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**Brand:** Old Navy

**Part One:** Product and Target Market

The product for analysis is a pair of *Sky-Hi* Wide Leg Jeans from the brand *Old Navy*. Fabric content is 99% cotton with an added 1% spandex. The target consumer is women in their 20-30's, living on a lower to middle class income, possibly ranging from \$49,000-\$62,000. Aesthetics the consumer is looking for would be leaning modest, possibly following a business casual dress code. Old Navy is a family focused brand, so it is assumed the customers share similar values when shopping with them. The target consumer does not shop often, usually only out of necessity, and relies on good quality items that last a few seasons, without compromising affordability. Analyzing the brand, Old Navy is known for decent quality denim that is easy to care for, along with a wide range of sizing, furthering their consumer market.

The five most important test results for the Old Navy jeans are wrinkle recovery, hand, drapeability, crocking, and durability strength. Wrinkle recovery was accepted, hand was accepted, the drapability for the front was accepted and the drapability for the back was not accepted as it was too stiff, crocking was not accepted, and durability strength was accepted. Changes recommended to improve product quality would be to improve drapability for the back of the fabric to meet the drapability of the front of the fabric, as well as improving crocking and perspiration. To make these changes in production, we could add elastane which would increase stretch, reduce stiffness, and improve drape. We could also use Tencel to reduce rigidity, or use ring-spun yarns instead of open-end to create a better bending performance. A lower yarn twist could also be used to increase pliability. To improve crocking resistance, we could increase dye fixation through improving/reducing oxidizing cycles, ensure proper yarn penetration, and use pre-reduced indigo with better fixation efficiency to minimize loose dye particles. Lastly, for better perspiration fastness, production could use a perspiration -resistant fixative. Improving these properties in production would create a low to moderate price increase overall.

Given that the target market for the *Sky-Hi* Wide Leg Jeans from Old Navy are shopping for convenience and affordable prices, these changes may not increase purchasability for our shopper, as a price increase may deter them from purchasing.

Our final consensus regarding the Old Navy jeans is accepted, as our customer would be satisfied with the overall performance of the Old Navy *Sky-Hi* Wide Leg Jeans, specifically the durability performance of the jeans which provided excellent results in breaking strength, seam strength, and pilling resistance.

## Part Two: Fabric Characteristics

| Fabric Characteristics         | Test Method     | Specifications  | Testing Results   | Comments  |
|--------------------------------|-----------------|---|---|---|
| Structure                      | Visual Analysis | As a rule, denim is woven as 3/1 twill, 2/1 twill, 3/1 broken twill, or 2/2 broken twill. | Average Warp = 6.79mm/g<br><br>Average Filling = 4.49mm/g   | —   |
| Count (epi X ppi or wpi X cpi) | ASTM D 3775     | 60-64 warp yarns per inch and 38-42 filling yarns per inch                                | <b>Warp:</b> 32.2in <sup>2</sup><br><br><b>Weft:</b> 22in <sup>2</sup>  | <b>Accepted</b>   |
| Fabric Name                    | —               | 100% Cotton Denim   | Left Hand Twill, 2xq weave  | —   |
| Weight                         | ASTM D 3776     | Bottom weight 14.5-ounce denim  | —   | —   |
| Bow/Skew                       | ASTM D 3882     | Bow: 1-2% of fabric width<br>Skew: 2-3%   | <b>Bow:</b><br><b>Sample 1:</b><br>0.39%<br><br><b>Sample 2:</b> 10%<br><br><b>Sample 3:</b> 20%<br><br><b>Skew:</b><br><b>Sample 1:</b><br>13.79%<br><br><b>Sample 2 &amp; 3:</b><br>No skew | <b>Not Accepted</b><br><br>Both the bow and skew are over the spec margin of error. |
| Yarns: Type (all)              | ASTM D 1059     | The drafted cotton fibers twist around the spandex core to produce an elastic ring-spun   | —   | —   |

|                                    |                         |   |           |                 |
|------------------------------------|-------------------------|---|-----------|-----------------|
|                                    |                         | type yarn   |           |                 |
| <b>Size/Number/Denier</b>          | ASTM D 1907             | Warp yarns for bottom weight jeans typically range in size from Ne 4.0 to Ne 12.5/1   | —         | —               |
| <b>Twist &amp; Twist Direction</b> | ASTM D 1422             | combinations of ring and open-end yarns. only Z-twist yarns are formed in open-end yarns, while ring-spun yarns have either Z or S. For that reason, open-end yarn can be used in left-hand twills when a more pronounced twill line is desirable | “S” twist | —               |
| <b>Fiber Content: Qualitative</b>  | ASTM D 20               | Body: Cotton and Spandex  | —         | —               |
| <b>Fiber Content: Quantitative</b> | ASTM 20A                | Body: 99% Cotton, 1% Spandex  | —         | —               |
| <b>Special Purpose Finish</b>      | AATCC 94                | N/A   | —         | <b>Accepted</b> |
| <b>Color: dye or pigment class</b> | No Standard Test Method | Dye   | —         | <b>Accepted</b> |
| <b>Stage When Colored</b>          | Visual Assessment       | Yarn dyed   | —         | <b>Accepted</b> |
| <b>Description of Color</b>        | ASTM D 2616             | Pantone: Dark Denim 19-4118 TCX   | —         | <b>Accepted</b> |

|                                       |             |   |   |   |
|---------------------------------------|-------------|---|---|---|
|                                       |             |  <p><b>PANTONE®</b><br/>19-4118 TCX<br/>Dark Denim</p>   |   |   |
| <b>Color Matching Requirements</b>    | AATCC 9     | <p><math>\Delta E \leq 1.0-1.5</math> is typically acceptable for denim</p> <p>Measurement usually in <i>CIELAB system</i> (<i>L, a, b</i>):</p> <ul style="list-style-type: none"> <li>• <i>L</i>: Lightness (0=black, 100=white)</li> <li>• <i>a</i>: Red-Green axis</li> <li>• <i>b</i>: Yellow-Blue axis</li> </ul> | — | — |
| <b>Fabric Defects/ Fabric Quality</b> | ASTM D 5430 | Level #01-#05 #01 being the worst and #05 being the best  | — | — |

### Part Three: Physical Performance

| Physical Performance                     | Test Method  | Specifications   | Testing Results   | Comments   |
|--|--|--|---|--|
| <b>Durability Tearing Strength</b>       | ASTM D 2261 Tongue (Single Rip)  | <b>Warp: <math>\geq 12</math> lbf</b><br><b>Fill: <math>\geq 10</math> lbf</b> | Ultimate Force<br><br><b>Sample 1:</b> 21.833<br><br><b>Sample 2:</b> 22.067<br><br><b>Sample 3:</b> 22.333<br><br><b>Sample 4:</b> 23.800<br><br><b>Sample 5:</b> 22.933 | <b>Accepted</b><br><br>Durability tearing strength is well above required specification.   |
| <b>Breaking Force</b>                    | ASTM D5034-08 Textile Fabrics Breaking Strength & elongation - Grab Strength | Warp: $\geq 250$ lbf, $\geq 15\%$<br><br>Fill: $\geq 150$ lbf, $\geq 10\%$     | Max elongation %<br><br><b>Sample 1:</b> 44.2%<br><br><b>Sample 2:</b> 45.7%<br><br><b>Sample 3:</b> 43.9%<br><br><b>Sample 4:</b> 45.0%<br><br><b>Sample 5:</b> 43.8%    | <b>Accepted</b><br><br>Our sample data far exceeds the required specification for breaking force.  |
| <b>Bursting Strength (Seam Strength)</b> | ASTM D 3786  | (lbs., min.)<br>40.0 < 9.0<br>45.0 > 9.0                                       | (mm/min)<br><br>Inner Seam<br><br><b>Sample 1:</b> 850<br><br><b>Sample 2:</b> 1,000<br><br><b>Sample 3:</b> 897<br><br>Sample 4: 880                                     | <b>Accepted</b><br><br>The seam bursting strength well exceeds the required specification. The seams were proven to be very durable for the fabric |

|                            |             |                             | <b>Sample 5:</b> 905  | weight.   |
|----------------------------|-------------|-----------------------------|---|---|
| <b>Pilling</b>             | ASTM D 3512 | 30 minute cycle<br>4.0+-0.5 | <b>Sample 1:</b> 4<br>(meets specs)<br><br><b>Sample 2:</b> 5<br>(does not meet)<br><br><b>Sample 3:</b> 5<br>(does not meet)<br><br><b>Sample 4:</b> 5<br>(does not meet)  | <b>Accepted</b><br><br>The test for pilling was accepted as the samples were between 4-t, meeting specifications. |
| <b>Abrasion resistance</b> | ASTM 3884   | Less than 2-3% mass loss    | <b>Sample 1:</b><br>50 Cycles<br>Initial weight: 5.77g<br>Final weight: 5.75g<br>2 grams of lost mass<br><br><u>0.3% mass lost</u><br><br><b>Sample 2:</b><br>65 Cycles<br>Initial weight: 5.82g<br>Final Weight: 5.77g<br>5 grams of lost mass<br><br><u>0.8% mass lost</u><br><br><b>Sample 3:</b><br>50 Cycles<br>Initial weight: 5.83g<br>Final weight: 5.75g<br>8 grams of lost mass | <b>Accepted</b><br><br>This meets specs because it did not lose over 3% of mass                                   |

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|---------------------------------|-------------|------------------------|--|---|
|                                 |             |                        | <u>1.4% mass lost</u><br><br><b>Sample 4:</b><br>50 Cycles<br>Initial weight:<br>5.76g<br>Final weight:<br>5.71g<br>5 grams of lost<br>mass<br><br><u>0.8% mass lost</u><br><br><b>Sample 5:</b><br>50 Cycles<br>Initial weight:<br>5.89g<br>Final weight:<br>5.84g<br>5 grams of lost<br>mass<br><br><u>0.8% mass lost</u><br><br>Average Mass<br>Loss:<br><br><u>0.82% mass lost</u> |   |
| <b>Snagging</b>                 | ASTM D 3939 | 600 cycles<br>4.5+-0.5 | <b>Sample 1:</b> 4<br>(slight<br>Snagging)<br><br><b>Sample 2:</b> 4<br>(slight<br>Snagging)   | <b>Accepted</b><br><br>Meets<br>specifications.<br>The sample had<br>very slight<br>snagging and<br>appeared to be<br>very durable<br>during testing. |
| <b>Colorfastness:<br/>Light</b> | AATCC 16    | (min) 20 AFU -<br>3.5  | 4 - little to no<br>change   | <b>Accepted</b><br><br>The sample was<br>left in direct   |

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|                                 |          |   |   | sunlight for around 6 weeks, showing little to no change in color.   |
| <b>Water Impact Penetration</b> | AATCC 42 | Water Absorbed:<br>Pass Threshold:<br>≤ 20g<br><br>Fail Threshold:<br>> 20g | <b>Sample 1:</b><br>Blotting paper-initial weight: 12.87g<br>Final weight: 32.74g<br>Percentage dry: -154.39%<br><br><b>Sample 2:</b><br>Blotting paper-initial weight: 12.87g<br>Final weight: 33.74g<br>Percentage dry: -162.16%<br><br><b>Sample 3:</b><br>Blotting paper-initial weight: 12.87g<br>Final weight: 33.67g<br>Percentage dry: -171.62%<br><br><b>Average initial weight:</b> 12.87g<br><br><b>Average final weight:</b> 33.36g<br><br><b>Average percentage dry:</b> 159.39% | <b>Not Accepted</b><br><br>Samples #2 and Sample #03 surpassed the fail threshold, therefore we do not accept. |
| <b>Cleaning</b>                 | -----    | -----   | -----   | -----  |
| <b>Accelerated Washing</b>      | AATCC 61 | <b>Minimum:</b>   | <b>Sample 1:</b><br>Denim shade   | <b>Accepted</b>  |

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|                     |          | <p>1 being the worst staining/shade change and 5 being no change</p> <p>Shade change: 3-5<br/>Stain: 3-5</p> | <p>change: 3<br/>Multifiber strip staining: 5</p> <p><b>Sample 2:</b><br/>Denim Shade change: 2-3<br/>Multifiber strip staining: 5</p> <p><b>Sample 3:</b><br/>Denim shade change: 3-4<br/>Multifiber strip staining: 5</p> <p><b>Sample 4:</b><br/>Denim shade change: 3<br/>Multifiber strip staining: 5</p> | <p>Four out of five meet the specifications with low color change and staining.</p>    |
| <b>Crocking</b>     | AATCC 8  | (min) Dry: 3.5<br>Wet 1.5  | <p>Sample 1 color change (wet): 4-5 does not meet</p> <p>Sample 1 color change (dry): 4<br/>Does not meet</p> <p>Sample 2 color staining (wet): 1-2 Meets specs</p> <p>Sample 2 color staining (dry): 3<br/>Meets Specs</p>  | <p><b>Not Accepted</b></p> <p>Two out of four samples did not meet specifications.</p> |
| <b>Perspiration</b> | AATCC 15 | <b>Perspiration Fastness:</b><br>Color change:   | <b>Sample 1:Denim Color Change:</b> 2-3  | <p><b>Not Accepted</b></p> <p>All samples did</p>                                      |

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|  |  | 4.0+-0.5<br>Staining-Cotton:<br>4.0+-0.5   | <b>Sample 1:</b><br><b>Staining-Cotton</b><br>: 5<br><br><b>Sample 2:</b><br><b>Denim Color</b><br><b>Change: 2</b>  | not meet<br>specifications.   |
| <b>Frosting</b>                                    | AATCC 120  | 4.0% +- 0.5%   | —  | —   |
| <b>Dimensional<br/>Stability</b>                   | AATCC 96   | Length x Width<br>3.0 x 3.0  | —  | —   |
| <b>Durable press/<br/>appearance<br/>retention</b> | ASTM 124   | 3-4 / 5 after 5<br>washes  | —  | —   |
| <b>Hand</b>  | ASTM D123 –<br>Standard<br>Terminology for<br>Textile Terms<br>(subjective hand<br>evaluation<br>terminology). | <p>“Moderate hand,” not<br/>crispy; no<br/>excessive<br/>hardness that<br/>would affect<br/>wear comfort</p> <p>Thermal<br/>Element:<br/>- Warm or<br/>Cool</p> <p>Testing Scale: 1<br/>being Coolest, 5<br/>being Warmest</p> <p><b>Physical Touch:</b><br/>Testing Scale: 1<br/>being Smooth, 5<br/>being Rough</p> <p><b>Stiffness:</b><br/>Testing Scale: 1<br/>being the most<br/>Limp and 5<br/>being the most<br/>Stiff</p> | <p><b>Thermal<br/>Element:</b><br/><b>Sample #01:</b><br/>Average 3.2</p> <p><b>Sample #02:</b><br/>Average 2.7</p> <p><b>Sample #03:</b><br/>Average 3.1</p> <p><b>Physical Touch:</b><br/><b>Sample #01:</b><br/>Average 2.7</p> <p><b>Sample #02:</b><br/>Average 2.8</p> <p><b>Sample #03:</b><br/>Average 2.3</p> <p><b>Stiffness:</b><br/><b>Sample #01:</b><br/>Average 2.8</p> <p><b>Sample #02:</b><br/>Average 2.4</p> <p><b>Sample #03:</b><br/>Average 2.9</p> | <p><b>Accepted</b></p> <p>Hand was<br/>accepted as there<br/>was no<br/>excessive<br/>hardness that<br/>would affect<br/>wear or comfort.</p> |

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| <b>Absorbency<br/>(Wicking)</b> | AATCC 79 | 50–150% for<br>100% cotton<br>denim | <p><b>Sample #01</b><br/> <b>Filling:</b><br/>           Starting: 1"<br/>           Wick: 2 <math>\frac{3}{4}</math>"<br/> <br/> <u>36.36%</u><br/> <u>Does not meet</u><br/> <u>specs</u></p> <p><b>Sample #02</b><br/> <b>Filling:</b><br/>           Starting: 1"<br/>           Wick: 3"<br/> <br/> <u>33.33%</u><br/> <u>Does not meet</u><br/> <u>specs</u></p> <p><b>Sample #03</b><br/> <b>Filling</b><br/>           Starting: 1"<br/>           Wick: 2.75"<br/> <br/> <u>36.36%</u><br/> <u>Does not meet</u><br/> <u>specs</u></p> <p><b>Sample #01</b><br/> <b>Warp:</b><br/>           Starting: 1"<br/>           Wick: 3.5"<br/> <br/> <u>28.57%</u><br/> <u>Does not meet</u><br/> <u>specs</u></p> <p><b>Sample #02</b><br/> <b>Warp:</b></p> | <p><b>Not Accepted</b></p> <p>All samples failed to meet specification, except for Sample #03 Warp.</p> |

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|                                     |            |                                       | <p>Starting: 1”<br/>Wick: 3.5”</p> <p><u>28.57%</u><br/><u>Does not meet</u><br/><u>specs</u></p> <p><b>Sample #03</b><br/><b>Warp:</b><br/>Starting: 2.5”<br/>Wick: 3.625”</p> <p><u>68.97%</u><br/><u>Meets specs</u></p> <p>Average Wick:<br/>3.275”</p> |  |
| <b>Water repellency/ resistance</b> | AATCC 22   | Rating 70–100 (AATCC 0–100 scale)     | <p><b>Sample 1:</b> 0<br/>Complete wetting of the entire face of specimen</p> <p><b>Sample 2:</b> 0</p> <p><b>Sample 3:</b> 0</p>   | <p><b>Not Accepted</b></p> <p>All samples had complete wetting of the entire face of the specimen.</p> |
| <b>Flammability</b>                 | ASTM D6413 | Average burn time: $\geq 3.5$ seconds | <p>5 samples warp and weft</p> <p><b>Warp:</b></p> <p><b>Average Open Flame Time:</b><br/>1:03 minutes</p> <p><b>Average Afterglow Time:</b> 4 minutes</p> <p><b>Weft:</b></p> <p><b>Average Open Flame time:</b></p>                                       | <p><b>Not Accepted</b></p> <p>All samples did not meet specification.</p>                              |

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|                               |            |                          | <p>1:02 minutes</p> <p><b>Average Afterglow Time:</b> 4.50 minutes</p> <p>Does not meet specs because the open flame is longer than 3.5 seconds</p>   |  |
| <b>Elongation/ elasticity</b> | ASTM D5034 | Warp: 2–3%<br>Weft: 4–5% | <p>Sample #01: 50.9%</p> <p>Sample #02: 49.6%</p> <p>Sample #03: 50.7%</p> <p>Sample #04: 41.3%</p> <p>Sample #05: 49.9%</p> <p>Sample #06: 50.9%</p> <p>Sample #07: 51.2%</p> <p>Sample #08: 45.2%</p> | <p><b>Accepted</b></p> <p>Our samples well exceeded the needed specification for elongation/elasticity.</p>                    |
| <b>Drape</b>                  |            | 70-80%                   | <p><b>Front of Fabric:</b> 64.52% (stiff) Meets Specs</p> <p><b>Back of Fabric:</b> 87.44% (stiff) Does not meet specs</p>  | <p><b>Not Accepted</b></p> <p>The front of the fabric was 64.52% - stiff while still meeting specs. The back of fabric was</p> |

|                  |                           |   |   |  |
|------------------|---------------------------|---|---|--|
|                  |                           |   |   | 87.44%, stiff while not meeting specs.   |
| <b>Stiffness</b> | ASTM D1388                | Testing Scale: 1 being the most Limp and 5 being the most Stiff         | <p><b>Stiffness:</b></p> <p><u>Sample #01:</u><br/>Ripley: 2.5<br/>Autumn: 2.5<br/>Sophia: 3<br/>Brigitta: 3<br/>Max: 3</p> <p><b>Average:</b> 2.8</p> <p><u>Sample #02:</u><br/>Ripley: 2<br/>Autumn: 2.4<br/>Sophia: 2.8<br/>Brigitta: 2.5<br/>Max: 2.5</p> <p><b>Average:</b> 2.44</p> <p><u>Sample #03:</u><br/>Ripley: 3<br/>Autumn: 2.5<br/>Sophia: 3<br/>Brigitta: 3<br/>Max: 3</p> <p><b>Average:</b> 2.9</p> | <p><b>Accepted</b></p> <p>Each group member wrote ratings for each sample and then the average of all ratings was calculated. These averages aligned with the product and its stiffness needs.</p> |
| <b>Creasing</b>  | ASTM D1295                | Appearance rating 3–4/5 after 5 washes                                  | —   | —  |
| <b>Wrinkling</b> | AATCC 66 Wrinkle Recovery | Warp: greater than or equal to 55-60. Weft: greater than or equal 50-55 | <p><b>Sample #01:</b> 3</p> <p><b>Sample #02:</b> 3</p> <p><b>Sample #03:</b> 4</p>   | <p><b>Accepted</b></p> <p>Sample pieces showed strong wrinkle recovery</p>   |

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|--|--|---|---|--|
|  |  | <p>degrees<br/>Samples are ranked on a scale from 1 to 5, 1 being the most wrinkled and 5 being the least wrinkled.</p> | <p><b>Sample #04:</b> 3<br/><b>Sample #05:</b> 3<br/><b>Sample #06:</b> 4</p> | <p>- minimal wrinkles remained after 24 hours.</p> |
|--|--|---|---|--|

#### Part Four: Product Characteristics

| Product Characteristics     | Test Method   | Specifications                   | Testing Results                                | Comments                                    |
|-----------------------------|---|----------------------------------|--|---|
| <b>Components</b>           | Waistband, pockets, pant legs, waistband loops                        | —                                | —  | —   |
| <b>Materials</b>            | Knit cotton, cotton lining, thread, rivet, metal zipper, metal button | —                                | —  | —   |
| <b>Thread Type and Size</b> | ASTM D 204  | Polyester thread, tex $60 \pm 5$ | —  | —   |
| <b>Lining</b>               | ASTM D 276  | 3oz/yd <sup>2</sup> +- 0.20      | —  | —   |
| <b>Closures</b>             | Metal zipper and metal button   | —                                | —  | —   |
| <b>Stitch Density</b>       | ASTM D 6193   | 6-8 Stitch per Inch              | —  | —   |
| <b>Seam/Hem Strength</b>    | ASTM D1683  | 100 lbf +- 10                    | Results on page 14                             |   |
| <b>Seam Density</b>         |   | 10-12 SPI<br>3-inch sample       | 516 5-Thread Safety<br><b>Sample 1:</b> 11 SPI | <b>Accepted</b><br>Average samples meet the |

|                            |                         |                           |   |  |
|----------------------------|-------------------------|---------------------------|---|--|
|                            |                         |                           | <b>Sample 2:</b> 11<br>SPI<br><br><b>Sample 3:</b> 10<br>SPI<br><br><b>Sample 4:</b> 9 SPI<br><br><b>Sample 5:</b> 9 SPI<br><br><b>Sample 6:</b> 10<br>SPI<br><br><b>Average SPI</b><br><b>Approx:</b> 10                         | specification for a 3-inch sample.   |
| <b>Stitch Type</b>         | ASTM D6193              |                           |   |  |
| <b>Seam/Hem appearance</b> | ASTM D6193              | 3 inch sample<br>9-12 SPI | 516 Seam<br><br><b>Sample 1:</b> 10<br>SPI<br><br><b>Sample 2:</b> 10<br>SPI<br><br><b>Sample 3:</b> 10<br>SPI<br><br><b>Sample 4:</b> 11<br>SPI<br><br><b>Sample 5:</b> 11<br>SPI<br><br><b>Average SPI</b><br><b>Approx:</b> 10 | <b>Accepted</b><br><br>All samples meet the specification range for a 3-inch sample. |
| <b>Care Label Content</b>  | ASTM D 276              | N/A                       | —   | —  |
| <b>Seams/Slippage</b>      | ASTM D163               | 30 lbf $\pm$ 3            | —   | —  |
| <b>Seam/Hem Allowance</b>  | No Standard Test Method | —                         | —   | —  |

|                         |   |   |   |   |
|-------------------------|---|---|---|---|
| <b>Closures</b>         | No Standard Test Method   | Metal zipper and button   | — | — |
| <b>Cost</b>             | No Standard Test Method   | \$44.95 (Style #732521)   | — | — |
| <b>Put-up/Packaging</b> | In plastic bag from factory to store/consumer   | Folding spec: fold in half along the crotch and inseam so both legs are aligned. Then fold pant legs to mid leg length and fold again so that the size sticker is facing up | — | — |
| <b>Labeling</b>         | Sticker with size on left pant leg. Paper label with size and price on the front left side waistband seam | —   | — | — |

## Part Five: Performance & Evaluation

| Performance & Evaluation | Test Method             | Specs                                |
|--------------------------|-------------------------|--------------------------------------|
| <b>Cost</b>              | No Standard Test Method | \$44.95 (Style #732521)              |
| <b>Durability</b>        | —                       | —                                    |
|                          | ASTM D5034              | Warp $\geq$ 578 N, Fill $\geq$ 244 N |
|                          | ASTM D5035              | Warp $\geq$ 667 N, Fill $\geq$ 267 N |

| Performance & Evaluation | Test Method | Specs | Testing Results | Comments |
|--------------------------|-------------|-------|-----------------|----------|
|                          |             |       |                 |          |

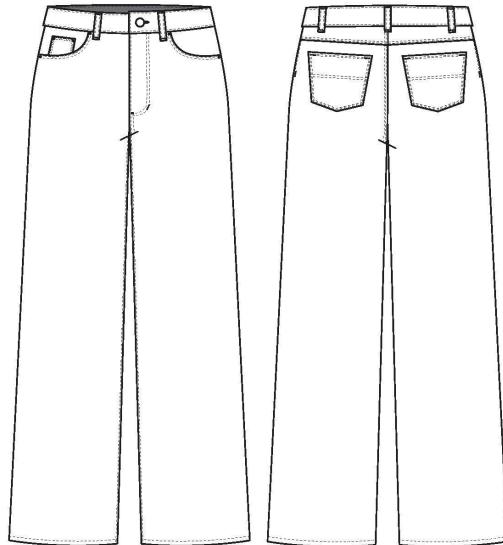
|                                       |            |  |  |   |
|---------------------------------------|------------|--|--|---|
| <b>Care/Appearance Retention</b>      | —          | —  | —  |   |
| <b>Color Fastness to Laundering</b>   | AATCC TM61 | Grade $\geq 4$ for color change and staining after laundering        | —  |   |
| <b>Color Fastness to Light</b>        | AATCC TM16 | Grade $\geq 4$ for colorfastness to light after 2 months             | 4 - little to no change  | <b>Accepted</b><br><br>Sample meets the color fastness specification.   |
| <b>Color Fastness to Perspiration</b> | AATCC TM15 | Grade $\geq 2$ for colorfastness to perspiration (acid and alkaline) | <b>Sample 1:</b><br>Denim color change: 2-3<br><br><b>Sample 2:</b><br>Denim color change: 2<br><br>Multifiber strip color staining: 5<br><br>Multifiber strip color staining: 3-4 | <b>Accepted</b><br><br>All samples had a denim color change and multifiber strip staining within the specifications |
| <b>Comfort Safety</b>                 | MTC 501    | Class I, Standard Flammability                                       | —  | —   |

## Part Six: Acceptance Levels

| Acceptance Levels              | Test Method | Specs  |
|--------------------------------|-------------|--|
| <b>Criteria for Acceptance</b> | ASTM D6554  | <b>Breaking Strength:</b> Warp $\geq 578$ N, Fill $\geq 244$ N<br><b>Tear Strength:</b> Warp $\geq 35$ N, Fill $\geq 15$ N |

|   |  |   |
|---|--|---|
|   |  | <b>Seam Slippage</b> ( $\frac{1}{4}$ " separation): $\geq 133$ N<br><b>Skewness</b> : 2x1 Twill - 4.5% $\pm 3\%$<br><b>Dimensional Change</b> : $\leq 4\%$<br><b>Flammability</b> : Class I |
| <b>Accept/Reject &amp; Why</b>                | No Standard Test Method  | N/A   |
| <b>Defect Level and Types</b>                 | Defects would be found through running all the tests of the <i>Physical Performance</i> and <i>Product Characteristics</i> categories. | Level #01-#05<br>#01 being the worst, and #05 being the best.   |
| <b>Suggested Product Changes &amp; Impact</b> | No Standard Test Method  | N/A   |

## Part Seven: Sample Measurements



**Zone 1:** Crotch down

**Zone 2:** Back

**Zone 3:** Crotch up

| Part Being Measured                      | Seam Type                                       | Measurement   |
|--|---|---|
| <b>Side Seam</b>                         | LSq   | 43 $\frac{1}{4}$ " $\pm \frac{1}{8}$ "  |
| <b>Inseam</b>                            | LSc Seam with 504 Overedge stitch               | 31 $\frac{1}{2}$ " $\pm \frac{1}{8}$ "  |
| <b>Leg Opening</b>                       | EFb Seam 301 Lockstitch                         | 21" $\pm \frac{1}{8}$ "   |
| <b>Leg Band Height</b>                   | N/A   | $\frac{3}{4}$ " $\pm \frac{1}{8}$ "   |
| <b>Symmetry:</b>                         |   | Both leg circumferences and leg lengths must be symmetrical $\pm \frac{1}{8}$ " |
| <b>Waistband:</b><br>● Width<br>● Height | EFa Seam with 406 Coverstitch & 401 Chainstitch | Width: 43" $\pm \frac{1}{8}$ "<br>Height: 1 $\frac{1}{2}$ " $\pm \frac{1}{8}$ " |

|                                    |                                   |                                       |
|------------------------------------|-----------------------------------|---------------------------------------|
| <b>Pocket:</b><br>● Opening Length | SSi Seam with 504 Overedge stitch | 7 $\frac{1}{4}$ " $\pm \frac{1}{8}$ " |
| <b>Crotch:</b>                     | Lsas Seam with 301 lockstitch     | 34" $\pm \frac{1}{8}$ "               |

## Tearing Strength and Breaking Strength Charted Results

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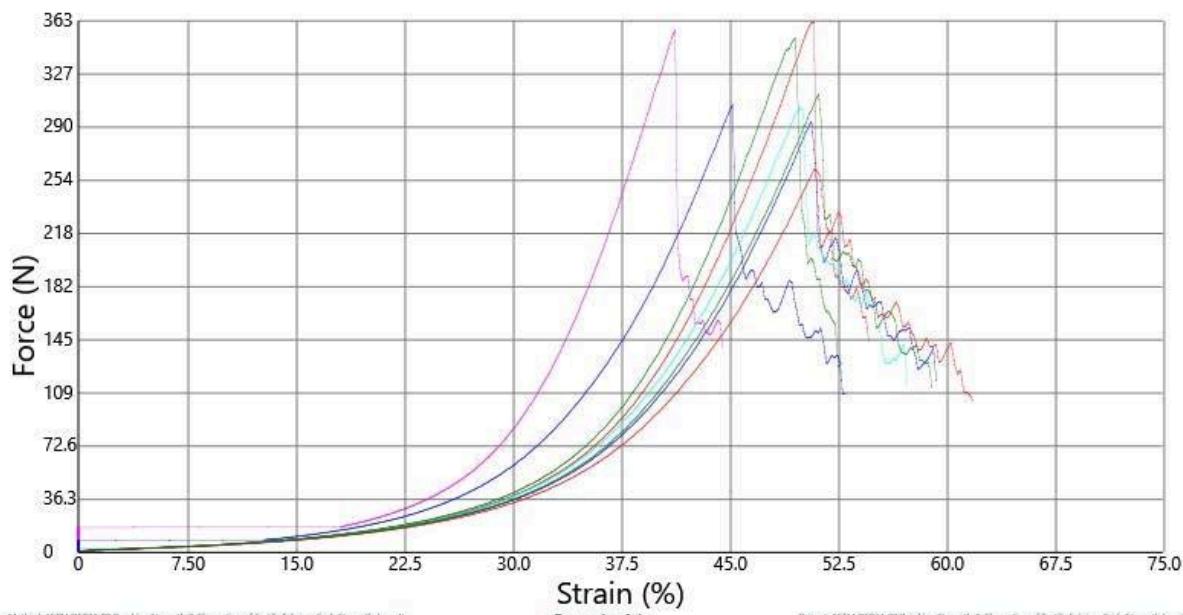
Iowa State University  
ASTM D5034-08 Textile Fabrics  
Breaking Strength & Elongation - Grab Strength

Lot: 1  
Style: filling  
Color: Denim  
Operator: chunhui  
Start Date: 11 Nov, 2025

Temperature: Ambient  
Humidity: Ambient  
Gage Length: 75.0 mm  
Test Speed: 300 mm/min  
Preload: 1.00 N

Direction: Filling

|         | Breaking Force<br>N | Max Elongation<br>% |
|---------|---------------------|---------------------|
| 362     | 50.9                |                     |
| 351     | 49.6                |                     |
| 294     | 50.7                |                     |
| 356     | 41.3                |                     |
| 303     | 49.9                |                     |
| 262     | 50.9                |                     |
| 313     | 51.2                |                     |
| 306     | 45.2                |                     |
| Average | 318                 | 48.7                |
| SD      | 35.2                | 3.6                 |



Method: ASTM D5034-08 Breaking Strength & Elongation of Textile Fabrics -Grab Strength (rev. 4)  
v10.4.0.3 - 803778GB - Iowa State University

- Page 1 of 1 -

Output: ASTM D5034-08 Breaking Strength & Elongation of Textile Fabrics -Grab Strength (rev. 6)  
H5KT/150 : 500DN. Printed: 11/11/2025 1:15 PM

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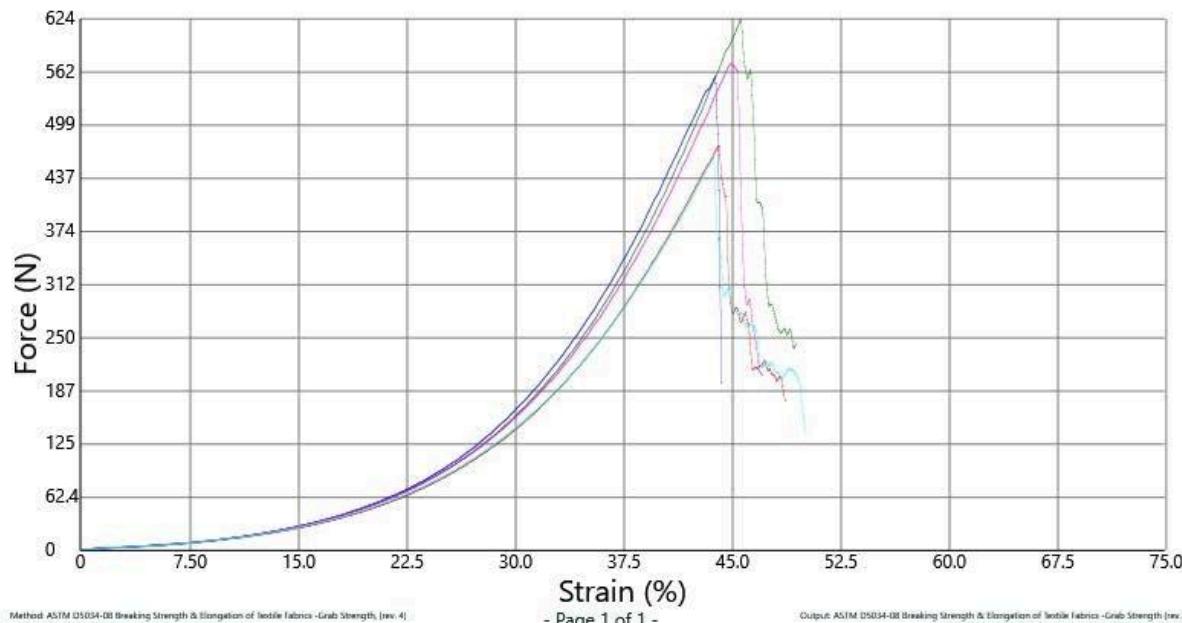
Iowa State University  
ASTM D5034-08 Textile Fabrics  
Breaking Strength & Elongation - Grab Strength

Lot: 1  
Style: Warp  
Color: Denim  
Operator: chunhui  
Start Date: 11 Nov, 2025

Temperature: Ambient  
Humidity: Ambient  
Gage Length: 75.0 mm  
Test Speed: 300 mm/min  
Preload: 1.00 N

### Direction: Warp

|         | Breaking Force<br>N | Max Elongation<br>% |
|---------|---------------------|---------------------|
| 475     | 44.2                |                     |
| 623     | 45.7                |                     |
| 556     | 43.9                |                     |
| 572     | 45.0                |                     |
| 462     | 43.8                |                     |
| Average | 538                 | 44.5                |
| SD      | 68.0                | .8                  |



Arc'Teryx  
ASTM D 434: 1995  
Resistance to Slippage of Yarns in Woven Fabrics Using a Standard Seam

Batch Start Date and Time: 11/13/2025 12:15 PM

PO#:

Lot:

2

Style:

Inner Seam

Color:

Denim

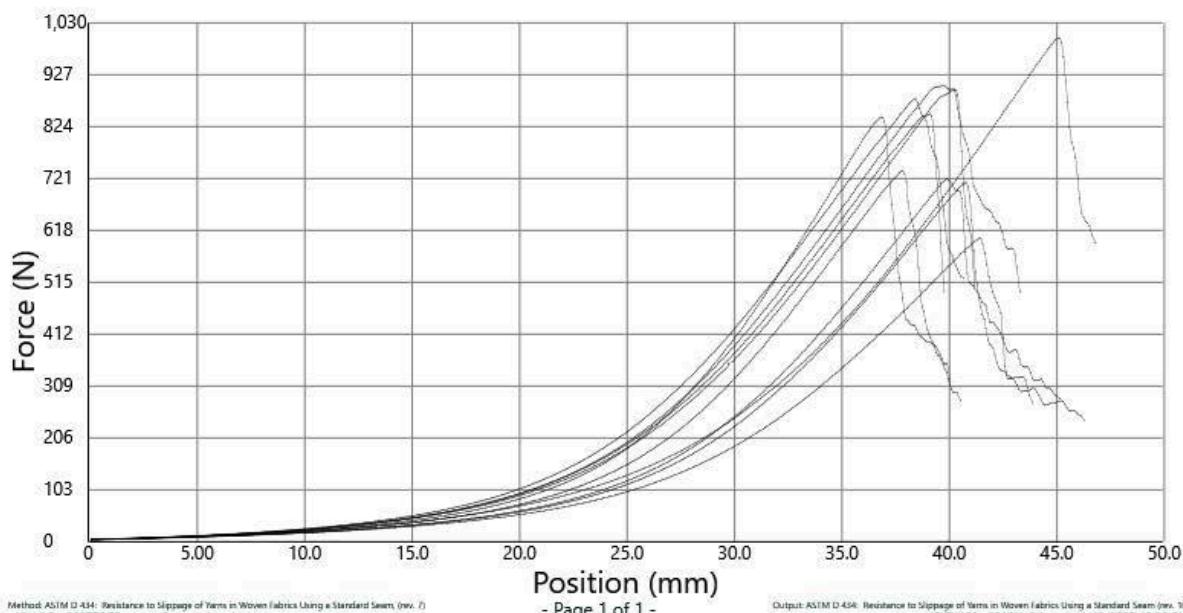
Technician:

Group 1

Ambient Temperature: Ambient  
Relative Humidity: Ambient  
Jaw separation: 75.0 mm  
Speed: 300 mm/min  
Compensation Load: 4.50 N  
Seam Opening: 6.40 mm

Direction: Cross Direction: MD Seam

| Fabric Breaking Force<br>N | Seam Breaking Force<br>N | Seam Slippage<br>N | Attributes           |
|----------------------------|--------------------------|--------------------|----------------------|
| 713                        | 850                      | N/F                | Fabric tears at seam |
| 602                        | 1,000                    | N/F                | Fabric tears         |
| 720                        | 897                      | N/F                | Fabric tears at jaws |
| 735                        | 880                      | N/F                | Fabric tears at seam |
| 843                        | 905                      | N/F                | Fabric tears at seam |
| Average                    | 906                      | N/A                |                      |
| SD                         | 56.5                     | N/A                |                      |



Method: ASTM D 434: Resistance to Slippage of Yarns in Woven Fabrics Using a Standard Seam (rev. 7)  
v10.4.0.3 - 803778GB - Iowa State University

- Page 1 of 1 -

Output: ASTM D 434: Resistance to Slippage of Yarns in Woven Fabrics Using a Standard Seam (rev. 10)  
HSKT/150 : 5000N. Printed: 11/13/2025 12:29 PM

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Iowa State University  
ASTM D 2261 - 11

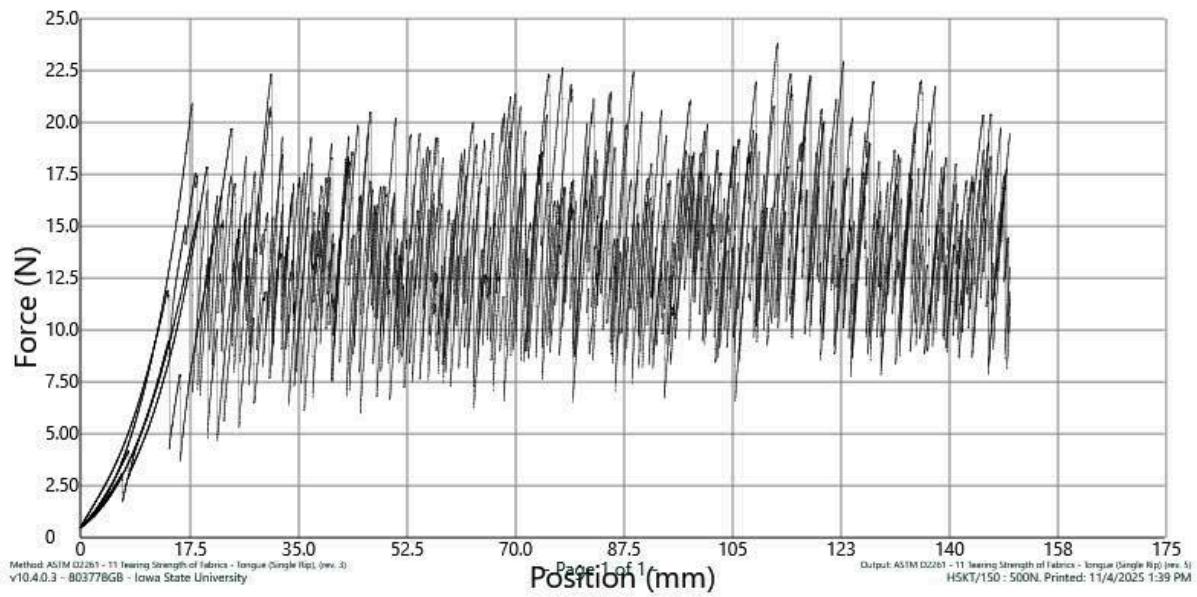
### Tearing Strength of Fabrics - Tongue (Single Rip)

Lot: 1  
Style: Denim  
Color: Blue  
Operator:  
Batch Start Date and Time: 11/4/2025 1:15 PM

Temperature: Ambient  
Humidity: Ambient  
Nominal Grip Separation: 75.0 mm  
Test Speed: 50.0 mm/min  
Take-Up load: 0.50 N  
Pull Length: 150 mm

#### Direction: Fill

| Number of Peaks<br>(Option 1) | Avg 5 Highest Peaks<br>(Option 1) | Ultimate Force<br>(Option 2) |
|-------------------------------|-----------------------------------|------------------------------|
| N                             | N                                 | N                            |
| 75                            | 20.847                            | 21.833                       |
| 73                            | 20.053                            | 22.067                       |
| 68                            | 21.743                            | 22.333                       |
| 65                            | 22.210                            | 23.800                       |
| 66                            | 22.450                            | 22.933                       |
| Average                       | 21.461                            | 22.593                       |
| SD                            | 0.997                             | 0.790                        |



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Iowa State University  
ASTM D 2261 - 11

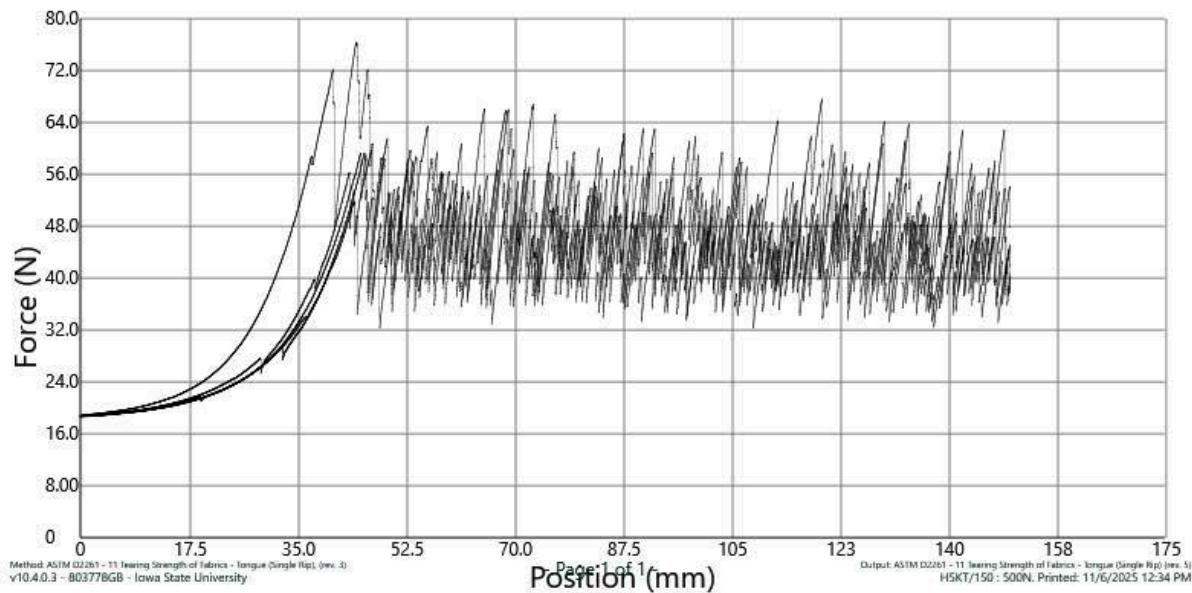
### Tearing Strength of Fabrics - Tongue (Single Rip)

Lot: 1  
Style: Denim  
Color: Blue  
Operator:  
Batch Start Date and Time: 11/6/2025 12:12 PM

Temperature: Ambient  
Humidity: Ambient  
Nominal Grip Separation: 75.0 mm  
Test Speed: 50.0 mm/min  
Take-Up load: 0.50 N  
Pull Length: 150 mm

#### Direction: Warp

| Number of Peaks<br>(Option 1) | Avg 5 Highest Peaks<br>(Option 1) | Ultimate Force<br>(Option 2) |
|-------------------------------|-----------------------------------|------------------------------|
| N                             | N                                 | N                            |
| 53                            | 64.177                            | 67.600                       |
| 51                            | 65.657                            | 66.750                       |
| 51                            | 67.460                            | 76.300                       |
| 55                            | 59.080                            | 62.933                       |
| 46                            | 58.653                            | 65.750                       |
| Average                       | 63.006                            | 67.867                       |
| SD                            | 3.956                             | 5.031                        |



## Meeting Minutes:

### **Week 4:**

- Planned out our semester schedule
- Completed Bow & skew testing
- Set up Colorfastness to Light in classroom

### **Week 5:**

- Completed Hand test

### **Week 6:**

- Completed Drapability Testing

### **Week 7:**

- Completed Drapability Testing
- Started Elongation/elasticity testing

### **Week 8:**

Spring Break

### **Week 9:**

- Started flammability test
- Finished Elongation/elasticity testing

### **Week 10:**

- Finished flammability test

### **Week 11:**

- Completed bursting strength test
- Completed abrasion resistance test
- Completed Perspiration Test

### **Week 12:**

- Completed Snagging test
- Completed pilling test
- Prepped Wrinkle recovery testing

### **Week 13:**

- Completed Absorbency(wicking) test
- Completed water repellency/Resistance test
- Finished Wrinkle recovery testing

### **Week 14:**

- Completed Accelerated Washing test
- Completed Stiffness test

### **Week 15:**

- Wrapped up testing and worked on final paper

## Work Cited

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JC Penny Pamphlet