British Standard Method for

Numerical designation of fabric faults by visual inspection

Méthode de désignation numérique des défauts des étoffes visibles à l'œil nu

Verfahren zur numerischen Bezeichnung von Gewebefehlern bei Sichtprüfung

Foreword

This British Standard has been prepared under the direction of the Fibres, Yarns, Fabrics and Production Standards Committee.

A variety of differing methods of assessing and expressing fabric faults is currently in use, and having reviewed these it was agreed that a single method which is applicable to a wide range of fabrics be published as a British Standard to improve communications. It is hoped that this will be viewed as provision of a common language between fabric producers and fabric users.

This standard is intended to be used as a means for the numerical designation of fabric 'quality' insofar as the occurrence of faults is concerned. The standard also allows the position of faults to be identified. No acceptable levels are given or suggested since these will depend on the end-use to which the fabric is to be put and should be agreed between the interested parties. The method is particularly useful for the comparison of similar fabrics for a specific end-use from different batches or sources.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

1. Scope

This British Standard describes a method for the numerical designation of faults in finished fabrics by visual inspection and gives a means of indicating the position of faults.

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

2. Definition

For the purposes of this British Standard the following definition applies.

fabric fault. Any feature within the usable width of a fabric which, if it appeared in a finished product, would downgrade that product.

NOTE. This definition does not cover variations in length or width of fabrics which can be determined using BS 1930 and BS 1931.

3. Principle

The fabric is examined visually for faults and points are allocated depending on the dimensions and location of the faults.

4. Sampling

If a system of sample inspection is required, the interested parties shall agree on AQL levels (see BS 6001). The pieces examined shall be identified.

5. Procedure and expression of results

5.1 Numerical designation of faults. The threshold limit for the minimum size of fault shall be agreed between the interested parties.

Examine the face side of the fabric unless otherwise requested by the purchaser. Use of an inspection machine sufficiently wide to enable the fabric to be examined full

width is acceptable. Note the occurrence of any fabric faults (see clause 2) and assign numerical values to each fault, depending on the size of the fault in any direction as follows:

from the agreed threshold limit up to 25 cm in any direction: 1 point;

for every further 25 cm or part thereof in any direction: add 1 further point.

In assigning points, no more than 4 points per m^2 shall be allocated regardless of the number or size of individual faults, and no account shall be taken of a fault within 50 cm on either side of an extended or running fault, or within 25 cm of a 1 point fault.

Record the frequency of full width cuts and, subject to agreement, any other major fault.

Record the length of the piece.

Express the result as the number of points per 100 m^2.

5.2 **Indication of the position of faults.** By agreement, if required, indicate the positions of faults by inserting strings, tags or markers at the selvedge of the piece subject to the following.

(a) Two or more faults on the same lateral axis shall be shown by one indicator only*.

(b) Two or more faults within 25 cm on the longitudinal axis shall be shown by one indicator only*.

6. Report

The report shall include the following particulars:

(a) the number of this British Standard, i.e. BS 6395;

(b) the threshold limit for minimum fault size;

(c) the length of the piece;

(d) the fault rating in points per 100 m^2;

(e) the number of full width cuts, and, if required, the number of any other major faults;

(f) if required, the number of faults of each point value;

(g) if required, the number of strings per piece.

*In some cases this means that the number of indicators per piece will be less than the number of faults per piece.