

**RESISTANCE TO SNAGGED THREADS
MACE SNAGGING METHOD**

No use restriction

This is a translation, the French original shall be used in all cases of litigation

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RESISTANCE TO SNAGGED THREADS - MACE SNAGGING METHOD	D44 5600	2/10
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RECORDS

Indice	Date	Nature of modifications
OR	07/12/2005	CREATION OF THE TEST METHOD.
A	18/12/2007	REVISION OF PARAGRAPHS 5.1., 8., 9. AND 11. ADDITION OF PARAGRAPOH 5.2.

PARTICIPANTS

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CONTENTS

1. OBJECT AND FIELD OF APPLICATION	3
2. REFERENCE DOCUMENTS	3
2.1. NORMS	3
2.2. REGULATIONS	3
2.3. OTHERS DOCUMENTS	3
3. TERMINOLOGY AND DEFINITION	3
3.1. DEFINITIONS	3
3.2. ACRONYMS	3
4. PRINCIPLE OF THE TEST METHOD	3
5. EQUIPMENT	4
5.1. MACE SNAGGING	4
5.2. STEMS STANDARD OR CONESHAPED DIPSTICK GRADUATED	5
5.3. CONDITIONED ROOM	5
6. PREPARATION OF THE SOLUTIONS	5
7. SAMPLE REPRESENTATIVENESS	5
8. PREPARATION OF THE TEST-TUBES	5
9. PROCEDURE	6
10. REMARKS	6
11. EXPRESSION OF THE RESULTS	6
12. TEST REPORT	7
ANNEXE SCALE OF STANDARD PHOTOGRAPH (ICI)	8

1.OBJECT AND FIELD OF APPLICATION

This method has as an aim the evaluation of the resistance of the textiles to drawn wire.

2.REFERENCE DOCUMENTS

2.1.NORMS

[A10 0153](#) TEST REPORT - DRAFTING

2.2.REGULATIONS

Not applicable.

2.3.OTHERS DOCUMENTS

Not applicable.

3.TERMINOLOGY AND DEFINITION

A dictionary (glossary) of the main terms used in the Amont Technico Industriel (Technical Industrial Upstream) activities and of their definitions can be consulted in-house via the [Nectar](http://nectar.inetpsa.com) glossary (<http://nectar.inetpsa.com>). This glossary is constantly updated.

3.1.DEFINITIONS

Not applicable.

3.2.ACRONYMS

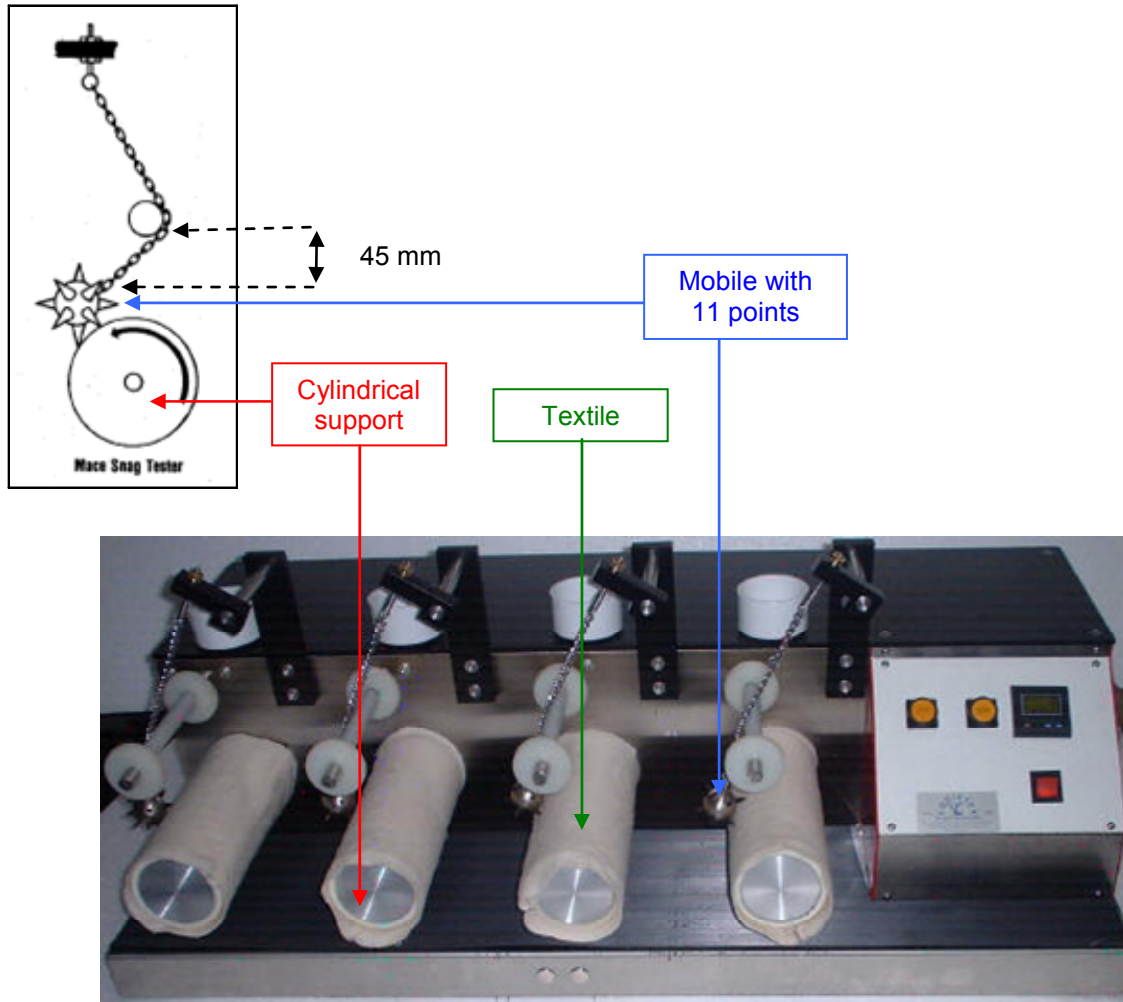
Not applicable.

4.PRINCIPLE OF THE TEST METHOD

The test consists in passing the textile to MACE SNAGGING. The points come to strike the textile of appearance in rotation on a cylindrical component and thus to draw from wire if the textile is sensitive.

5.EQUIPMENT

5.1.MACE SNAGGING



The consumable one for this machine is the following:

- **Retaining sleeves out of felt**, to replace as soon as their surface becomes rough, has holes, or presents an excessive attrition,
- **Points**, to replace as soon as those are damaged or when it is noted a formation of too severe or irregular tears.
This checking is done by touching by comparing the points in the course of use with pilot points not having never been useful,
- **Rubber seals** allowing to fix the test-tube on the drum.

As an indication, these consumable can be obtained from the limited-liability company:

VERSON VLIES COURCIER LLC (VVC)
 25 rue de Bousbecque - 59126 LINSELLES (France)
 Tel.: + 33.3.20.46 .59.66 - Fax: +.33.3.20.03.17.38
 E-mail: v.gurdal@vvc.fr
 Site: <http://www.vvc.fr/>

5.2.STEMS STANDARD OR CONESHAPED DIPSTICK GRADUATED

5.3.CONDITIONED ROOM

At 23 °C ± 2 °C and 50 % ± 5 % of relative humidity.

6.PREPARATION OF THE SOLUTIONS

Not applicable.

7.SAMPLE REPRESENTATIVENESS

The samples must be representative of the variable to be characterized. To ensure this representativeness, one should know the main characteristics of the studied population. The criteria of selection of samples must be specified in the Test Report (TR), whose contents are defined in the standard [A10 0156](#).

In case of any doubt about sampling, contact the PSA service *DTI/DITV/PMXP/MXP/EMR/GHDD* in order to find out the directives to apply.

8.PREPARATION OF THE TEST-TUBES

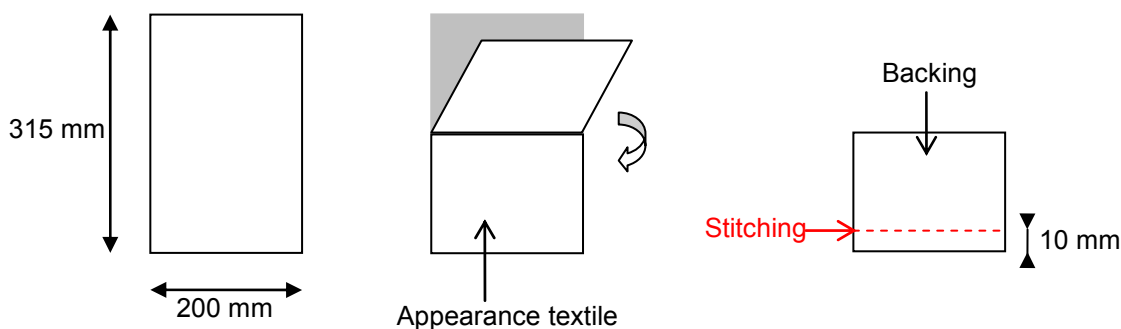
Dimensions of the test-tubes to take in the textile to test are 315 mm ± 2 mm by 200 mm ± 2 mm.

In the case of lines and woofs and of braided, take 4 test-tubes in the longitudinal direction and 4 test-tubes in the direction through.

In the case of bay sizes, take 6 test-tubes in the longitudinal direction and 6 test-tubes in the direction through.

Prepare sufficient test-tubes so that all the types of reasons can be evaluated.

Fold the test-tubes into two in the length direction, with the textile of aspect directed towards the interior, and sew in the direction of the width at 10 mm of the two ends to obtain a cylinder-shaped form.



9. PROCEDURE

- Place the felt retaining sleeve in the center of the drum, wet it with warm water, remove the surplus of moisture, and let dry completely. It is possible to use a low heat to accelerate drying, if necessary. The retaining sleeve will be adjusted narrowly with the drum while shrinking.
- Check the attrition of the points before each test as indicated in the § 5.1.
- Before fixing the test-tubes on the drums, check the presence of blemishes on the test-tubes such as incidental tears, clumps, ... which can influence the evaluation.
- Position the test-tubes on the drum of the testing device so that the textile of aspect is directed towards outside. Fold back the heel piece of seam on each side of the strand of seam. Fix the test-tubes with the rubber seals (see § 5.1.)
- Regulate the distance between the ball and the bar with the chock standard provided with the machine. This distance is about 45 mm \pm 1 mm. Adjust if necessary, the screw on the higher coupling. Check this distance before each test.
- Put the apparatus goes from there at the speed indicated in the normative documents.
- Withdraw the test-tube after the number of cycles indicated in the normative documents.
- Cut the test-tube on the level of the seam in order to observe a plane surface.

10. REMARKS

Not applicable.

11. EXPRESSION OF THE RESULTS

The tendency to drawn ropes is evaluated by practice the following quotation:

- For the observation, eliminate the 1st centimetre all around the test-tube.
- Evaluate the test-tube using the scale of standard photographs (ICI) (see Appendix). This evaluation is expressed by a note going from 1 (much impact) to 5 (not of impact).
- Check if there are wire fractures. **Any wire fracture is judged out of specification.**
- Then, analyze using the stems standard in the following way drawn loop piles:

- **Case of the Lines and Woofs and of braided:**

Measure the highest loop pile for each of the 4 test-tubes of each direction.

The end result is, for each direction and the 4 confused test-tubes, the least good of quotations on the scale and the least good pellet-size of loop pile.

- **Case of the bay sizes:**

On the 6 test-tubes of the longitudinal (all confused test-tubes), measure all the loop piles corresponding to note 1, then with note 2,.... Stop as soon as 5 loop piles are found for the same note (see operating station of quotation below).

Note 1	Note 2	Note 3	Note 4	Note 5	Note 6	Note 7	Note 8
So more than 4 loop piles are \geq 6 mm	So more than 4 loop piles are \geq 4.5 mm	So more than 4 loop piles are \geq 3.5 mm	So more than 4 loop piles are \geq 3 mm	So more than 4 loop piles are \geq 2.5 mm	So more than 4 loop piles are \geq 2 mm	So more than 4 loop piles are \geq 1.5 mm	So more than 4 loop piles are $<$ 1.5 mm

The end result is, for each direction and the 6 confused test-tubes, the least good of quotations on the scale and the note found for the pellet-size of the loop piles.

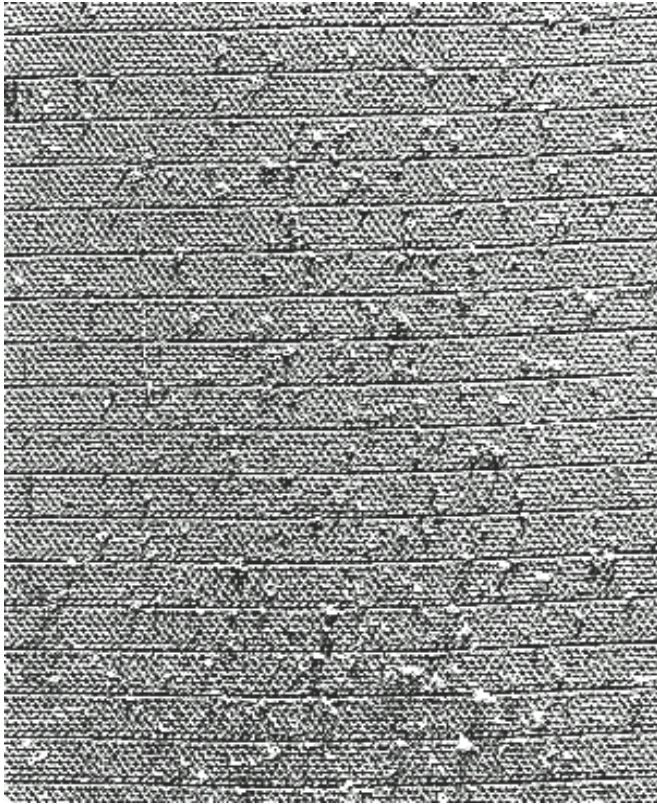
12. TEST REPORT

The form and the minimal contents of the report of test are defined in the standard [A10 0156](#).

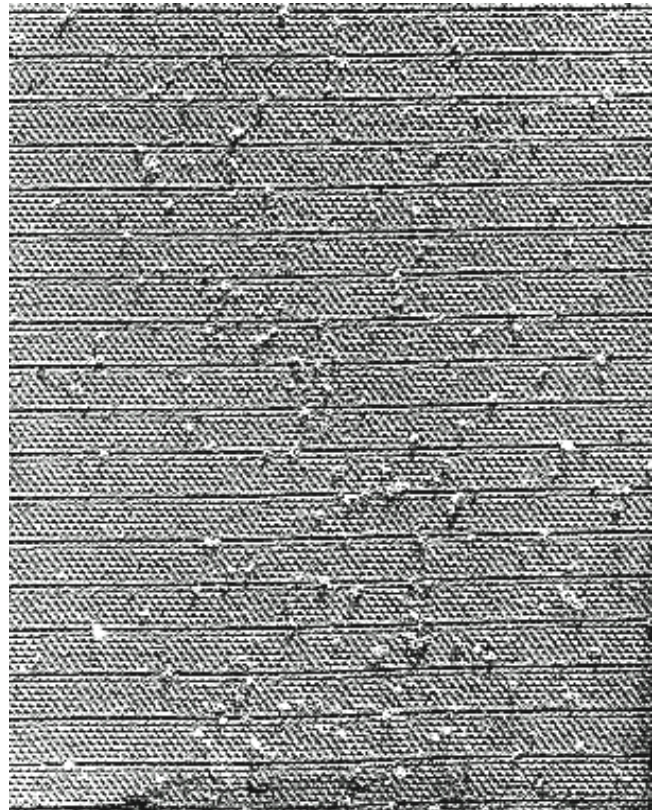
In addition to the results obtained, the test report must indicate:

- the reference of this method,
- particular conditions of test,
- the direction (L or T) of the test-tube,
- the number of cycles realized and speed used if these parameters differ from those specified in the normative documents,
- operational details not envisaged in the method as well as the possible incidents likely to have acted on the results.

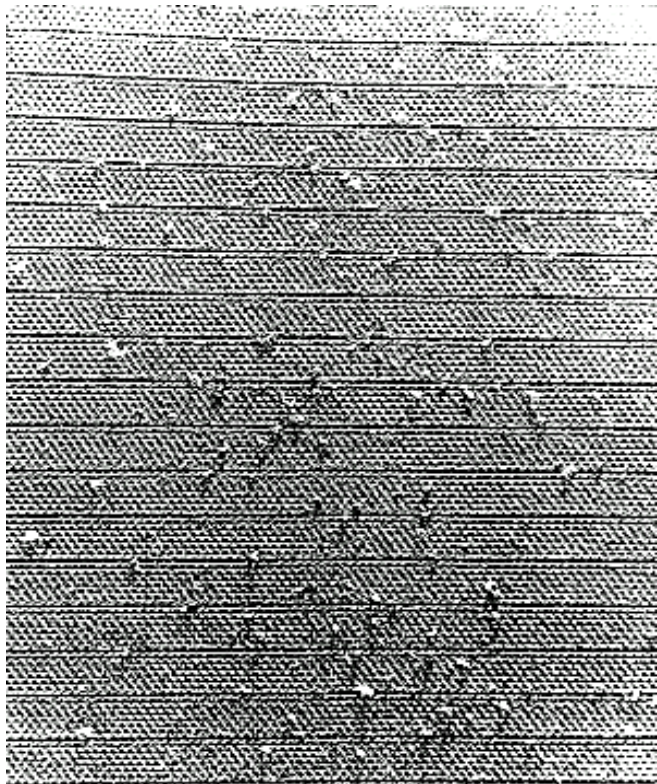
Annexe
Scale of standard photograph (ICI)



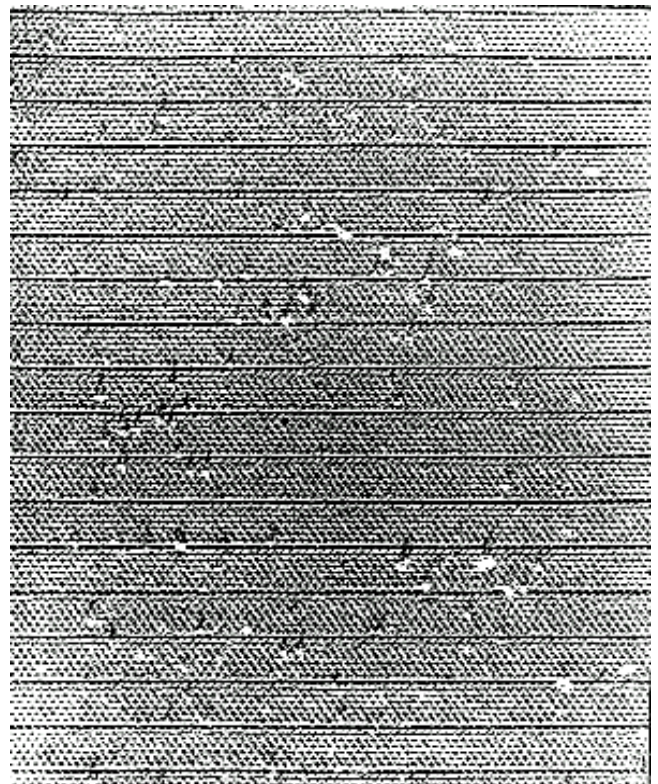
1



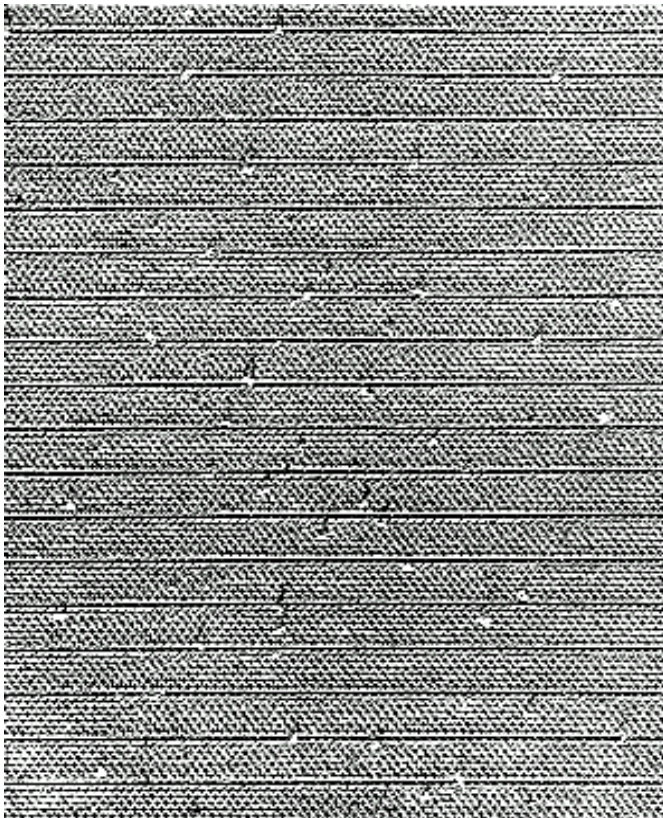
1-2



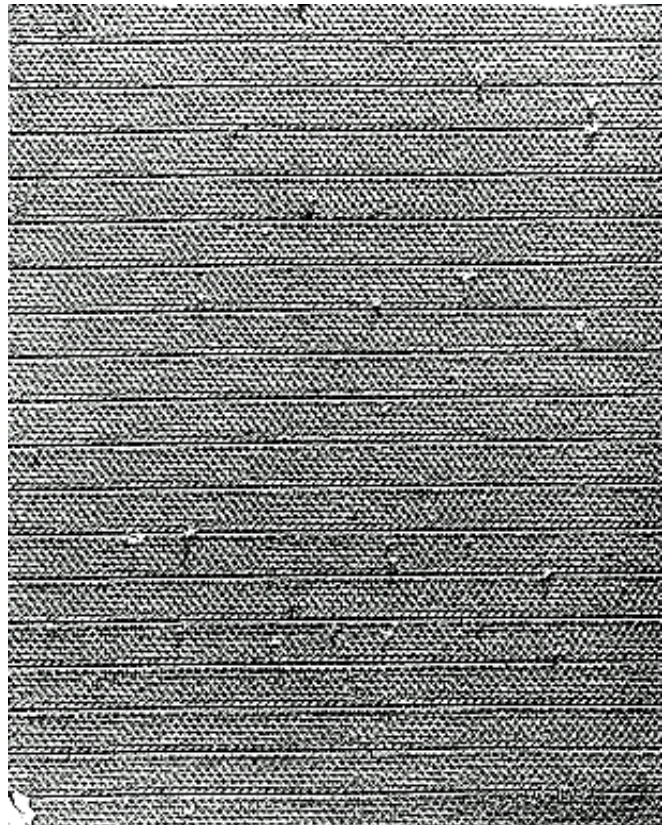
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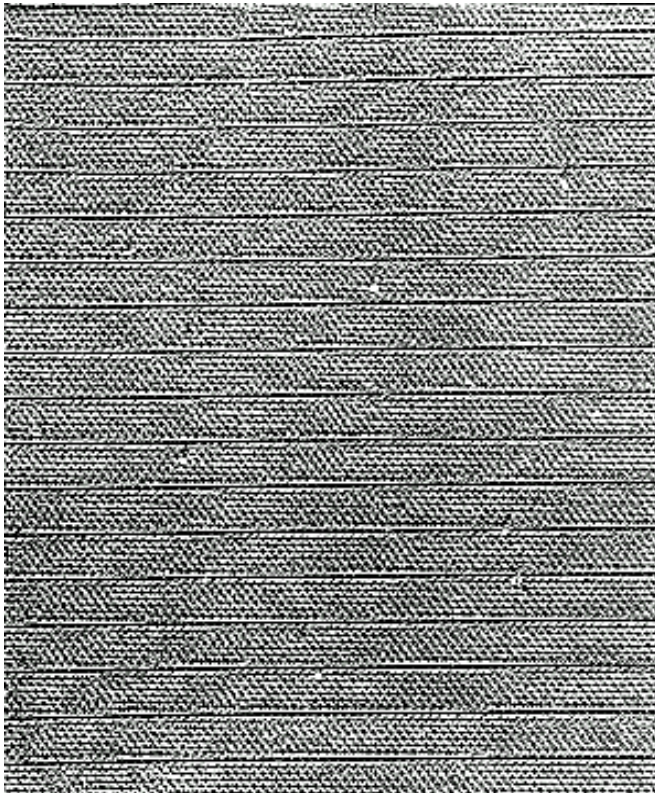
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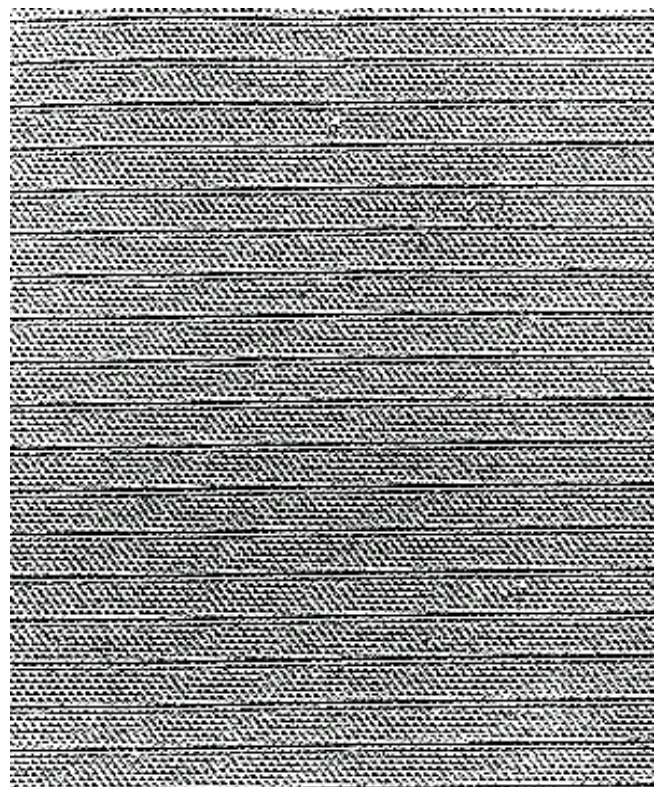
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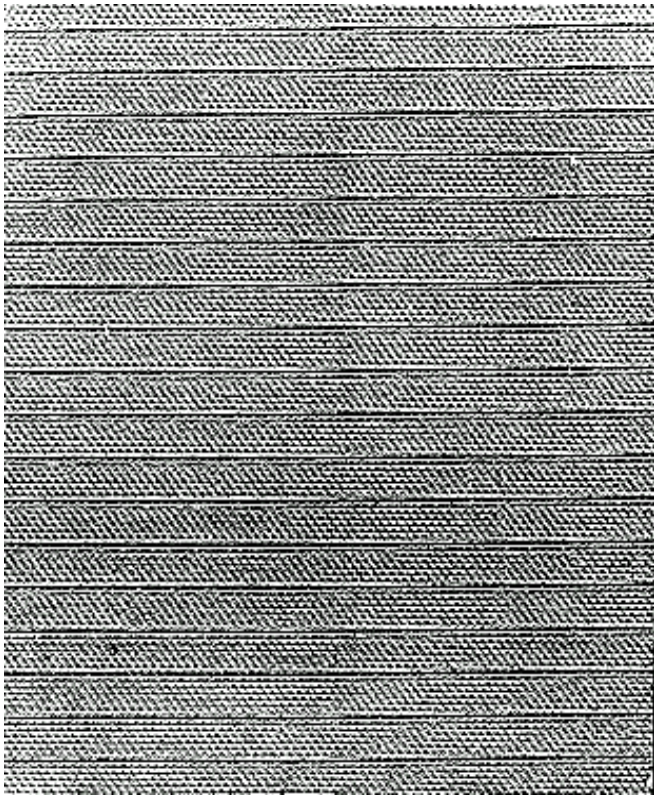
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4-5



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