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PILE FABRICS FOR INSULATION

WADC TECHNICAL REPORT 54-374

PILE FABRICS FOR INSULATION

CHARLES W. LONG

MATERIALS LABORATORY

JUNE 1955

PROJECT No. 7320

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This report covers work conducted from August 1952 to August 1954.

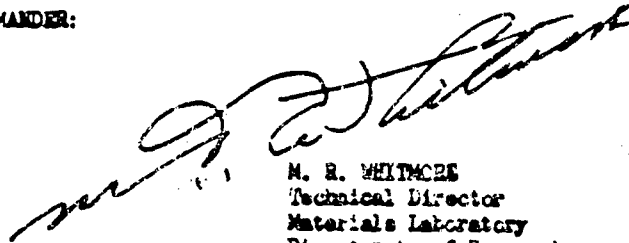
ABSTRACT

This is a report on pile fabrics made from synthetic fibers, cotton, wool and numerous blends thereof. There were three techniques employed in the construction of the pile fabrics developed under this project: (1) woven cut pile fabrics by Goodall Sanford, Inc., (2) inserted pile, knitted fabrics by George W. Borg Corporation and (3) napped and/or brushed pile, knitted fabrics by Princeton Knitting Mills, Inc. All the samples developed were compared to the standard wool pile fabric made according to requirements of AF Specification MIL-C-5563. Each sample was tested for warmth and compression characteristics to determine the effect, if any, of varying thicknesses, blends, and constructions. It was observed that the type fiber has little effect on the warmth of a pile fabric; however, Orlon, Dacron and Dynel consistently appear slightly better. Results show that possibly a double thickness of a relatively thin pile fabric should deserve consideration. Also included in this report are the results of a study on the mathematical relationship between the warmth of a fabric and the physical properties of the fabric.

PUBLICATION REVIEW

This report has been reviewed and is approved.

FOR THE COMMANDER:



M. R. WHITMORE
Technical Director
Materials Laboratory
Directorate of Research

TABLE OF CONTENTS

	<u>Page</u>
INTRODUCTION	vii
I PILE FABRICS FOR INSULATION	1
II DISCUSSION OF TEST METHODS	7
III CALCULATION OF CONDUCTANCE	10
IV BIBLIOGRAPHY	16
V APPENDIX I	17

LIST OF ILLUSTRATIONS

Figure		Page
1	Thermal Conductance Tester	8
2	Compressibility Tester	9
3	Conductance Versus Degree of Porosity Curve	15
4	Compression Curves for Samples 458, 460 and 462.	18
5	Compression Curves for Samples 464, 466 and 468.	19
6	Compression Curves for Samples 470, 472 and 474.	20
7	Compression Curves for Samples 476, 478 and 480.	21
8	Compression Curves for Samples 482, 484 and 486.	22
9	Compression Curves for Samples M11, M13 and M15.	23
10	Compression Curves for Samples M14, M15, M16 and M17.	24
11	Compression Curves for Samples M18, M19 and M20.	25
12	Compression Curves for Samples 1, 2 and 4.	26
13	Compression Curves for Samples 3, 5 and 8.	27
14	Compression Curves for Samples 6, 7 and 9.	28
15	Porosity Versus Thickness Curves for Samples 8, 456, 462 and 464.	29
16	Porosity Versus Thickness Curves for Samples 6, 7, 468 and 484.	30
17	Porosity Versus Thickness Curves for Samples 3, 6, 458, 470 and 474.	31
18	Porosity Versus Thickness Curves for Samples 466, 472, 478 and 480.	32
19	Porosity Versus Thickness Curves for Samples 1, 2, 4, 9, 476, 482 and 486.	33
20	Porosity Versus Thickness Curves for Samples M11, M12, M13 and M17.	34
21	Porosity Versus Thickness Curves for Samples M14, M15 and M16.	35
22	Porosity Versus Thickness Curves for Samples M18, M19 and M20.	36
23	Weight to Weight Ratio, Bar Graph.	37
24	No Load Porosity, Bar Graph.	38
25	% Compressibility, Bar Graph.	39

LIST OF TABLES

Table		Page
1	Woven Cut Pile Fabrics	2
2	Knitted-Inserted Pile Fabrics	3
3	Knitted and Napped Pile Fabrics	4
4	Complete Physical Properties of Samples 1 and ML 10	6
5	Physical Properties of Fifteen Fabrics	13
6	Correlation Equation Terms	14

INTRODUCTION

This project was a result of the wool conservation program. Currently a wool pile fabric with a woven cotton base cloth is being used extensively by the Air Force as an insulation fabric in flight garments, cold weather gear, etc. The objective of this investigation was to develop an insulation fabric of synthetic fibers or fibers other than wool, that would be equal to or an improvement over the presently used wool pile fabric. First attempts included the development of a honeycomb weave fabric. This type fabric contains a considerable amount of air space which is a requirement of a good insulating fabric; however, for proper warmth an increase in thickness would be necessary which, in turn, would increase the weight to the extent that this type fabric would not be practical. Consideration was also given to a freeze type fabric which, in many cases, also presents a weight problem. Pile fabrics, on the other hand, can be light weight, of required thickness, and low cost.

PILE FABRICS FOR INSULATION

Although the basic requirement of an insulation fabric is to produce proper warmth for the wearer, there are other requirements that must be taken into consideration. They are wearability, tendency to "mat" after being compressed, shrinkage to laundering and sewability.

Because the insulation fabric is employed between layers of other fabrics, there is no requirement for abrasion resistance; however, it is required to have good wearability. Wearability is a general requirement which includes physical properties not usually called out as a definite requirement in addition to the basic requirements. An insulation fabric that has good wear properties will exhibit nearly the same physical properties, after being put into service for prolonged lengths of time, as it initially exhibited.

To be considered in evaluating the suitability of a pile fabric is the tendency to "mat" or "rat" after being compressed. It would be very undesirable for a pile fabric to remain at the compressed thickness after a load is relieved. The thickness, and consequently the porosity (per cent air), which are the determining warmth properties of a fabric, would be reduced. Therefore, the fabric should be resilient, or should return to the original thickness after being compressed.

Minimum shrinkage in cleaning and good sewability are obvious requirements. Some garments which employ the use of an insulation fabric will be laundered, while others may be dry cleaned. The sewability characteristics of the insulation fabric should not necessitate the use of any equipment other than conventional types used in fabrication of clothing.

The results of tests conducted on all fabrics are given in Tables 1, 2 and 3. Compression versus thickness curves and porosity versus thickness curves are presented in Appendix I to further illustrate these characteristics of each fabric. Figures 23, 24 and 25 of Appendix I are bar graphs which show the weight-to-warmth ratio, no load porosity, and compressibility, respectively, for each fabric.

Woven, cut pile, fabrics; Manufacturer: Goodall-Sanford, Inc.

These fabrics were constructed like the standard wool pile fabric described in Specification MIL-C-5563. The weights and thicknesses of all of these fabrics were nearly the same, ranging in thickness from .242 inch to .365 inch, and in weight from 15.75 ounces per square yard to 18.86 ounces per square yard.

Advantages of these fabrics are that they possess good compression and resilience properties. Shrinkage can be held to a minimum due to the construction, and there will be no fabrication problem.

Table 1

Woven Cut Pile Fabrics

Sample Number	Fibre	Blend	Fabric Thickness Inches	Compressibility Percent	Porosity No Load	Full Load 176 lbs/in ²	Weight oz/yd ²	Conductance *	Weight To Warmth Ratio **
458	100% Dynel	100% Dynel	.263	46.4	94.4	89.8	16.14	3.35	54.1
460	100% Dacron	100% Dacron	.311	42.8	95.5	92.1	16.60	2.37	39.3
462	100% Orlon	100% Orlon	.251	39.7	93.9	89.8	15.75	2.91	45.3
464	75% Dynel 25% Vicara	100% Cotton	.253	51.8	93.6	86.5	17.82	3.69	65.8
466	100% Dynel	100% Cotton	.242	47.1	94.0	88.6	16.94	3.19	54.2
468	75% Dacron	100% Cotton	.347	48.6	55.3	90.9	17.42	2.42	42.2
470	25% Dynel 75% Dacron	100% Cotton	.311	47.9	94.9	90.1	17.79	2.18	38.5
472	25% Vicara 50% Dacron	100% Cotton	.321	39.9	94.9	91.6	18.44	2.61	48.0
474	50% Dynel 50% Orlon	100% Cotton	.282	42.4	93.5	88.7	16.82	3.03	50.8
476	25% Vicara 50% Orlon	100% Cotton	.319	50.6	92.5	84.7	17.45	2.88	50.2
478	50% Dynel 50% Orlon	100% Cotton	.263	35.8	91.9	87.3	17.61	2.73	48.1
480	50% Acrilan	100% Cotton	.365	43.9	95.4	91.9	18.86	1.77	33.3
482	100% Wool	100% Cotton	.272	35.3	93.7	89.7	17.58	3.09	54.3
484	50% Orlon	100% Cotton	.296	36.1	94.4	91.2	17.44	2.64	46.9
486	50% Dacron	100% Cotton	.281	37.2	94.8	91.6	17.63	2.36	41.7
MIL-C-5553	100% Dacron	100% Cotton	.434	46.5	96.6	93.7	17.22	1.58	27.21

* Conductance = calories per second per square meter per ° Centigrade temperature differential.
 ** Weight to Warmth Ratio = required weight of fabric to produce a conductance of 1.00

Table 2
Enlited - Inserted Pile Fabric

Sample Number	Pile	Blend	Fabric Thickness Inches	Compressibility Percent	Porosity No Load	Porosity Full Load 176 gm/in^2	Weight oz/yd ²	Conductance *	Weight To Marsh Ratio **
ML 1	50% Dacron 50% Acrylic	100% Cotton	.382	61.7	95.8	89.1	18.54	1.77	32.8
ML 3	100% Dynal	100% Cotton	.436	39.9	96.6	93.3	18.29	2.24	40.9
ML 4	100% Orion	100% Cotton	.504	48.0	96.5	93.3	16.85	1.87	31.5
ML 5	100% Dacron	100% Cotton	.532	66.1	97.2	91.8	16.21	1.87	30.4
ML 6	100% Dynal	100% Cotton	.432	65.4	95.5	92.3	19.22	1.79	34.4
ML 7	100% Nylon	100% Cotton	.506	58.1	96.3	91.2	18.92	1.58	29.9
ML 8	100% Wool	100% Cotton	.544	62.1	97.1	94.3	19.45	1.66	32.3
ML 9	100% Nylon	100% Cotton	.450	61.0	96.9	92.1	12.30	2.18	26.8
ML 10	100% Dynal	100% Cotton	.390	59.0	96.8	92.0	11.74	2.12	29.6
ML-C-5563	100% Wool	100% Cotton	.434	46.5	96.6	93.7	17.22	1.58	27.2

* Conductance = Calories per second per square meter per ° Centigrade temperature differential.
 ** Weight To Marsh Ratio = Required weight of fabric to produce a conductance of 1.00

Table 3

Knitted and Waxed Pile Fabric

Sample Number	Pile	Blend	Base	Fabric Thickness Inches	Compressibility Percent	Porosity No Load	Porosity Full Load 176 gr/in ²	Weight oz/yd ²	Conductance *	Weight To Warmth Ratio **
1	100% Orion	100% Orion	100% Orion	.259	42.6	96.2	93.5	8.32	2.76	22.9
2	100% Dacron	100% Dacron	100% Dacron	.246	43.3	93.6	88.7	15.31	2.97	45.5
3	100% Nylon	100% Nylon	100% Nylon	.250	44.8	93.0	87.4	14.91	3.22	45.0
4	100% Orion	100% Orion	100% Orion	.274	48.9	95.8	91.8	10.03	2.98	28.7
5	100% Orion	100% Orion	100% Orion	.218	48.6	95.2	90.6	9.21	3.80	34.9
6	100% Orion	100% Orion	100% Orion	.288	46.6	96.4	93.3	9.06	2.65	24.0
7	100% Dacron	100% Dacron	100% Dacron	.278	36.3	95.9	93.4	11.95	2.46	29.4
8	100% Dacron	100% Dacron	100% Dacron	.265	36.8	96.9	93.7	10.86	2.51	27.2
9	100% Dacron	100% Dacron	100% Dacron	.298	43.6	95.5	91.9	13.97	2.51	34.6
11 ***	100% Orion	100% Orion	100% Orion	.518	42.6	96.2	93.5	16.64	1.41	23.4
ML-5503	100% Wool	100% Wool	100% Cotton	.434	46.5	96.6	93.7	17.22	1.58	27.21

* Conductance = Calories per second per square meter per ° Centigrade temperature differential.

** Weight to Warmth Ratio = Required weight of fabric to produce a conductance of 1.00.

*** Double thickness of No. 1 Sample.

Disadvantages of this type of fabric are that nearly all of the samples were as heavy or heavier than the wool control sample and the porosities were generally low which contributes to the high weight-to-warmth ratio. The cost of this type fabric would be somewhat higher than a similar knitted fabric.

Knitted, inserted pile, fabric; Manufacturer: George W. Borg Corp.

These fabrics were made by inserting the pile from a sliver form into the base fabric while on the knitting machine. The machine pulls the fibers into the base fabric and anchors them so they can not be easily pulled out. The thicknesses and weights of these samples were all nearly the same except for ML 9 and ML 10 which were considerably lighter and not quite as thick.

Advantages of this type of fabric are high porosities, low conductance, and relatively low cost.

Disadvantages include high weight and therefore high weight-to-warmth ratio. ML 9 and ML 10 being lightweight had lower weight-to-warmth ratios; however, the compressibility of these fabrics was high. Also the shrinkage in laundering was high.

Knitted, napped pile fabric; Manufacturer: Princeton Knitting Mills, Inc.

These fabrics were knitted with a terry loop on the face which was napped to give a smooth pile effect. These fabrics were light weight and not very thick.

Advantages of this type fabric are light weight, high porosity, good strength, and low cost.

Disadvantages are not outstanding.

One fabric of the knitted, inserted pile type, ML 10, and one of the knitted napped pile type, No. 1, were considered to possess the best qualities of the samples submitted. Sufficient yardage of the samples was requested of the contractor for further test and evaluation. Complete physical properties of these samples are presented in Table 4. Consideration has been given to a double thickness of Sample No. 1. There is a somewhat greater warmth obtained from a double thickness of a fabric than a single fabric of the same total thickness.* In this case the total weight would be less than that of the standard sample, the thickness slightly more, and the warmth afforded would be greater. The porosity is high enough for proper warmth, as shown in Table 3, and yet, low enough to eliminate any insulation loss due to convection air currents. The disadvantage of this particular material is flammability. Such a fabric made of Orlon is very flammable.

* American Wool Handbook, Second Edition, 1948, p. 162.

Table 4

COMPLETE PHYSICAL PROPERTIES OF SAMPLES 1 AND ML 10

Properties	No. 1	ML 10
Weight oz/yd ²	6.99	10.78
Breaking strength - lbs/in		
Wales	48.8	40.0
Courses	52.0	35.0
Bursting strength - lbs		
Ball burst	98.4	60.0
Thickness - ins	.321	.274
MEK Extractable matter - %	1.19	0.74 *
Shrinkage in laundering		
100°F - %		
Wales	1.21	7.34
Courses	.33	+1.71
212°F - %		
Wales	16.71	1.14
Courses	3.92	19.21
Thickness after laundering - ins.		
100°F	.315	.280
212°F	.180	.274
Compressibility - %		
Original	53.76	64.05
After 100°F laundering	55.42	58.57
After 212°F laundering	55.68	45.25
Weight to warmth ratio	17.76	44.35

* CCl₄ used instead of MEK

Summary

It can be concluded that synthetic pile fabrics are equally as warm as wool pile fabrics and in most cases can be made lighter. In the event that the present supply of wool were to become critical or that the demand for wool exceeded the availability, a suitable synthetic pile fabric could be produced economically to replace the presently used wool pile fabric. However, it would not be advantageous to utilize synthetics unless such a condition should arise, because of the flammability characteristics of such synthetic fabrics. Generally, synthetic pile fabrics will melt or burn very rapidly, in contrast to wool pile fabrics which neither melt nor exhibit a fast rate of burning.

DISCUSSION OF TEST METHODS

TERMAL TRANSMISSION

The apparatus used was a Central Scientific Company thermal conductance device, Figure 1. This device does not take into consideration the unit thickness of the test sample, but rather the total thickness. When the sample had been positioned for test it was compressed to a pressure of 23 grams per square inch. By use of the line rheostat, the galvanometer was then adjusted slightly above full scale reading. As heat was transmitted through the fabric, the galvanometer needle deflected downward until it reached the full scale mark, at which time the test was started. Galvanometer readings were taken in increments of 5 minutes for 30 minutes and recorded.

The galvanometer readings were plotted on a semilog scale, Y axis, against "time" on the rectangular scale, X axis. From this curve the Central Scientific Company tester gave the conductance corresponding to the angle of depression. The conductance represents the rate of heat transmission without consideration of fabric thickness. If the conductance is multiplied by the sample weight in ounces per square yard, the result is the weight-to-warmth ratio, which is defined as the weight of the material necessary to produce a conductance of 1.00.

COMPRESSIBILITY AND POROSITY

Compressibility - The apparatus used was a cylindrical glass tube 1.5 inches in diameter with a fixed rule attached, which was graduated in 1/100 inches. See Figure 2. For each test, five sample thicknesses, 1.5 inches in diameter were placed in the graduated cylinder. Thin pieces of paper of the same diameter as the samples were placed between each sample to prevent them from intermeshing at the plane of contact. Known weights were applied in increments of 16 grams per square inch from 0 load to a load of 176 grams per square inch from which the compression curves in Appendix I were plotted.

FIGURE 1

CENTRAL SCIENTIFIC COMPANY THERMAL CONDUCTANCE TESTER

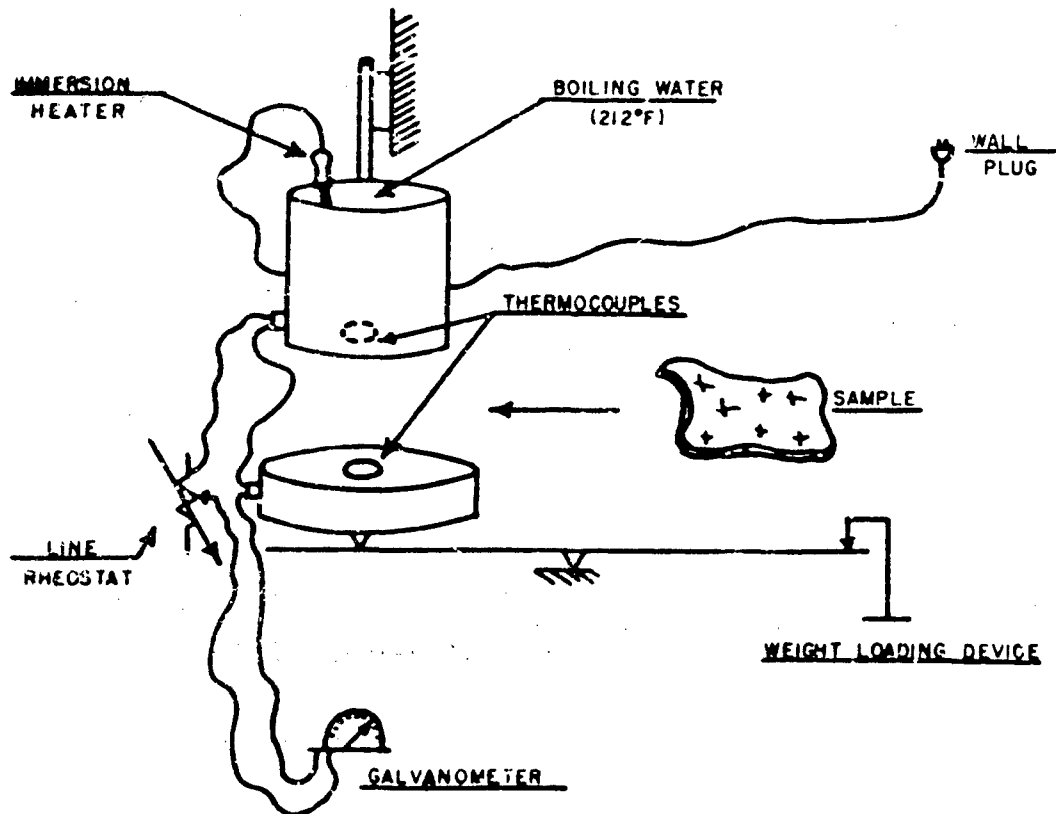
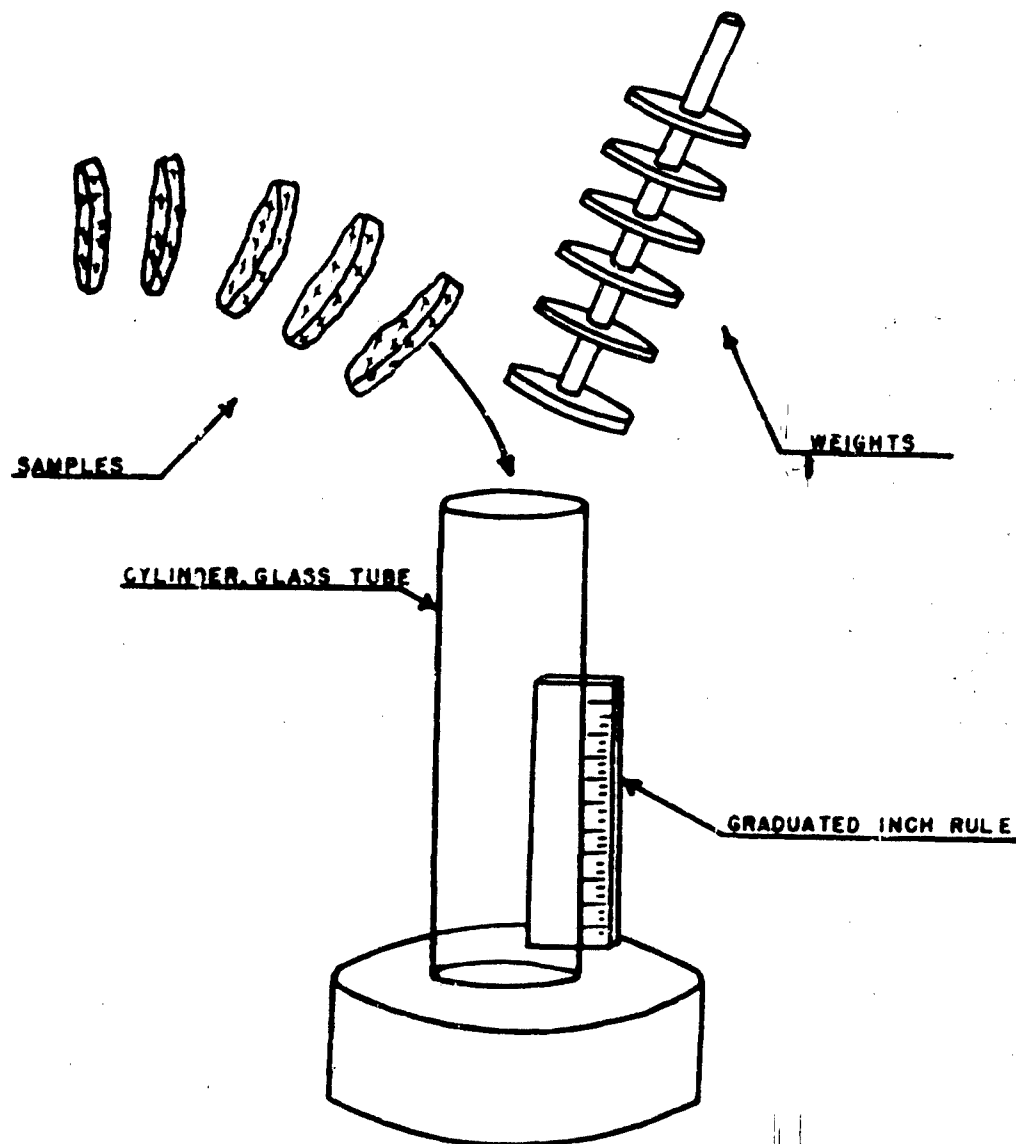


FIGURE 2

COMPRESSIBILITY TESTER



WADC DR 54-374

The compressibility was determined as follows:

$$a. \% \text{ Compressibility} = \frac{(\text{no load thickness} - \text{full load thickness})}{\text{No load thickness}} \times 100$$

It is to be noted that the above thickness is based on one sample thickness. The thickness taken from the scale during test was reduced by the thickness of the separators and divided by 5, the number of samples tested.

The porosity, percent air by volume, was calculated for each fabric thickness obtained in determination of compressibility. Porosity versus thickness curves were plotted and are presented in Appendix I. The porosity was calculated as follows:

$$b. \% F = \frac{.00338 \times W \times 100}{t D_f}$$

$$c. F = 100\% - \% F$$

where: .00338 converts ounces per square yard to grams per square centimeter

$\% F$ = percent fiber by volume

W = fabric weight in ounces per square yard

t = fabric thickness in centimeters

D_f = fiber density in grams per cubic centimeter

F = porosity - percent air by volume

In determining the compressibility by the above outlined method there is one source of error that could very possibly affect the results. The samples tend to spread out as weight is applied on top of them. This causes the surface around the circumference of the samples to be pressed against the walls of the glass cylinder, which exerts a frictional force against downward movement as additional weights are applied. This source of error is evident; however, it is small.

CALCULATION OF CONDUCTANCE

The total warmth of a fabric is determined by the heat transmission properties of that fabric. A "warm" fabric acts as an insulator, and therefore resists the transmission of heat.

Total insulation would be a perfect vacuum. For practical applications, dead air space is the best insulator, or from a textile standpoint, the fabric with the highest porosity. The percent air in a fabric by volume is called porosity. Over a wide range of pile fabrics, including napped, inserted, and cut pile, the results of many tests show that the porosities of these fabrics, unloaded, are in excess of 90% and less than 98%. Results presented in Tables 1, 2 and 3 show that the porosities are all nearly the

ness. It has also been established that the type of fiber has very little effect on the thermal insulation of a fabric. The little effect which might be due to the type of fiber is either too small to measure or masked by other factors which have a much greater effect. Therefore, the most important properties of an insulating pile fabric are the compressional resistance of the fabric and the tendency of the fabric to return to its original thickness after repeated cycles of loading and unloading, assuming that the initial thickness can be controlled.

There is a definite relationship between the warmth of a fabric and its degree of porosity (porosity x thickness). The most practical measurement of warmth is by determination of the thermal conductance, C , which is defined as the amount of heat to pass through a given medium of certain area over a definite length of time with a given temperature difference (calories per second per square centimeter, per 1°C . Temperature differential). The assumption will be made that the conductance of a fabric is proportional to the degree of porosity of the fabric. That is

$$(a) C' \propto tP$$

where t is the fabric thickness in centimeters and P is the porosity of the fabric. Theoretically, if the thickness is increased, the conductance will decrease. Likewise, if the porosity is increased, the conductance will decrease and therefore

$$(b) C' = \frac{b}{tP}$$

where b is an equation constant. There will always be a certain amount of air in a fabric, and P will be greater than 0. Keeping this in mind, let t approach 0, and C' will approach infinity. Then let t approach infinity and C' will approach 0. Theoretically, then, equation (b) satisfies the conditions of a rectangular hyperbola, the equation of which is

$$(c) y = \frac{k}{x}$$

where $y = C'$, $k = b$, and $x = tP$.

If both sides of equation (b) are multiplied by tP , then

$$(d) b = C' Pt$$

t may be measured directly in centimeters. P may be determined from equations (b) and (c) from the discussion of test methods. To determine C , many analytical measurements were made on a Central Scientific Company thermal conductance device with fabrics of different structure, weight and thickness. From these test results an average b was determined from equation (d). From 15 fabrics the average b was 1.54 and therefore,

$$(e) C' = \frac{1.54}{tP}$$

The basic heat law for any material states that $C_t = K$; where K is the thermal conductivity of the material in cal/sec/cm/cm²/°C. If K of a fabric is multiplied by the porosity, percent air, in the fabric, the result is the thermal conductivity of air, and therefore $K_{air} = 1.54 = b$.

Actual tests have been conducted to determine the conductance of air on the Central Scientific Company thermal conductance device with a measured air space of 1 cm. The conductance of air was found to be 1.47 cal/cm²/sec/°C. If $t = 1$ in the basic heat law, $C = K$, the thermal conductivity of air would be 1.47 cal/sec/cm/cm²/°C.

The data in Table 5 give the physical properties of 15 fabrics tested which include the conductance obtained by test C and the calculated conductance obtained from equation (e), C' . Table 5 gives the numerical coefficient of correlation based on a perfect correlation factor of 1.0.

The calculated conductance, C' , appears to correlate quite well with the conductance, C , obtained by test. Figure 3 shows the relationship of the tested conductance to the degree of porosity. However, there are several sources of error possible to affect the results. Examples are machine error, error in reading the machine, inaccurate loading and slight variation in room conditions. Probably the most likely source of error in calculating C' is taking the sample thickness. As previously stated, C was based on a fabric thickness corresponding to a load of 23 gm/in², and that thickness was not actually recorded. Since it was necessary to know this thickness to calculate C' so both C and C' would be based on the same thickness, the thickness corresponding to a load of 23 gm/in² was taken from compression curves similar to those in Appendix I.

From the data in Table 5, the results show there is better correlation between C and C' in the range of higher porosities. This can be explained due to the fact that equation (e) does not take in consideration the thermal characteristics of the fibrous material. In the range of higher porosities with, for example, 6% fiber by volume, the amount of fiber has an extremely small effect on heat transmission. However, in the case of felt where there is 26% fiber, the heat transmission is affected and equation (e) does not apply with as great a degree of accuracy. If the limiting factors of equation (e) are taken to the extreme where k approaches 0, the conductance would increase to an infinite maximum, which in no case would ever be true. All materials exhibit some resistance to heat transmission. In a nonporous material the heat transmission characteristics can not be based on the amount of air, but on the thermal properties of the material. In the case of fabrics it would be highly complicated to consider the effect of the fibrous material in determining conductance. In such case, factors requiring consideration would be conductivity of the fibrous material, area of fiber in contact with the source of heat, and the arrangement of the fibers. Still, equation (e) will hold true with a negligible degree of error for fabrics with porosities in excess of about 35%.

Table 5
Physical Properties of Filtecar Fabrics

Designation	Fiber	Dye Sample	Fiber Density g./cc.	Weight oz./yds.	Thickness cm.	Porosity %	Degree of Porosity	Conductance (tested) C.	Conductance (cal) C.
1	Emerycloth Cloth		1.32	15.8	.482	91.5	.441	3.38	3.50
2	Std wool Out Filt		1.41	17.2	.930	95.6	.891	1.58	1.73
3	Woolour		1.32	19.8	.279	81.8	.288	1.57	6.76
4	Spun Nylon		1.14	15.9	.711	93.4	.804	2.54	2.32
5	Knapped Filt No. 1		1.17	8.3	.516	95.7	.512	2.76	2.89
6	Knapped Filt No. 5		1.17	9.2	.432	93.9	.406	3.80	3.79
7	Knapped Filt No. 7		1.38	11.9	.574	94.9	.544	2.46	2.83
8	Out Filt., No. 460		1.36	16.6	.668	93.5	.626	2.37	2.46
9	Out Filt., No. 458		1.31	15.1	.537	92.3	.496	3.35	3.11
10	Out Filt., No. 464		1.30	17.3	.528	91.3	.473	3.59	3.26
11	Out Filt., No. 468		1.36	17.4	.662	93.4	.608	2.42	2.94
12	Inserted Filt No. ML 4		1.17	16.9	.942	94.8	.892	1.87	1.73
13	Inserted Filt No. ML 5		1.43	16.2	.984	96.1	.946	1.87	1.64
14	Inserted Filt No. ML 7		1.26	18.9	1.025	94.8	.973	1.58	1.58
15	Wool Felt		1.32	64.5	.635	74.0	.462	2.38	3.29

* Porosity times Thickness/100

** cal/sec/cm²/°C

*** Equation constant = Conductance, C. times degree of porosity

Table 6
Equation Terms

Sample Designation	X_1	X_2	X_1^2	X_2^2	X_1X_2
1	3.50	3.38	12.20	11.40	11.82
2	1.73	1.63	2.98	2.66	2.82
3	6.76	5.97	45.50	35.60	40.40
4	2.32	2.54	5.38	6.43	5.88
5	2.89	2.76	8.35	7.60	7.97
6	3.79	3.80	14.15	14.40	14.39
7	2.83	2.46	8.00	6.03	6.96
8	2.46	2.37	6.03	5.61	5.83
9	3.11	3.35	9.64	11.20	10.41
10	3.26	3.69	10.61	13.60	12.02
11	2.54	2.42	6.45	5.85	6.14
12	1.73	1.87	2.99	3.50	3.23
13	1.64	1.87	2.69	3.50	3.07
14	1.58	1.58	2.50	2.50	2.48
15	3.29	2.38	10.80	5.65	7.83
Total	43.43	42.07	148.27	135.53	141.25

X_1 = Calculated conductances C' ; which is to be estimated

X_2 = Conductances by test C

N = Number of measurements

r = Coefficient of correlation

When the values from Table 6 are substituted in the following equation,

$$r = \frac{N \sum X_1 X_2 - (\sum X_1)(\sum X_2)}{\sqrt{[N \sum X_1^2 - (\sum X_1)^2][N \sum X_2^2 - (\sum X_2)^2]}}$$

the coefficient of correlation,

$$r = .977$$

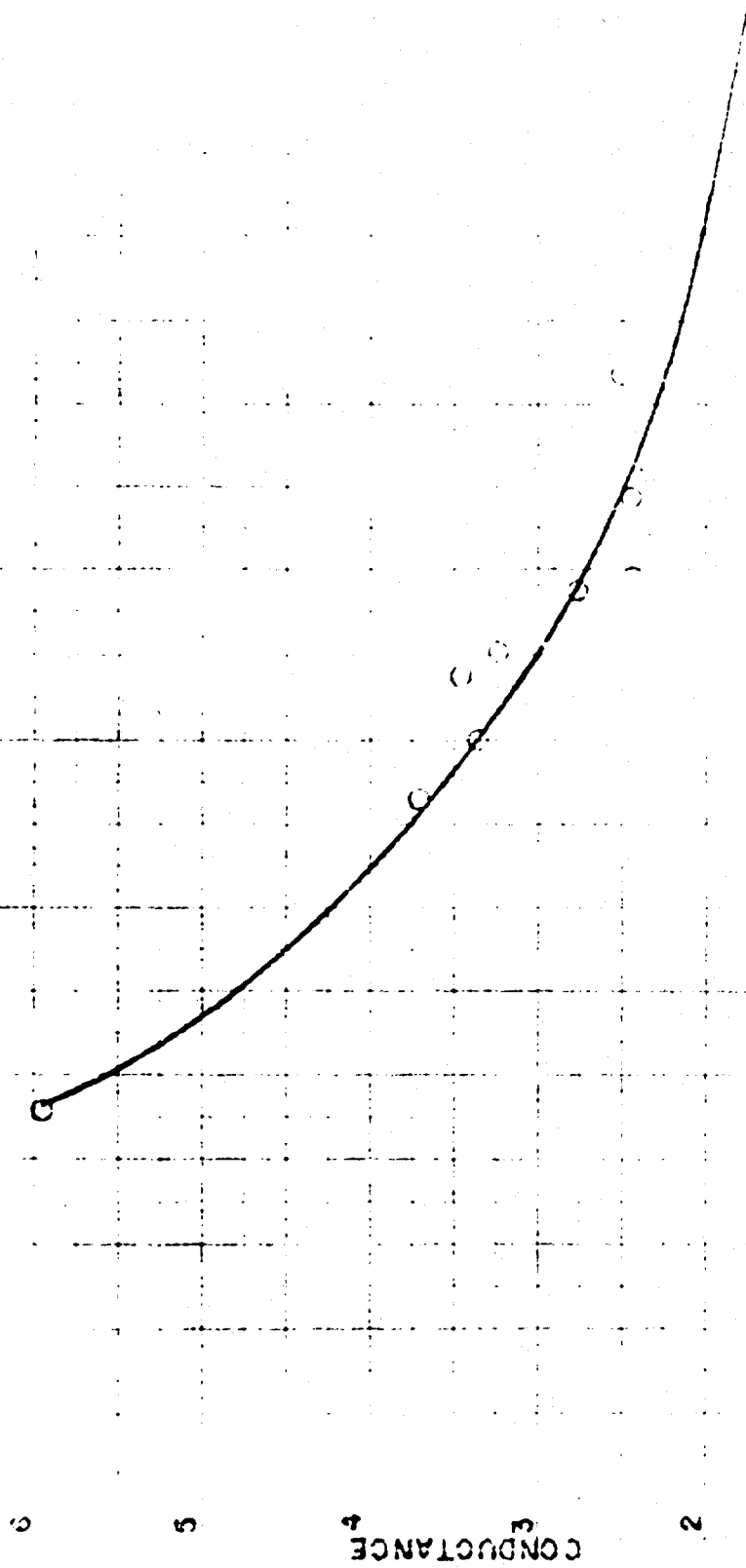


FIG. 3 CONDUCTANCE VS DEGREE OF POROSITY

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Report No. 30, The German Woolen and Worsted Industry in World
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Wool Handbook, Second Edition, pp. 158-168

APPENDIX I

ENC IN 54-374

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FIG. 1

THICKNESS VS. LOAD CURVES

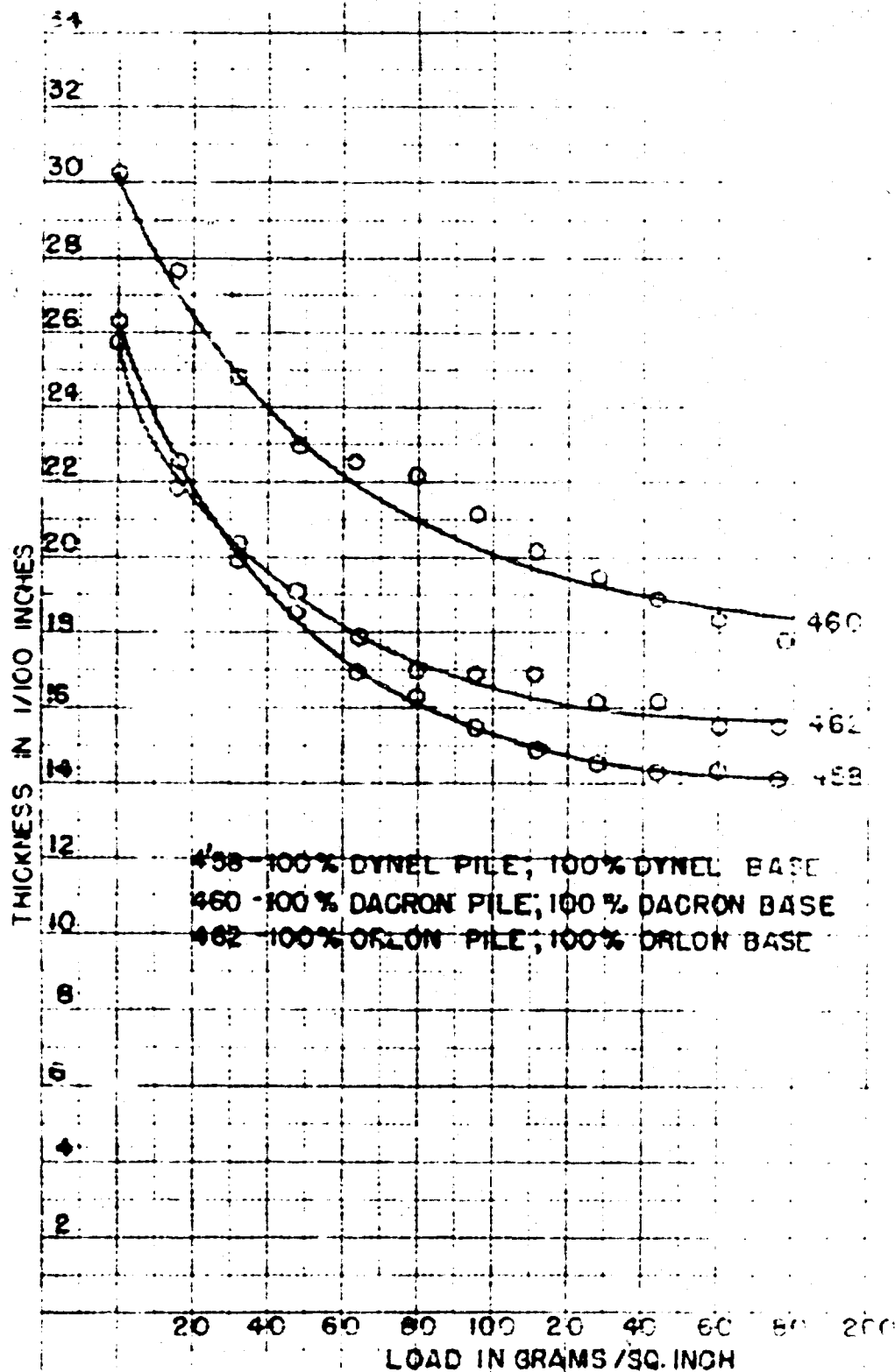


FIG. 5

THICKNESS VS. LOAD CURVES

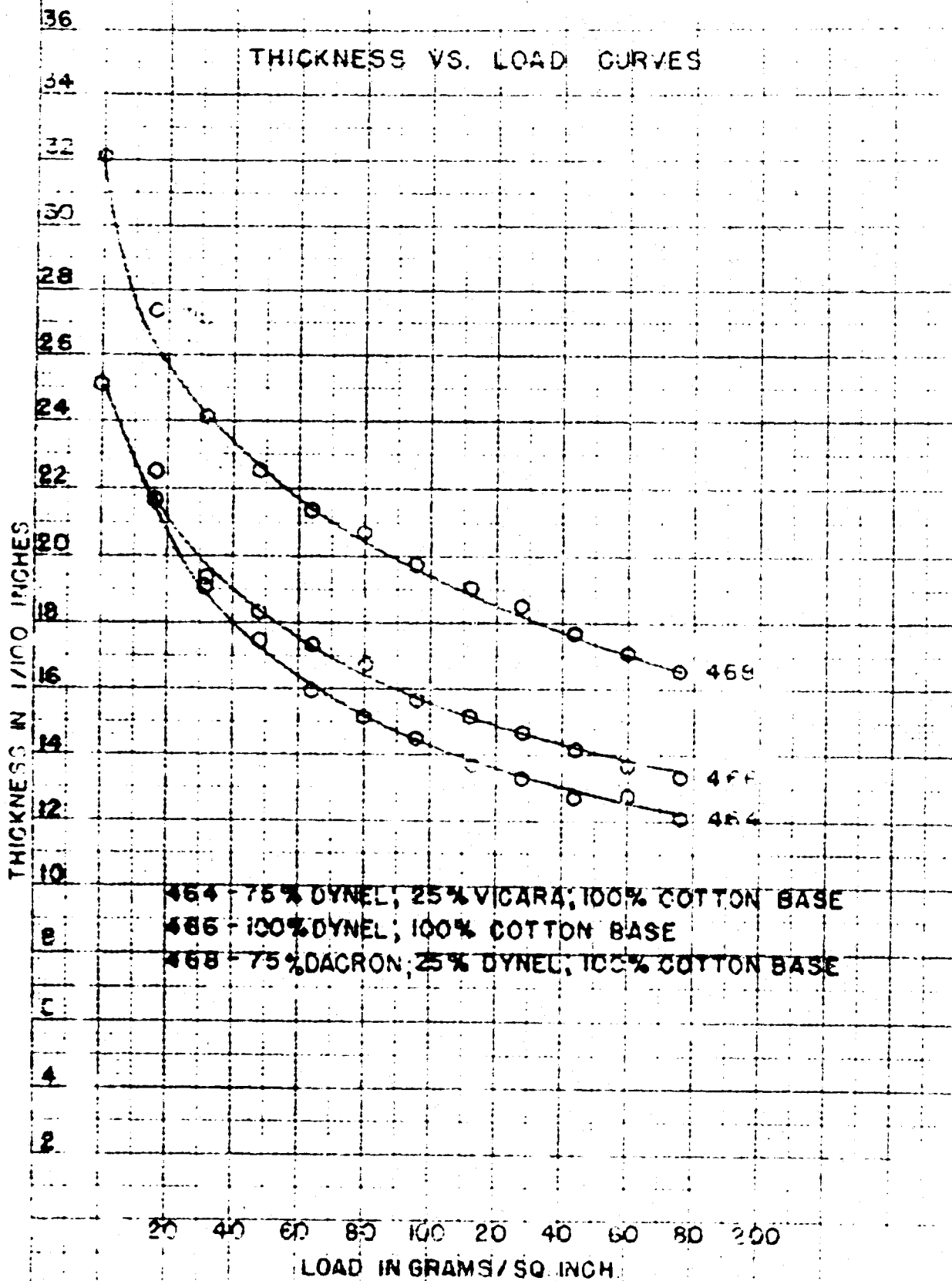


FIG. 6

THICKNESS VS. LOAD CURVES

THICKNESS IN 1/100 INCHES

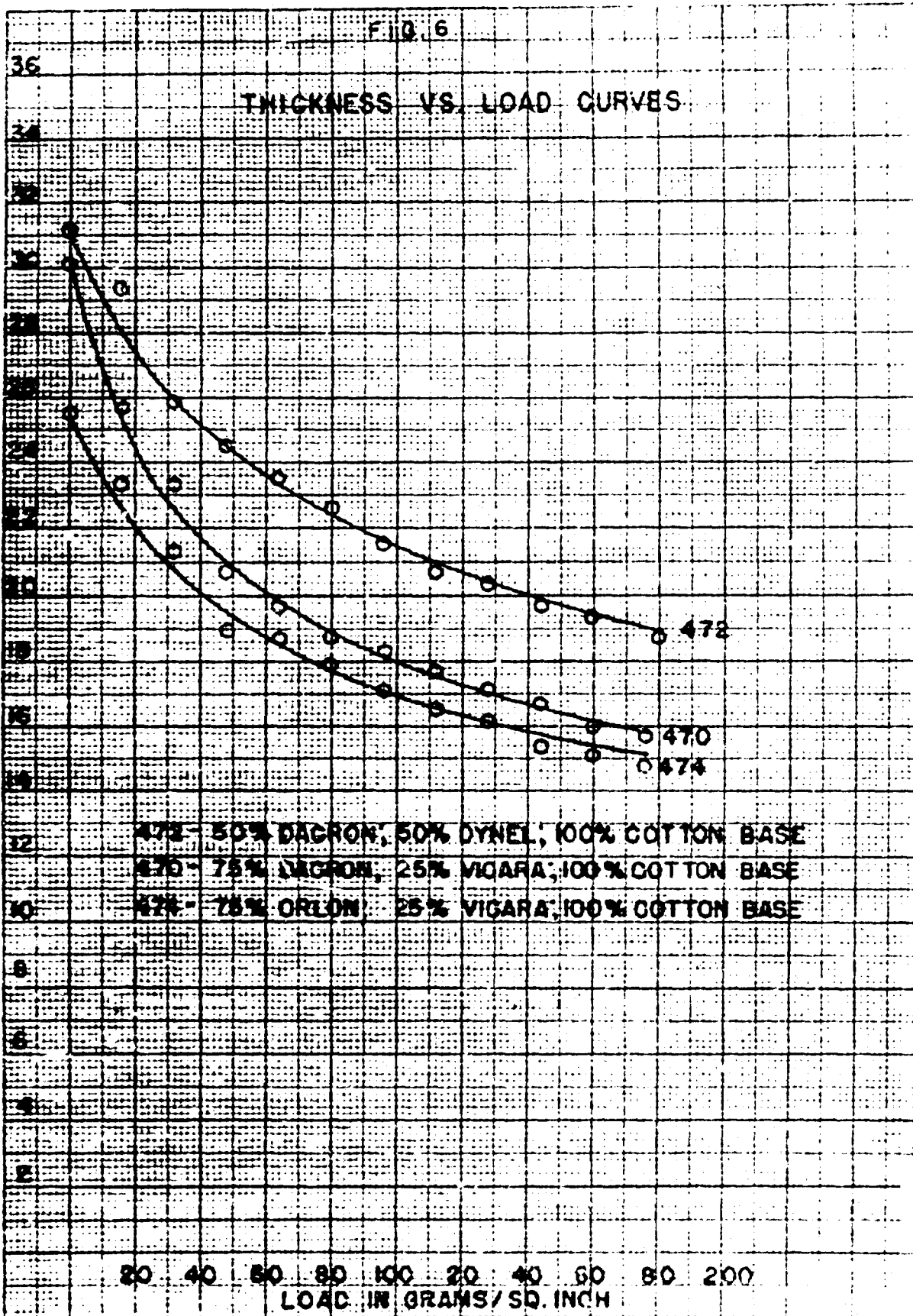


FIG. 1

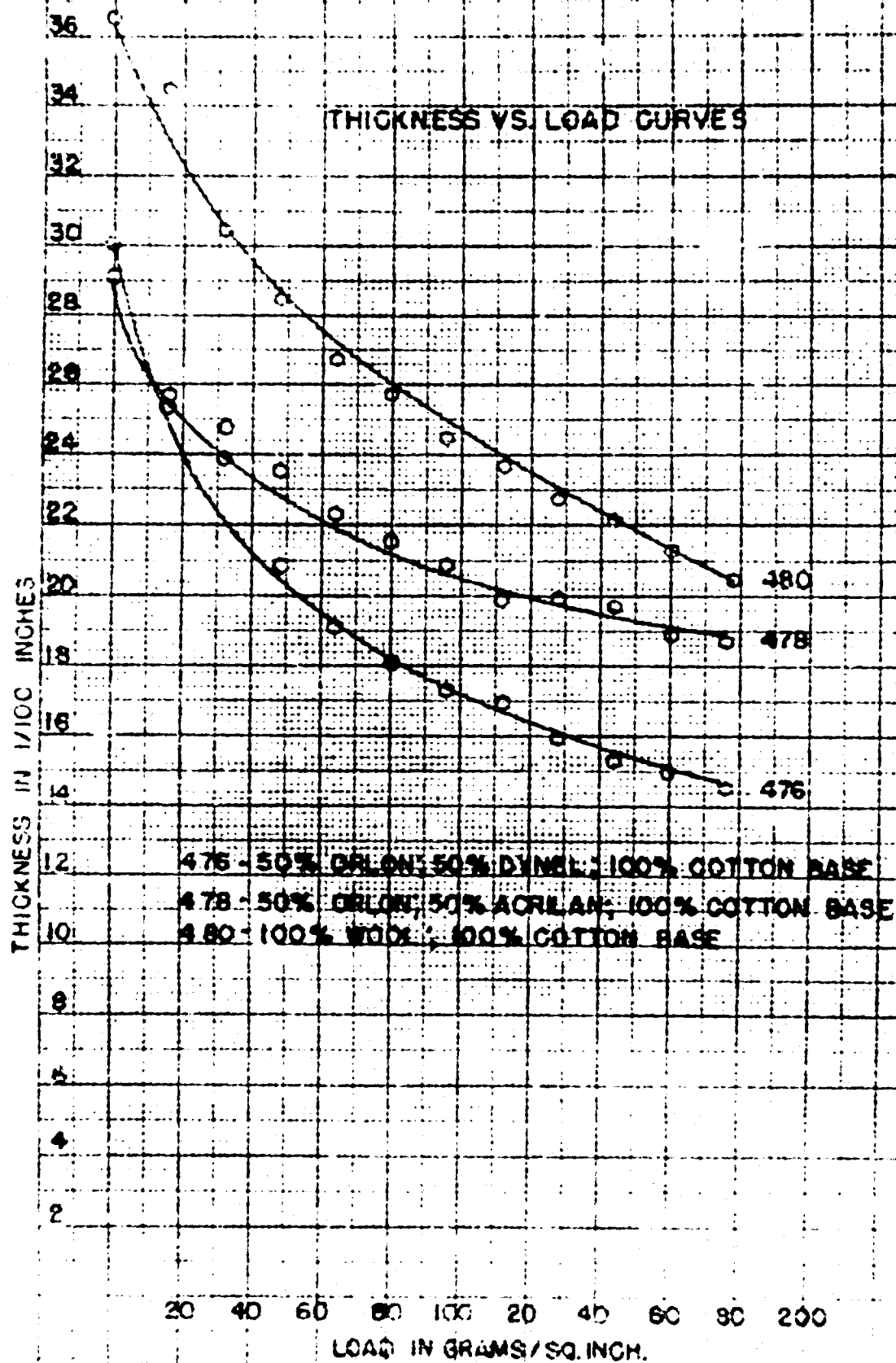


FIG. 8

THICKNESS VS. LOAD CURVES

THICKNESS IN 1/100 INCHES

36
34
32
30
28
26
24
22
20
18
16
14
12
10
8
6
4
2

20 40 60 80 100 120 140 160 180 200

LOAD IN GRAMS/SQ. INCH

484
486
482

482 - 100% ORLON; 100% COTTON BASE

484 - 50% ORLON; 50% DACRON; 100% COTTON BASE

486 - 100% DACRON; 100% COTTON BASE

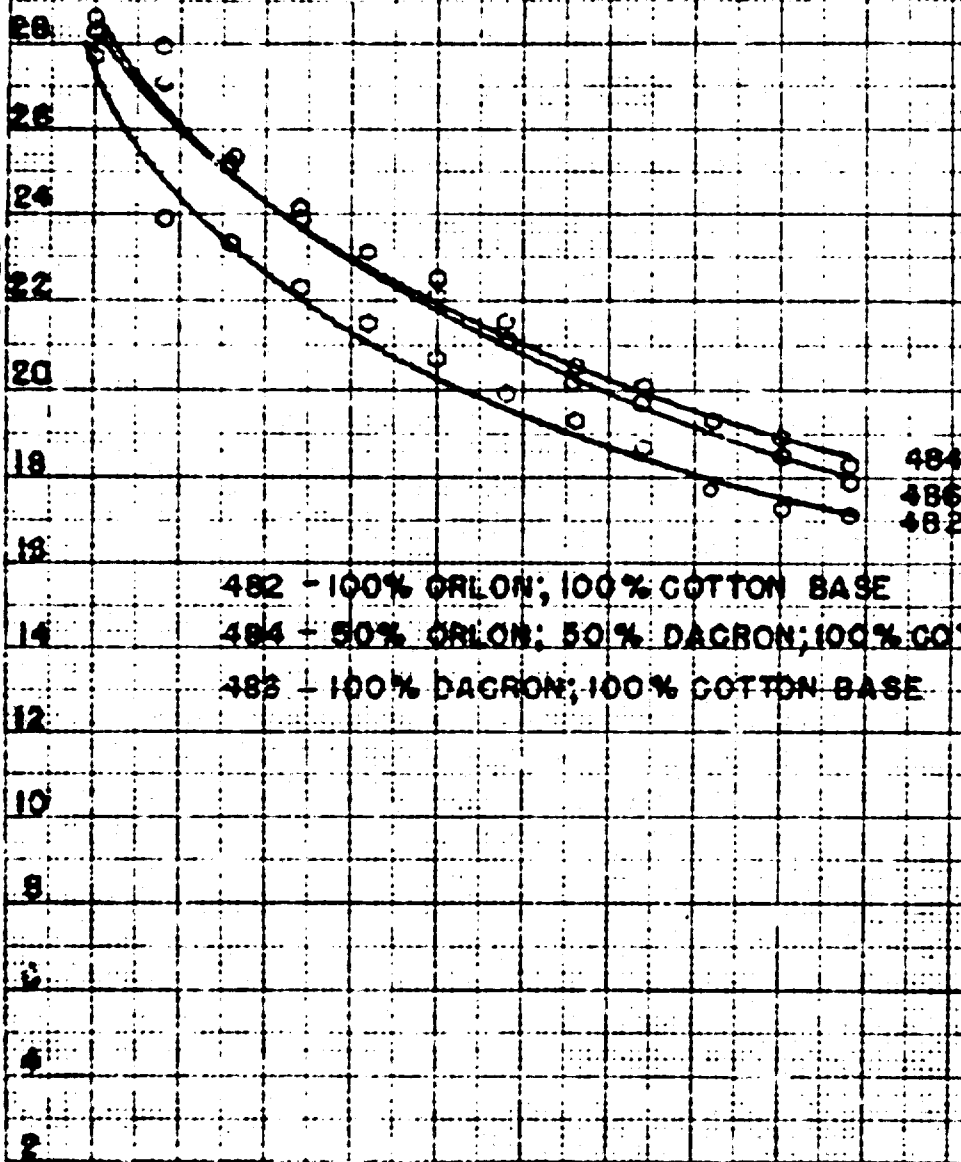
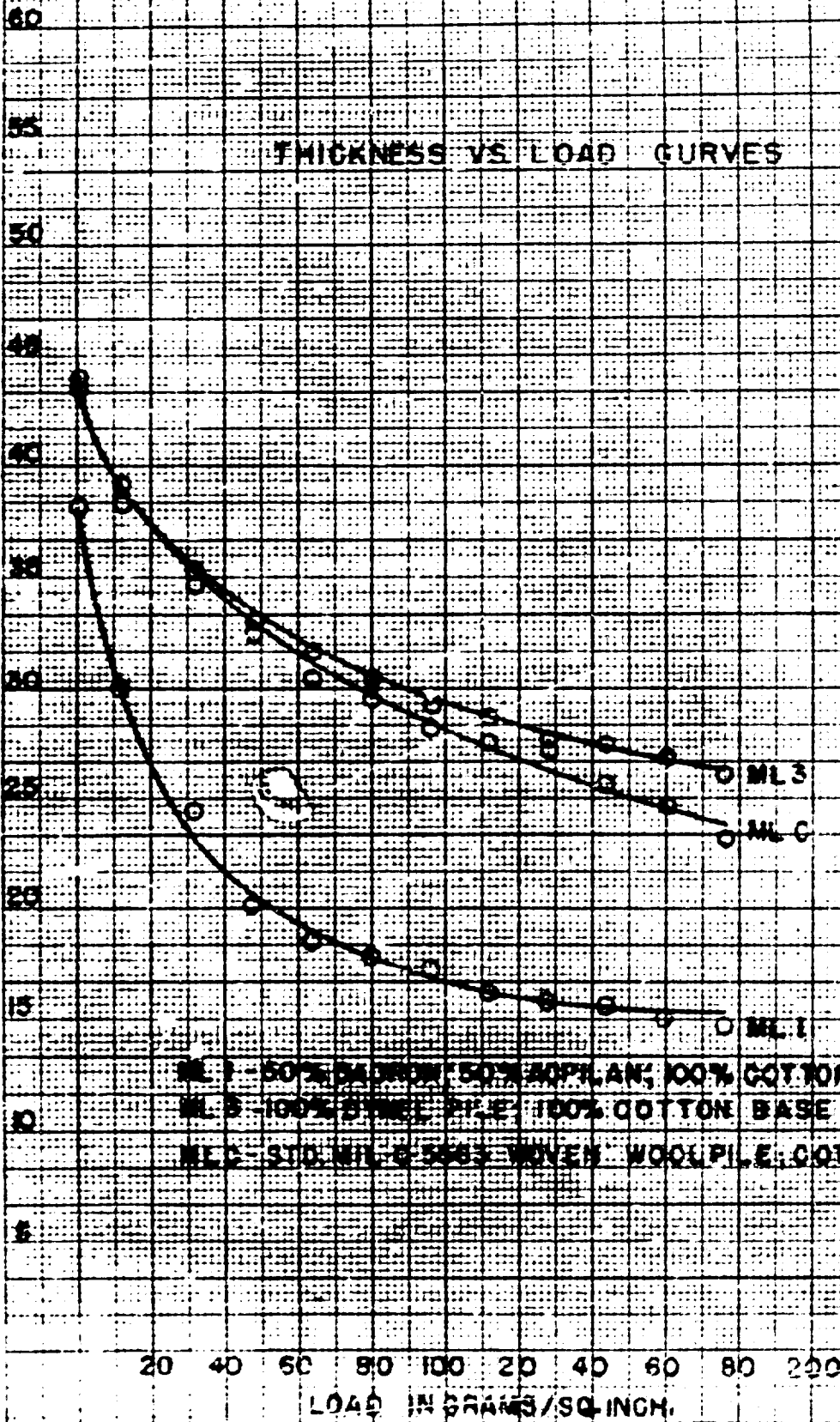


FIG. 9

THICKNESS VS. LOAD CURVES

THICKNESS IN 1/100 INCHES



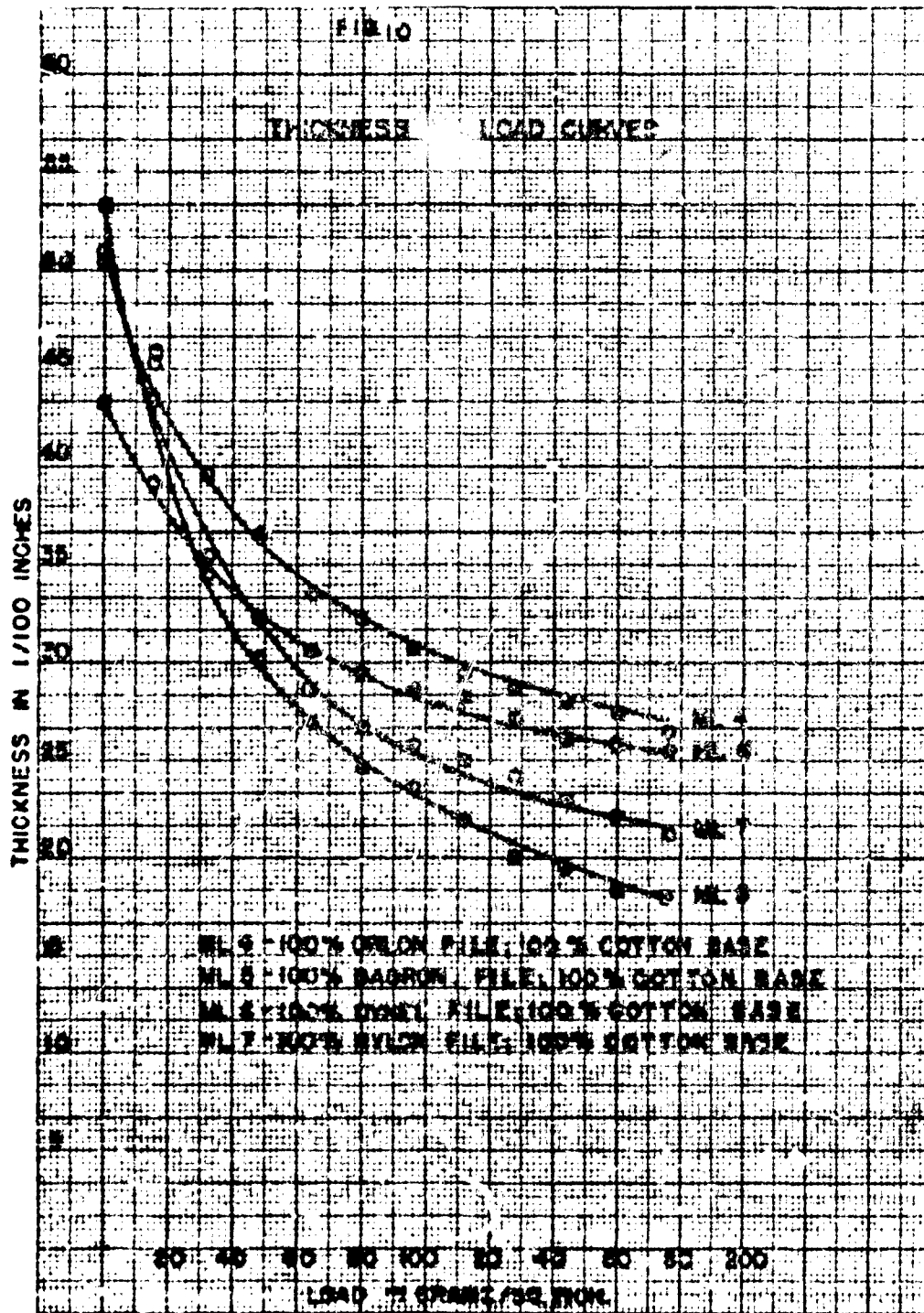


FIG. 11

THICKNESS VS LOAD CURVES

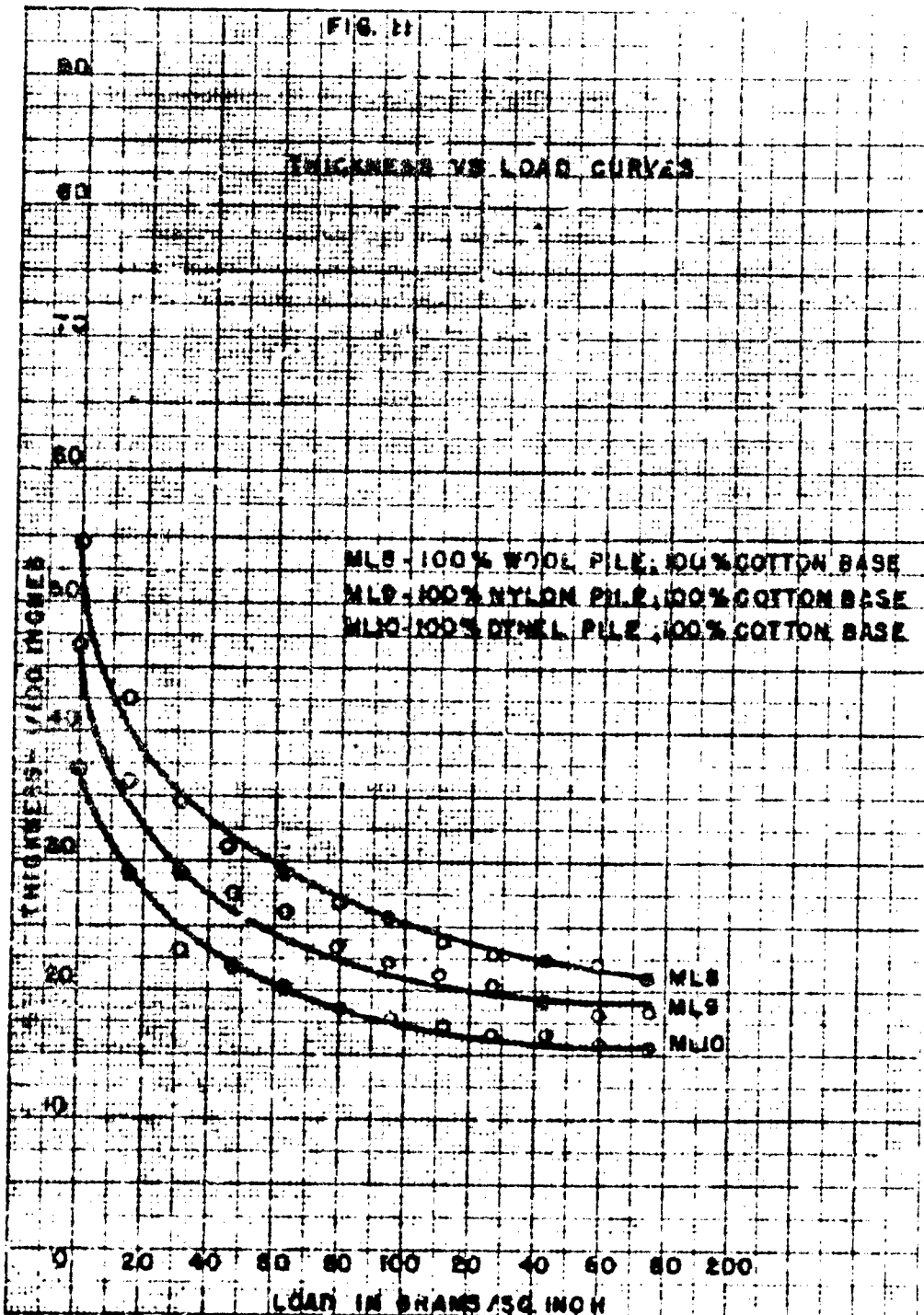


FIG. 12

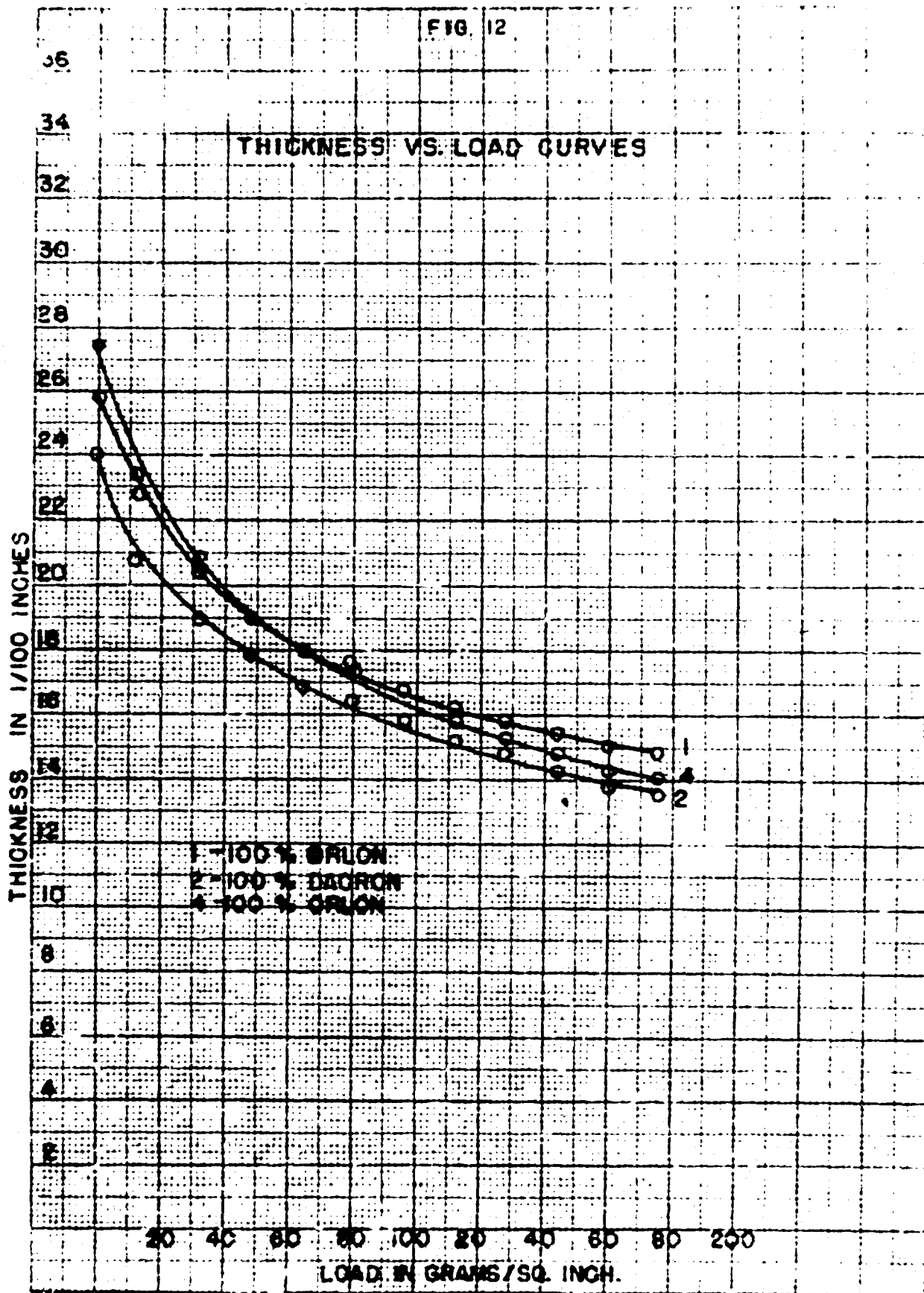


FIG. 13

THICKNESS VS. LOAD CURVES

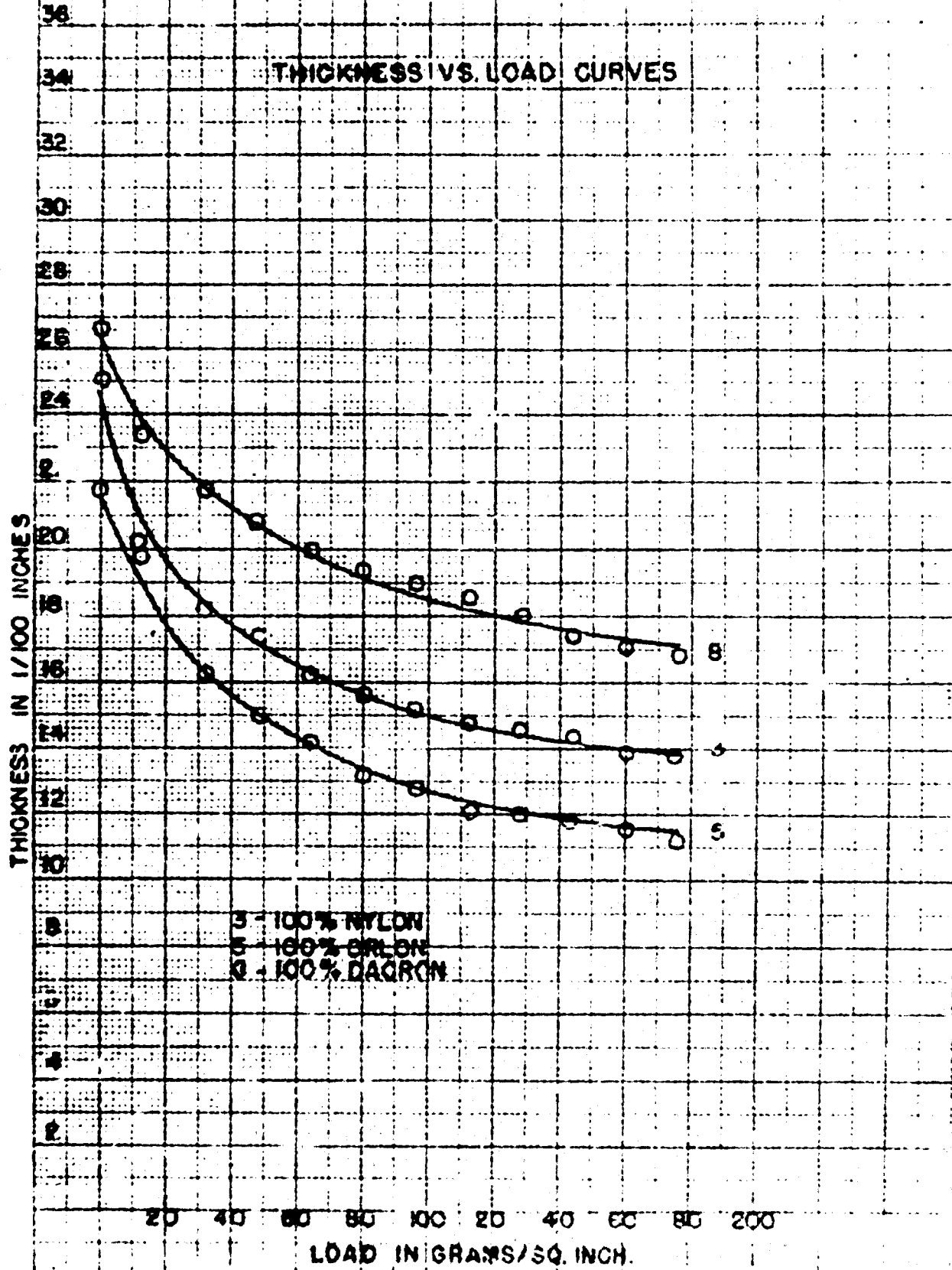
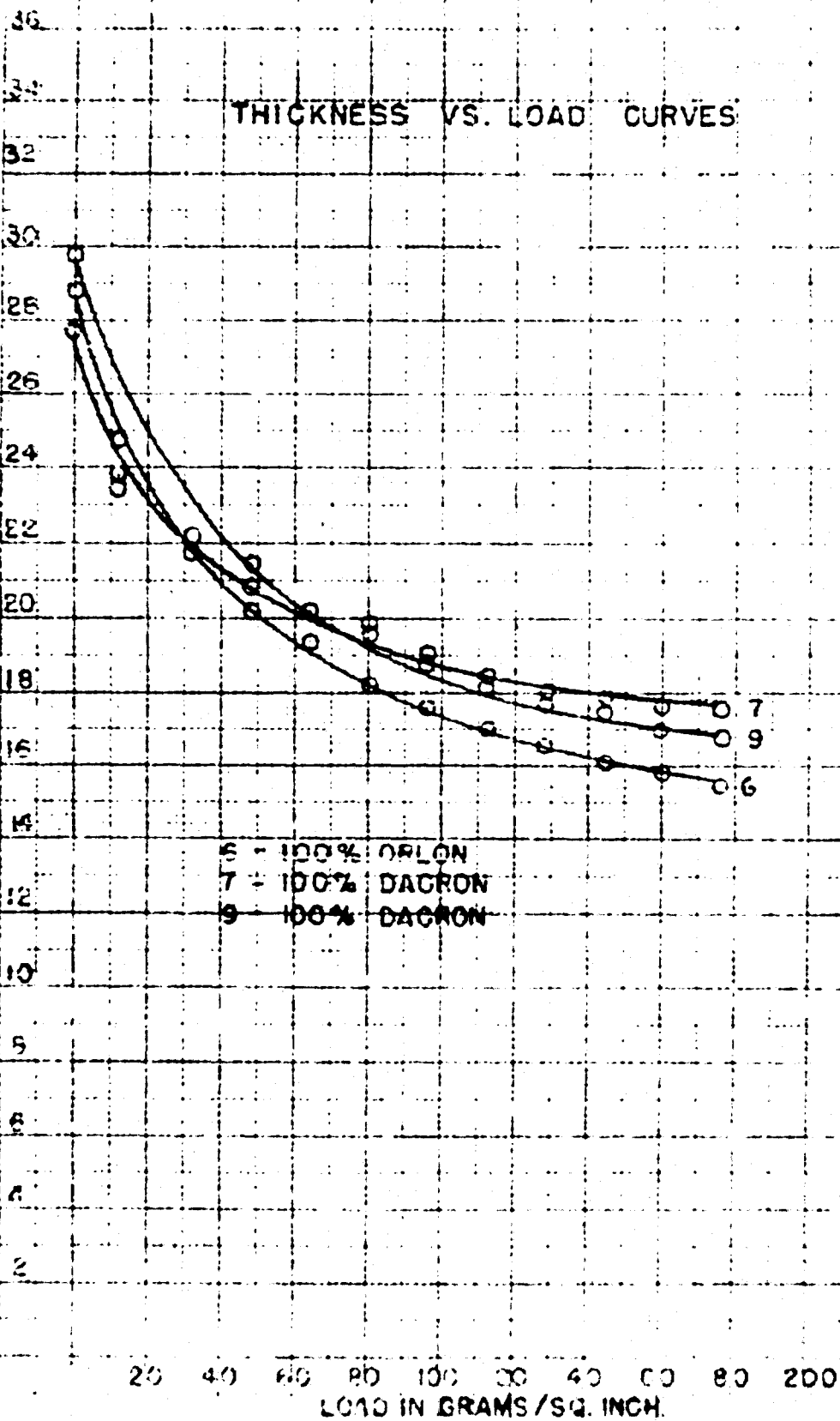


FIG. 14

THICKNESS VS. LOAD CURVES

THICKNESS IN 1/100 INCHES



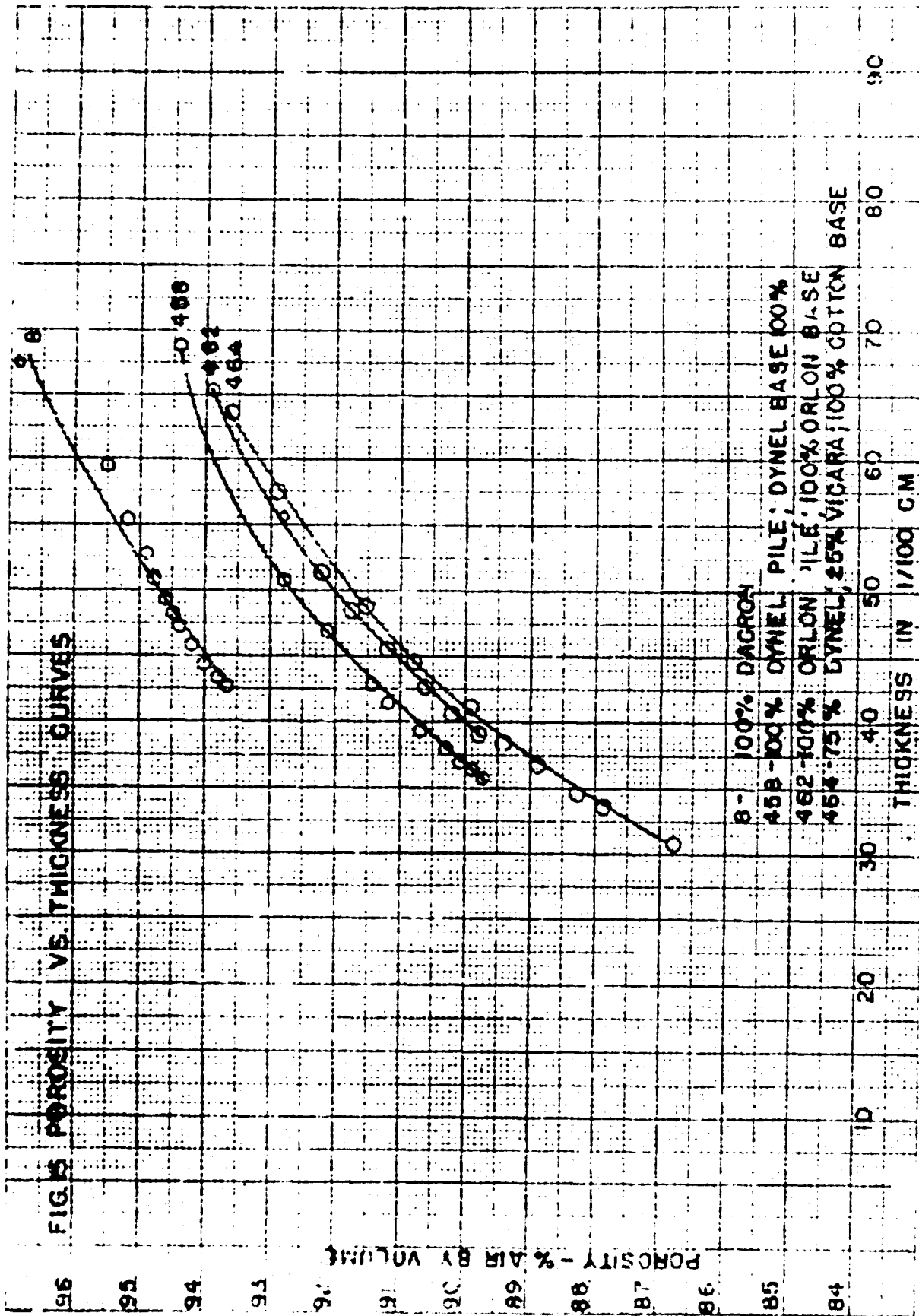
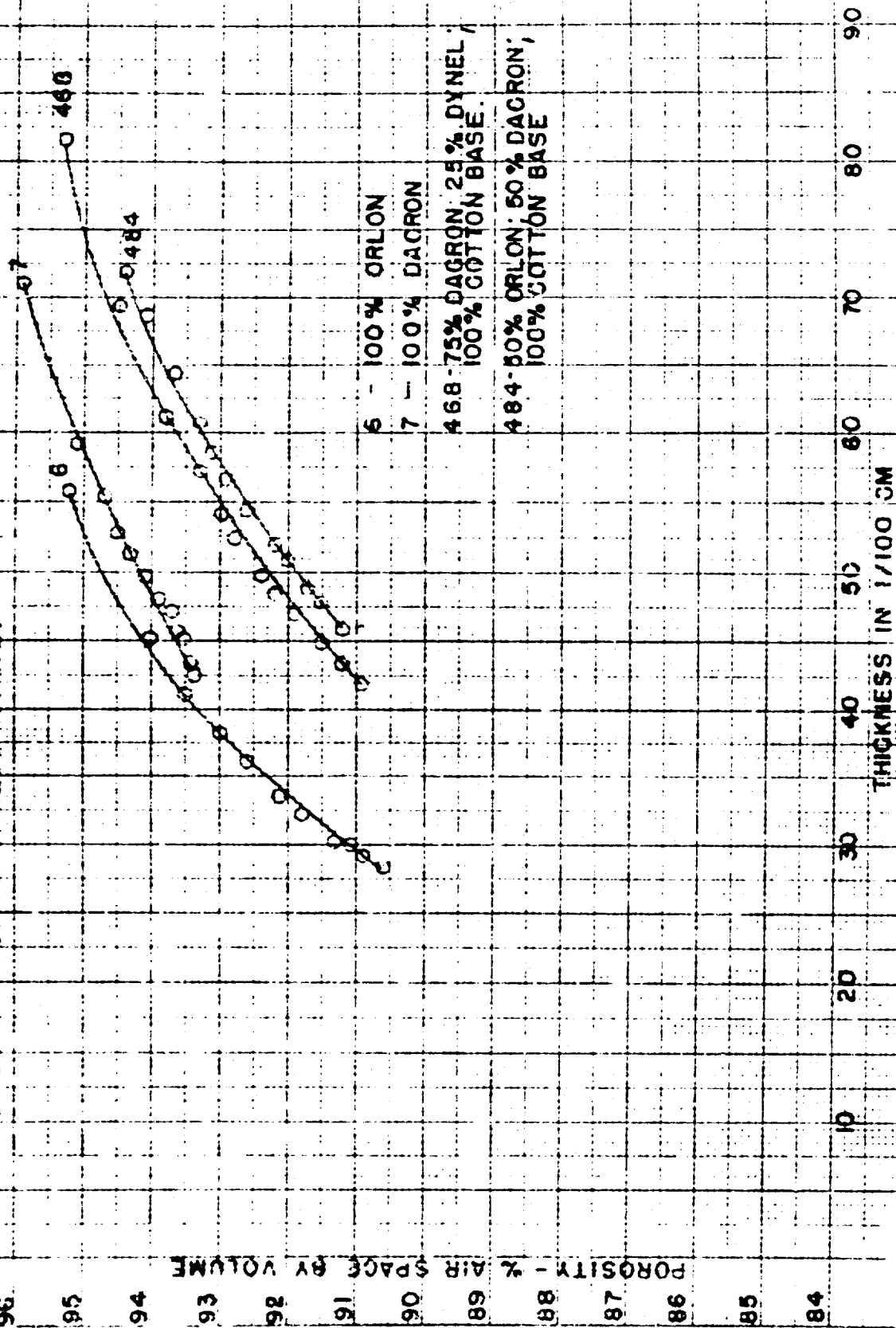
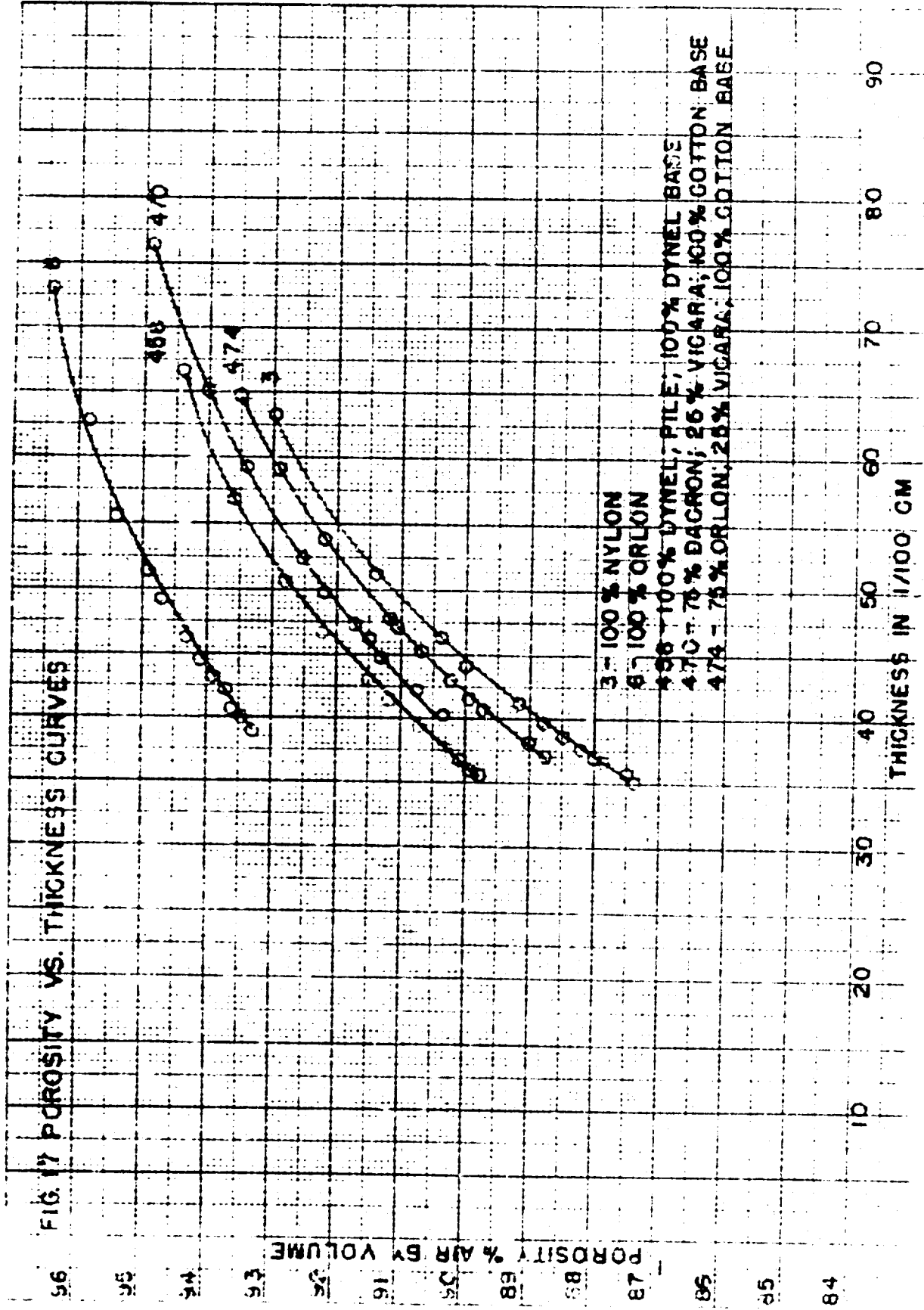
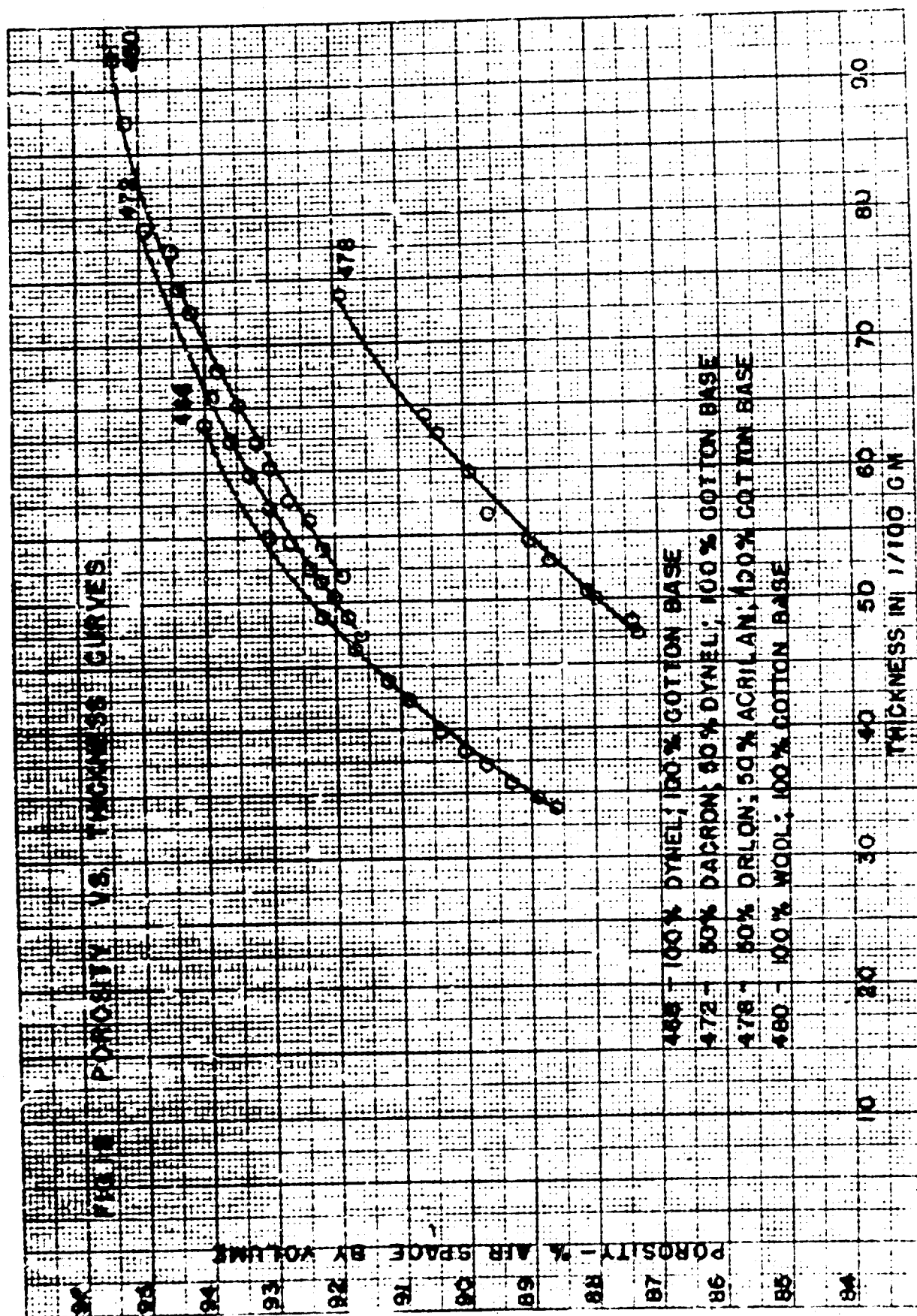
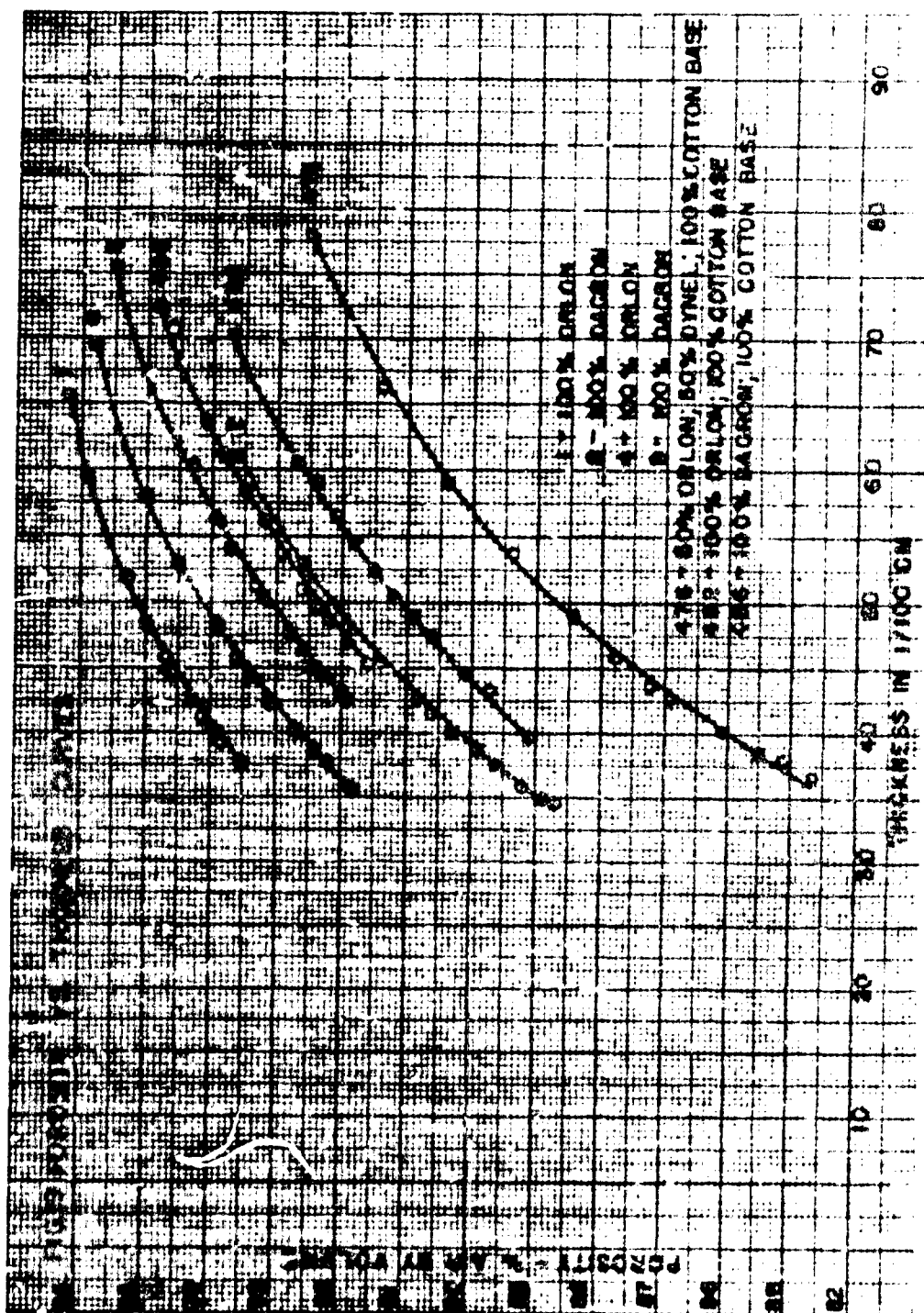


FIG. 16 POROSITY VS. THICKNESS CURVES









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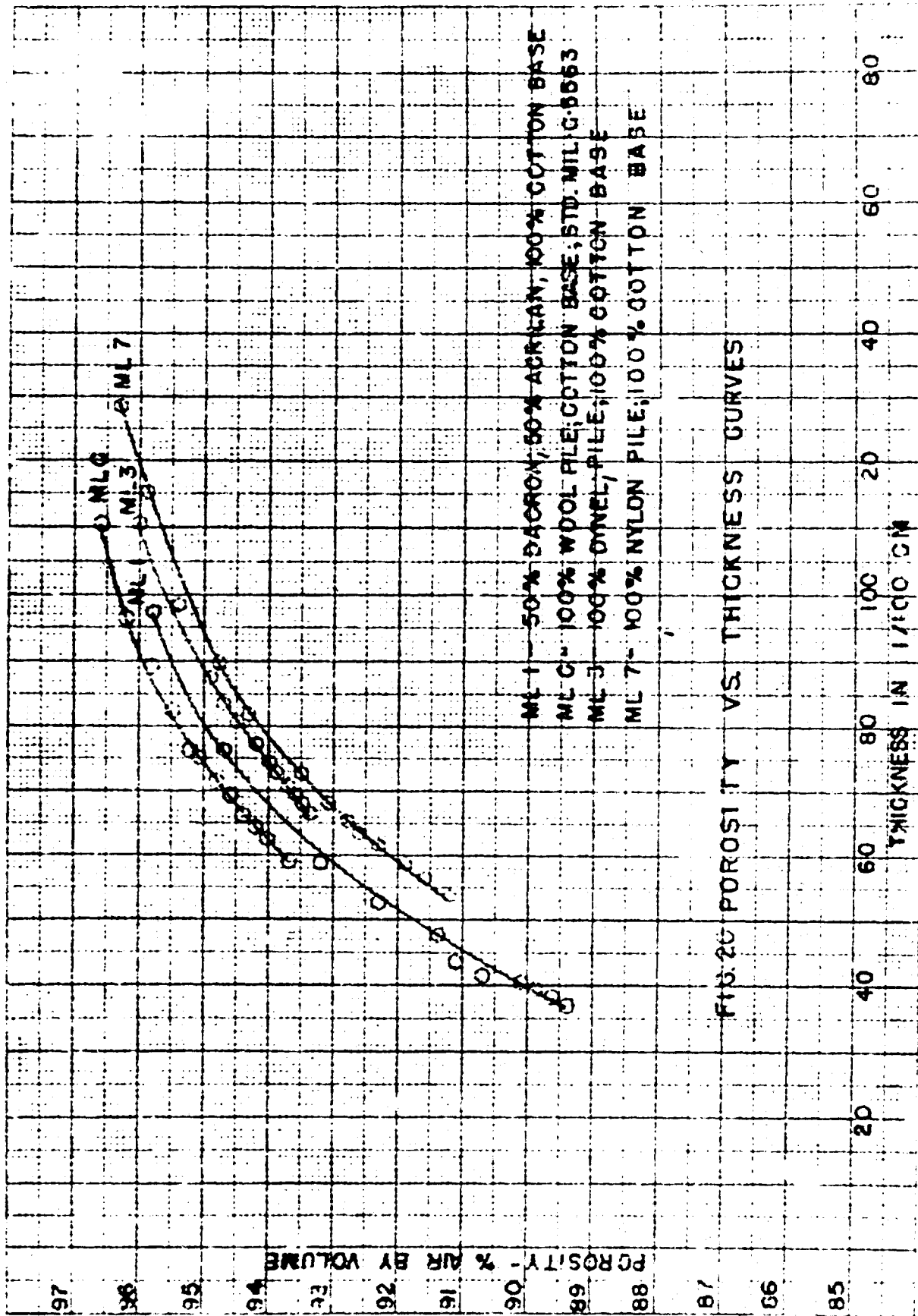


FIG. 20 POROSITY VS. THICKNESS CURVES

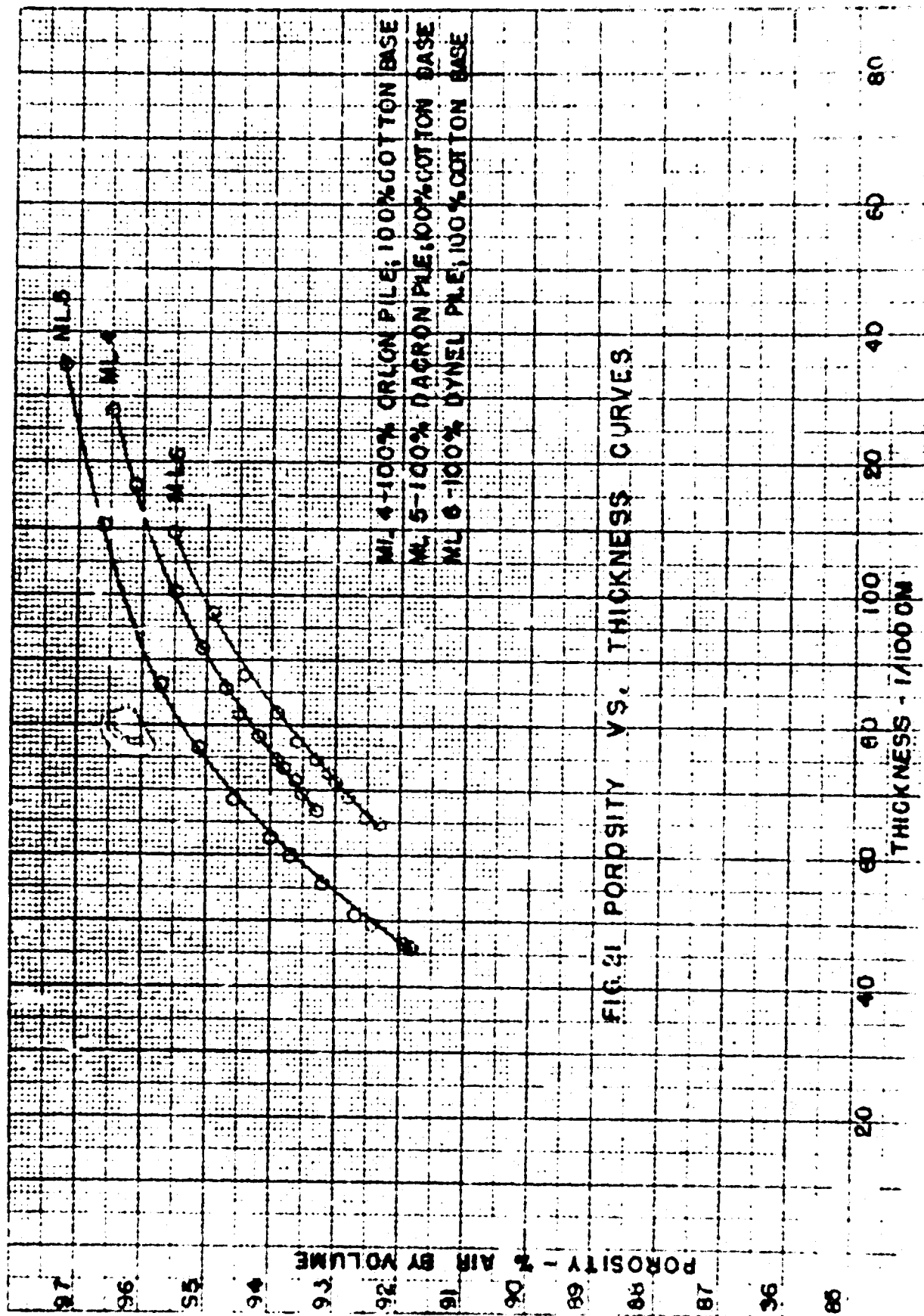


FIG. 21 POROSITY VS. THICKNESS CURVES

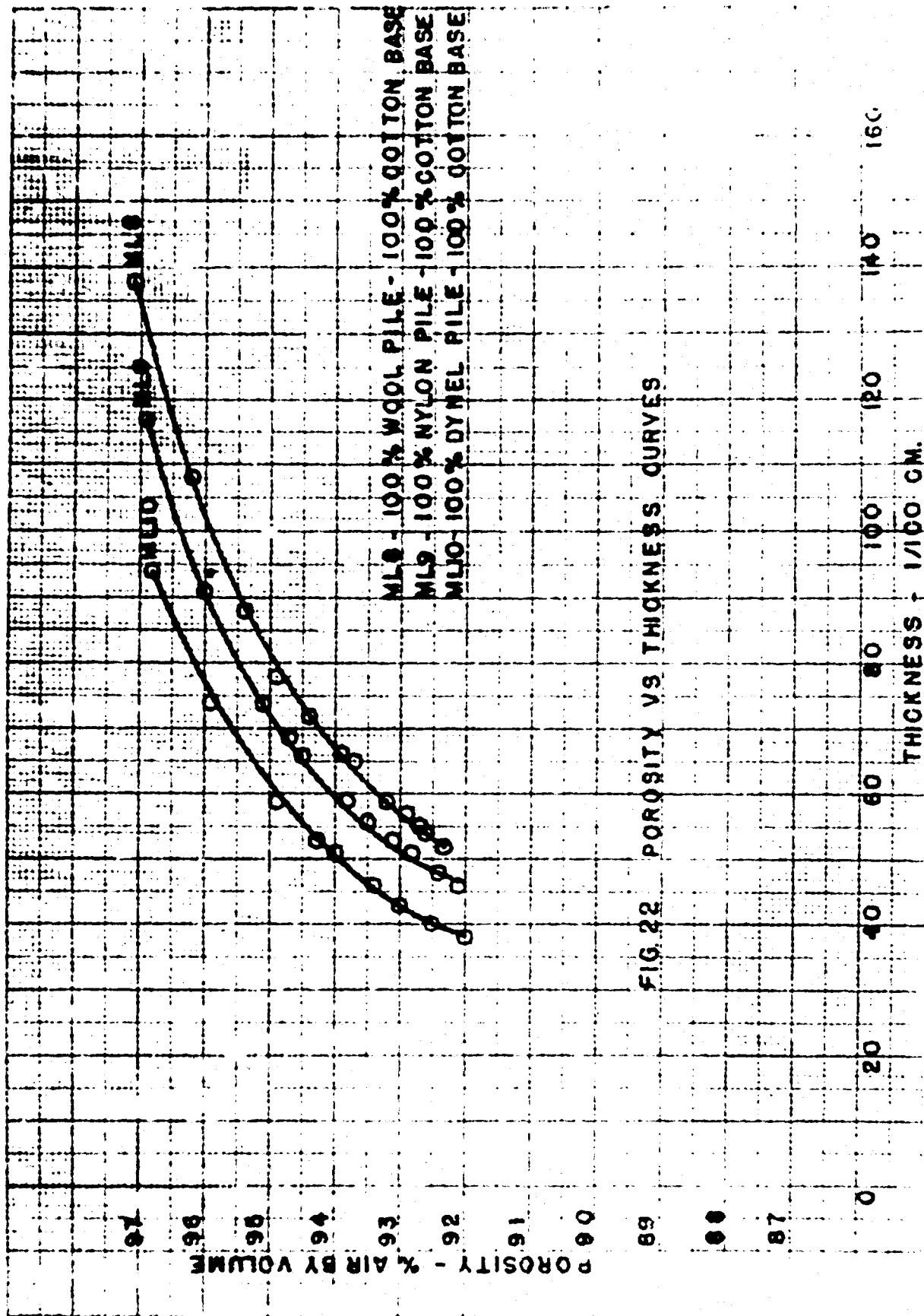
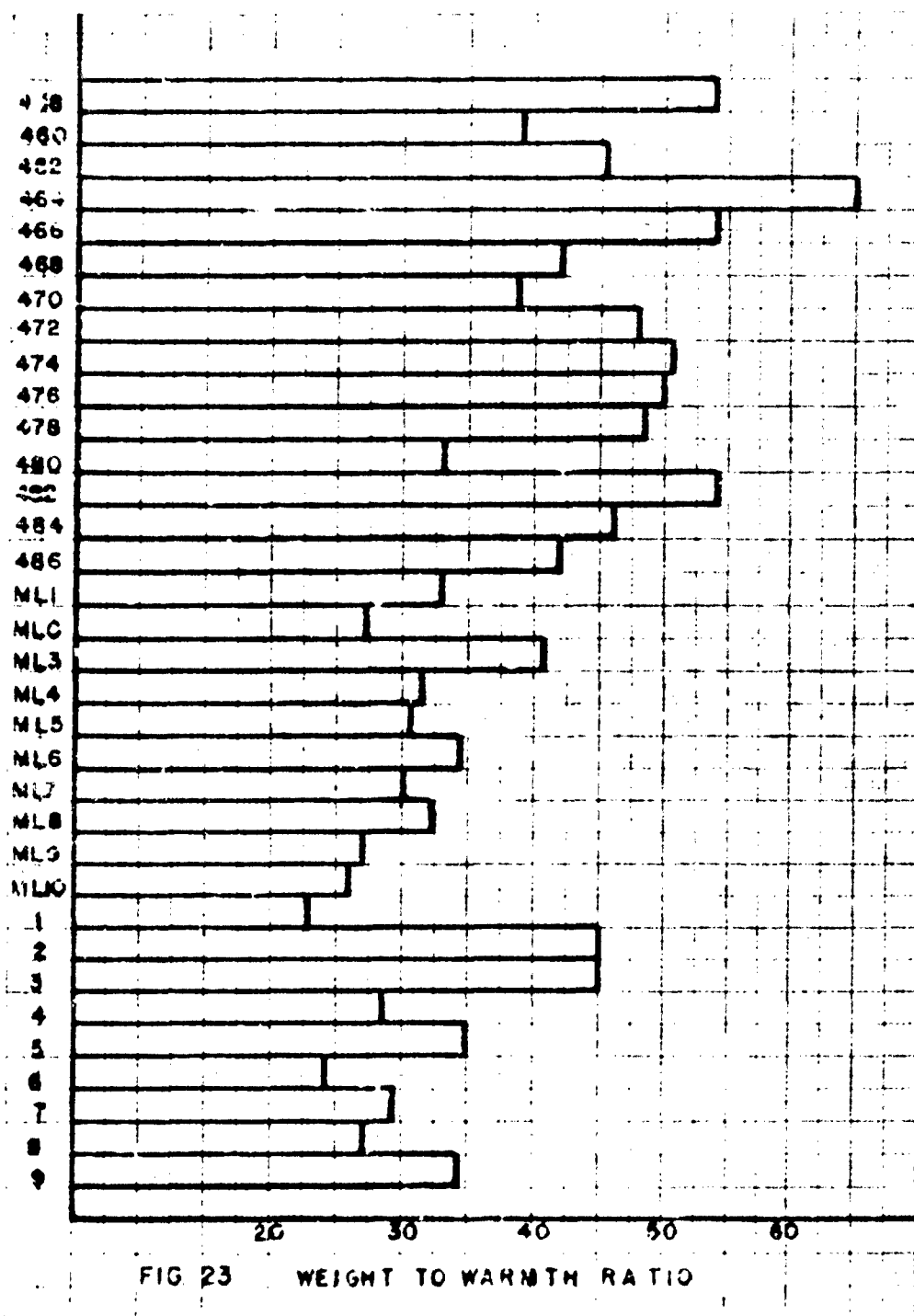


FIG. 22 POROSITY VS THICKNESS CURVES



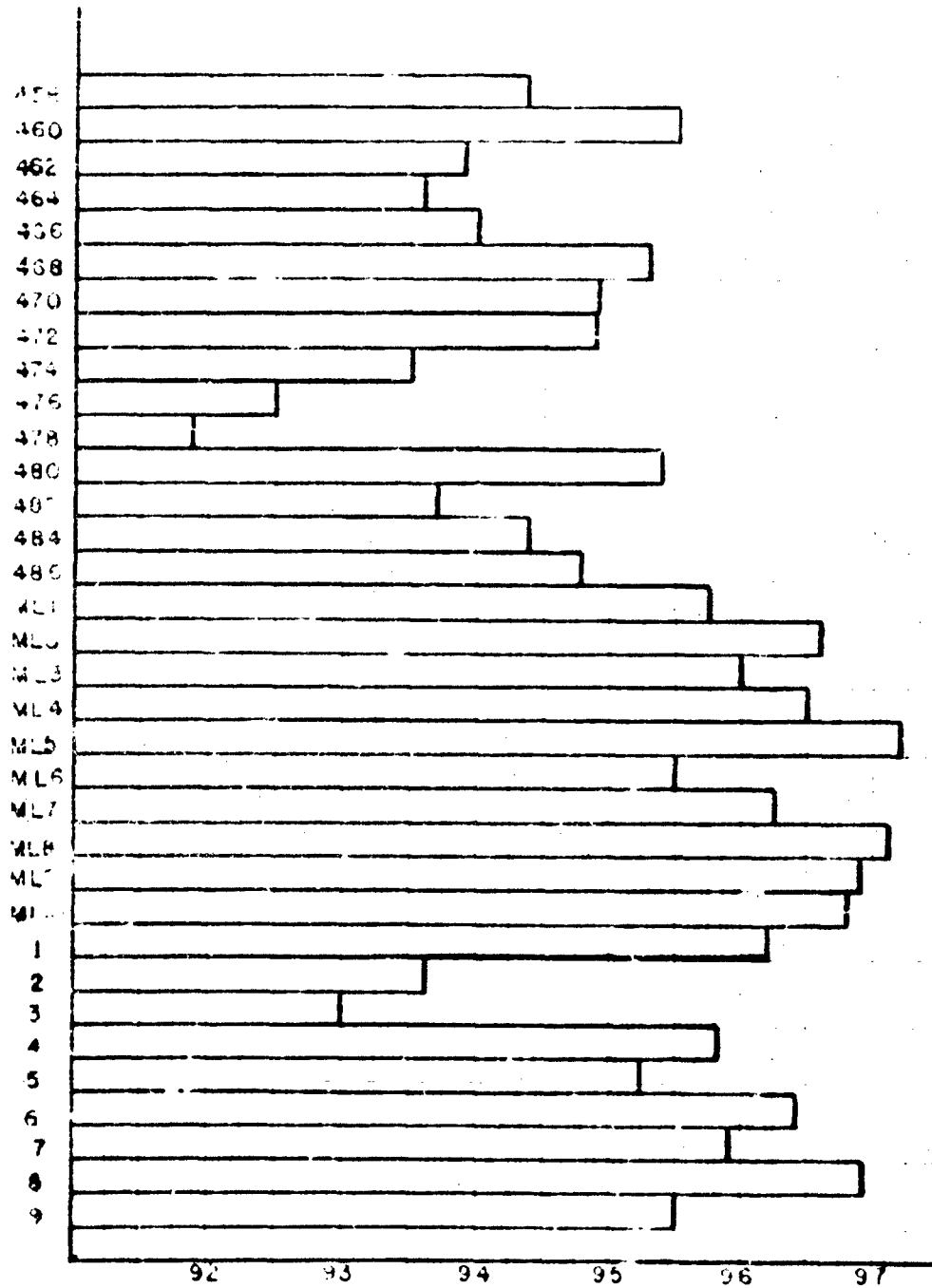


FIG. 24 POROSITY AT NO LOAD

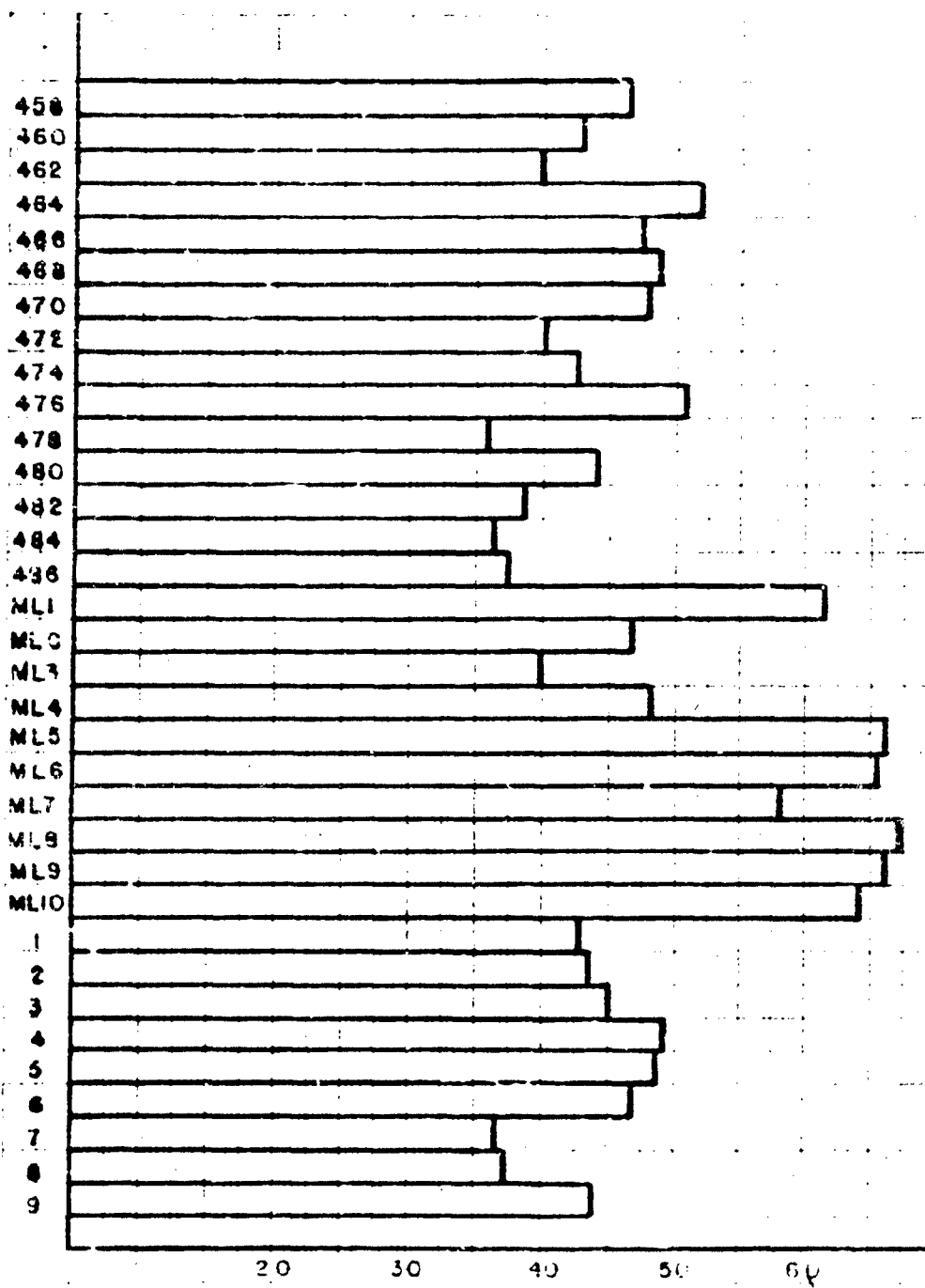


FIG 25 % COMPRESSIBILITY

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