does not extend above the fabric surface. Distortions include conditions where (1) tension on a snagged yarn has changed the size of some loops within a knitted fabric and the result is a pucker on the surface of the fabric, and (2) tension on a snagged yarn has caused a yarn to break off within a woven fabric and the result is a change in the texture where the yarn used to be. **D3939, D5362**

double bow, *n*—two fabric bows, arcing in the same direction, as in a flattened M or W depending on the viewing angle. (Compare **double reverse bow** and **double bow**.)

DISCUSSION—In tubular knits, there may be differential bowing between the top and the bottom of the tube. **D3882, D3990**

double hooked bow, *n*—one hooked bow at each side of the fabric that arc in opposite directions. (See also **hooked bow**.) **D3882, D3990**

double reverse bow, *n*—two fabric bows arcing in opposite directions. (See also **bow**. Compare **double bow**.) **D3882**

double-rub, *n*—*in oscillatory cylinder abrasion testing*, one forward and one backward motion required to complete one cycle. **[D13.60] D4157**

double-stroke, *n*—*in flex and abrasion testing*, an abrasion cycle that consists of one forward and one backward motion. **D3885**

duck, *n*—a compact, firm, heavy, plain-weave cotton fabric, mass per square yard 6 to 50 oz. (See also **flat duck**, and **plied yarn duck**.) **D4850**

durable-press, *adj*—having the ability to retain substantially the initial shape, flat seams, pressed-in creases, and unwrinkled appearance during use and after laundering or drycleaning. (See **wash and wear**.)

DISCUSSION—The use of the term **permanent-press**, *adj*, as a substitute for **durable-press** is not recommended. **D4850**

elastic fabric, *n*—a fabric made from an elastomer either alone or in combination with other textiles.

DISCUSSION—At room temperature an elastic fabric will stretch under tension and will return quickly and forcibly to substantially its original dimensions and shape when tension is removed.

Elastic fabrics may be manufactured by weaving, braiding, knitting, or other processes. **D1775, D4850, D4964**

elastic tape, *n*—a tape containing rubber or other elastomers to permit rubber-like stretch in at least one direction. **D4850**

elastic webbing, *n*—a webbing containing rubber or other elastomers to permit rubber-like stretch in at least one direction. **D4850**

elongation, *n*—the ratio of the extension of a material to the length of the material prior to stretching, expressed as a percent. **[D13.60] D4848, D4964, D5034, D5035**

elongation, *n*—the ratio of the extension of a material to the length of the material prior to stretching. (Compare extension.) [D13.59] **D4848, D5278**

end, *n*—*in woven fabric*, an individual warp yarn (single or ply) or cord. **D3775**

end count, *n*—*in woven fabric*, the number of individual warp yarns per inch of fabric regardless of whether they are comprised of single or plied components **D3775**

extension, *n*—the change in length of a material due to stretching. [D13.59, D13.60] **D4848, D4964, D5034**

extension-recovery cycle, *n*—*in tension testing*, the continuous extension of a specimen, with a momentary hold at a specified extension, followed by a controlled rate of return to zero extension. [D13.59] **D4848, D4964**

fabric, *n*—*in textiles*, planar structure consisting of yarns or fibers. **D6797**

fabric, *n*—*in textiles*, a planar structure consisting of yarns or fibers. **D737, D1388, D1424, D3787 D4850, D5587**

fabric growth, *n*—the difference between the original length of a specimen and its length after the application of a specified tension for a prescribed time and the subsequent removal of the tension.

DISCUSSION—Fabric growth is usually expressed as a percentage of the length of the specimen prior to loading. (see also permanent deformation) **D6614**

fabric growth, *n*—the increase in the original length of a specimen after the application of a specified force for a prescribed time and the subsequent removal of the tension.

DISCUSSION—Fabric growth usually is expressed as a percentage of the length of the specimen prior to application of the force. (See also permanent deformation.) **D2594, D3107**

fabric roof-system, *n*—a system of coated fabric or laminated fabric along with support cables, edge ropes, clamps, neoprene, roof drains, arch wear strips, and anchor bolts that constitutes the outside top covering of a building. **D4851**

fabric stretch, *n*—the increase in length of a specimen of fabric resulting from a tension applied under specified conditions.

DISCUSSION—Fabric stretch is usually expressed as a percentage of the length of the specimen prior to loading. **D6614**

fabric stretch, *n*—the increase in length of a specimen of fabric resulting from a force applied under specified conditions.

DISCUSSION—The difference is usually expressed as a percentage of the initial length of the fabric specimen. Fabric stretch differs from fabric elongation in that the latter (up to the point of rupture) reflects the instantaneously existing amount of stretch under a constantly increasing tension force. **D2594, D3107**

fatiguing force, *n*—*in testing sewn seams*, the force that is repeatedly applied to a test specimen. **D4033**

filler, *n*—*in testing sewn seams* nonfibrous material, such as insoluble clays or gypsum, together with starches, gums, and so forth, added to a fabric to increase its weight or to modify the appearance or handle of the fabric. (*Syn.* back-sizing.) (Compare **sizing**.) **D4850**

filling, *n*—*in woven fabric*, an individual yarn running from selvage to selvage at right angles to the warp in a woven fabric. **D3775**

filling elongation and tension, *n*—stretch or tension measured at right angles to the warp direction of the fabric. **D1775**

filling-faced twill, *n*—a weave in which filling yarns float over warp yarns, to produce a diagonal effect in the resulting fabric. (See also **twill weave** and **warp faced twill**.) **D4850**

filling tests, *n*—*in fabric testing*, tests in which the filling yarns are torn. **D1424**

filling-to-filling seam, *n*—a sewn seam in which the yarns in the filling direction on both sides of the sewn seam are perpendicular to the seam. **D4033**

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). **D3887**

finished yield, *n*—*in knitted fabrics*, the number of finished square metres per kilogram (square yards per pound) of finished fabric. **D3887**

flagging, *n*—*in sewn seams*, a mode of failure evidenced by slippage of one or more yarns entirely out of the original seam. **D4033**

flat duck, *n*—duck fabric having the warp of two single yarns woven as one and either single or plied filling yarn. (See also **duck**.) **D4850**

flexibility, *n*—that property of a material to endure repeated flexing, bending, or bowing without rupture. **D3885, D4850**

flexural rigidity, *n*—*general*—resistance to bending; *specific*—work per unit width which is required to bend a fabric to unit radius of curvature. **D1388**

float, *n*—*in woven fabric*, the portion of a warp or filling yarn that extends unbound over two or more filling or warp yarns. **D4850**

foam tear, *n*—a condition wherein the foam portion of a laminated fabric ruptures prior to the failure of the bond. **D2724**

force, *n*—a physical influence exerted by one body on another which produces acceleration of bodies that are free to move and deformation of bodies that are not free to move. [D13.59] **D4848, D4964**

force-recovery cycle, *n*—*in elastic fabric testing*, a continuous curve or plot of force versus elongation (with movement stopped momentarily at point of reversal) describing the elongation and recovery of an elastic fabric; also known as the loading and unloading cycle. **D1775**

fused fabric, *n*—a type of bonded fabric made by adhering a fusible fabric to another fabric, such as for use in an interlining. **D2724**

fusible fabric, *n*—a utilitarian fabric which has a thermoplastic adhesive applied to one side, sometimes in a pattern of dots, so that the surface can be bonded to another fabric surface by the use of heat and pressure. **D2724**

fuzz, *n*—tangled fiber ends that protrude from the surface of a yarn or fabric. [D13.60] **D3511, D3512, D4970**

gage, *n*—in knitted fabrics, a measure of fineness expressing the number of needles per unit of width (across the wales).

D4850

gage, *n*—in full-fashioned hosiery, a measure of fineness expressing the number of needles per 38 m (1.5 in.) on the needle bar.

D4850

gage, *n*—in warp knitting, for simplex, tricot, milanese, number of needles per English inch; for raschel, kayloom, twice the number of needles per English inch.

D4850

gaiting, *n*—in warp knitting, the setting of a guide bar one or more needle spaces to the right or left in order to increase the pattern possibilities.

D4850

grab test, *n*—in fabric testing, a tensile test in which the central part of the width of the specimen is gripped in the clamps.

DISCUSSION—For example, if the specimen width is 100 mm (4.0 in.) and the width of the jaw faces 25 mm (1.0 in.), the specimen is gripped in the clamp with approximately 37.5 mm (1.5 in.) of fabric protruding from each side of the jaws.

D4850, D5034

grade, *n*—in warp knitting, a term used to indicate the defect index evaluation of fabric determined by the number of defects per unit, for example per pound, per linear yard, or per square yard.

D4350, D4850

grade, *v*—to assign a numerical value based on number, size, and severity of defects seen during a visual inspection.

D5430

growth, *n*—of textiles, the difference between the original length of a specimen and its length after the application of a specified force for a prescribed time, and the subsequent removal of the force. (See also **permanent deformation** and **dimensional change**.)

D2594, D3107

hooked bow, *n*—a fabric condition in which the filling yarns or knitted courses are in the proper position for most of the fabric width but are pulled out of alignment at one side of the fabric. (See also **double hooked bow**.)

D3882

impregnated fabric, *n*—a fabric in which the interstices between the yarns are completely filled with the impregnating compound throughout the thickness of the fabric, as distinguished from sized or coated fabrics, where these interstices are not completely filled.

DISCUSSION—A fabric woven from impregnated yarns, but not impregnated after weaving, is not an impregnated fabric.

D4850

inspection, *n*—the process of measuring, examining, testing, gaging, or otherwise comparing a characteristic or property of a material with applicable requirements. In this case only by visual examination.

D5430

interlining, *n*—any textile which is intended for incorporation into an article of wearing apparel as a layer between an outer shell and inner lining.

D2724

jacket, *n*—a textile, woven or felted into tubular or sleeve form, ready for covering and shrinking on a machine roll.

D4850

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

D3786, D3787, D3789, D3882, D3887, D4850, D5378

laid fabric, *n*—a fabric made without filling yarn, the parallel warp yarns being held together by means of rubber latex or

other binding material.

D4850

laminated fabric, *n*—a layered fabric structure wherein a face or outer fabric is joined to a continuous sheet material, such as polyurethane foam, in such a way that the identity of the continuous sheet material is retained, either by the flame method or by an adhesive, and this in turn normally, but not always, is joined on the back with a backing fabric such as tricot. (

D2724

laminated fabric, *n*—in fabric roof systems, a flexible fabric system composed of superimposed layers of fabric firmly united by bonding or impregnating with an adherent polymeric material to one or more surfaces.

D4851

length, *n*—of a fabric, the distance from one end of a fabric to the other, measured parallel to the side edge of the fabric while it is under zero tension and is free of folds or wrinkles.

D3773, D3887

length of tear, *n*—in tear testing of fabrics, the measured distance propagated in a specimen by a tearing force from the initiation of the test to the termination of the test.

D1424

lisle, *n*—a fine high-twisted and hard-twisted thread, at least two-ply, used especially for hosiery.

DISCUSSION—Lisle refers also to knit goods used in gloves or hose made from lisle thread (first made in Lisle, France). Threads have been made with cotton or wool. For hosiery, a minimum twist for a given count is specified by the Federal Trade Commission.

D4850

Lissajous figure, *n*—geometric figure that starts as a straight line, then becomes a widening ellipse and narrows to again become a straight line. There are 16 rubs in one Lissajous figure.

[D13.60] D4966

loop tension, *n*—in elastic material testing, the total tension at any specified extension that is exerted on a specimen in a loop formation.

D4964

lot, *n*—in bonded, fused, or laminated fabric, a single run on the bonding or laminating machine in which the processing is carried out without stopping or changing processing conditions, and consisting of either a single dye lot or a single gray goods lot.

D2724

low-power stretch, *n*—that property of a fabric whereby it exhibits high fabric stretch and good recovery from low tension.

D2594

machine direction, **MD**, *n*—the direction in the plane of the fabric parallel to the direction of manufacture.

DISCUSSION—This term is used to refer to the direction analogous to warpwise or warp direction in knitted or woven fabrics, respectively.

[D13.59] D737, D1388, D1424, D1777, D2261

major defect, *n*—a defect other than critical, that judgment and experience indicate is likely to materially reduce the usability of a product for its intended purpose.

D5430

median force, *n*—in tensile testing, that force level that is exceeded by half the recorded peaks and which in turn exceeds the other half of the recorded peaks, in a specified distance of cross-head travel.

D2261

minor defect, *n*—a defect that is not likely to materially reduce the usability of the product from its intended purpose, or is a departure from established standards having little bearing on the effective use of operation of a product.

D5430