



Designation: D3936 – 17

Standard Test Method for Resistance to Delamination of the Secondary Backing of Pile Yarn Floor Covering¹

This standard is issued under the fixed designation D3936; 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.

1. Scope

1.1 This test method covers the measurement of the resistance to delamination of the secondary backing applied to some pile yarn floor coverings.

1.2 This test method is applicable to all backings including natural manufactured fibers or attached cushion.

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.*

1.5 *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](#)

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

[D4697 Guide for Maintaining Test Methods in the User's Laboratory \(Withdrawn 2009\)](#)³

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

[E177 Practice for Use of the Terms Precision and Bias in](#)

ASTM Test Methods

3. Terminology

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

3.1.1 The following terms are relevant to this standard: attached cushion, carpet, constant-rate-of-extension, finished, finished pile yarn floor covering, floor covering, peak force, pile, pile yarn floor covering, resistance to delamination, secondary backing, textile floor covering, tufted fabric.

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

4. Summary of Test Method

4.1 A specimen is separated manually for a distance of about 1.5 in. (38 mm). Each layer then is placed in opposing clamps of a tensile tester, and the force to continue the separation for a specified distance is recorded. The peak forces in specified length intervals are averaged and the resistance to delamination calculated.

5. Significance and Use

5.1 This test method is used for acceptance testing of commercial shipments. Comparative tests as directed in [5.2](#) may be advisable.

5.2 In a case of a dispute arising from differences in reported test results when 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 for the investigation of bias. As a minimum, the two parties should take a group of test samples that are as homogenous as possible and are from a lot of material of the type in question. The test samples then should be assigned randomly in equal numbers to each laboratory for testing. The average results from the two laboratories should be compared using a statistical 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 with consideration to the known bias.

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.

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

5.3 This test method is useful to evaluate quality and cost control during the manufacture of pile yarn floor covering. Both appearance and performance of the pile floor covering can be affected by delamination of the secondary backing.

6. Apparatus

6.1 *Tensile Testing Machine*—A constant-rate-of extension (CRE) type conforming to Specification **D76** with a constant rate of speed of 12 ± 0.5 in./min (304 ± 10 mm/min) is preferred. A constant-rate-of-traverse (CRT) type tensile testing machine conforming to Specification **D76** and operated at the same speed is permitted. There may be no overall correlation with CRE-type and CRT-type testing machines. Consequently, the two machines cannot be used interchangeably. In case of controversy, the CRE-type testing machine shall prevail.

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 *Tape*, self adhering, cloth reinforced tape has been found suitable.

7. Sampling

7.1 *Lot Sample*—As a lot sample for acceptance testing, take at random the number of rolls or pieces of pile yarn floor covering as directed in an applicable material specification or other agreement between the purchaser and the supplier. Consider the rolls or pieces of pile yarn floor covering to be the primary sampling units. In the absence of such an agreement, take one roll or piece from the lot to be tested.

NOTE 1—An adequate specification or other agreement between the purchaser and supplier requires taking into account the variability between rolls or pieces of pile yarn floor covering and between specimens from a roll or pieces of pile yarn floor covering to provide a sampling plan with a meaningful producer's risk, consumer's risk, acceptable quality level, and limiting quality level.

7.2 *Laboratory Sample*—For acceptance testing, take a laboratory sampling unit that is a minimum of 18 in. (457 mm) in the machine direction by full width (cross machine direction) from each roll or piece in the lot sample.

7.3 *Test Specimens*—From each laboratory sampling unit, cut three specimens with the longer direction parallel to the machine direction. Consider the long dimension as the direction of the test.

7.3.1 *Secondary Back of Textile Construction*—Cut the specimens 3 ± 0.08 in. by at least 6 in. (76 ± 2 mm by at least 150 mm).

7.3.2 *Attached Cushion Construction*—Cut the specimens 2 ± 0.08 in. by at least 6 in. (50 ± 2 mm by at least 152 mm).

7.3.3 *Specimen Sampling and Labelling*—Take specimens, representing a broad distribution along the length and across the width of each laboratory sampling unit. Take one specimen near each edge of the laboratory sampling unit but no nearer

the extreme edge than 5 % of its width, and take one specimen from the center area. Ensure that specimens are free of folds, creases or wrinkles. Avoid getting oil, water, grease, etc., on the specimens when handling. Label to maintain specimen identity.

8. Conditioning

8.1 Condition and determine that moisture equilibrium for testing has been attained as directed in Practice **D1776**.

9. Preparation of Specimens

9.1 At one end of the specimen, manually separate the secondary backing from the pile yarn floor covering for approximately 1.5 in. (38 mm).

9.2 Cover the attached cushion side of each test specimen with self-adhering cloth reinforced tape. At one end of the test specimen, manually separate the attached cushion from the test specimen for approximately 1.5 in. (38 mm).

10. Preparation and Verification of Apparatus Systems

10.1 *Preparation of Tensile Testing Machine:*

10.1.1 Prepare the machine according to the manufacturer's instructions and using the conditions given in **10.1.2 – 10.2.2**.

10.1.2 Set the distances between the clamps at 1.0 ± 0.05 in. (25.4 ± 1 mm). Select the full-scale force range of the testing machine such that the maximum force occurs between 15 and 85 % of full-scale force. Verify the testing machine for this range.

10.1.3 Select the testing machine speed of 12 ± 0.5 in./min (304 ± 10 mm/min).

10.1.4 When using a microprocessor automatic data gathering system, set the appropriate parameters as defined in the manufacturer's instructions.

10.2 *Verification of the Total Operating System of the Apparatus:*

10.2.1 Verify the total operating system, for example, loading, clamping, and recording or data collection, whenever there are changes in the loading system, especially an increase, or clamping mechanism by testing a control material.

10.2.2 Compare the data with the previous data, if the average is outside the tolerances established, and recheck the total system to locate the cause of the deviation (see Guide **D4697**).

11. Procedure

11.1 Mount the loose end of the secondary backing or attached cushion, as applicable, in the stationary clamp jaws and the other loose end of the specimen in the movable clamp. Apply uniform tension across the clamp width of the specimen (see **Fig. 1**).

11.2 Start the machine and autographic recording device. If the attached cushion breaks, record that the resistance to delamination exceeds the breaking force of the cushion.

11.3 A trace from the recording device consisting of a series of peaks, each representing the force at which the layers have separated, and troughs corresponding to the fall back of the force will be generated. After the initial peak is recorded and an additional 3 in. (76 mm) of the specimen has been delaminated,

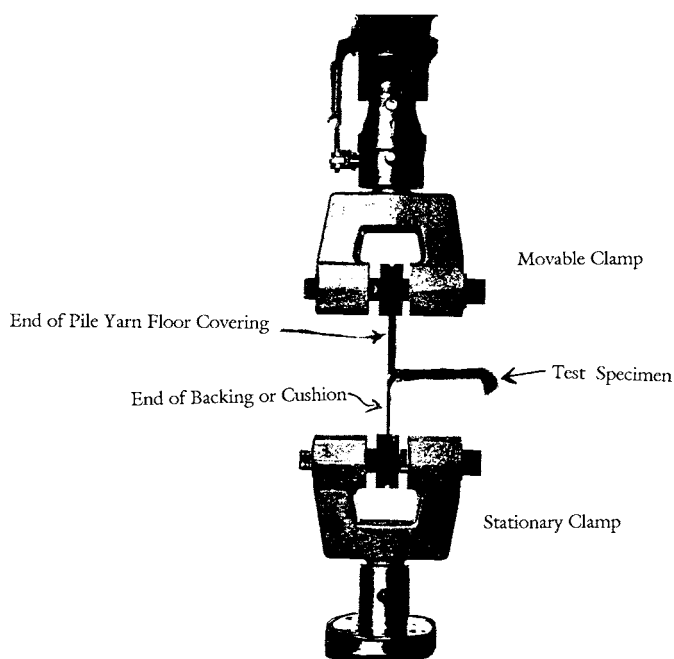


FIG. 1 Specimen Mounted in Clamps

(this represents approximately 6.0 in. (152 mm) of jaw separation), stop the machine, and return the crosshead to the start position.

11.4 Remove the delaminated specimen from the clamps, and test the remaining specimens.

12. Calculation

12.1 From the recording device, determine the value of the highest peak in each 0.5-in. (13 mm) interval of delamination, ignoring the initial peak force (which represents approximately 1.0 in. (25 mm) of jaw separation). Average these five peak forces for each specimen to the nearest 0.1 lbf (0.5 N) (see Fig. 2).

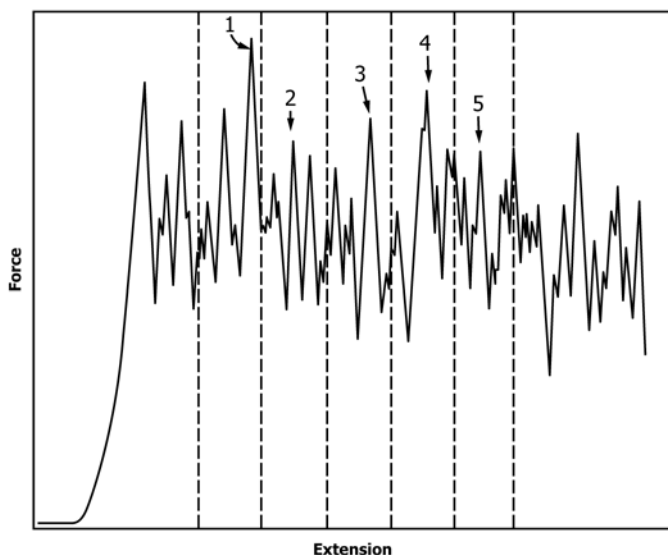


FIG. 2 Typical Autographic Trace Showing Highest Peaks in 6 Length Intervals

12.2 Calculate the resistance to delamination for each specimen to the nearest 0.1 lbf (0.5 N)/unit width, using the following equation:

$$D = F/W \tag{1}$$

where:

D = resistance to delamination, lbf/in. (N/mm),
F = average peak force for the specimen, lbf (N), and
W = specimen width, 3 in. (76 mm).

12.3 Calculate the average resistance to delamination for each laboratory sampling unit and for the lot, or both.

12.4 Calculate the standard deviation or coefficient of variation, or both, if requested.

13. Report

13.1 State that the resistance to delamination was determined as directed in Test Method D3936. Describe the material or product sampled and the method of sampling used.

13.2 Report the following information:

13.2.1 The resistance to delamination for each specimen and laboratory sampling unit and for the lot.

13.2.2 On attached cushion specimens, if the cushion breaks, report the peak force and note that the resistance to delamination exceeds the breaking force of the cushion.

13.2.3 If calculated, the standard deviation, or coefficient of variation, or both.

13.2.4 Record the type of testing machine.

14. Precision and Bias

14.1 The precision of this test method is based on an interlaboratory study of D3936, Test Method for Resistance to Delamination of the Secondary Backing of Pile Yarn Floor Covering, conducted in [2011]. Five laboratories participated in this study. All of the laboratories reported three replicate test results for five different carpet constructions. Every “test result” reported represents the average of three readings. Except for the use of only five laboratories, Practice E691 was followed for the design and analysis of the data; the details are given in and ASTM Research Report.⁴

14.1.1 *Repeatability limit (r)*—Two test results obtained within one laboratory shall be judged not equivalent if they differ by more than the “*r*” value for that material; “*r*” is the interval representing the critical difference between two test results for the same material, obtained by the same operator using the same equipment on the same day in the same laboratory.

14.1.1.1 Repeatability limits are listed in Table 1.

14.1.2 *Reproducibility limit (R)*—Two test results shall be judged not equivalent if they differ by more than the “*R*” value for that material; “*R*” is the interval representing the critical difference between two test results for the same material, obtained by different operators using different equipment in different laboratories.

14.1.2.1 Reproducibility limits are listed in Table 1.

⁴ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:D13-1135.

TABLE 1 Delamination Strength (lbs per in²)

Carpet Specimen	Average ^A	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	\bar{x}	s_r	s_R	r	R
MultiLevel Loop	4.66	0.36	0.51	1.00	1.42
Beige LCL	4.52	0.42	0.70	1.19	1.96
Green Brown Cut Pile	3.05	0.46	0.71	1.28	2.00
Light Beige Cut Pile	2.77	0.23	0.51	0.65	1.42
Light Brown Cut Pile	2.80	0.49	0.75	1.37	2.09
Population Average Results				1.10	1.78

^A The average of the laboratories' calculated averages.

14.1.3 The above terms (repeatability limit and reproducibility limit) are used as specified in Practice E177.

14.1.4 Any judgment in accordance with statements 14.1.1 and 14.1.2 would normally have an approximate 95 % probability of being correct, however the precision statistics obtained in this ILS must not be treated as exact mathematical quantities which are applicable to all circumstances and uses. The limited number of materials tested and laboratories reporting results guarantees that there will be times when differences greater than predicted by the ILS results will arise, sometimes with considerably greater or smaller frequency than the 95 % probability limit would imply. The repeatability limit and the reproducibility limit should be considered as general guides,

and the associated probability of 95 % as only a rough indicator of what can be expected.

14.2 *Bias*—At the time of the study, there was no accepted reference material suitable for determining the bias for this test method, therefore no statement on bias is being made.

14.3 The precision statement was determined through statistical examination of 75 results, from five laboratories, on five materials.

15. Keywords

15.1 carpet; peel; pile yarn floor covering; strength delamination; textile floor covering

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