Method for

Designation of ticket numbers of industrial sewing threads

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Numérotation par étiquetage des fils à coudre industriels

Verfahren zur Bestimmung der Etikettennumerierung (Titer) bei technischen Nähgarnen

Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Textiles and Clothing Standards Policy Committee (TCM/-) to Technical Committee TCM/28, upon which the following bodies were represented:

British Association of Clothing Machinery Manufacturers
British Clothing Industry Association
British Polyolefin Textiles Association
Consumer Policy Committee of BSI
Flax and Linen Association (GB)
Furniture Industry Research Association
Linen Sewing Thread Manufacturers' Association
Man-made Fibres Producers' Committee
Ministry of Defence
SATRA Footwear Technology Centre
Textile Institute
Textile Research Council

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Contents

Foreword

This British Standard has been prepared under the direction of the Textiles and Clothing Standards Policy Committee and supersedes BS 4134 : 1983 which is withdrawn.

The principal changes introduced in this revision are that the standard has been revised as a method of designation, the definitions have been deleted and the tables of ticket numbers deleted.

When introducing new threads, it is recommended that manufacturers adopt ticket numbers in accordance with this standard. Some existing sewing threads have ticket numbers that currently enjoy commercial recognition but are not in line with this British Standard. These arise because of changes in the designation of the linear density of available yarns since the first publication of this standard in 1967.

Attention is also drawn to BS 947, which gives information relating to the Tex System and other traditional systems for designating linear density of yarns, and to BS 4985, which provides a conversion table to rounded values in the Tex System.

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Method

1 Scope

This British Standard describes a method for designation of ticket numbering of industrial sewing threads.

It covers sewing threads made wholly or in part from man-made fibres and sewing threads made from cotton.

Formulae for deriving 3-ply metric and 3-ply cotton equivalents, on which the BS ticket numbers are based, are given.

NOTE. The titles of the publications referred to in this standard are listed on the inside back cover.

2 Definitions

For the purposes of this British Standard the definitions given in BS 6157 apply.

3 Principle

The BS ticket numbers of sewing threads are designated from the total nominal input linear density of all the component yarns expressed as 3-ply equivalents.

4 Designation of ticket number

4.1 Designation

The ticket number shall be designated from the total nominal input decitex value regardless of thread construction (1-ply, 2-ply, 3-ply, etc.) converted to the 3-ply relevant equivalent as described in clause **6**. It shall be rounded as specified in **4.2** and **4.3**.

4.2 Man-made fibre threads

Man-made fibre threads shall be rounded as follows:

(a) for ticket numbers finer than 160, round down to the nearest multiple of 20;

(b) for ticket numbers 80 to 160, round down to the nearest multiple of 10;

(c) for ticket numbers 30 to 75, round down to the nearest multiple of five;

(d) for ticket numbers 18 to 28, round down to the nearest even number;

(e) for ticket numbers 17 and coarser, round down to the nearest whole number.

4.3 Cotton threads

Cotton threads shall be rounded as follows:

(a) for ticket numbers finer than 90, round off to the nearest multiple of 20;

(b) for ticket numbers 40 to 90, round off to the nearest multiple of 10;

(c) for ticket numbers coarser than 40, round off to the nearest even number.

5 Conversion factors

5.1 Metric count from decitex for man-made threads

For man-made threads, the metric count is given by the following:

$$\text{metric count (in N·m)} = \frac{10\,000}{\text{total nominal input linear density (in dtex)}}$$

5.2 Cotton count from decitex

For cotton threads, the cotton count is given by the following:

$$\text{cotton count (in Ne}_C\text{)} = \frac{5905}{\text{total nominal input linear density (in dtex)}}$$

6 Formula for deriving 3-ply metric count equivalents

6.1 Formula

For man-made sewing threads calculate an approximation of the 3-ply metric equivalent from the following:

$$\text{3-ply metric equivalent} = \text{metric count (in N·m)} \times 3$$

Therefore

$$\text{3-ply metric equivalent} = \frac{30\,000}{\text{total nominal input linear density (in dtex)}}$$

6.2 Sample calculation

The following is an example of how to calculate the BS ticket number for a 3-ply thread:

$$\text{total input (in dtex)} = 235 \text{ dtex} \times 3 \text{ (ply)}$$

$$\text{3-ply metric equivalent} = \frac{30\,000}{235 \times 3}$$

$$= 42.55$$

and BS ticket number = 40 (42.55 rounded down to nearest 5)

7 Formula for deriving 3-ply cotton count equivalents

7.1 Formula

For cotton sewing threads, calculate an approximation of the 3-ply cotton count equivalent from the following:

$$\text{3-ply cotton count equivalent} = \text{cotton count (in Ne}_C\text{)} \times 3$$

Therefore

3-ply cotton count equivalent =

$$\frac{17\,715}{\text{total nominal input linear density (in dtex)}}$$

7.2 Sample calculation

The following is an example of how to calculate the BS ticket number for a 3-ply thread:

total input (in dtex) = 100 dtex × 3 (ply)

3-ply cotton equivalent = $\frac{17\,715}{100 \times 3}$

= 59.05

and BS ticket number = 60 (59.05 rounded off to nearest 10)