



Standard Practice for Determining Ticket Numbers for Sewing Threads¹

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1. Scope

1.1 This practice establishes standard ticket numbers for sewing thread regardless of fiber content or type of thread.

1.2 The values stated in inch-pound units are to be regarded as the standard; the values in English units are provided as information only and are not exact equivalents.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 123 Terminology Relating to Textiles²

D 204 Test Methods for Sewing Threads²

D 861 Practice for Use of the Tex System to Designate Linear Density of Fibers, Yarn Intermediates, and Yarns²

D 1907 Test Method for Linear Density of Yarn (Yarn Number) by the Skein Method²

2.2 ANSI Standard:

ANSI/ASQC Z1.4 Sampling Procedures for Inspection by Attributes³

3. Terminology

3.1 Definitions:

3.1.1 *greige thread, n*—undyed or unfinished sewing thread in the state following final plying or an equivalent step in a processing sequence such as extruding or braiding.

3.1.2 *sewing thread, n*—a flexible small diameter yarn or strand, usually treated with a surface coating, lubricant, or both, intended to be used to stitch one or more pieces of material or an object to a material.

3.1.3 *ticket number, n*—in sewing thread, the designator assigned to a sewing thread to designate its approximate linear density.

3.1.3.1 *Discussion*—The ticket number is an indicator of the approximate amount of fiber present. The smaller the number,

the finer the thread (lesser amount of fiber); and the larger the number, the coarser the thread (greater amount of fiber). This designator represents a size variation which will range from three numbers apart up to 50 numbers apart. The narrow range is important so that there is not a wide disparity in the linear density of the sizes indicated by a single designator. The wide range of numbers designate heaviest (coarser) yarns where difference in yield is less of a critical factor relative to linear density.

3.1.4 For definitions of other textile terms used in this practice, refer to Terminology D 123. For other definitions of terms relating to thread, refer to Methods D 204.

4. Significance and Use

4.1 This system of sewing thread ticket numbers was developed to overcome the confusion arising from the use by the thread industry of a multiple number of undefined and unrelated ticketing systems.

4.2 The practice is used by sewing thread manufacturers to determine the ticket number to be assigned to a sewing thread. The ticket number is an indicator of the amount of raw fiber in the thread. It is based on greige thread rather than finished thread because finishing processes such as bleaching, dyeing, stretching, mercerizing, or sewing finish application significantly change the apparent thread size so that it may become an inadequate indicator of raw fiber present. Because of the foregoing it is not practical to verify the ticket number by sizing the finished thread.

5. Sampling

5.1 *Lot*—Unless otherwise agreed upon between the purchaser and supplier, a lot shall be a discrete manufacturing unit produced in a given period of time not to exceed a calendar month.

5.2 *Lot Sample*—Select the number of specimens as directed in ANSI/ASQC Z1.4 using single sampling with a general inspection level of S1 and a 1.0 AQL.

5.3 *Laboratory Sample*—As a laboratory sample for acceptance testing, take each unit in the lot sample.

5.4 *Test Specimens*—From each package in the laboratory sample, take one specimen.

6. Requirements

6.1 Sewing thread ticket numbers shall be based on the

¹ This practice is under the jurisdiction of ASTM Committee D13 on Textiles and is the direct responsibility of Subcommittee D13.58 on Yarn Test Methods, General. Current edition approved Sept. 10, 2001. Published December 2001. Originally published as D 3823 – 78. Last previous edition D 3823 – 94.

² *Annual Book of ASTM Standards*, Vol 07.01.

³ Available from American National Standards Institute, 11 W. 42nd Street, 13th Floor, New York, NY 10036.