



Standard Test Method for Tuft Bind of Pile Yarn Floor Coverings¹

This standard is issued under the fixed designation D1335; 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 Department of Defense.

1. Scope

1.1 This test method covers the measurement of force required to pull or break a tuft from a pile floor covering sample.

1.2 This test method is applicable to both cut and loop pile yarn floor covering.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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

[D76 Specification for Tensile Testing Machines for Textiles](#)

[D123 Terminology Relating to Textiles](#)

[D1776 Practice for Conditioning and Testing Textiles](#)

[D2904 Practice for Interlaboratory Testing of a Textile Test Method that Produces Normally Distributed Data](#)

[D2906 Practice for Statements on Precision and Bias for Textiles](#)³

[D5684 Terminology Relating to Pile Floor Coverings](#)

3. Terminology

3.1 For all terminology related to Pile Floor Coverings, D13.21, refer to Terminology [D5684](#).

¹ This test method is under the jurisdiction of ASTM Committee [D13](#) on Textiles and is the direct responsibility of Subcommittee [D13.21](#) on Pile Floor Coverings.

Current edition approved Aug. 1, 2011. Published September 2011. Originally approved in 1954. Discontinued in November 1995 and reinstated as D1335 – 98. Last previous edition approved in 2005 as D1335 – 05. DOI: 10.1520/D1335-11.

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³ Withdrawn.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.

3.1.1 The following terms are relevant to this standard: carpet, constant-rate-of-extension, cut pile yarn floor covering, finished, finished pile yarn floor covering, floor covering, loop pile yarn floor covering, pile, pile yarn floor covering, textile floor covering, tuft, tuft bind, tuft leg, tufted fabric.

3.2 For all other terminology related to textiles see Terminology [D123](#).

4. Summary of Method

4.1 A test sample is mounted in a special clamping fixture to the base of a tensile testing machine. A hook (for loops specimen) or a tuft clamp (for cut pile specimen) are used to remove a specimen from the sample. The force to pull the specimen free from the test sample is measured as the tuft bind.

5. Significance and Use

5.1 Test Method D1335 for tuft bind of pile yarn floor coverings is being used for acceptance testing of commercial shipments. Comparative tests as directed in [5.1.1](#) may be advisable.

5.1.1 In case of a dispute arising from differences in reported test results using this test method, 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 from the investigation of bias. As a minimum, the two parties should take a group of test samples that are homogeneous as possible and are from a lot of material of the type in question. The test samples should then be randomly assigned in equal numbers to each laboratory for testing. The average results from the two laboratories should be compared using appropriate statistical analysis, and a probability level chosen by the two parties before testing 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 with consideration to the known bias.

5.2 The satisfactory performance of a pile yarn floor covering depends to a considerable extent on the maintenance of its original appearance. In a cut pile yarn floor covering an inadequate tuft bind may result in complete loss of pile in areas exposed to severe wear. In a looped pile yarn floor covering

with inadequate tuft bind the pile loops may be pulled out to form unsightly long loops which may be hazardous.

6. Apparatus

6.1 *Tensile Testing Machine*, Constant-rate-of-extension (CRE) type, conforming to Specification D76, with a capacity selected such that the force required to complete the test falls within 15 to 85 % of full scale. A full scale ranging from 1 to 25 lbf (4.45 to 111 N) is generally adequate. For constant-rate-of-extension (CRE) type and constant-rate-of-traverse (CRT) type machines, the rate is 12 ± 0.5 in./min (300 ± 10 mm/min). In case of controversy the CRE type tensile testing machine shall prevail.

NOTE 1—The test results obtained with different types of testing machines is not always the same.

6.2 *Clamps and Jaw Faces*—The use of hydraulic or pneumatic clamping systems with a minimum of 1 by 3 in. (25 by 76 mm) serrated or padded faces designed to minimize slippage in the clamps during testing is recommended. Manual clamping is permitted providing no slippage of the specimen is observed. The faces shall be parallel and have matching centers with respect to one another in the same clamp and to the corresponding jaw face of the other clamp.

6.3 *Metal Cylindrical Sample Holder*, 6.0 ± 0.5 in. (152 ± 12 mm) long made from 1.5 ± 0.06 in. (38 ± 1.5 mm) outside diameter tubing with a section 2.0 ± 0.2 in. (50 ± 5.0 mm) long and 1.5 ± 0.2 in. (38 ± 5 mm) wide cut away from the center portion of the tubing. See Fig. 1 and Fig. 2. The sample holder should be constructed in a manner that will permit



FIG. 2 Cylinder Configuration

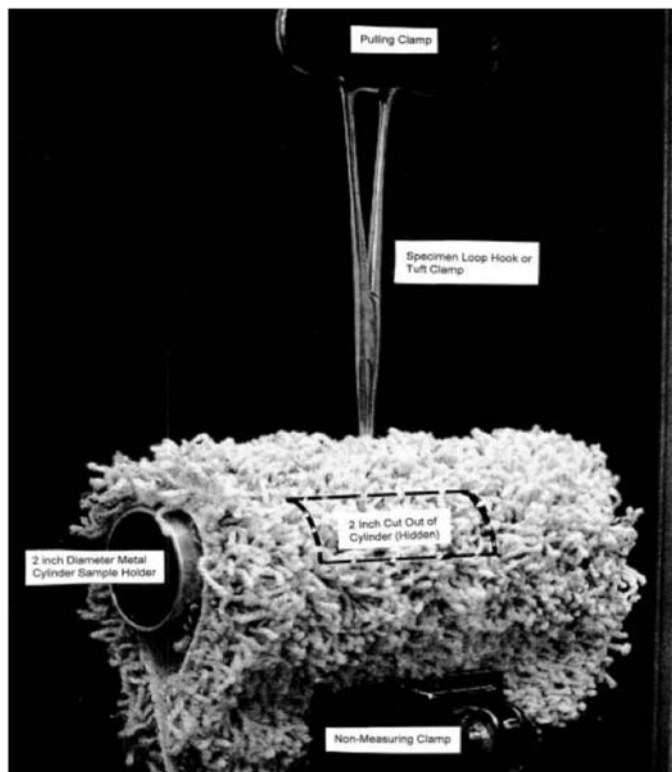


FIG. 1 Relative Position of Cylinder Opening, Cylinder, the Cylinder, Hook or Tuft Clamp and the Carpet Sample

clamping the test sample in the non-measuring clamp of the tensile testing machine or replacement of the non-measuring clamp by the sample holder.

6.4 *Tuft Clamp*, for use with a cut pile specimen. The clamp is a tweezer-like device that can be used to grip a single tuft tightly enough to ensure removal from the sample without slippage. The gripping of the tuft by the tuft clamp is shown in Fig. 3. Alternatively, a hemostat⁴ can be used.

6.5 *Loop Hook*, for use with loop pile specimen. The hook should be designed to readily pass through a tufted loop. The hook should be made of steel wire having a diameter of at least $1/32$ in. (0.8 mm). The wire must be constructed so that it can be hooked into the test specimen and then clamped/attached to, or replace, the measuring clamp of the test machine. (See Fig. 4).

⁴ Hemostats suitable for this purpose can be obtained from many laboratory equipment suppliers.

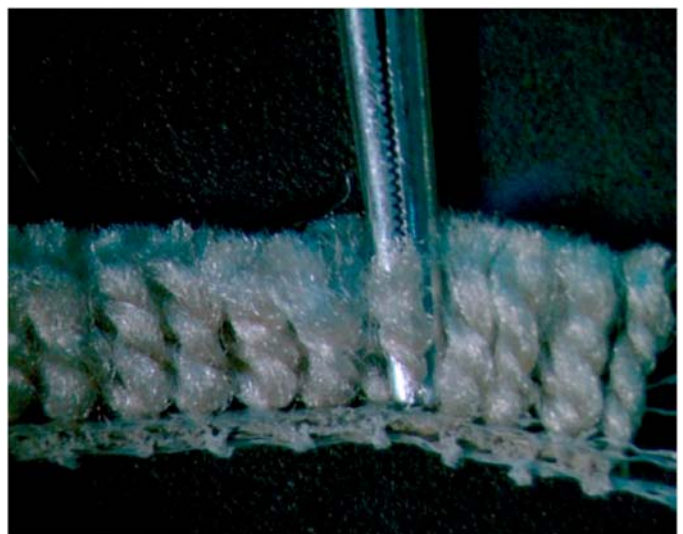


FIG. 3 Tuft Clamp Device Gripping Tuft Leg