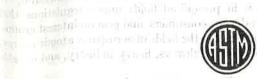
1967 BOOK OF ASTM STANDARDS

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With Related Material



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PART 24 - Disputation of the contract of the state of the contract of

Textile Materials-Yarns, Fabrics, and General Methods

Includes standards of:

Committee D-13 on Textile Materials

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A list of committee members may be found in the ASTM Year Book.

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ASTM

THE American Society for Testing and Materials is an international, nonprofit, technical, scientific, and educational society devoted to "... the promotion of knowledge of the materials of engineering, and the standardization of specifications and methods of testing."

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A cordial invitation to become affiliated as members in the Society is extended to individuals and organizations who are concerned with the fields of work in which ASTM is active or who would find it of interest and benefit to keep in close touch with the work of the Society. Information on membership is given on the application forms bound in the back of this book. For further information, contact ASTM Headquarters, 1916 Race St., Philadelphia, Pa. 19103.

The appearance of the Book of ASTM Standards is a tribute to the sincere efforts of the technical committees responsible for the development and review of the standards, and of the many individuals serving on the committees. The committees responsible for developing the standards appearing in this part are listed on the title page. The names of persons serving on these committees and the organizations they represent are listed in the ASTM Year Book which is published annually. Because of their contribution, personal recognition would be justified. However, this list is too extensive and covers too many fields of interest to include as part of this volume.

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> Printed in Baltimore, U.S.A. October, 1967



LE RECOVERY (D 1295)

Report

cted in ASTM Method D 1295 and rt the average warp and filling (or a necessary, warp-face, warp-back, g-face and filling-back) recovery es. If both normal and high-humidatmospheres have been used, report sets of average values.

Precision

.1 Results of interlaboratory tests e shown significant differences in veen-laboratory precision.

...2 Using three specimens for each p, as prescribed in the method, the in-laboratory precision of the aver-for warp or filling, as measured by variance, has ranged from a low of a high of 140 deg squared. A varie of under 40 deg squared is consideratisfactory.

...3 When the within-laboratory prem is satisfactory, different laboraes will rank a group of fabrics in the
me order, even though they differ in
mabsolute values obtained. Results,
mefore, can be used to make decisions
make confidence about the relative quality
method, however,
mot be recommended for acceptance
mg.

Standard Method of Test for

TUFT BIND OF PILE FLOOR COVERINGS'



ASTM Designation: D 1335 - 67

This Standard of the American Society for Testing and Materials is issued under the fixed designation D 1335; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval.

1. Scope

1.1 This method covers the determination of the force required to pull a tuft completely out of a cut pile floor covering or to pull one or both legs of a loop free from the backing of looped pile floor covering.

NOTE 1—For the determination of other properties of pile floor coverings refer to ASTM Methods D 418, Testing Woven Pile Floor Coverings² and ASTM Methods D 1486, Testing Tuíted Pile Floor Coverings.²

2. Definitions

2.1 *Tuft*, *n*.—The cut or uncut loops forming the face of a tufted or woven pile floor covering.

2.2 Tuft Bind, n.—The force required to pull a tuft from a cut pile floor covering or to pull free one leg of a loop from a looped pile floor covering.

Note 2—The force is generally expressed in pounds-force.

¹Under the standardization procedure of the Society, this method is under the jurisdiction of the ASTM Committee D-13 on Textile Materials, and is the direct responsibility of Subtommittee A-11 on Pile Floor Coverings. A list of committee members may be found in the ASTM Year Book.

Current edition accepted Sept. 8, 1967.
Originally issued 1954. Replaces D 1335 - 60 T.

*Appears in this publication.

2.3 Pile Floor Covering, n.—A pile fabric intended for use as a floor covering. The pile may be in the form of cut loops or loops, or both. Both the cut loops and the loops may vary in height.

2.4 Looped Pile Floor Covering, n.—A pile floor covering in which the pile is composed of loops.

2.5 Cut Pile Floor Covering, n.—A pile floor covering in which the pile is composed of tufts in the form of cut loops.

2.6 For definitions of other terms used in this method, refer to ASTM Definitions D 123, Terms Relating to Textile Materials.²

3. Summary of Method

3.1 The force required to pull a cut loop from a cut pile floor covering or to pull one or both legs of a loop from a looped pile floor covering is determined by a tensile testing machine. The required load or force is reported in poundsforce (lbf) or kilograms-force (kgf).

4. Uses and Significance

4.1 The satisfactory performance of a pile floor covering depends to a considerable extent on the maintenance of its original appearance. In a cut pile floor

61-97 X

Test for Tuft Bind of Pile Floor Coverings (D 1335)

covering an inadequate tuft bind may result in complete loss of pile in areas exposed to severe wear. In a looped pile floor covering with inadequate tuft bind the pile loops may be pulled out to form unsightly long tufts or occasionally hazardous loops.

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4.2 The wide range of capacity of tensile testing machines is specified to cover the application of the method to intermediate products (without back coating) which might have a tuft bind of less than 1 lb and also to cover the use of the method when it is desired to determine

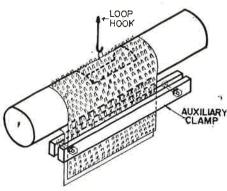


Fig. 1—Specimen Holder, Cut-Away Type.

that the tuft bind exceeds a specified value of 3 to 4 lb, for example, without taking the time to pull the tuft out completely.

4.3 In cases when a floor covering contains both cut and uncut pile, an equal number of each type of pile should be tested.

5. Apparatus

5.1 Tensile Testing Machine, conforming to ASTM Specifications D 76, for Tensile Testing Machines for Textile Materials, with a capacity selected such that the force required to complete the test falls within 20 to 80 per cent of full scale. Full scale loads ranging from 1 to 25 lb (0.5 to 11 kg) are generally adequate. The testing machines must be operable at

the specified rates; for constant-rate-of-traverse (CRT) and constant-rate-of-extension (CRE) types— 12 ± 0.5 in. (305 \pm 10 mm)/min. For constant-rate-of-load (CRL) type, the full load of the tester shall be applied in 20 sec.

Note 3—The level of test results obtained with different types of testing machines is not always the same.

5.2 Cylindrical Specimen Holder, Cut-Away Type, consisting of a 6-in. (152-mm) length of 1.5-in. (38-mm) outside diameter tubing with a section 2 in. (51 mm) long having half of the tubing cut away. See Fig. 1. This specimen holder should be constructed in a manner that will permit clamping the test specimen in the nonmeasuring, pulling clamp of the tensile testing machine or replacement of the nonmeasuring clamp by the specimen holder.

5.3 Tuft Clamp, for use only with cut pile floor coverings, consisting of a tweezer-like clamp that can be used to grip a single tuft tightly enough to assure removal of the whole tuft from the fabric without slippage of the tuft in the clamp. Alternatively, a hemostat³ can be used.

5.4 Loop Hook, for use only with looped pile floor coverings, consisting of a hook which can be readily passed through the loop and hooked under the top of the loop. The hook should be made of wire having a diameter of at least $\frac{1}{32}$ in. (0.8 mm) and should be so constructed that it will not cut the loop during the normal test procedure. The shank of the hook should be so constructed that it can be clamped in the measuring clamp or can replace the measuring clamp of the test machine.

Note 4—Because the tuft clamp of loop hook is attached to, or replaces, the usual measuring clamp of the test machine, it is necessary to

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³ Hemostats suitable for this purpose can be obtained from the Fisher Scientific Co., Catalog 65, Catalog No. 8-907, Forceps, Kelly Hemostatic.

cified rates; for constant-rate-of-(CRT) and constant-rate-of-ex-(CRE) types—12 ± 0.5 in, 10 mm)/min. For constant-rate-(CRL) type, the full load of the nall be applied in 20 sec.

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rype, consisting of a 6-in. (152ngth of 1.5-in. (38-mm) outside or tubing with a section 2 in. (51ng having half of the tubing cut bee Fig. 1. This specimen holder be constructed in a manner that mit clamping the test specimen in measuring, pulling clamp of the testing machine or replacement of measuring clamp by the specimen

fuft Clamp, for use only with cut oor coverings, consisting of a -like clamp that can be used to ingle tuft tightly enough to assure l of the whole tuft from the fabric slippage of the tuft in the clamp. tively, a hemostat³ can be used. Loop Hook, for use only with pile floor coverings, consisting of which can be readily passed the loop and hooked under the he loop. The hook should be made having a diameter of at least (0.8 mm) and should be so cond that it will not cut the loop the normal test procedure. The of the hook should be so cond that it can be clamped in the ing clamp or can replace the measlamp of the test machine.

4—Because the tuft clamp or loop hook ned to, or replaces, the usual measuring of the test machine, it is necessary to

nostats suitable for this purpose can be I from the Fisher Scientific Co., Catalog alog No. 8-907, Forceps, Kelly Hemocompensate for the effect of the altered weight of the clamp to retain the previous calibration of the testing machine.

6. Sampling

6.1 Take a lot sample and a laboratory sample as directed in the applicable material specification. In the absence of such specification, select a sample representative of the roll or piece to be tested and of sufficient size so that five specimens each about 6 in. (150 mm) wide and about 8 in. (200 mm) long can be cut from it.

NOTE 5—If the pile floor covering is back coated, exercise care in handling the sample in order that the back coating is not broken or otherwise disturbed.

7. Conditioning

7.1 Bring the specimens to moisture equilibrium for testing in the standard atmosphere for testing textiles approaching equilibrium from the dry side. Determine that moisture equilibrium for testing has been attained as directed in ASTM Method D 1776, Conditioning Textiles and Textile Products for Testing.²

8. Preparation of Apparatus

8.1 If required, replace the nonmeasuring clamp of the test machine with the specimen holder described in 5.2.

8.2 Replace the measuring clamp of the test machine with, or attach to the measuring clamp of the test machine, the tuft clamp described in 5.3 or the loophook described in 5.4, depending upon which is required for the type of pile floor covering under test (Note 4).

9. Procedure

9.1 Test the conditioned specimens in the standard atmosphere for testing textiles.

9.2 Adjust the constant-rate-of-traverse (CRT) or the constant-rate-of-extension (CRE) type testing machine to

operate at a rate of 12 ± 0.5 in. (305 \pm 10 mm)/min. Adjust the constant-rate-of-load (CRL) type tester so that the full load is applied in 20 sec.

9.3 Cut Pile Floor Coverings:

9.3.1 Mount the test specimen on the specimen holder with the rows of tufts at a right angle to the long axis of the holder in such a position that the tuft to be tested is approximately centered over the cut-away portion of the specimen holder. Adjust the tension so that the specimen presents an undistorted cylindrical surface over the cut-away sec-

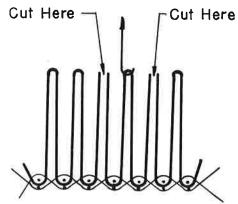


Fig. 2—Arrangement of Hook and Loops for Testing.

tion of the specimen holder. Locate the tuft to be pulled directly below the center of the pulling clamp or hook.

9.3.2 Select only one tuft for testing from any one row of tufts and allow at least 1 in. (26 mm) between any tuft tested and the edge of the specimen.

9.3.3 Using the tuft clamp grip one leg (side) of the original loop. Make certain that all fibers forming the tuft are securely gripped by the tuft clamp. Take care not to pinch, "break the back," or otherwise deform the carpet in the selection of, and attachment of the clamp to, the tuft under test.

9.3.4 Determine tuft bind in poundsforce or kilograms-force to the nearest TEST FOR TUFT BIND OF PILE FLOOR COVERINGS (D 1335)

0.1 lbf or 50 gf required to pull out the tuft from the pile floor covering.

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9.3.5 Repeat this procedure on two additional tufts from different rows of tufts.

9.4 Looped Pile Floor Covering:

9.4.1 Mount the test specimen on the specimen holder as described in 9.3.1.

9.4.2 Select a location where three adjacent loops are formed by the same end. Cut completely through the first and third loops and test the center loop (Note 6). See Fig. 2.

Note 6—If this procedure is not followed, a spurious value may be obtained if one or both ends of the loop under test is buried in the back construction for a number of construction unit repeats.

9.4.3 Insert the loop hook in the loop to be tested. Determine the pounds-force or kilograms-force to the nearest 0.1 lbf or 50 gf required to pull at least one leg of the loop from the pile floor covering.

9.4.4 Repeat this procedure on two additional loops from other rows of loops.

10. Calculations

10.1 Calculate the average force required for all specimens tested for a sample to the nearest 0.1 lbf (50 gf).

11. Report

11.1 State that the tests were performed as directed in ASTM Method D 1335 and give the following information:

11.1.1 Average tuft bind in poundsforce or kilograms-force to the nearest 0.1 lbf or 50 gf value of the test results,

11.1.2 Number of specimens tested,

11.1.3 Type of floor covering tested, and

11.1.4 Type of tensile testing machine on which the tests were performed.

12. Precision

12.1 Repeatability—The within-laboratory precision, at the 95 per cent probability level, of the average of three replicates is expected to be within ±7 per cent of the average tuft bind.

12.2 Reproducibility—The precision, at the 95 per cent probability level, of the difference between two laboratories, each making three measurements, is expected to be within ±15 per cent of the average tuft bind.

Note 7—These values of precision are based on interlaboratory testing by three laboratories on a series of samples that represent most styles of currently produced carpets.

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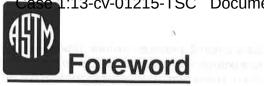
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practice—a definitive procedure for performing one or more specific operations or functions that does not produce a test result. (Compare test method.)

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Discussion-A practice is not a downgraded test method. Examples of practices include procedures for conducting interlaboratory testing programs or other statistical procedures; for writing statements on sampling or precision and accuracy; and for selection, preparation, application, inspection, necessary precautions for use or disposal, installation, maintenance, and operation of testing equipment.

specification-a precise statement of a set of requirements to be satisfied by a material, product, system, or service that indicates the procedures for determining whether each of the requirements is satisfied.

Discussion-It is desirable to express the requirements numerically in terms of appropriate units together with their limits.

terminology-a document comprising definitions of terms; descriptions of terms; explanations of symbols, abbreviations, or acronyms.

test method-a definitive procedure for the identification, measurement, and evaluation of one or more qualities, characteristics, or properties of a material, product, system, or service that produces a test result. (Compare practice.)

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Each ASTM Standard has a unique serial designation. It is comprised of a capital letter indicating general classification (A, ferrous metals; B, nonferrous metals; C, cementitious, ceramic, concrete, and masonry materials; D, miscellaneous materials; E, miscellaneous subjects; F, materials for specific applications; G, corrosion, deterioration, and degradation of materials; ES, emergency standards; P, proposals), a serial number (one to four digits), a dash, and the year of issue.

In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1990 have as their final number, 90. A letter following this number indicates more than one revision during that year, that is 90a indicates the second revision in 1990, 90b the third revision, etc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1990). A superscript epsilon indicates an editorial change since the last revision or reapproval; $\epsilon 1$ for the first change, $\epsilon 2$ for the second, etc.

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In each scrial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1992 have as their final number, 92. A tetter following this number indicates more than one revision during that year, that is 92a Indicates the second revision in 1992, 92b the third revision, atc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1992). A superscript epsilon indicates an editorial change since the last revision or reapproval; (1 for the first change, (2 for the second, etc.)

If a standard is written in acceptable metric utilts and has a companion standard written in inch-pound units (or other units) the metric standard is identified by a letter M after the serial number; this standard contains "hard metric" units.

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In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1993 have as their final number, 93. A letter following this number indicates more than one revision during that year, that is 93a indicates the second revision in 1993, 93b the third revision, etc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1993). A superscript epsilon indicates an editorial change since the last revision or reapproval; $\epsilon 1$ for the first change, $\epsilon 2$ for the second, etc.

If a standard is written in acceptable metric units and has a companion standard written in inch-pound units (or other units), the metric standard is identified by a letter M after the serial number; this standard contains "hard metric" units.

If a standard is written in inch-pound units (or other units) and acceptable metric units, the document is identified by a dual alphanumeric designation.

When reference is made to a standard, the *complete* designation should be given. Best practice is to state the *designation and title*.

The boldface number(s) following the title refer to the volume(s) of the *Annual Book of ASTM Standards* in which the standard appears.

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Each ASTM Standard has a unique serial designation. It is comprised of a capital letter indicating general classification (A, ferrous metals; B, nonferrous metals; C, cementitious, ceramic, concrete, and masonry materials; D, miscellaneous materials; E, miscellaneous subjects; F, materials for specific applications; G, corrosion, deterioration, and degradation of materials; ES, emergency standards; P, proposals), a serial number (one to four digits), a dash, and the year of issue.

In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1994 have as their final number, 94. A letter following this number indicates more than one revision during that year, that is 94a indicates the second revision in 1994, 94b the third revision, etc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1994). A superscript epsilon indicates an editorial change since the last revision or reapproval; £1 for the first change, £2 for the second, etc.

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2 Discontinued 1968: Specification for Carbon and Alloy Steel Forgings for Turbine Generator Rotors and Shafts; Replaced by A 469

3 Discontinued 1984: Specification for Steel Forgings, Carbon and Alloy, for Turbine Generator Rotors and Shafts; Replaced by A 470

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A 295-4 Specification for High-Carbon Anti-Friction Bearing Steel, 01.05 Discontinued 1980: Specification for Corrosion-Resistant Iron-Chromium and Iron-Chromium Nickel and Nickel-B Alloy Castings; Replaced by A 743. A 744

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A 302/A302M-90 Specification for Pressure Vessel Plates, Alloy Steel, Manganese-Molybdenum and Manganese-Molybdenum-Nickel, 01.04 Discontinued 1970: Specification for Hot-Rolled Carbon Steel Strip of Structural Quality; Replaced by A 570

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7 Discontinued 1975: Method of Macroetch Testing and Inspection of Steel Forgings; Replaced by E 381

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A 403/A403M-94a Specification for Wrought Austenitic Stainless Steel Piping Fittings, 01.01

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A 415 Discontinued 1970: Specification for Hot-Holled Carbon Steel Sheets Commercial Quality; Replaced by A 569

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A 443 Discontinued 1966: Method of Notch Toughness of Turbine and Generator Steel Forgings; Combined with A 370

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A 446/A446M Discontinued 1994; Specification for Steel Sheet, Zinc-Coaled

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D 737 Discontinued 1995; Test Method for Air Permeability of Textile Fabrics D 738 Discontinued 1972; Methods of Testing and Tolerances for Rope Made

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D 743 Discontinued 1948; Specification for Nonrigid Ethyl Cellulose Plastics D 744 Discontinued 1956; Specification for Nonrigid Vinyl Chloride Plastics D 745 Discontinued 1950; Specification for Nonrigid Vinyl Butyral Plastics

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17 Discontinued 1927; Specification for Bronze Castings in the Rough for

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B 20 Discontinued 1940; Specification for Cartridge Brass Sheet, Strip, Plate, Bar, and Disks; Combined with B 19

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\$42-93 Specification for Seamless Copper Pipe, Standard Sizes, 02.01

\$43-94 Specification for Seamless Red Brass Pipe, Standard Sizes, 02.01

\$44 Discontinued 1937; Specification for Copper and Copper-Alloy Seamless Condenser Tubes and Ferrule Stock; Replaced by B.111

\$45 Discontinued 1942; Methods for Testing Chemical Analysis of Brasses Discontinued 1943; Methods of Testing Chemical Analysis for sulfur in special brasses and bronzes: Replaced by E.54

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B 55 Tubes and Ferrule Stock

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B 58 Discontinued 1946; Specification for Aluminum-Base Alloys in Ingot Form for Sand Castings; Replaced by B 179

B 59 Discontinued 1941; Specification for Aluminum-Bronze Sand Castings;

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B 71 Discontinued 1942; Methods of Testing Chemical Analysis of Nickel-Changium-Iron Alloys

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B 87 Discontinued 1938; Specification for Hard-Drawn Copper Transmission Cable; Peplaced by B 8

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 B 144 Discontinued 1973; Specification for High-Leaded Tin-Bronze Sand
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 B 146 Discontinued 1973; Specification for Leaded Yellow Brass Sand
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 7 Discontinued 1973; Specification for High-Strength Yellow Brass (Manganese Bronze) and Leaded High-Strength Yellow Brass (Leaded Manganese Bronze) Sand Castings; Replaced by B 584
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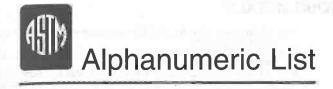
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Each ASTM standard has a unique serial designation. It is comprised of a capital letter indicating general classification (A, ferrous metals; B, nonferrous metals; C, cementitious, cermanic, concrete, and masonry materials; D, miscellaneous materials; E, miscellaneous subjects; F, materials for specific applications; G, corrosion, deterioration, and degradation of materials; ES, emergency standards; P, proposals; PS, provisional standards), a serial number to four digits), a dash, and the year of issue.

In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1997 have as their final number, 97. A letter following this number indicates more than one revision during that year, that is 97a indicates the second revision in 1997, 97b the third revision, etc. Standards that have been reapproved without change are the third revision in parentheses as part of the designation number, for example, (1997). A superscript epsilon indicates an editorial change since the last revision or reapproval; €1 for the first change, €2 for the second, etc.

If a standard is written in acceptable metric units and has a companion standard written in inch-pound units (or other units), the metric standard is identified by a letter M after the serial number; this standard contains "hard metric" units.

If a standard is written in inch-pound units (or other units) and acceptable metric units, the document is identified by adual alphanumeric designation.

When reference is made to a standard, the *complete* designation should be given. Best practice is to state the designation and title.

The boldface number(s) following the title refer to the volume(s) of the *Annual Book of ASTM Standards* in which the standard appears.

This list includes only those standards which appear in the 1997 edition of each volume of the *Annual Book of ASTM Standards*. New and revised standards that were approved after the closing date for the volume are available as separate reprints and will be listed in next year's edition.

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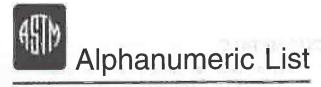
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In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1998 have as their final number, 98. A letter following this number indicates more than one revision during that year, that is 98a indicates the second revision in 1998, 98b the third revision, etc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1998). A superscript epsilon indicates an editorial change since the last revision or reapproval; $\epsilon 1$ for the first change, $\epsilon 2$ for the second, etc.

If a standard is written in acceptable metric units and has a companion standard written in inch-pound units (or other units), the metric standard is identified by a letter M after the serial number; this standard contains "hard metric" units.

If a standard is written in inch-pound units (or other units) and acceptable metric units, the document is identified by a dual alphanumeric designation.

When reference is made to a standard, the *complete* designation should be given. Best practice is to state the *designation and title*.

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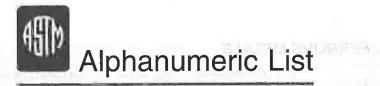
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Each ASTM standard has a unique serial designation. It is comprised of a capital letter indicating general classification (A, ferrous metals; B, nonferrous metals; C, cementitious, cermanic, concrete, and masonry materials; D, miscellaneous materials; E, miscellaneous subjects; F, materials for specific applications; G, corrosion, deterioration, and degradation of materials; ES, emergency standards; P, proposals; PS, provisional standards), a serial number (one to four digits), a dash, and the year of issue.

In each serial designation, the number following the dash indicates the year of original adoption as standard or, in the case of revision, the year of last revision. Thus, standards adopted or revised during the year 1999 have as their final number, 99. A letter following this number indicates more than one revision during that year, that is 99a indicates the second revision in 1999, 99b the third revision, etc. Standards that have been reapproved without change are indicated by the year of last reapproval in parentheses as part of the designation number, for example, (1999). A superscript epsilon indicates an editorial change since the last revision or reapproval; €1 for the first change, €2 for the second, etc.

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- D 1299 Discontinued 1992; Test Method for Shrinkage of Molded and Laminated Thermosetting Plastics at Elevated Temperature
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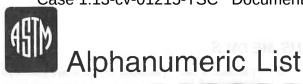
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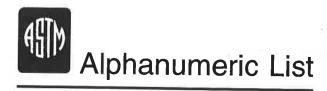
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