



Designation: **D1230–10 (Reapproved 2016)^{ε1} D1230 – 17**

Standard Test Method for Flammability of Apparel Textiles¹

This standard is issued under the fixed designation D1230; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

~~^{ε1} NOTE—The terminology section was editorially revised in April 2016.~~

1. Scope

1.1 This test method covers the evaluation of the flammability of textile fabrics as they reach the consumer for ~~or from apparel~~ items other than children's sleepwear or protective clothing.

1.2 This test method measures and describes the response of materials, products, or assemblies to heat and flame under controlled conditions, but does not by itself incorporate all factors required for fire hazard or risk assessment of the materials, products, or assemblies under actual fire conditions.

1.3 Fire testing is inherently hazardous. Adequate safeguards for personnel and property shall be employed in conducting these tests.

NOTE 1—This test method is not identical to 16 CFR Part 1610, Flammability of Clothing Textiles. Consumer Product Safety Commission regulations require that clothing fabrics introduced into commerce meet the requirements of 16 CFR Part 1610.

1.4 The values stated in SI units are to be regarded as the standard; inch-pound units are provided for information only.

1.5 *This test method 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 test method to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D123 Terminology Relating to Textiles](#)

[E176D3136 Terminology of Fire Standards Relating to Care Labeling for Apparel, Textile, Home Furnishing, and Leather Products](#)

[D4391 Terminology Relating to The Burning Behavior of Textiles](#)

[E176 Terminology of Fire Standards](#)

2.2 *AATCC Test Method:*³

[124 - 2011 Smoothness Appearance of Fabrics after Repeated Home Laundering](#)

2.3 *CPSC Guidance Document:*⁴

[16 CFR Part 1610 Standard for the Flammability of Clothing Textiles October 2008](#)

2.4 *ISO Standards*⁵

[ISO 4880 Burning behaviour of textiles and textile products](#)

[ISO 13943 Fire safety](#)

¹ This test method is under the jurisdiction of ASTM Committee [D13](#) on Textiles and is the direct responsibility of Subcommittee [D13.52](#) on Flammability. Current edition approved April 1, 2016 July 15, 2017. Published April 2016 August 2017. Originally approved in 1952. Last previous edition approved in 2010 as [D1230–10–10 \(2016\)^{ε1}](#). DOI: [10.1520/D1230-10R16E01-10.1520/D1230-17](#).

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 AATCC Technical Manual of the American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 27709.

⁴ Available from the U.S. Consumer Product Safety Commission, [www.cpsc.gov](#).

⁵ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, [http://www.iso.ch](#).

3. Terminology

3.1 ~~For Terminology related to the burning behavior of textiles, See Terminology~~ The following terms are relevant to this standard: base burn, burn time, combustible ~~D4391~~-textile, dry cleaning, flame application time, flame spread, flame-spread time, flame retardant, flame-retardant-treated, flammability, ignition, interlining, laundering, plain surface textile fabric, raised fiber surface, refurbish, surface flash.

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3.2 For terms related to burning behavior of textiles, See Terminology [D4391](#).

3.3 For terms related to fabric treatments and finishings, see Terminology [D3136](#).

3.4 For terms related to fabric treatments and finishings, see Terminology in the referenced AATCC test method.

3.5 For terminology related to fire issues other than burning behavior of textiles, see Terminology [E176](#) and ISO 13943. In case of conflict, the terminology in [E176](#) will prevail.

3.6 ~~For all other terminology terms related to textiles, see Terminology [D123](#); and the American Association of Textile Chemists and Colorists test method.~~

4. Summary of Test Method

4.1 The test method provides methods of testing the flammability of textiles from or intended to be used for apparel, explains three classes of flammability, sets forth the requirements for classifying textiles, and warns against the use of single or multilayer textile fabrics that have burning characteristics considered by the trade to make them unsuitable for apparel.

4.2 Specimens cut from the textile are prepared by brushing if they have a raised fiber surface. All textiles require testing before and after refurbishing. Refurbishing consists of one cycle of drycleaning followed by laundering of all textiles. A specimen is inserted in a frame, dried in an oven and placed in a dessicator before testing. The framed specimen is held in the flammability tester at an angle of 45°, a standardized flame is applied to the surface near the lower end for 1 ± 0.1 s, and the time required for the flame to proceed up the fabric a distance of 127 ± 0.2 mm ($5 \pm 0.0190,008$ in.) is recorded. Notation is made as to whether the base of a raised-surface fabric ignites, chars, melts, or fuses.

5. Significance and Use

5.1 Test Method D1230 cannot be recommended for the acceptance testing of commercial shipments since Federal regulations require apparel fabrics to meet the criteria of 16 CFR Part 1610 and correlation of test results with actual performance has not been established. Although Test Method D1230 is not recommended for acceptance testing, it is useful because it provides a ~~less expensive and time-consuming research tool than 16 CFR Part 1610 method to test general non-regulated textile fabrics.~~

5.1.1 ~~In case of a dispute arising from differences in reported test results when using Test Method D1230 for testing of commercial shipments, the purchaser and the supplier shall conduct comparative tests to determine if there is a statistical bias between their laboratories. Competent statistical assistance is recommended for the investigation of bias. At a minimum, the two parties shall take a group of test specimens which are as homogeneous as possible and which are from a lot of material of the type in question. The test specimens shall be randomly assigned in equal numbers to each laboratory for testing. The average results from the two laboratories shall be compared using a nonparametric test for unpaired data and an acceptable probability level chosen by the two parties before testing is begun. If a bias is found, either its cause must be found and corrected or the purchaser and the supplier must agree to interpret future test results in light of the known bias.~~

5.2 All fabrics made of natural or regenerated cellulose, as well as many made from other natural or man-made fibers, are combustible. Some combustible fabrics when used for clothing are potentially dangerous to the wearer because of such factors as ease of ignition, flame spread time, amount of heat released, and design of the garment. This test measures two such factors: ease of ignition and flame spread time.

5.3 In order to place fabrics in one of the three flammability classes, arbitrary limits have been selected for time of application of the flame and for time of flame spread. These limits are based on extensive testing experience and are believed to be a useful guide in judging the relative flammability of apparel textiles. It must be understood, however, that no guarantee can be given and none is implied that garments made from a fabric or product falling into any one of the flammability classes will not be hazardous under some conditions.

5.3.1 Because of the sensitivity of fabrics to ambient atmospheric conditions, technique of specimen preparation, and inherent variability in the cloth itself, test results are not always closely reproducible either in the same laboratory or among several laboratories.

5.4 Finishes and fabric surface changes can exert a large effect on flammability. Therefore, fabrics are tested before as well as after one cycle of drycleaning followed by laundering.

5.5 ~~This test method is not applicable to hats, gloves, footwear, or interlining fabrics.~~

6. Apparatus and Materials

6.1 *Flammability Tester*, with a separate timer capable of providing flame impingement on the specimen for $1 + 0.01$ s as shown in Fig. 1 or an equivalent electrically operated tester equipped with an automatic electric timer, as described in Annex A1. Testers are normally supplied with specimen holders.

6.2 *Brushing Device*, as shown in Fig. 2, Fig. 3 and Fig. 4 and described in Annex A1.

6.3 *Drycleaning Machine*—A commercial dry cleaning machine shall be capable of providing a complete automatic dry-to-dry cycle using perchloroethylene solvent and a cationic drycleaning detergent.

6.4 *Laboratory Drying Oven*.

6.5 *Desiccator*,

6.6 *Anhydrous Silica Gel*,

6.7 *Butane*, CP.

6.8 *AATCC 1993 Standard Reference Detergent*.³

6.9 *Perchlorylene*, commercial grade.

6.10 *Drycleaning Detergent*, amine sulfonate type/(catatonic).

6.11 *Cotton Sewing Thread*, No. 50, mercerized.

7. Sampling

7.1 *Lot Sample*—As a lot sample for testing, take at random the number of primary sampling units directed in an applicable material specification or other agreement between the purchaser and the supplier. For fabric, consider rolls of fabric to be the primary sampling units. For garments, consider shipping cartons to be the primary sampling units.

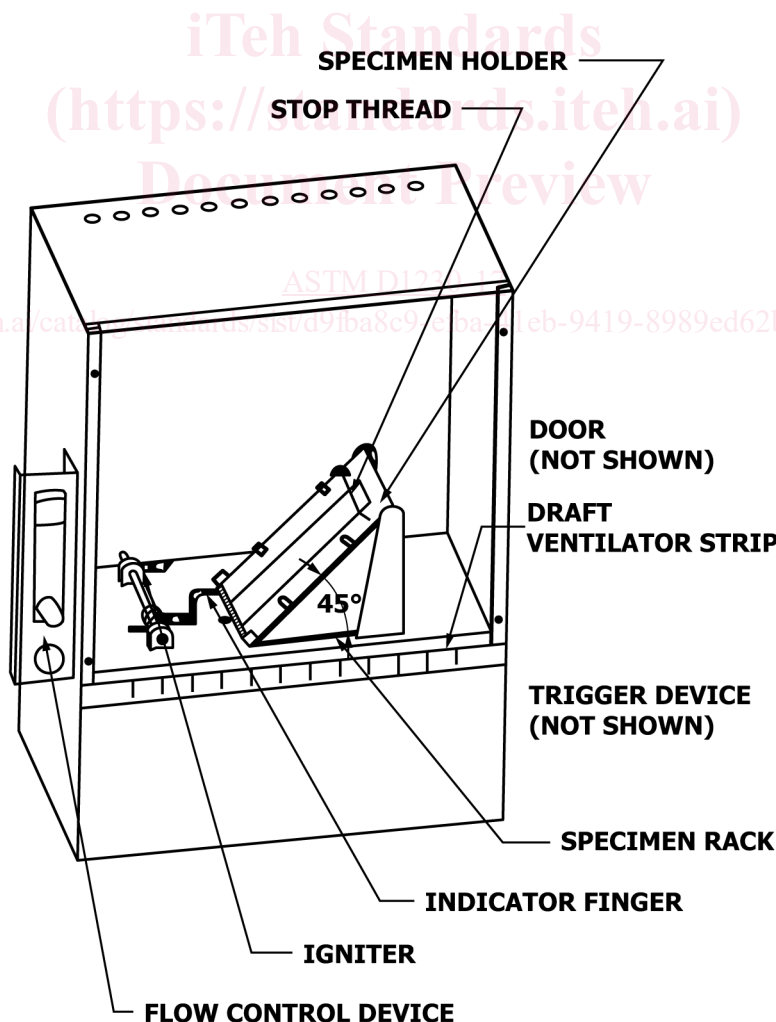
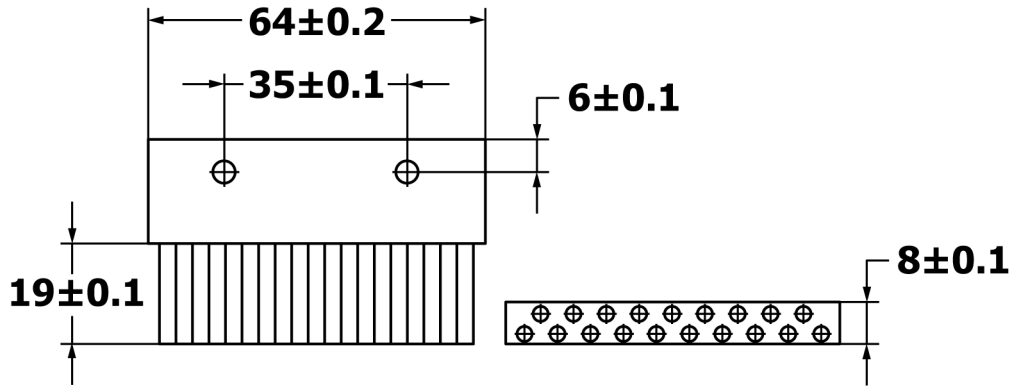


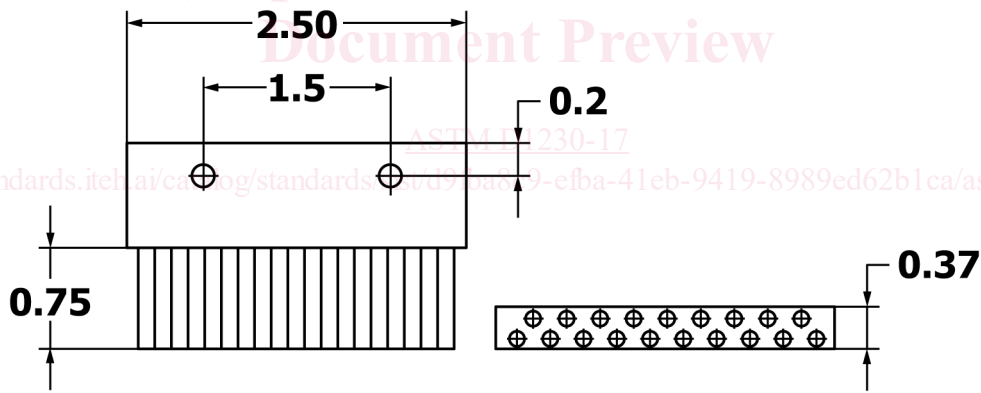
FIG. 1 Sketch of Typical Flammability Apparatus



**BRUSH CONSISTS OF NYLON BRISTLES
0.04 DIAMETER ± 0.01
20 BRISTLES PER TUFT AND 4 TUFTS PER INCH**

**NOTE: DIMENSIONS IN
MILLIMETERS
TOLERANCE ± 0.5
UNLESS OTHERWISE NOTED**

FIG. 2 Brush (SI)

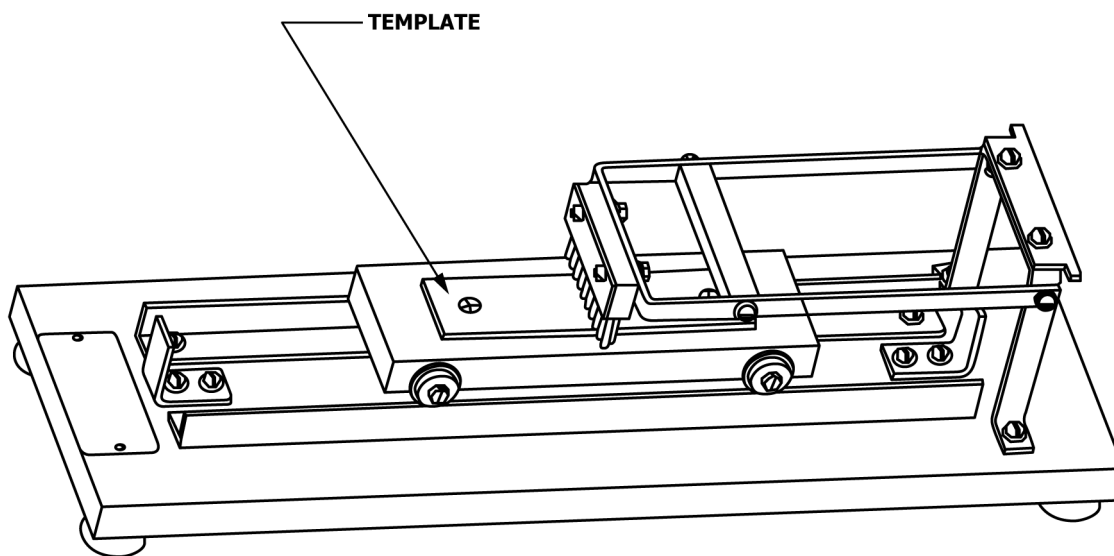


**BRUSH CONSISTS OF NYLON BRISTLES
0.016 DIAMETER ± 0.004
20 BRISTLES PER TUFT AND 4 TUFTS PER INCH**

**NOTE: DIMENSIONS IN
INCHES
TOLERANCE ± 0.019
UNLESS OTHERWISE NOTED**

FIG. 3 Brush (in./lb)

NOTE 2—A realistic specification or other agreement between the purchaser and the supplier requires taking into account the variability between



NOTE 1—See Fig. 5 and Fig. 6.
FIG. 4 Brushing Device

primary sampling units and within primary sampling units so as to provide a sampling plan which has a meaningful producer's risk, consumer's risk, acceptable quality level, and limiting quality level. A lot sample normally consists of a very small fraction of the total primary sampling units.

7.2 *Laboratory Sample*—As a laboratory sample for testing, proceed as follows:

7.2.1 For fabric take a full-width swatch ½ m (½ yd) long from the end of each roll of fabric in the lot sample, after first discarding any fabric from the very outside of the roll that contains folds, creases, or any evidence of displaced weave.

7.2.2 For garments, take the number of garments per shipping carton in the lot sample directed in an applicable material specification or other agreement between the purchaser and supplier.

7.3 *Test Specimens:*

7.3.1 Use exploratory tests as directed in to select the orientation of specimens, the face of the fabric to be tested, and the part of any pattern to be tested so as to maximize the rate of flame spread.

7.3.2 For fabric, cut final test specimens from each swatch in the laboratory sample as directed in 9.1. For fabrics that can be refurbished, cut additional final test specimens from each swatch in the lot sample after the swatches have been refurbished as directed in 9.2. Identify the specimens as coming from a swatch before or after refurbishing.

7.3.3 For garments, cut final test specimens from each garment in the laboratory sample as directed in 9.1. For garments that can be refurbished, cut additional final test specimens from each garment in the lot sample after the garments have been refurbished as directed in 9.2. Identify the specimens as coming from a garment before or after refurbishing.

8. Preparation of Specimens

8.1 Perform tests on the fabric as it will reach the consumer. Accomplish exploratory finished production fabric or fabric taken from the finished apparel product. Perform preliminary testing to determine the proper orientation of specimens, face which side of fabric, and which part of pattern to be tested by marking and cutting (see determine the fastest burning area 8.2) a single 50 by 150 mm (2 by 6 in.) specimen for each fabric surface, direction, and pattern and testing according to Section 10.

NOTE 3—For fabric with a raised-fiber surface, it is usually found that the long dimension of the specimen needs to be parallel with the lay of the pile, and that flame spread is most rapid when progressing against the lay of the pile.

8.1.1 Mark and cut (see 8.2) a single 50 by 150 mm (2 by 6 in.) specimen for each fabric surface, direction, and pattern and testing according to Section 10.

NOTE 3—For fabric with a raised-fiber surface, it is usually found that the long dimension of the specimen needs to be parallel with the lay of the pile, and that flame spread is most rapid when progressing against the lay of the pile.

8.2 *Marking and Cutting, General Directions*—Mark out the required number of specimens (See Section 9) each 50 by 150 mm (2 by 6 in.) on the surface opposite that to be tested, with the long dimension in the direction in which burning is most rapid as established in the preliminary trials (See 8.1). Long dimension is the longer length of test specimen for purposes of this method. In cases where it is difficult to determine the direction of the lay of the nap, it is possible to identify it following the method stated in the CPSC Laboratory Manual: Laboratory Test Manual for 16 CFR Part 1610. Identify the end of each specimen toward which, and on the surface of which flame spread is most rapid by attaching a staple to it. Then cut specimens from the fabric. Place any identification markings on the side and end opposite of that to be tested.

9. Specimens for Final Testing

9.1 Test all fabrics as received per 9.1.1. If fabric is Class 3 as-received (See Sections 11 and 12) proceed to Section 13. If fabric is Class 1 or Class 2 as-received (See Sections 11 and 12) proceed to 9.1.2.

9.1.1 *Fabric as Received*—Cut five specimens (see, however, 11.1) as directed in 8.2, in addition to the one previously tested in the preliminary trials. *Specimen* is a section of sample to be tested having specific dimension. Five or ten specimens are required to be tested for a complete test. (Refer to Section 11 for additional information as to when an additional five specimens are required.)

9.1.2 *Refurbished Fabric*—Cut a swatch large enough to provide five or ten specimens, as indicated in 11.1, with allowance for shrinkage in dry cleaning and washing, and subject the swatch to drycleaning and washing procedures as per 9.2. *Specimen* is a section of sample to be tested having specific dimension. Five or ten specimens are required to be tested for a complete test. (Refer to Section 11 for additional information as to the need for an additional five specimens.)

9.2 *Refurbishing:*

9.2.1 *Drycleaning:*

9.2.1.1 *Solvent: Perchloroethylene, commercial grade*

Detergent class: Cationic.

Cleaning time: 10 to 15 min.

Extraction time: 3 min.

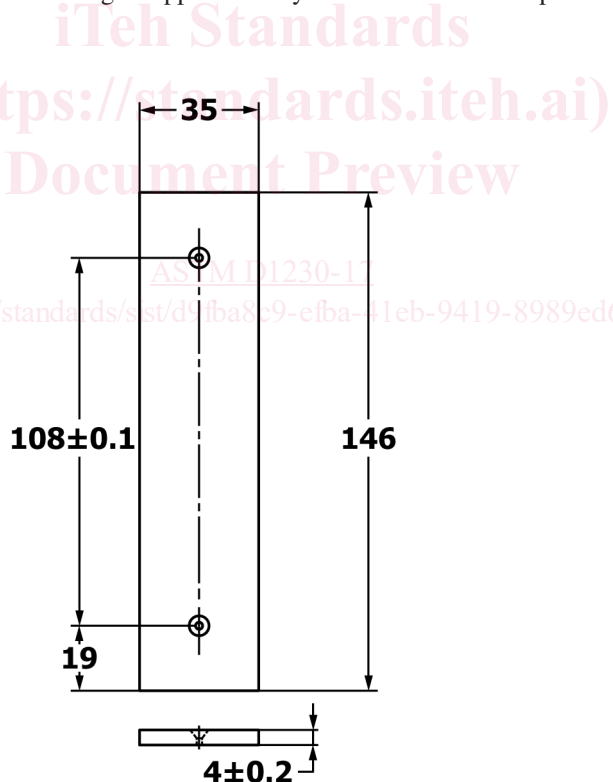
Drying Temperature: 60 to 66°C (140 to 150°F).

Drying Time: 18 to 20 min.

Cool Down/Deodorization time: 5 min.

9.2.1.2 Perchloroethylene is toxic and a suspected carcinogen, and the usual precautions for handling chlorinated solvents need to be taken. Perchloroethylene is to be used only under well-ventilated conditions. The solvent is nonflammable.

9.2.1.3 Samples shall be dry cleaned in a load that is 80 % of the machine’s capacity. If necessary, ballast of clean textile pieces or garments, white or light in color, and consisting of approximately 80 % of wool fabric pieces and 20 % cotton pieces shall be used.



NOTES:

1. TWO HOLES Ø1.6 COUNTERSINK FOR FLAT HEAD SCREW
2. DIMENSIONS IN MILLIMETERS
3. TOLERANCE ± 0.5 UNLESS OTHERWISE NOTED

FIG. 5 Brushing Device Template (SI)