भारतीय मानक ब्यूरो BUREAU OF INDIAN STANDRADS

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Doc No.: TXD 13(22872) August 2023

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वस्त्रादि — वाय् आकाशीय प्रयोजनों के लिए नायलॉन सिलाई धागे — विशिष्टि

(IS 4229 का तीसरा पूनरीक्षण)

Draft Indian Standard

TEXTILES — NYLON SEWING THREADS FOR AEROSPACE PURPOSES — SPECIFICATION

(Third Revision of IS 4229)

ICS: 49.025.60

Textile Materials for Aeronautical and	Last date for receipt of comments is
Related Products Sectional Committee, TXD 13	30 October 2023

FOREWORD

(Formal clauses will be added later)

This Indian standard was first published in 1967 and subsequently revised in 1978 and 1992. The third revision has been made in the light of experience gained since its last revision and to incorporate the following major changes:

- a) Linear density of nylon sewing threads of all varieties has been modified;
- b) Packing and marking clauses have been updated; and
- c) References to Indian standards have been updated.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1 SCOPE

This standard prescribes the constructional particulars and performance requirements for 6 varieties of nylon sewing threads used for stitching aerospace textile materials.

2 REFERENCES

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards

are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards listed in Annex A.

3 YARN

Bright, high tenacity nylon 6 or nylon 6.6, shall be identified by confirmatory test of microscopic and dissolution as prescribed in IS 667 shall be used in the manufacture of sewing thread. The yarn shall be even and uniform with suitable twist to produce a balanced thread.

4 FINISH

4.1 General

The threads shall be supplied heat set and in one of the following conditions according to the agreement between the buyer and the seller:

a) Undyed;b) Undyed and bonded;c) Dyed, or; andd) Dyed and bonded.

4.2 A lubricating finish may be applied to the thread to facilitate its performance.

4.3 Finishing and bonding agents shall not contain substances known to promote microbiological growth.

4.4 Dyeing

If dyeing is required, the colour and depth of shade shall be as specified in contract or order. For dyeing, metallic or chrome dyes shall not be used. The dyeing should be uniform throughout and dyed threads should be free from dyeing defects.

5 REQUIREMENTS

5.1 The nylon sewing threads shall conform to the requirements specified in Table 1 and Table 2.

Table 1 Physical Requirements

		Structure of Sewing Thread		Length per	Average Breaking	Average Extension at
SI No	Variety	Filament	No. of Plies	Unit Mass,	Strength,	Break,
51 140.	No.	Yarn Linear		m/kg, <i>Min</i>	N, Min	Percent, Max
		Density,		(see Note 1)	(see Note 1	(see
		Tex			and 2)	Note 1)
(1)	(2)	(3)	(4)	(5)	(6)	(7)
i)	L1	23.3	2	18 500	23.5	28
ii)	L2	23.3	3	12 300	35.0	28
iii)	H1	23.3	6 (2 × 3)	6 150	71.0	28
iv)	H2	23.3	9 (3 × 3)	4 100	106.0	28
v)	H3	23.3	$12(4 \times 3)$	3 075	141.0	28
vi)	H4	23.3	18 (6 × 3)	2 050	211.0	28

(*Clauses* 5.1 and 5.2)

Method of Test, Ref to	IS 7071		IS 4910 (Part 2)	IS 4910 (Part 3)	
NOTES 1 In case of dyed threads, 5 percent relaxation shall be allowed in length per unit mass, breaking strength and extension at break. 2 In case of dyed and bond threads , additional 10 percent relaxation shall be provided in length per unit mass and filament linear density of yarn 3 No individual reading of breaking strength shall be less than the 95 percent of the specified value.					

Table 2 Chemical Requirements

(*Clause* 5.1)

SI.	Characteristic	Requirement	Method of Test, Ref to	
No.		-		
(1)	(2)	(3)	(4)	
i)	Colour fastness to:			
	a) Light	5 or better	IS/ISO 105-B01	
	b) Washing, Test B (2)	4 or better	IS/ISO 105-C10	
	c) Dry-cleaning	4 or better	IS/ISO 105-D01	
ii)	Conductivity of aqueous extract (<i>see</i> Notes 1 and 2), S/cm Max	150	IS 4420	
iii)	<i>p</i> H value of aqueous extract	6 to 8	IS 1390	
iv)	Water soluble chlorides, as NaCl, <i>Max,</i> percent	0.1	IS 4202	
v)	Water soluble sulphates, as Na ₂ SO ₄ , <i>Max</i> , percent	0.25	IS 4203	
NOTES	5			
1 The fact Harden and a shift of a set and a labor to be a mind and a be and a be and a time and a time and the set of a day				

1 Test for *p*H value, water soluble chlorides and sulphates to be carried out only when the conductivity exceeds the specified value. 2 The nylon sewing thread failing in respect of conductivity shall be rejected if it fails also in respect of pH, water soluble chlorides or water-soluble sulphates

5.2 Twist

Threads shall be supplied with suitable twist levels as agreed to between the buyer and the seller so as to meet the requirements given in Table 1. The twist shall not vary more than \pm 10 percent for any level of twist.

5.2.1 The direction of twist in single yarn and final thread shall be at the discretion of the manufacturer. However, the direction of twist starting from single yarn should be S/Z for plied and S/S/Z for cabled threads.

5.2.2 The amount of twist shall be tested in accordance with IS 832(Part 1).

5.3 Extension Under Load

The extension of the threads, when subjected to a load equal to 25 percent of the specified strength for (60 ± 5) s, shall not exceed 15 percent.

5.4 Shrinkage in Boiling Water

The mean shrinkage of the threads in boiling water, when determined in accordance with the method prescribed in IS 4910 (Part 5), shall not exceed 2.5 percent.

5.5 Sewing Properties

5.5.1 Threads of minimum length per unit mass of not less than 9 000 m/kg shall be tested in accordance with Annex B. The stitching pattern shall be completed without slipped or broken stitches and the number of malformed stitches shall not exceed two.

5.5.2 Threads other than those specified in **5.5.1** shall be tested in accordance with Annex C. The stitches pattern shall be completed without slipped or broken stitches and the number of malformed stitches shall not exceed two.

6 SEALED SAMPLE

6.1 If, in order to specify the shade, tone, finish, and general appearance, etc, a sample has been agreed upon between the buyer and the seller and sealed, the supply shall be in conformity with the sealed sample in such respects.

6.1.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

7 PACKAGING

The nylon sewing threads shall be compactly wound on reels or bobbins or in any other form and supplied as detailed in the contract or order. The free end of the thread shall be securely fastened to prevent unravelling.

8 MARKING

8.1 Each package shall be marked, preferably by a label, with the following information:

- a) Manufacturer's name, initials, or trade-mark;
- b) Name of the material;
- c) Variety No. (see Table 1);
- d) Finish of Yarn;
- e) Nominal length or mass of thread in metres in a unit package;
- f) Year of manufacture; and
- g) Indication of the source of manufacture.

8.1.1 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act*, 2016 and the Rules and Regulations framed there under, and the products may be marked with the Standard Mark.

9 PACKING

9.1 Unless otherwise specified, the package containing the nylon sewing thread shall be packed in accordance with IS 1066.

10 SAMPLING AND CRITERIA FOR CONFORMITY

10.1 Lot

The quantity of sewing thread of same quality and variety delivered to a buyer against one dispatch note shall constitute a lot.

10.2 The conformity of the lot to the requirements of this standard shall be determined on the basis of tests carried out on the sample selected from it. Unless otherwise agreed to between the buyer and the seller, the number of packages to be selected from a lot shall be according to Table 3. To ensure randomness of selection, methods given in IS 4905 shall be followed.

Table 3 Sample Size and Permissible Number of Non-Conforming Packages (Clauses 10.2 and 10.3)

SI No.	Lot Size	Sample Size	Permissible Number of Non- Conforming Packages
(1)	(2)	(3)	(4)
i)	Upto 100	5	0
ii)	101 to 300	10	0
iii)	301 to 500	15	0
iv)	501 to 1 000	20	1
v)	1 001 and above	30	1

10.3 The sample size and criteria for conformity for various characteristics shall be as follows:

Sl	Characteristics	Samples Size	Criteria for Conformity
No.			
(1)	(2)	(3)	(4)
a)	Breaking strength, Elongation at Break, length (m/kg), Twist per metre, Extension under Specified Load and Mass, and Length of Sewing Thread.	All the packages according to col 2 of Table 3.	Non-conforming packages not to exceed corresponding number given in col 4 of Table 3.

b)	Colour Fastness, Conductivity	Two packages for	All the packages to satisfy
	of Aqueous Extract, pH value	a lot of 300	the relevant requirements.
	of Aqueous Extract, Water	packages and three	
	Soluble Chlorides, Water	above 300.	
	Soluble Sulphates, Shrinkage		
	in Boiling Water and Sewing		
	Properties.		

ANNEX A (Clause 2) LIST OF REFERRED STANDARDS

IS No.	Title
IS 667 : 1981	Methods for Identification of textile fibres (first revision)
IS 832 (Part 1) : 2021 IS 1066 : 1980	Textiles — Determination of twist in yarns Part 1 Direct counting method (<i>third revision</i>) Code for packaging of sewing threads (<i>first revision</i>)
IS 1390 : 2022	Textiles — Determination of p H of aqueous extract (<i>third revision</i>)
IS 4202 : 2022	Method for determination of chloride content of textile materials (<i>first revision</i>)
IS 4203 : 2022	Method for determination of sulphate content in textile materials (<i>first revision</i>)
IS 4420 : 2022	Methods for determination of conductivity of aqueous and organic extracts of textile materials (<i>first revision</i>)
IS 4727 : 2020	Textiles — Nylon webbing for aeronautical purposes — Specification (<i>first revision</i>)
IS 4905 : 2015	Random sampling and randomization procedures (first revision)
IS 4910	Tyre yarns cords and tyre cord fabrics made from man-made fibres methods of test — Methods of test
(Part 2) : 2023	Part 2 Linear density (second revision)
(Part 3) : 2023	Part 3 Load and elongation properties (second revision)
(Part 5) : 2023	Part 5 Heat shrinkage and heat shrinkage force (second revision)
IS/ISO 105-B02 : 2014 IS/ISO 105-C10: 2006 IS/ISO 105-D01 : 2010	Textiles — Tests for colour fastness Part B02 Colour fastness to artificial light : Xenon arc fading lamp test Textiles — Tests for colour fastness Part C10 Colour fastness to washing with soap or soap and soda Textiles — Tests for colour fastness Part D01 Colour fastness to drycleaning using perchloroethylene solvent

ANNEX B

(*Clause* 5.5.1)

TEST FOR SEWING PROPERTIES FOR THREADS OF LINEAR DENSITY ABOVE 9000 METRES PER KILOGRAM

B-1 GENERAL

The properties of the fabric on which this test is to be performed shall be according to the agreement between the buyer and the seller.

B-2 TEST SPECIMEN

The test specimen shall consist of four full-width lengths, each approximately 1 m long, of nylon parachute fabric laid out in stack.

B-3 APPARATUS

A twin-needled lockstitch sewing machine capable of stitching at the rate of $3\ 250 \pm 250$ stitches per minute, maintaining 32 stitches/dm, properly adjusted for tension, 8 mm gauge, and fitted with an appropriate size of needle, shall be used.

B-4 PROCEDURE

Stitch the test piece at the rate given in **B-2** as shown in Fig. 1 lifting the foot and needle but not cutting the thread at the end of each straight run to enable the test piece to be turned. Ignore any slight looping at each corner.



All dimensions in millimetres.

FIG. 1 TEST PIECE FOR LIGHT SEWING THREADS

ANNEX C

(*Clause* 5.5.2)

TEST FOR SEWING PROPERTIES FOR THREADS OF LINEAR DENSITY LESS THAN 9 000 METRES PER KILOGRAM

C-1 TEST SPECIMEN

Four test specimens of dyed nylon webbing conforming to IS 4727 shall be tested. Each specimen shall consist of the layers of webbing, approximately 45 mm wide and 0.5 m long as given below:

a) For threads of varieties No. H1 and H2	2 layers
b) For threads of varieties No. H3 and H4	3 layers

C-2 APPARATUS

A single-needle lockstitch sewing machine, capable of stitching at the rate of 250 ± 40 stitches per minute, maintaining 20 stitches/dm, properly adjusted for tension and fitted with an appropriate size of needle shall be used. Application of lubricant to the needle is permitted.

C-3 PROCEDURE

Stitch together the webbings of each test piece with two four point double W's and a gate pattern, as shown in Fig. 2.



All dimensions in millimetres.

FIG. 2 TEST PIECE FOR HEAVY SEWING THREADS