



Designation: D1683/D1683M – 17 (Reapproved 2018)

Standard Test Method for Failure in Sewn Seams of Woven Fabrics¹

This standard is issued under the fixed designation D1683/D1683M; 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.

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

INTRODUCTION

The structural integrity of textile products made of woven fabrics is dependent on how well the pieces that are cut from rolls of fabric have been joined together. To measure this integrity requires understanding the inter-relationship between two distinct test methods.

(a) The first evaluation is done by testing fabric using Test Method **D5034**. This standard is used to measure the resistance of a woven fabric to rupture in the warp direction and, the filling yarn direction. The test method measures the force needed to rupture the fabric causing the destruction of the fabric and the loss of its structural integrity. This loss of structural integrity causes yarn slippage, that is, the displacement and change of yarn spacing causing an irreversible fabric failure.

(b) Before completing the second evaluation, an analysis and determination of the anticipated failure mode needs to be completed by the fabric weaver or textile product manufacturer. While the failure mode for a woven fabric textile product sewn seam can demonstrate various and distinct levels, it is imperative to have agreement and understanding about the expected performance or service life of the end use product. Is the seam engineering used to build the textile product intended to perform for a “single incident” discarded and replaced, or is the end use product designed and engineered to be subjected to regular care and maintenance to include repairs?

(c) The second evaluation is done by using this test method, D1683/D1683M, to test fabric sections that have been cut and then sewn together using procedures that select a specific combination of sewing thread, stitch type, seam type, and stitch density. These are the seam engineering variables that determine which of the following outcomes can occur: (1) the fabric, at a force similar to that when tested using Test Method **D5034**, will rupture adjacent to the stitch line causing the destruction and loss of fabric integrity, and the failure of the textile structure; (2) the sewing thread used in the specific stitch configuration will rupture, at a force less than 85 % of the fabric break strength, such that the fabric integrity will be sufficient to enable repair of the textile structure along the same axis.

1. Scope

1.1 This test method measures the sewn seam strength in woven fabrics by applying a force perpendicular to the sewn seams.

1.1.1 The axis perpendicular to the sewn seam can represent either the warp yarn axis or filling yarn axis, the same axis tested when using grab Test Method **D5034**.

1.1.1.1 This test method is applicable to sewn seams obtained from a previously sewn article or seams sewn with fabric samples using one of two specific seam assemblies as shown in **Table 1**.

1.2 This test method is used when the maximum breaking force measurement to rupture of a woven fabric sewn seam is required.

¹ This test method is under the jurisdiction of ASTM Committee **D13** on Textiles and is the direct responsibility of Subcommittee **D13.54** on Subassemblies.

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1.2.1 This test method is used when the seam efficiency measurement of a woven fabric sewn seam is required.

1.2.2 This test method is used to identify the sewn seam strength threshold at which the failure of the stitching occurs, without damage to the fabric, so that the textile product can be repaired.

1.2.3 This test method is used to identify the force at which seam strength results in slippage and displacement of warp yarns, filling yarns, or any combination of these yarns.

1.3 This test method does not predict actual wear performance of a seam.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately 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 non-conformance with the standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the*

TABLE 1 Standard/Default Seam Assembly Specification^A

Fabric Mass: $\leq 4 \text{ oz/yd}^2$ [130 g/m ²]		
Mass	Procedure A up to 4 oz/yd ² [130 g/m ²]	Procedure B up to 4 oz/yd ² [130 g/m ²]
Seam allowance	13 mm [0.5 in.]	13 mm [0.5 in.]
Needle:		
Size	Metric 90 [0.036 in.]	Metric 90 [0.036 in.]
Finish	chrome	chrome
Point	thin ball (No. 1/No. 23)	thin ball (No. 1/No. 23)
Sewing thread size:		
Spun Polyester	Tex 40	Tex 40
Polyester-Core	Tex 40	Tex 40
Seam Type	Ssa-1	Ssa-1
Stitch Type	301	401
Stitch Density	4.7 \pm 1/2 stitches per centimetre [12 \pm 1/2 stitches per inch]	4.7 \pm 1/2 stitches per centimetre [12 \pm 1/2 stitches per inch]
Fabric Mass: $> 4 \text{ oz/yd}^2$ [130 g/m ²] $\leq 8 \text{ oz/yd}^2$ [270 g/m ²]		
Mass	Procedure A 4 oz/yd ² [130 g/m ²] up to 8 oz/yd ² 270 g/m ²	Procedure B 4 oz/yd ² [130 g/m ²] up to 270 g/m ² [8 oz/yd ²]
Seam Allowance	13 mm [0.5 in.]	13 mm [0.5 in.]
Needle:		
Size	Metric 110 [0.044 in.]	Metric 110 [0.044 in.]
Finish	chrome	chrome
Point	ball	ball
Sewing Thread:		
Spun Polyester	Tex 60	Tex 60
Polyester-Core	Tex 60	Tex 60
Seam type	SSa-1	SSa-1
Stitch type	301	401
Stitch density	3.1 \pm 1/2 stitches per centimetre [8 \pm 1/2 stitches per inch]	3.1 \pm 1/2 stitches per centimetre [8.5 \pm 1/2 stitches per inch]
Fabric Mass: $> 8 \text{ oz/yd}^2$ [270 g/m ²] $\leq 12 \text{ oz/yd}^2$ [405 g/m ²]		
Mass	8 oz/yd ² [270 g/m ²] up to 12 oz/yd ² [405 g/m ²]	8 oz/yd ² [270 g/m ²] up to 12 oz/yd ² [405 g/m ²]
Seam allowance	13 mm [0.5 in.]	13 mm [0.5 in.]
Needle:		
Size	Metric 120	Metric 120
Finish	chrome	chrome
Point	ball	ball
Sewing thread size:		
Spun Polyester	Tex 80	Tex 80
Polyester-Core	Tex 80	Tex 80
Seam type	Ssa-1	SSa-1
Stitch type	301	401
Stitch density	3.1 \pm 1/2 stitches per centimetre [8 \pm 1/2 stitches per inch]	3.1 \pm 1/2 stitches per centimetre [8.5 \pm 1/2 stitches per inch]

^A A complete description of seam types and stitch types can be found in Practice [D6193](#).

NOTE 1—When the performance of a woven textile structure requires data to indicate the maximum seam strength that will result in the failure of fabric on either side of seam, the standard seam can be changed to use the Lapped seam type construction with two or more rows of stitching: Lsc-2; Lsc-3; Lsc-4; and the maximum number of stitches per inch that can be used. (See Practice [D6193](#).)

responsibility of the user of this standard to establish appropriate safety, health, and environmental 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

- [D76 Specification for Tensile Testing Machines for Textiles](#)
- [D123 Terminology Relating to Textiles](#)

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.

- [D1776 Practice for Conditioning and Testing Textiles](#)
- [D5034 Test Method for Breaking Strength and Elongation of Textile Fabrics \(Grab Test\)](#)
- [D6193 Practice for Stitches and Seams](#)
- [D7722 Terminology Relating to Industrial Textile Stitches and Seams](#)
- [E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods](#)
- [E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method](#)

3. Terminology

3.1 Definitions:

3.2 The following terms are relevant to this standard: needle damage; seam allowance; seam assembly; seam efficiency; seam engineering; seam failure; seam slippage; seam type; sewn seam; sewn seam strength; slippage; standard seam; stitch; stitch density; stitch gage; stitch type; yarn slippage.

3.3 For terminology related to seams and stitched, see Terminology **D7722**.

3.4 For definitions of other textile terms used in this test method, refer to Terminology **D123**.

4. Summary of Test Method

4.1 Sewn fabric sections are placed in a test machine so that an applied force, perpendicular to the stitching, can be exerted until one of the following phenomena occur:

4.1.1 Failure of sewing thread stitchline without damage to fabric (sewn seam strength) (seam efficiency).

4.1.2 Failure caused by a force sufficient to stress the sewn seam and displace one or more fabric yarns from their original position so as to cause fabric failure due to difference in alignment, spacing, or both.

5. Significance and Use

5.1 The manufacturing of textile products uses seam engineering to determine the best combination of sewing thread, stitch type, seam type, and stitch density to construct the end use structure. These four seam engineering variables contribute to a textile product being able to achieve the maximum sewn seam strength performance and structural integrity when cut pieces of fabric are joined together.

5.1.1 It is known that for some textile structures the seam engineering variables are selected to meet a “one time performance requirement.” This means that following the “single incident” during which the maximum performance potential or capability of the textile structure has been met, it is expected to be discarded and replaced with another “new” unit. For example: an inflatable restraint in an automobile. Once deployed, it must be replaced; it cannot be re-used. Likewise, there are other textile structures, intended to be used multiple times, while also being subjected to various care and maintenance regimens.

5.1.2 This test method enables the fabric producer of woven fabrics, the textile producer, and other users of the test method to determine which seam engineering choices can be made relative to: sewing thread tex size; seam type; stitch type; and stitch density to determine the potential outcomes that can occur when a particular woven fabric is used:

(a) What is the maximum force at which sewn seam strength failure will enable products made with this fabric to be repaired?

(b) What is the highest seam efficiency percentage attained?

(c) What is the maximum force at which the sewn seam strength results in seam slippage that can cause yarn slippage, yarn displacement and fabric failure?

5.1.2.1 The maximum force at which sewn seam strength or the highest seam efficiency retained demonstrate failure of the stitching without causing the displacement of one or more fabric yarns from their original position mean that the product can be repaired. When the failure results in displacement of yarns, the textile product will need to be replaced.

5.1.3 The procedures used in this test method represent two primary seam engineering techniques identified in Practice **D6193** and used to manufacture products made of woven textile fabrics.

5.1.4 In case of dispute arising from differences in reported test results when using this test method for acceptance testing of commercial shipments, the purchaser and the supplier should perform comparative tests to determine if there is a statistical bias between their laboratories. Competent statistical assistance is recommended for the investigation of bias. As a minimum, the two parties should take a group of test specimens from the same lot of fabric to be evaluated, which utilize a like seam assembly (or standard seam assembly). The test specimens should then be randomly assigned in equal numbers to each laboratory for testing. If a bias is found, either its cause must be determined and corrected, or the purchaser and supplier must agree to interpret future test results in light of the known bias.

5.2 This test method can be used to determine the sewn seam strength and sewn seam efficiency of a specified seam assembly with each fabric. Because sewn seam strength and sewn seam efficiency varies with each fabric, both of the standard seam assemblies, noted in **Table 1**, should be used when comparing the seam strength of different fabrics. **Table 1** lists the default seam assembly specifications to be used for fabrics made with fine, medium and heavy count yarns. If a determination cannot be made as to which seam is the best suited for a particular fabric, all should be evaluated.

5.3 Seams prepared for this test method should be made by competent factory sewing operators familiar with the potential for damage to the integrity of the sewn seam when stitching is improperly done.

5.3.1 If competent factory sewing operators are not accessible, a laboratory technician familiar with the potential for damage of an improperly sewn seam may prepare the seamed test specimens. It is imperative for purchaser/supplier to understand the impact an improperly sewn seam will have on test results.

5.4 This test method is applicable whenever a determination of sewn seam strength is required. The breaking force of the seam and fabric will permit estimation of seam efficiency. This test method can be used as an aid for estimating seam strength for any given fabric.

5.5 Seam engineering techniques for specific fabric types can also be determined by utilizing this test method.

5.6 This test method can be used to determine when the sewn seam is affected by seam slippage. While the ultimate consequence of this phenomenon is rupture, seam slippage greater than either the values stated in customer specifications, or as agreed upon by purchaser/supplier may severely reduce the integrity such that the product cannot be used for its intended purpose.

6. Apparatus

6.1 *Tensile Testing Machine*, as used in Test Method **D5034** conforming to Specification **D76**, and preferably a constant-rate-of-extension (CRE) type of machine capable of jaw separation rate of 305 ± 10 mm/min [12.0 ± 0.5 in./min] and an interfaced computer response to record the force-extension