BRITISH STANDARD

BS 7141 :
Part 1 : 1991

Narrow fabrics

Part 1. Specification for polyamide and polyolefin woven tapes and webbings

Tissus étroits
Partie 1. Rubans et sangles en polyamide et polyoléfine tissés

Feste Gewebe
Teil 1. Webbänder und Gurtbänder aus Polyamid und Polyolefin

BSI
STANDARDS

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/7, upon which the following bodies were represented:

British Narrow Fabrics Association
British Polyolefin Textiles Association
Consumer Policy Committee of BSI
Home Laundering Consultative Council
Man-made Fibres Producers' Committee
Ministry of Defence
SATRA Footwear Technology Centre
Society of Dyers and Colourists
Textile Institute

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Specification

1 Scope

This Part of BS 7141 specifies requirements for polyamide and polyolefin woven narrow fabrics (tapes and webbings) for use in the public sector and for general use.

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 Part of BS 7141 the following definitions apply.

2.1 batch

A definite quantity of some commodity produced under presumed uniform conditions.

2.2 beading

A feature of narrow fabrics in which one or both of the selvedges stand proud of the fabric, usually due to the edge lock threads being unduly thick.

NOTE. It is usually classed as a defect, but sometimes, in special cases, is required as a feature of the fabric.

2.3 bias

Curvature exhibited by a narrow fabric in the horizontal plane when laid flat on a horizontal surface.

2.4 narrow fabric

Any fabric made by interlacing fibres or yarns which (in the UK) does not exceed 450 mm in width. In the USA and for the purposes of the Combined Nomenclature of the European Community for tariff purposes the upper limit of width is 300 mm. A characteristic of a narrow fabric is that its edges are an essential feature.

2.5 needleloom

A shuttleless loom in which the weft is drawn from a stationary supply and introduced into the shed in the form of a double-pick by a weft insertion needle. The weft is retained at the opposite selvedge by the action of knitting, or by introduction of a locking thread from a separate supply.

2.6 needleloom selvedge

The selvedge opposite to that from which the weft is inserted in a narrow fabric needleloom.

NOTE 1. Usually this selvedge is formed by knitting together successive double-pick weft loops, sometimes in combination with, or exclusively by means of a locking thread from a stationary supply. Alternatively, the locking thread may be supplied from a small spool arranged to be passed through the extremities of the weft loops.

NOTE 2. A needleloom selvedge system is illustrated in figure 1.

2.7 pick

A single operation of the weft insertion mechanism in weaving. Thus the 'double-pick' inserted by a needleloom is defined as one pick.

2.8 selvedge

When used without qualification, a longitudinal edge of a fabric formed during weaving, with the weft not only turning at the edges but also passing continuously across the width of the fabric from edge to edge.

2.9 shuttleloom

A weaving machine that uses a shuttle to insert the weft.

2.10 stuffer thread

A thread incorporated in a woven, knitted or braided structure, sometimes for the purpose of limiting its extension, sometimes to provide bulk and strength.

2.11 spirality

Twisting of a narrow fabric around the vertical axis when held at one end in the vertical position.

2.12 tape

A woven fabric, generally plain-weave, used in non-loadbearing applications and for the reinforcing of fabrics to resist wear and deformation.

2.13 V draft

In twill fabrics having alternate right and left twills forming a series of Vs, the number of V formations across the fabric width.

2.14 weave

The pattern of interlacing of warp yarns and weft yarns in a woven fabric.

2.15 webbing

A woven narrow fabric, the prime function of which is loadbearing.

NOTE. Webbing is generally of a coarse weave and often has multiple plies.

3 Sampling

Samples shall not be taken from the first 3 m of textile manufactured. Sampling shall be as follows.

(a) Woven fabrics, loomstate.

(1) For fabrics woven from beams, take one sample from one piece per beam.

NOTE. The quantity of fabric produced from one weaver's beam or from a creel contains the same warp yarns throughout and is woven in one particular form. As such, it constitutes a unique batch or unit of production, provided that weft yarn of substantially consistent quality has been used. If a fresh delivery of weft yarn of unproved quality is introduced during weaving the warp, a fresh batch has been created and further samples for complete fabric tests become necessary. Manufacturers should maintain continuous quality control of weft yarn in respect of the relevant properties, e.g. type of fibre, linear density, strength.

(2) For fabrics woven from creels, take one sample from one piece from each continuously woven length not exceeding 5000 m.

Foreword

This Part of BS 7141 has been prepared under the direction of the Textiles and Clothing Standards Policy Committee. It includes the woven tapes and webbings falling within the scope of this standard that were previously specified by the Ministry of Defence. The standard is intended for use by the public sector when purchasing woven tapes and webbings.

Cross-references are given in appendix A, and information specifically required by the Ministry of Defence and which was previously contained in Defence Standards is given in appendix B. Appendix C gives yarn constructions used to manufacture to the standard patterns. Appendix D gives recommendations for product properties which are desirable but which, with present technology, cannot be specified objectively.

Other Parts of BS 7141 are as follows:

Part 2 Specification for cotton webbings for personal load carrying purposes

Part 3 Specification for wool tapes

Part 4 Specification for woven elastic webbings containing natural rubber

Part 5 Specification for elastic flat braids containing natural rubber

Part 6 Specification for laces for footwear and other purposes.

Compliance with a British Standard does not of itself confer immunity from legal obligations. In particular attention is drawn to The Textile Products (Indications of Fibre Content) Regulations S.I 1986 No. 26.

(3) If several narrow fabrics are woven simultaneously in the same loom, take one sample from each continuously woven length not exceeding 5000 m.

(b) Woven fabrics, piece treated.

(1) For woven fabrics already proved by test in loomstate, take one sample from one piece per finisher's batch per fabric type and manufacturer.

(2) For woven fabrics not subject to test in loomstate, take one sample from one piece per weaver's beam or each continuously woven length not exceeding 5000 m per finisher's batch.

(3) If a finisher's batch consists of further pieces from a weaver's beam, or from continuously woven lengths previously proved by test in the finished condition, take one sample from one piece from the finisher's batch.

In the event of dispute, samples shall be pre-conditioned for 4 h at a relative humidity not exceeding 10 % and a temperature not greater than 50 °C, and subsequently exposed to the standard temperate atmosphere for testing textiles, as defined in BS 1051, for not less than 24 h and tested without removal from that atmosphere.

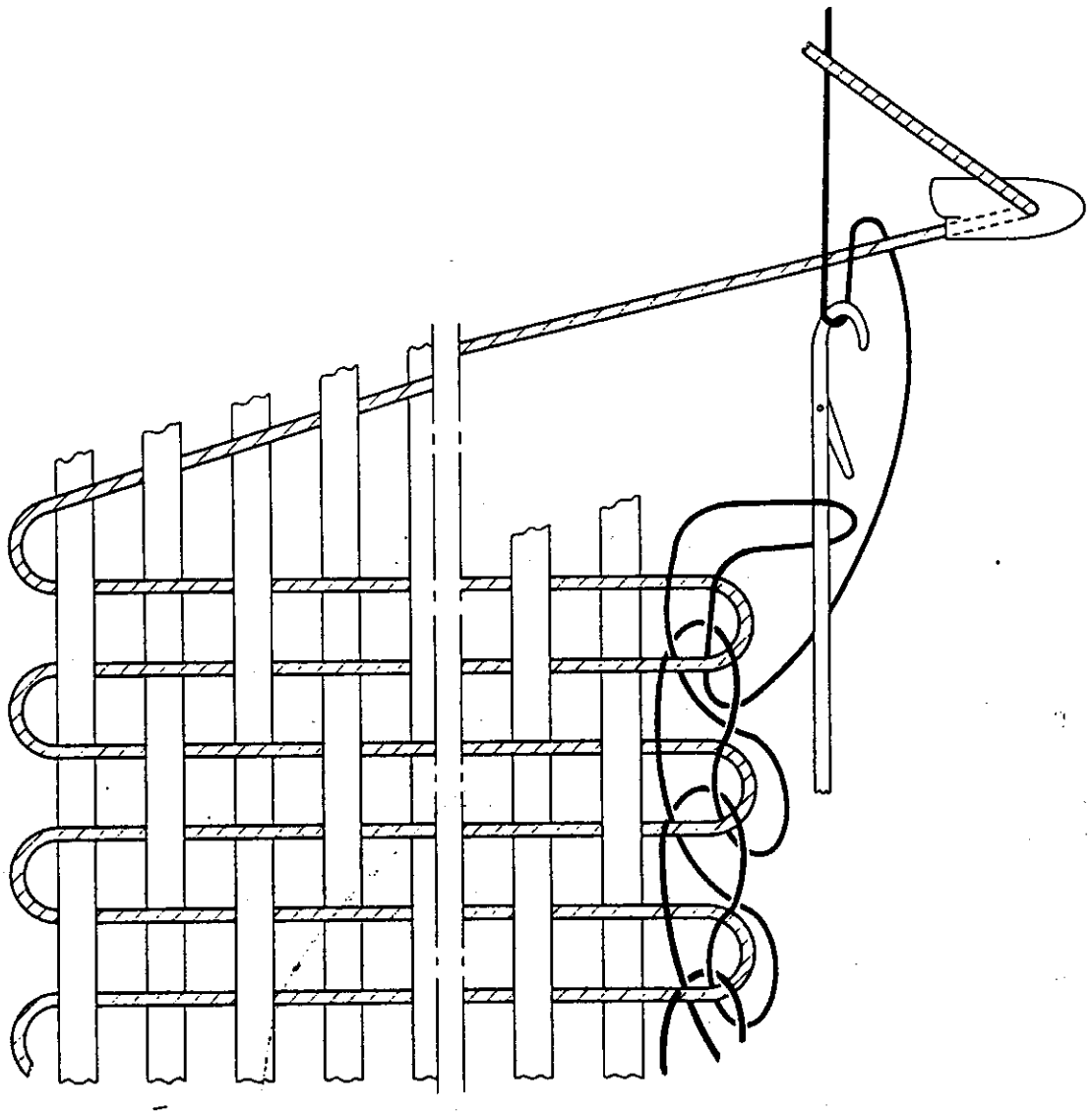

Figure 1. Needleloom selvedge system

4 Polyamide (nylon) webbings

4.1 Yarn

The webbings shall be manufactured from bright continuous filament polyamide 6.6 yarn. The yarn shall not be sized.

NOTE. Yarn construction details are given in appendix C.

4.2 Construction and properties

The fabrics shall be woven either in a shuttleloom, or in a needleloom manner. In the latter case the weaving used shall be one of the following:

(a) with spool type interlocking in the body of the webbing as shown in figure 2;

(b) the weft knitted with a locking thread as shown in figure 3;

(c) the weft secured by two knitted locking threads as shown in figure 4.

NOTE. The knitted edge of a needleloom construction should be uniform and even.

The weave description and fabric properties shall be as given in table 1.

4.3 Dyeing

Sulphur black dyes shall not be used.

4.4 Colour fastness

The colour fastness of the yarn or finished fabric shall be as given in table 2.

NOTE. If the colour fastness of the yarn has been tested prior to manufacture, there is no need to carry out further tests after manufacture.

4.5 Dimensional stability

The dimensional stability of the fabric as supplied shall be such that, when tested in accordance with appendix E, the shrinkage of the length shall not exceed 2 %.

4.6 pH of aqueous extract

The pH of the aqueous extract, when determined in accordance with the hot water method described in BS 3266, shall be not less than 5 and not more than 8.

4.7 Extension

The minimum extension of pattern number 5447 fabric, when tested in accordance with appendix F, shall be not less than 10 %.

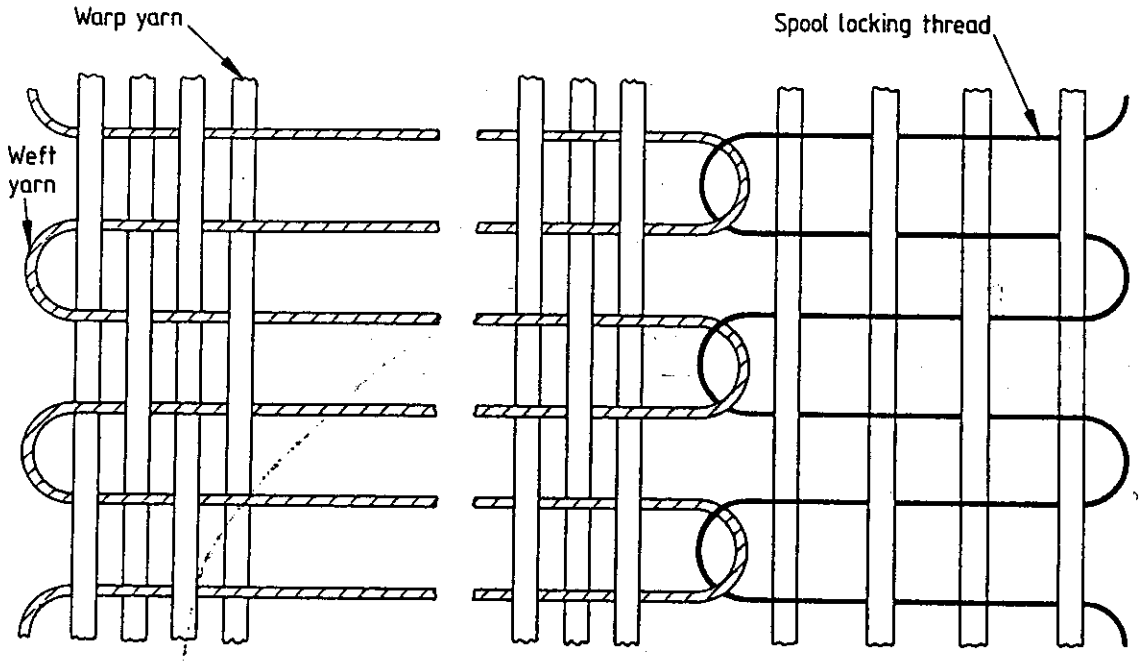

Figure 2. Needleloom construction with spool type interlocking

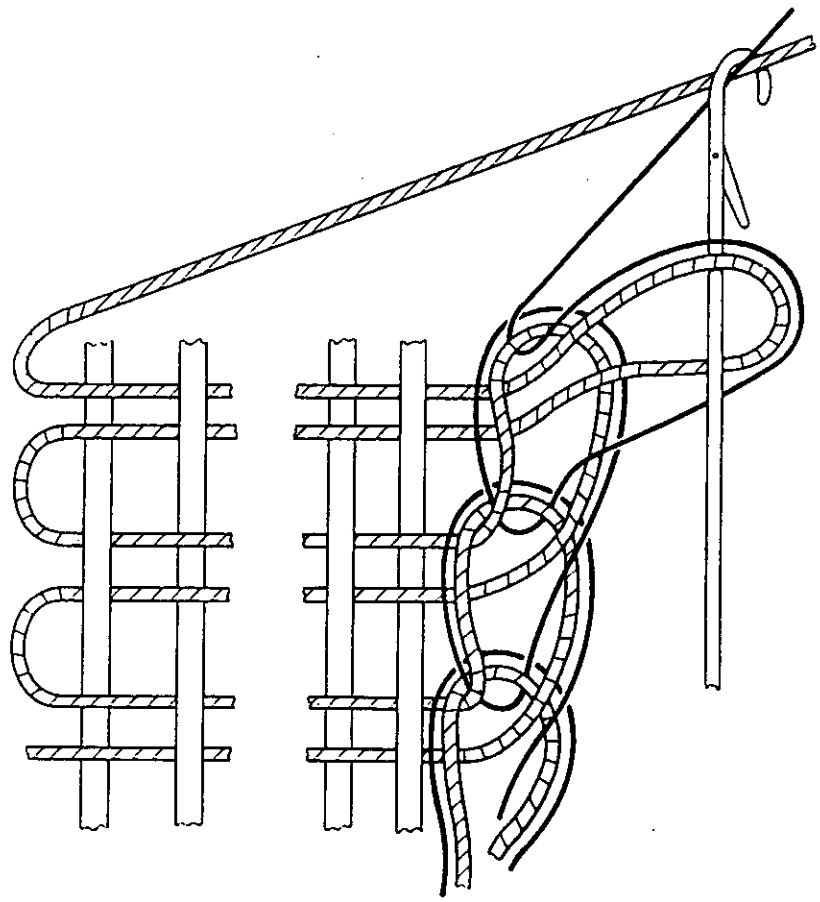

Figure 3. Needleloom construction with the weft knitted with a locking thread

5 Polyethylene (polyolefin) webbings

The webbing shall be woven from manufactured yarn of round cross section of 0.375 mm diameter spun from high density polyethylene (specific gravity 0.94 to 0.96) and shall be woven as given in table 3 and shown in figure 5. The webbing shall be as given in table 3.

NOTE. If a white web is required the pigmentation should be such that there is no yellowing in use or in storage.

6 Marking

Tapes and webbings shall be provided with a ticket or other means of marking carrying the following information:

(a) the number and date of this Part of BS 7141, i.e. BS 7141 : Part 1 : 1991[1)];

(b) the reference number of the product in accordance with table 1;

(c) the name, trademark or other means of identification of the manufacturer.

NOTE. For MoD contracts, additional information will include the contract number, the NATO stock number where appropriate (see table 4), and the pattern number (see table 1).

[1)] Marking BS 7141 : Part 1 : 1991 on or in relation to a product represents a manufacturer's declaration of conformity, i.e. a claim by or on behalf of the manufacturer that the product meets the requirements of the standard. The accuracy of the claim is therefore solely the responsibility of the person making the claim. Such a declaration is not to be confused with third party certification of conformity, which may also be desirable.

Table 1. Fabric construction and properties for polyamide (nylon) webbings

Pattern number	Width (determined in accordance with BS 1930)	Number of warp threads in width			Picks per 100 mm (± 10)	Weave details	Nominal mass per unit length	Nominal thickness[1]	Minimum breaking strength[2]
		Main warp	Selvedge	Binder					
	mm						g/m	mm	N
9350	12 ± 1	59	—	14	170	Two ply plain with binders weaving 2 × 2 alternately	10.0	1.20	3 500
9350	19 ± 1	95	—	22	170	Two ply plain with binders weaving 2 × 2 alternately	17.0	1.20	4 500
9350	25 ± 1	123	—	29	170	Two ply plain with binders weaving 2 × 2 alternately	22.0	1.20	7 000
9351	25 ± 1	167	—	20	120	Two ply plain with binders weaving 1 × 1	27.0	1.55	9 000
9352	50 ± 2	264	—	—	80	2 × 2 V twill	62.5	1.50	26 500
9353	100 ± 3	350	—	—	170	2 × 2 twill double V	49.0	0.76	18 000
9354	32 ± 2	184	11	46	130	Two ply plain with binders weaving 1 × 1: 54 mm solid, 22 mm buttonhole, 57 mm solid. Buttonhole offset 6 mm from the centre	48.0	2.03	4 500
9355	64 ± 2	351	—	—	140	Two ply plain tubular	56.0	1.50	18 000
9438	25 ± 1	80	—	—	210	2 × 2 twill	3.5	0.45	1 070
9439	19 ± 1	94	—	—	210	2 × 2 V twill	3.9	0.45	1 400
9440	25 ± 1	130	—	—	210	2 × 2 V twill	5.0	0.45	1 870
9442	12 ± 1	50	—	—	140	2 × 2 V twill	7.0	1.00	2 250
9442	19 ± 1	74	—	—	140	2 × 2 V twill	12.0	1.00	3 350
9442	25 ± 1	100	—	—	140	2 × 2 V twill	15.0	1.00	4 500
9442	38 ± 2	150	—	—	140	2 × 2 V twill	22.0	1.00	6 675
9442	44 ± 2	176	—	—	140	2 × 2 V twill	26.0	1.00	7 790
9442	50 ± 2	200	—	—	140	2 × 2 V twill	30.0	1.00	9 000
9442	55 ± 2	224	—	—	140	2 × 2 V twill	33.0	1.00	10 000
9442	64 ± 2	250	—	—	140	2 × 2 V twill	39.0	1.00	11 125
9442	75 ± 2	300	—	—	140	2 × 2 V twill	45.0	1.00	13 350
9442	100 ± 3	400	—	—	140	2 × 2 V twill	60.0	1.00	18 000
9443	10 ± 1	30	—	—	170	2 × 2 twill	5.0	.90	1 350
9446	38 ± 2	200	15	26	100	Two ply plain with binders weaving 2 × 2 alternately. Face and back warp yarns weaving 2 as 1. Edge warp yarns single	90.0	.00	26 500
9447	25 ± 1	180	—	—	170	See figure 5, weave A	8.0		800
9454	38 ± 2	279	—	34	100	Two ply plain with binders weaving 1 × 1	40.0	1.40	13 500
9472	32 + 1, − 2	122	40 stuffers	11	110	Two ply plain with beaded edges with binders weaving 2 × 2. Warp ends weaving 2 as 1. 6 mm beads with selvedge	76.0	—	—

[1] Measured in accordance with BS 2544 under a pressure of 20 kPa.
[2] Measured in accordance with BS 2576 using full width of sample.
NOTE. When produced on a shuttleless loom (two picks per shed), the weft yarn should be half the linear density stated and may be single or folded.

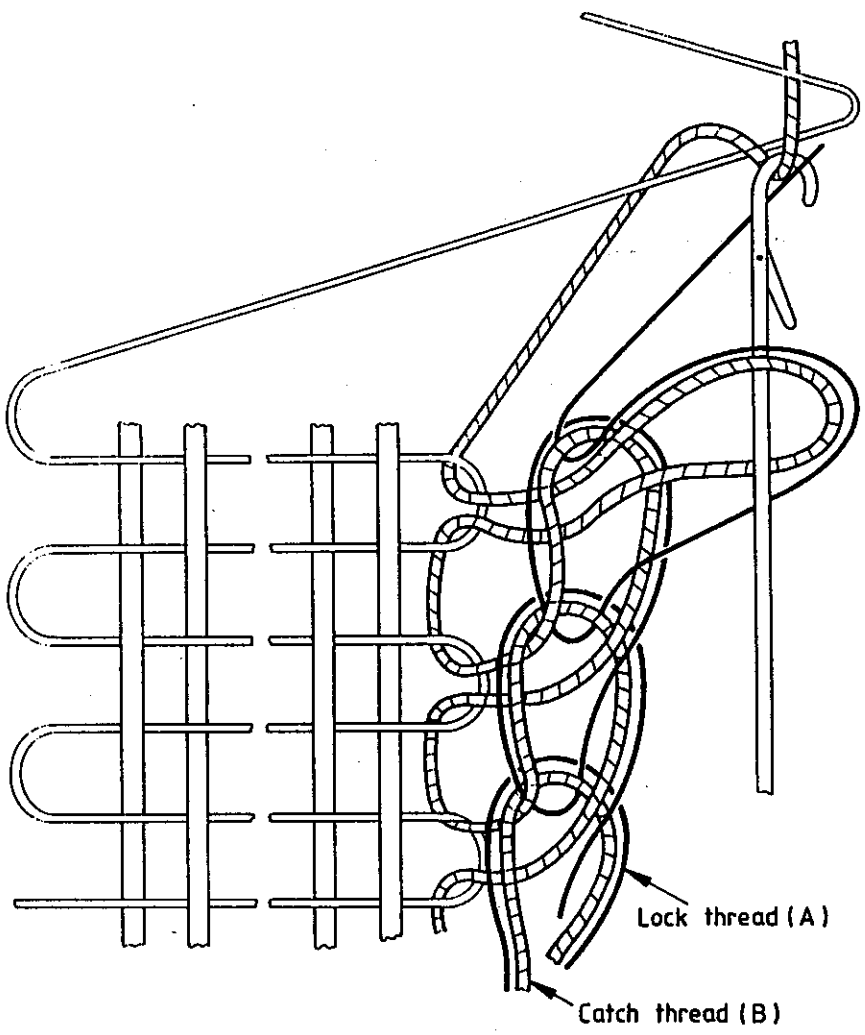

Figure 4. Needleloom construction with the weft secured by two knitted locking threads

Table 2. Minimum colour fastness ratings					
Method of test in accordance with BS 1006					
Xenon light, section B02	Rubbing, section X12	Washing, section C06, test B2S		Perspiration, section E04	
	Dry and wet	Colour change	Staining	Colour change	Staining
6	4 - 5	4 - 5	3 - 4	4 - 5	4

Table 3. Fabric construction for polyethylene webbings						
Reference number	Construction (weave description)	Width determined in accordance with BS 1930 (tolerance +0, −2)	Main warp ends	Binder ends	Extra fabric ends	Minimum picks per 100 mm (determined in accordance with BS 2862)
		mm				
PW1	4 ply (see figure 5, weave B)	57	382	46	—	236
PW2		27	174	20	—	236
PW3		19	134	15	—	236
PW4		44	294	35	—	236
PW5	2 ply (see figure 5, weave C)	32	107	24	—	141
PW6		13	47	9	—	141
PW7	Pocketed (see figure 5, weave D)	32	63	24	42	260

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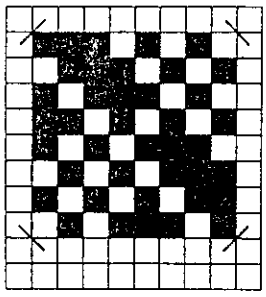
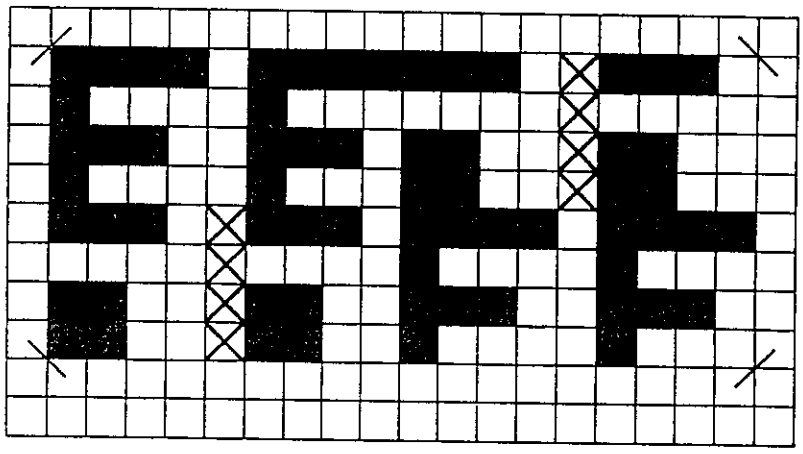


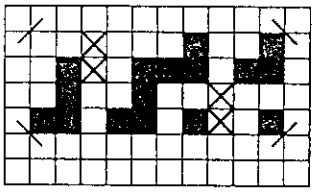
Warp up

Weave A



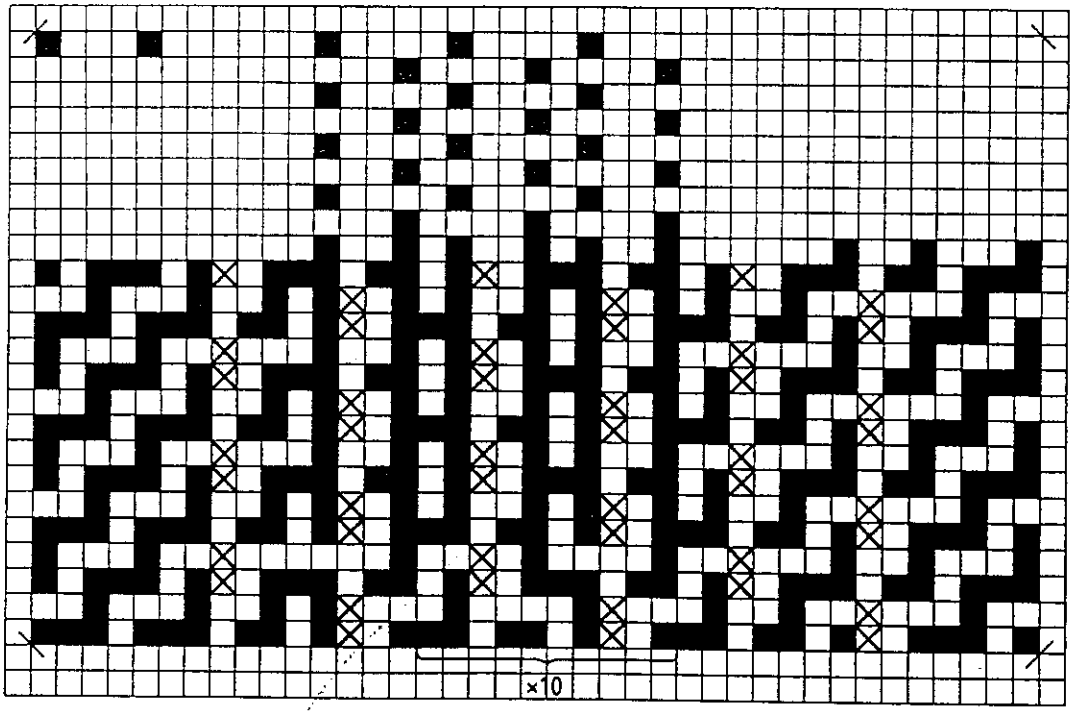
Binder

Weave B



Binder

Weave C



Weave D

Figure 5. Weave descriptions

Appendices

Appendix A. Cross-references

Cross-references between the reference numbers specified in this Part of BS 7141, the reference numbers in previous standards and NATO stock numbers are listed in table 4.

Table 4. Cross-references

Reference pattern number	Previous reference or nearest equivalent	Width	NATO stock number
		mm	
9350	UK/SC 3632E-9350	—	—
9351	UK/SC 3632E-9351	25	8305-99-135-2583
9352	UK/SC 3632E-9352	50	8305-99-135-2584
9353	UK/SC 3632E-9353	100	8305-99-135-2585
9354	UK/SC 3632E-9354	32	8305-99-135-2586
9355	UK/SC 3632E-9355	64	8305-99-135-2587
9438	UK/SC 3632E-9438	25	8305-99-136-8184
9439	UK/SC 3632E-9439	—	—
9440	UK/SC 3632E-9440	—	—
9442	UK/SC 3632E-9442	—	—
9443	UK/SC 3632E-9443	—	—
9446	UK/SC 3632E-9446	38	8305-99-136-9965
9447	UK/SC 3632E-9447	—	—
9454	UK/SC 3632E-9454	38	8305-99-137-854151- AMD 7730
9472	UK/SC 3993	32	—
PW1	UK/SC 3373A (9039)	—	8305-99-973-6060
PW2	UK/SC 3373A (9040)	—	—
PW3	UK/SC 3373A (9046)	—	—
PW4	UK/SC 3373A (9046)	—	—
PW5	UK/SC 3373A (9041)	—	—
PW6	UK/SC 3373A (9042)	—	—
PW7	UK/SC 3373A (9043)	—	—

NOTE. NATO stock numbers are for olive drab coloured polyamide webbings. AMD 7730

Appendix B. Supplementary information for MoD contracts

B.1 Standard pattern

A standard pattern, obtainable from the authority named in the tender or contract provides criteria for any properties not specified in this standard.

B.2 Non-compliance

In the event of non-compliance with the specified requirements, any resampling is at the discretion of the Quality Assurance Directorate.

B.3 Inspection

The scale of inspection and testing is at the discretion of the Quality Assurance Directorate named in the contract.

B.4 Packaging

The tape or webbing is to be delivered rolled. Packaging (preservation, identification and packing) is to be in accordance with the contract.

B.5 Delivered lengths, joins and marking of joins

The roll length will vary according to the mass per unit length of the tape or webbing but no roll is to be less than 50 m or of such a size as to be inconvenient for the user. Rolls of not more than two lengths will be accepted provided that the shorter length is not less than 10 m. The position of the cut or join is to be indicated by a marker in the selvedge and a note on the piece ticket. The number of pieces containing joins is to be indicated on the consignment documents.

NOTE. Pattern numbers 9350, 9351, 9352, 9353, 9354, 9355, 9438, 9439, 9440, 9442, 9443, 9447, and 9454 may carry a suffix letter A, B, C, D, or E, indicating that the fabric should be dyed to the colour of the standard pattern as follows:

no suffix = natural (scoured);
A = olive drab;
B = khaki;
C = navy blue;
D = blue grey;
E = fawn.

Appendix C. Yarn constructions

To assist manufacturers, yarns recommended for use in the products are given in table 5.

Table 5. Yarn construction for standard patterns

Pattern number	Warp yarn		Weft yarn						
	Main	Binder	Conventional	Shuttleless	Lock thread system				
					As shown in figure 1	As shown in figure 2	As shown in figure 3	As shown in figure 4	
								Lock (A)	Catch (B)
9350	R940/1 Z100	R940/1 Z100	R940/1 Z100	R470/1 Z150		R470/1 Z150	R235/1 Z150	R110/1 Z200	R235/1 Z150
9351	R940/1 Z100	R940/1 Z100	R1880/2 Z100	R940/1 Z100		R940/1 Z100	R470/1 Z150	R235/1 Z150	R470/1 Z150
9352	R1880/2 Z100		R940/1 Z100	R470/1 Z150		R470/1 Z150	R235/1 Z150	R110/1 Z200	R235/1 Z150
9353	R940/1 Z100		R470/1 Z150	R235/1 Z150		R235/1 Z150	R110/1 Z200	R78/1 Z200	R110/1 Z200
9354	R1880/2 Z100	R1880/2 Z100	R640/2 Z400 spun	R330/2 Z450 spun		R330/2 Z450 spun	R156/2 Z450 spun	R78/2 Z450 spun	R156/2 Z450 spun
9355	R940/1 Z100		R1880/2 Z100	R940/1 Z100		R940/1 Z100	R470/1 Z150	R235/1 Z150	R470/1 Z150
9438	R235/1 Z150		R235/1 Z150	R110/1 Z150		R110/1 Z200			
9439	R235/1 Z150		R235/1 Z150	R110/1 Z150		R110/1 Z200			
9440	R235/1 Z150		R235/1 Z150	R110/1 Z150		R110/1 Z200			
9442	R940/1 Z100		R940/1 Z100	R470/1 Z150		R470/1 Z150	R235/1 Z150	R110/1 Z200	R235/1 Z150
9443	R940/1 Z100		R940/1 Z100	R470/1 Z150		R470/1 Z150	R235/1 Z150	R110/1 Z200	R235/1 Z150
9447	R156/2 Z100 crimped		R660/2 Z400 spun	R330/1 Z450 spun	R156/2 Z100 crimped	R330/1 Z450 spun			
9454				R940/1 Z100		R940/1 Z100	R470/1 Z100	R235/1 Z150	R470/1 Z150
9472	R2820/3		R2820/3	R1410/3 Z100		R1410/3 Z100	R1410/3 Z100		

NOTE 1. Values for twist are given in turns per metre.
NOTE 2. The tolerances on twist are ± 20 %

Appendix D. Additional recommendations

D.1 Spirality

If the yarn twists in the narrow fabric structure are unbalanced the fabric can exhibit spirality. Narrow fabrics should not exhibit this defect to any significant degree.

D.2 Bias

In some specialized end uses, bias is a required feature but in most general purpose uses it is not. In the latter case, the maximum deviation from a straight line when the fabric is laid on a horizontal surface should not exceed 10 mm in 1 m.

D.3 Visible faults

The fabric should be free from all visible defects such as stains, holes, slubs and unevenness of colour or texture.

D.4 Beading

Unless required as a special effect in particular end uses, narrow fabrics should not exhibit beading.

Appendix E. Method of test for determination of dimensional stability on heating in boiling water

E.1 Preparation of specimen

Cut a specimen not less than 450 mm long, and make a mark approximately 50 mm from each end.

E.2 Procedure

With the specimen laid on a flat surface and covered with a sheet of plate glass, measure the distance between the marks to the nearest millimetre. Lay the specimen flat, in water at the boil, and keep it approximately 25 mm below the water surface, using small weights as necessary. After immersion for 15 min in the boiling water, remove the specimen and allow it to dry on a flat surface at room temperature.

Condition the specimen in the standard temperate atmosphere for testing textiles specified in BS 1051.

Repeat the measurements through the plate glass.

E.3 Expression of results

Report the change in length, as a percentage of the original length of the portion of the specimen between the marks.

Appendix F. Method of test for extension

F.1 Apparatus

F.1.1 *Tensile testing machine*, complying with BS 2576.

F.2 Preparation of test specimen

Condition the specimen in the standard temperate atmosphere for testing textiles specified in BS 1051.

F.3 Procedure

With the specimen laid flat without tension, mark two gauge lines across the central portion, 100 mm apart. Clamp the specimen in the tensile testing machine and put the moving clamp in motion at a rate of 10 mm/min. Extend the specimen until a force of 5 N is being applied. Measure the length between the gauge lines before releasing the force.

F.4 Expression of results

Report the increase in length as a percentage of the original gauge length.

Publication(s) referred to

BS 1006	Methods of test for colour fastness of textiles and leather
BS 1051	Glossary of terms relating to the conditioning, testing and mass determination of textiles
BS 1930	Methods for determination of width of woven or knitted fabrics when relaxed at zero tension
BS 2544	Methods for determination of thickness of textile materials
BS 2576	Method for determination of breaking strength and elongation (strip method) of woven fabrics
BS 2862	Methods for determination of number of threads per unit length
BS 3266	Methods of test for determination of conductivity, pH, water-soluble matter, chloride and sulphate in aqueous extracts of textile materials
BS 7141	Narrow fabrics
	[1]Part 2 Specification for cotton webbings for personal load carrying purposes
	[1]Part 3 Specification for wool tapes
	[1]Part 4 Specification for woven elastic webbings containing natural rubber
	[1]Part 5 Specification for elastic flat braids containing natural rubber
	[1]Part 6 Specification for laces for footwear and other purposes
UK/SC 3632E	Webbing and tapes, textile, nylon
UK/SC 3373	Webbing, textile, polyethylene, white
UK/SC 3993	Sling, small arms for 7.62 mm L1A1

[1] Referred to in the foreword only.

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