



Standard Test Methods for Measuring Zipper Dimensions¹

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

^{ε1} NOTE—In Paragraph 8.1, reference to Section 41 was corrected editorially to Section 42 in April 2015.

1. Scope

1.1 These test methods cover the measurement of the dimensions of all types and sizes of zippers.

1.2 The test methods appear as follows:

	Sections
Chain Flatness	34 – 39
Chain Straightness	40 – 44
Chain Thickness	28 – 33
Chain Width	45 – 50
Length of Zipper or Parts	9 – 14
Longitudinal Dimensional Change	51 – 58
Slider Mouth Width	21 – 27
Tape Width	15 – 20

1.3 The values stated in either SI units or in other units shall be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently of the other, without combining values in any way.

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
- D1776 Practice for Conditioning and Testing Textiles
- D2050 Terminology Relating to Fasteners and Closures Used with Textiles
- D2051 Test Method for Durability of Finish of Zippers to Laundering

¹ These test methods are under the jurisdiction of ASTM Committee D13 on Textiles and are the direct responsibility of Subcommittee D13.54 on Subassemblies, Inc.

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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.

- D2052 Test Method for Colorfastness of Zippers to Dry-cleaning
 - D2053 Test Method for Colorfastness of Zippers to Light
 - D2054 Test Method for Colorfastness of Zipper Tapes to Crocking
 - D2057 Test Method for Colorfastness of Zippers to Laundering
 - D2058 Test Method for Durability of Finish of Zippers to Drycleaning
 - D2059 Test Method for Resistance of Zippers to Salt Spray (Fog)
 - D2061 Test Methods for Strength Tests for Zippers
 - D2062 Test Methods for Operability of Zippers
 - D2724 Test Methods for Bonded, Fused, and Laminated Apparel Fabrics
 - D2905 Practice for Statements on Number of Specimens for Textiles (Withdrawn 2008)³
 - D3657 Specification for Zipper Dimensions
 - E145 Specification for Gravity-Convection and Forced-Ventilation Ovens
- 2.2 *AATCC Method:*
- AATCC 143 Appearance of Apparel and Other Textile End Products After Repeated Home Launderings⁴
- 2.3 *ANSI Standard:*
- ANSI/ASQC Z1.4 Sampling Procedures for Inspection by Attributes⁵

3. Terminology

3.1 For definitions of terms relating to Subassemblies, D13.54, refer to Terminology D2050.

3.1.1 The following terms are relevant to this standard: dimension, zipper.

3.2 For all other terminology related to textiles, refer to Terminology D123.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Technical Manual of the American Association of Textile Chemists and Colorists, P. O. Box 12215, Research Triangle Park, NC 27709.

⁵ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

3.2.1 Optional key terms, not under the jurisdiction of this SC that must be used to understand this standard. If the optional term is necessary, a very exact and detailed discussion must also be included to indicate why this is so.

4. Significance and Use

4.1 The significance of specific tests is discussed in the appropriate sections.

4.2 These test methods are considered satisfactory for acceptance testing of commercial shipments because the test methods have been used extensively in the trade for this purpose, and because current estimates of between-laboratory precision are acceptable in most cases.

4.2.1 In case of a dispute arising from differences in reported test results when using Test Methods D2060 for acceptance testing of commercial shipments, the purchaser and the supplier should conduct 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 that are as homogeneous as possible and that are from a lot of material of the type in question. The test specimens should then be randomly assigned in equal numbers to each laboratory for testing. The average results from the two laboratories should be compared using Student's *t*-test for unpaired data and an acceptable probability level chosen by the two parties before the 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 the light of the known bias.

4.3 The test method(s) in these test methods, along with those in Test Methods D2051, D2052, D2053, D2054, D2057, D2058, D2059, D2061, and D2062, are a collection of proven test methods. They can be used as aids in the evaluation of zippers without the need for a thorough knowledge of zippers. The enumerated test methods do not provide for the evaluation of all zipper properties. Besides those properties measured by means of the enumerated test methods there are other properties that may be important for the satisfactory performance of

a zipper. Test methods for measuring those properties have not been published either because no practical methods have yet been developed or because a valid evaluation of the information resulting from existing unpublished methods requires an intimate and thorough knowledge of zippers.

5. Sampling

5.1 *Lot Sample*—As a lot sample for acceptance testing, take at random the number of individual containers from each shipping carton as directed in an applicable material specification or other agreement between the purchaser and the supplier. Consider individual containers from each shipping carton to be the primary sampling units.

NOTE 1—An adequate specification or other agreement between the purchaser and supplier requires taking into account the variability between shipping cartons and between zippers in a container to provide a sampling plan with a meaningful producer's risk, consumer's risk, acceptable quality level, and limiting quality level.

5.2 *Laboratory Sample and Test Specimens*—As a laboratory sample for acceptance testing, take the number of zippers specified in Section 7 at random from each container in the lot sample. Consider the zippers as both the laboratory sample and the test specimens.

6. Test Specimen

6.1 The test specimen shall consist of a completely assembled zipper or length of chain.

7. Number of Specimens

7.1 *All Properties Except Slider Mouth Width and Chain Width*—Take a number of zippers per individual container from each shipping carton such that the user may expect at the 90 % probability level that the test result for an individual container is no more than the amounts shown in Table 1, above or below the true average for the individual container. Determine the number of zippers per individual container as follows:

7.1.1 *Reliable Estimate of *s* or *v**—When there is a reliable estimate of *s* or *v* based upon extensive past records for similar materials tested in the user's laboratory as directed in these test

TABLE 1 Specimens Required Under Conditions of Known and Unknown Variability in User's Laboratory Units as Indicated

Property	Allowable Variation (Two-Sided)	Equation for <i>n</i> Using a Reliable Estimate of <i>s</i> or <i>v</i>	No Reliable Estimate of <i>s</i> or <i>v</i>	
			Number of Specimens	Basis ^A
Length, assembled zipper, % of the average	10.0	$n = 0.027 \times v^2$	1	0.70
Length, chain, % of the average	10.0	$n = 0.027 \times v^2$	1	0.39
Length, top tape end, % of the average	10.0	$n = 0.027 \times v^2$	1	4.56
Length, bottom tape end, % of the average	10.0	$n = 0.027 \times v^2$	3	9.09
Length, opening, % of the average	10.0	$n = 0.027 \times v^2$	1	0.87
Effective tape width, % of the average	10.0	$n = 0.027 \times v^2$	1	2.34
Full tape width, % of the average	10.0	$n = 0.027 \times v^2$	1	2.51
Chain thickness, % of the average	10.0	$n = 0.027 \times v^2$	1	0.64
Chain straightness, 1/32-in. increments	1.0	$n = 2.71 \times s^2$	1	0.59
Wet dimensional change, home laundry, percentage points	0.200	$n = 67.6 \times s^2$	17	0.49
Wet dimensional change, launder-ometer, percentage points	0.200	$n = 67.6 \times s^2$	12	0.41
Dimensional change in dry heat, percentage points	0.200	$n = 67.6 \times s^2$	10	0.38

^A The values of *s* or *v* in Table 1 are somewhat larger than will usually be found in practice (see 7.1.2).

methods, calculate n using the equations in **Table 1** which are based on (Eq 1) or (Eq 2) as noted in Test Method **D2905**, Section 5:

$$n = \frac{t^2 \times s^2}{E^2} \quad (1)$$

$$n = \frac{t^2 \times v^2}{A^2} \quad (2)$$

where:

- n = number of specimens (rounded upward to a whole number),
- s = reliable estimate of the standard deviation of individual observations in the user's laboratory under conditions of single-operator precision,
- v = reliable estimate of the coefficient of variation of individual observations in the user's laboratory under conditions of single-operator precision,
- t = 1.645, the value of Student's t for infinite degrees of freedom, for two-sided limits, and a 90 % probability level ($t^2 = 2.706$), E and A = values of the allowable variations listed in **Table 1**, and t^2/E^2 and t^2/A^2 = the basis for calculation of the constants in the equations in **Table 1**.

7.1.2 *No Reliable Estimate of s or v* —When there is no reliable estimate of s or v for the user's laboratory, (Eq 1) or (Eq 2) should not be used directly. Instead, specify the number of specimens shown in **Table 1**. This number of specimens is calculated using values of s or v , which are listed in **Table 1**, and that are somewhat larger values of s or v than are usually found in practice. When a reliable estimate of s or v for dimensional change or length of bottom end in the user's laboratory becomes available, the equations in **Table 1**, which are based on (Eq 1) and (Eq 2), will usually specify fewer specimens than are listed in **Table 1** for the condition when there is no reliable estimate of s or v .

7.2 *Slider Mouth Width and Chain Width*—Unless otherwise agreed upon, as when specified in an applicable material specification, take one specimen per lot.

8. Conditioning

8.1 For tests made as directed in Sections **12**, **18**, **37**, **42**, and **55**, bring the specimens to moisture equilibrium for testing in the standard atmosphere for testing textiles as directed in Practice **D1776**. Preconditioning is not required.

8.2 For tests made as directed in Sections **25** and **31**, specimens need not be preconditioned nor conditioned.

LENGTH OF ZIPPER OR PARTS

9. Summary of Test Method

9.1 The chain or zipper is placed on a flat surface and, with the aid of a suitable scale, the length of the zipper or desired zipper part is determined.

10. Significance and Use

10.1 These measurements are useful in determining conformance with a purchasing specification and suitability for end use products using zippers.

11. Apparatus

11.1 *Scale*, graduated in 0.5 mm or $\frac{1}{64}$ in.

12. Procedure

12.1 *Length of Completely Assembled Zipper*—Place the closed zipper flat on a horizontal working surface without tension, aligning the chain over a straight reference line on the working surface. Make marks on the working surface corresponding to the zipper extremities. Remove the zipper and, using the scale, measure the distance between the marks to the nearest 1.0 mm or $\frac{1}{32}$ in.

NOTE 2—For the bottom end, the zipper extremities are the bottom of the bottom stop or interlocking element for a nonseparable zipper. The bottom end of a separable zipper is the lowermost tape or reinforcing tape but not the overhang of the fixed retainer. For the top end, the zipper extremities are the top of the top stop, or top of the last element, whichever is the extreme for both nonseparable and separable zippers.

12.2 *Length of Chain*—Place the closed chain, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. Place the scale on one stringer flush alongside the outer edge of the interlockable elements or the outer edge of the bead if the bead extends beyond the elements. Measure the distance between the extreme ends of the chain to the nearest 1 mm or $\frac{1}{32}$ in.

12.3 *Length of Tape End*—Place the closed zipper, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. Place the end of the scale against the outermost surface of the outermost stationary component. Measure to the nearest 1.0 mm or $\frac{1}{32}$ in. the tape end length along the cord to the outermost point of the pinked or straight-cut edge. In a case where the lengths of the tape ends on the two stringers are different, measure the length of the shorter tape end. This test method is not applicable to tape ends that are cut or pinked on a diagonal in excess of 5° in either direction.

12.4 *Effective Length of Opening, Completely Assembled Zipper*—Place the closed zipper, without tension, flat on a horizontal working surface, aligning the chain over a straight reference line on the working surface. With a sharp-pointed pencil, make a reference mark even with the top of the slider. Move the slider to the extreme open position and make another reference mark even with the top of the slider. Measure the distance between the marks to the nearest 1.0 mm or $\frac{1}{32}$ in. This test method is not applicable to separable zippers.

13. Report

13.1 State that the specimens were tested as directed in Sections **9** – **14** of Test Methods **D2060**. Describe the material or product sampled and the method of sampling used.

13.2 Report the following information:

- 13.2.1 The specific property (or properties) measured,
- 13.2.2 Number and description, of specimens tested, and
- 13.2.3 Measured length of each specimen.

14. Precision and Bias

14.1 *Precision*—See Section **59**.

14.1.1 Precision of the test method is related to the care with which the operator reads the 1.0-mm ($\frac{1}{32}$ -in.) increments on