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# मानक

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IS 15891-2 (2011): TEXTILES — TEST METHODS FOR NON-WOVENS,  
Part 2: DETERMINATION OF THICKNESS [TXD 30: Geotextiles and  
Industrial Fabrics]



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“Knowledge is such a treasure which cannot be stolen”



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IS 15891 (Part 2) : 2011  
ISO 9073-2 : 1995

भारतीय मानक  
वस्त्रादि — बिना बुने हुए वस्त्रों की परीक्षण विधियाँ  
भाग 2 मोटाई ज्ञात करना

*Indian Standard*  
TEXTILES — TEST METHODS FOR NON-WOVENS  
PART 2 DETERMINATION OF THICKNESS

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**BUREAU OF INDIAN STANDARDS**  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
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## NATIONAL FOREWORD

This Indian Standard (Part 2) which is identical with ISO 9073-2 : 1995 'Textiles — Test methods for non-wovens — Part 2: Determination of thickness' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Geosynthetics Sectional Committee and approval of the Textile Division Council.

This standard has been published in various parts. The other parts in this series are:

- Part 1 Determination of mass per unit area
- Part 3 Determination of tensile strength and elongation
- Part 4 Determination of tear resistance
- Part 6 Absorption
- Part 7 Determination of bending length
- Part 8 Determination of liquid strike-through time (simulated urine)
- Part 9 Determination of drape coefficient

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

In this adopted standard reference appears to certain International Standards for which Indian Standards also exist. The corresponding Indian Standards which are to be substituted in their respective places are listed below along with their degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 139 : 1973 Textiles — Standard atmospheres for conditioning and testing	IS 6359 : 1971 Method for conditioning of textiles	Technically Equivalent
ISO 186 : 1985 Paper and board — Sampling to determine average quality	IS 2500 (Part 1) : 2000 Sampling procedure for inspection by attributes Part 1 Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection ( <i>third revision</i> )	do
ISO 3801 : 1977 Textiles — Woven fabrics — Determination of mass per unit length and mass per unit area	IS 1964 : 2001 Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics ( <i>second revision</i> )	do

(Continued on third cover)

*Indian Standard*  
**TEXTILES — TEST METHODS FOR NON-WOVENS**  
**PART 2 DETERMINATION OF THICKNESS**

## 1 Scope

This part of ISO 9073 specifies methods for the determination of the thickness, when under a specific pressure, of normal and bulky nonwoven textiles.

## 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 9073. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 9073 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 139:1973, *Textiles — Standard atmospheres for conditioning and testing*.

ISO 186:1994, *Paper and board — Sampling to determine average quality*.

## 3 Definitions

For the purposes of this part of ISO 9073, the following definitions apply.

**3.1 bulky nonwoven:** Nonwoven textile which is compressible by 20 % or more when the pressure applied changes from 0,1 kPa to 0,5 kPa.

**3.2 thickness:** Distance between the face and back of a nonwoven, measured as the distance between a reference plate on which the nonwoven rests and a parallel presser-foot that is applying a pressure to the nonwoven.

## 4 Principle

Measurement of the thickness of a nonwoven as the distance between the reference plate on which the nonwoven rests and a parallel presser-foot that exerts a specified pressure on the area under test.

## 5 Apparatus

### 5.1 For normal nonwovens

**5.1.1 Two circular horizontal plates,** attached to a stand, comprising an upper plate, or presser-foot, capable of moving vertically and having an area of approximately 2 500 mm<sup>2</sup>, and a reference plate having a plane surface of diameter at least 50 mm greater than that of the presser-foot.

**5.1.2 Measuring device,** having a scale with 0,01 mm graduations, for measuring the distance between the reference plate and the presser-foot (5.1.1).

### 5.2 For bulky nonwovens with a maximum thickness of 20 mm

NOTE 1 An example of suitable test apparatus is shown in figure 1.

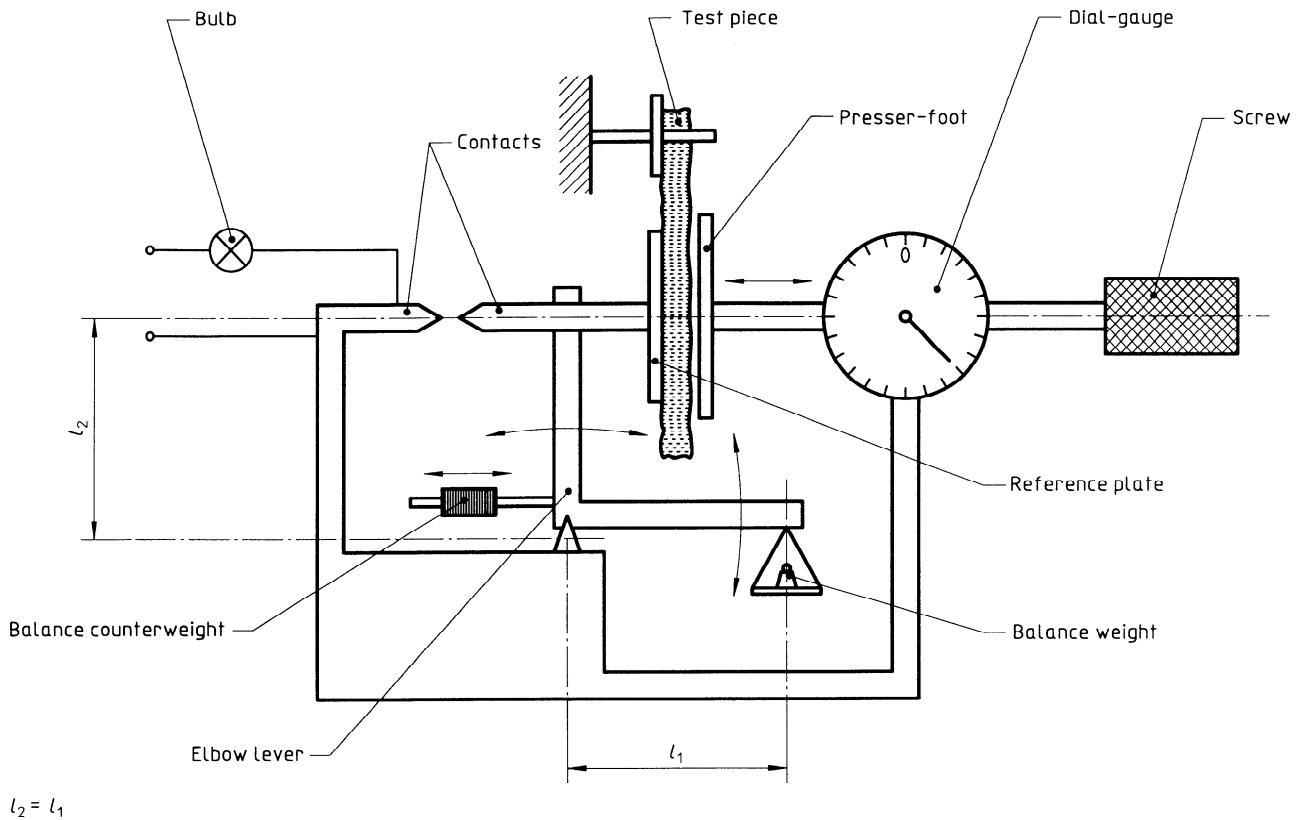


Figure 1 — Test apparatus for bulky nonwovens with a maximum thickness of 20 mm

**5.2.1 Vertical reference plate**, with an area of 1 000 mm<sup>2</sup>, **presser-foot** with an area of 2 500 mm<sup>2</sup>, and equipment to suspend the test piece vertically between them.

**5.2.2 Elbow lever**, with both arms of equal length, attached to the reference plate and capable of being balanced using a counterweight so that it exerts a very small force to the left when the balance weight (5.2.4) is not in position. The geometry of the lever is such that the balance weight gives a measuring pressure of 0,02 kPa.

**5.2.3 Electrical contacts**, which, when closed, cause a small bulb to become illuminated.

**5.2.4 Balance weight**, with a mass of 2,05 g ± 0,05 g, which, when in position, causes the contacts (5.2.3) to separate and extinguish the bulb.

**5.2.5 Screw**, which, when turned, drives the presser-foot to the left and presses the test piece with increasing pressure against the reference plate until the force on the balance is overcome and the bulb becomes illuminated.

**5.2.6 Dial-gauge**, to indicate the distance, in millimetres, between the reference plate and the presser-foot corresponding to the thickness of the test piece at the pressure applied.

### 5.3 For bulky nonwovens with a thickness greater than 20 mm

NOTE 2 An example of suitable test apparatus is shown in figure 2.



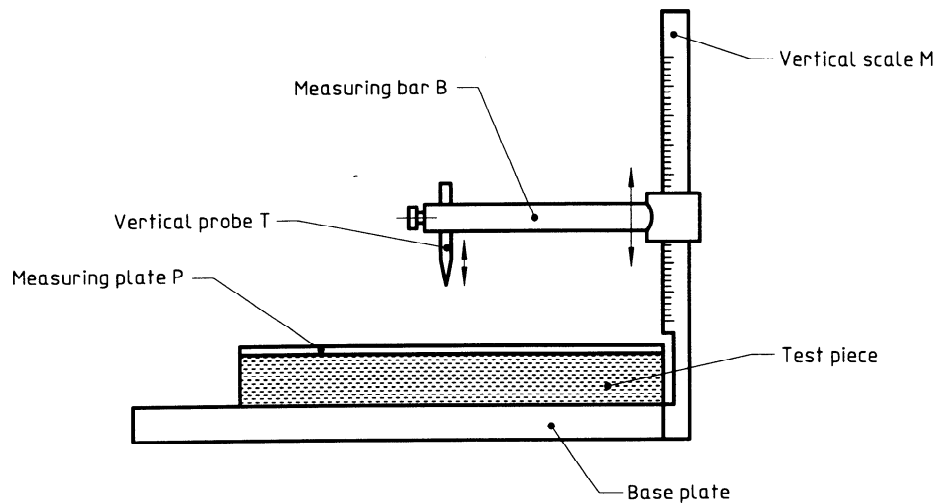


Figure 2 — Test apparatus for bulky nonwovens with a thickness greater than 20 mm

**5.3.1 Horizontal square base plate**, measuring 300 mm × 300 mm, having a smooth surface. In the centre of one side is a **vertical scale M** with graduations in millimetres, on which is placed a **horizontal measuring bar B**, which is movable in a vertical direction. This bar supports an **adjustable vertical probe T** at a distance of 100 mm from the vertical scale.

NOTE 3 The vertical probe T should be above the centre of the measuring plate P when in use (see 9.3.2), such that the measuring plate is not in contact with the scale.

**5.3.2 Square measuring plate P**, measuring  $(200 \text{ mm} \pm 0,2 \text{ mm}) \times (200 \text{ mm} \pm 0,2 \text{ mm})$  and a mass of  $82 \text{ g} \pm 2 \text{ g}$ , made of glass with a thickness of 0,7 mm, which can be brought to the required mass by the addition of weight-pieces to give a measuring pressure of 0,02 kPa.

NOTE 4 If additional weight-pieces are necessary, they should be distributed symmetrically so that there is even pressure over the whole area of the plate.

## 5.4 Stopwatch.

## 6 Sampling

Carry out sampling in accordance with ISO 186, ensuring that the areas from which the specimens are taken have no visible flaws and are not creased.

NOTE 5 This method of sampling recognizes and makes provisions for "anisotropy" (differences in properties along various directions, principally machine and cross directions) in the final specimens. However, these specimens are ran-

dom representatives of the material and in some cases it may be desirable to investigate systematic variations of properties (including anisotropy), for example across the width, or in certain positions along the length, of a given reel. In all such cases, special provisions should be agreed between purchaser and vendor and recorded in the test report. A procedure for more detailed examination of variability within a given batch of material is available in TAPPI T 74-05-11 and may be found helpful. This publication may be obtained from: The Technical Association of Pulp and Paper Industries, 1 Dunwoody Park, Atlanta, GA 30338, USA.

## 7 Preparation and conditioning of test pieces

**7.1** If the method of test [A, B or C (see clause 9)] has not been determined, cut 10 preliminary test pieces, each having an area larger than  $2\,500 \text{ mm}^2$ , and, after conditioning, carry out the procedure described in clause 8.

**7.2** For normal nonwovens, cut 10 test pieces, each having an area larger than  $2\,500 \text{ mm}^2$ .

**7.3** For bulky nonwovens with a maximum thickness of 20 mm, cut 10 test pieces, each having an area of  $(130 \text{ mm} \pm 5 \text{ mm}) \times (80 \text{ mm} \pm 5 \text{ mm})$ .

**7.4** For bulky nonwovens with a thickness greater than 20 mm, cut 10 test pieces, each having an area of  $(200 \text{ mm} \pm 0,2 \text{ mm}) \times (200 \text{ mm} \pm 0,2 \text{ mm})$ .

**7.5** Condition the test pieces as specified in ISO 139.



## 8 Preliminary procedure

**8.1** Carry out the tests in the standard atmosphere for testing (see ISO 139).

**8.2** Using the apparatus specified in 5.1, adjust the load on the presser-foot according to the manufacturer's instructions to give a uniform pressure of 0,1 kPa and set the measuring device to zero.

**8.3** Raise the presser-foot and place the preliminary test piece (7.1) carefully, without tension, on the reference plate. Ensure the test piece is positioned centrally with respect to the presser-foot. Lower the presser-foot carefully until contact is made with the test piece.

**8.4** Leave in contact for 10 s, adjust the measuring device to measure the thickness of the sample, and note the reading, in millimetres.

**8.5** Repeat the procedure for the other nine test pieces.

**8.6** Adjust the load on the presser-foot according to the manufacturer's instructions to give a uniform pressure of 0,5 kPa and adjust the measuring device to zero. Repeat the measurements on the same 10 test pieces.

**8.7** Calculate the difference between the results at pressures of 0,1 kPa and 0,5 kPa for each preliminary test piece and determine the mean thickness of the nonwoven.

**NOTE 6** It is recommended that reference specimens of known thickness are used to check the testing apparatus periodically.

**8.8** Test the nonwovens which were compressed by < 20 % of their thickness in this preliminary procedure in accordance with the procedure given in 9.1 (method A) and others in accordance with either 9.2 (method B) or 9.3 (method C), depending upon whether they have a thickness of less than or greater than 20 mm.

**NOTE 7** When different samples, close to the limits of each method, are to be compared, the comparison should be made using the same method.

## 9 Procedure

### 9.1 Method A for normal nonwovens

**9.1.1** Carry out the tests in the standard atmosphere for testing (see ISO 139).

**9.1.2** Using the apparatus specified in 5.1, adjust the load on the presser-foot according to the manufacturer's instructions to give a uniform pressure of 0,5 kPa and set the measuring device to zero.

**9.1.3** Raise the presser-foot, and position the test piece (7.2) centrally with respect to the presser-foot, and without tension, on the reference plate.

**9.1.4** Lower the presser-foot carefully until contact is made with the test piece, and leave in contact for 10 s.

**9.1.5** Adjust the measuring device and note the reading, in millimetres.

**9.1.6** Repeat the procedure on the other nine test pieces.

### 9.2 Method B for bulky nonwovens with a maximum thickness of 20 mm

**9.2.1** Carry out the tests in the standard atmosphere for testing (see ISO 139).

**9.2.2** Using the apparatus specified in 5.2, check that the sensitivity and zero are adjusted correctly when the balance weight of  $2,05 \text{ g} \pm 0,05 \text{ g}$  is in position.

**9.2.3** Move the presser-foot to the right and fasten the test piece (7.3) on the bearer pin so that it is suspended between the reference plate and the presser-foot.

**9.2.4** Move the presser-foot slowly to the left by means of the screw until the bulb is illuminated.

**9.2.5** After 10 s, read the thickness, in millimetres, from the dial-gauge, to the nearest 0,1 mm.

**NOTE 8** If further compression of the test piece during the 10 s period causes the contact to separate, the presser-foot should be adjusted to illuminate the bulb again before the thickness is read from the gauge.

**9.2.6** Repeat the procedure for the other nine test pieces.

### 9.3 Method C for bulky nonwovens with a thickness greater than 20 mm

**9.3.1** Carry out the tests in the standard atmosphere for testing (see ISO 139).

**9.3.2** Using the apparatus specified in 5.3, place the measuring plate on the base plate and, if necessary, adjust the height of the probe so that the reading on the scale is zero when the probe just touches the centre of the measuring plate.

**9.3.3** Place the test piece (7.4) centrally under the probe and place the measuring plate squarely on top of the test piece without applying excess pressure.

**9.3.4** After 10 s, move the measuring bar downwards until the probe touches the surface of the measuring plate, and read the thickness from the scale, to the nearest 0,5 mm.

**9.3.5** Repeat the test procedure for the other nine test pieces.

## 10 Expression of results

Use the 10 results obtained to calculate the mean

thickness of the nonwoven, in millimetres, and, if required, the coefficient of variation.

## 11 Test report

The test report shall include the following information:

- a) the number and year of publication of this part of ISO 9073, i.e. ISO 9073-2:1995;
- b) all details necessary for the identification of the material;
- c) the mean thickness of the nonwoven, in millimetres (see clause 10) and, if required, the coefficient of variation;
- d) the test method used;
- e) the conditioning atmosphere used;
- f) any unusual features noted during the testing, or deviations from the standard procedure;
- g) details of any reference specimens used (see note 6).

## TECHNICAL CORRIGENDUM 1

Technical Corrigendum 1 to International Standard ISO 9073-2:1995 was prepared by Technical Committee ISO/TC 38, *Textiles*.

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*Page 3*

Clause 6, NOTE 5 (r.h. column): the correct reference in line 9 should read TAPPI T 74-0S-11.

*(Continued from second cover)*

The conditioning temperature of  $20 \pm 2^{\circ}\text{C}$  as specified in International Standards is not suitable for tropical countries like India where the atmospheric temperature is normally much higher than  $20^{\circ}\text{C}$ . It is almost impossible to maintain this temperature specially during summer when the atmospheric temperature rises even up to  $50^{\circ}\text{C}$ . In view of the above, IS 6359 : 1971 which specifies a temperature of  $27 \pm 2^{\circ}\text{C}$  for conditioning of the test specimens for the tropical countries like India shall be referred.

Technical Corrigendum 1 to the above International Standard has been given at the end of this standard.

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 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

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### Amendments Issued Since Publication

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## BUREAU OF INDIAN STANDARDS

### Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002

Telephones: 2323 0131, 2323 3375, 2323 9402

Website: [www.bis.org.in](http://www.bis.org.in)

### Regional Offices:

Telephones

Central	: Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 2323 7617 2323 3841
Eastern	: 1/14 C.I.T. Scheme VII M, V.I.P. Road, Kankurgachi KOLKATA 700054	{ 2337 8499, 2337 8561 2337 8626, 2337 9120
Northern	: SCO 335-336, Sector 34-A, CHANDIGARH 160022	{ 260 3843 260 9285
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