

**Fed. Std. No. 4b**  
**SECTIONS I, II, and III**  
 July 29, 1964

**SUPERSEDING**  
 Fed. Std. No. 4a  
 Sections I and II  
 August 29, 1963

**FEDERAL STANDARD**

**GLOSSARY OF FABRIC IMPERFECTIONS**

*Authority. This standard is issued pursuant to the Federal Property and Administrative Services Act of 1949, as amended, and its application to the purchase of commodities referred to herein is mandatory on all Federal agencies.*

This standard consists of:

- Section I—Woven Cotton Fabrics.  
 Section II—Woven Woolen and Worsted Fabrics.  
 Section III—Woven Synthetic Fabrics.

**SECTION I—WOVEN COTTON FABRICS**

**1. PURPOSE AND SCOPE**

1.1 This section consists of a complete listing of woven cotton fabric imperfections, with definitions, arranged according to whether they are the result of the spinning, weaving, or finishing operations. The purpose is to bring together in one publication the general information on woven cotton fabric imperfections.

**2. ALPHABETICAL INDEX OF FABRIC IMPERFECTIONS**

**2.1 Imperfections and glossary numbers**

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Beaded selvage .....	54
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Change-in filling .....	14
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Coarse or heavy filling .....	1
Coarse or heavy pick .....	1
Corded selvage .....	54
Crack .....	12
Crease .....	59
Crooked cloth .....	93
Crowsfeet .....	67
Crushed pile .....	95
Curl .....	6
Curled selvage .....	48
Cut .....	91
Cut selvage .....	55
Dirty filling .....	24
Doctor streak .....	68
Double pick .....	4
Doubles .....	48
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Seam mark	61
Selvage mark	60
Shade bar	14
Shell-off	5A
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3. IMPERFECTIONS AND DEFINITIONS

3.1 Imperfections in filling direction.

3.1.1 *Thick places.* Imperfections which cause places in the cloth to be thicker than normal.

Glossary No.	Imperfection Commercial Terminology	Definition
1	Coarse or heavy filling Coarse or heavy pick	A yarn larger in diameter than normally being used in the cloth.
2	Heavy place Heavy filling bar Bad set mark (heavy side) Stop mark Starting mark (heavy side)	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of larger diameter than normally being used in the cloth or containing more than the normal number of picks.
8	Jerked-in filling Lashed-in filling Pull-in filling	An extra thread dragged into the shed with a proper pick and extending only a part of the way across the cloth.
4	Double pick Flat	Two or more picks in the same shed across the full width of the cloth.
5	Slub or slug Bunch Lump	An abruptly thickened place in the yarn.
5A	Slough-off Shell-off Ropy Filling	Filling which has slipped off bobbin and has been woven into the cloth along with the required pick.
6	Kink Loop Snarl Curl	A place in the cloth where a short length of yarn has spontaneously doubled on itself.

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Glossary No.	Imperfection Commercial Terminology	Definition
7	Knot	Self-descriptive.

**3.1.2 Thin places.** Imperfections which cause places in the cloth to be thinner than normal.

Glossary No.	Imperfection Commercial Terminology	Definition
8	Fine or light filling Fine or light pick	A yarn smaller in diameter than normally being used in the cloth.
9	Light place Fine filling bar Light filling bar Pull down Bad set mark (light side) Stop mark Starting mark (light side) Thin place	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of smaller diameter than normally being used in the cloth or containing less than the normal number of picks.

**3.1.3 Misweaves.** Imperfections in weave usually found in the filling direction.

Glossary No.	Imperfection Commercial Terminology	Definition
10	Mispick	A pick woven in improper order.
11	Broken pick Missing pick	A pick wholly or partially missing.
12	Crack Shyer (Shirer) Thin place	An open streak parallel with the filling and extending partly or entirely across the cloth.
13	Filling float Skip Overshot Harness drop	A place in the cloth where a filling yarn extends unbound over the end (s) with which it should be interlaced.
14	Mixed filling Change in filling Shade bar Mispily	Filling yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.

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Glossary No.	Imperfection Commercial Terminology	Definition
15	Tight pick or filling Stretched filling	Self-descriptive.
16	Slack pick or filling	Self-descriptive.
17	Hang pick Hang shot	A pick which is pulled out of line for a short distance producing a small triangular shaped hole in the cloth.

**3.1.4 Miscellaneous fillingwise imperfections.**

Glossary No.	Imperfection Commercial Terminology	Definition
18	Barré mark	One or more picks in the cloth characterized by an apparent difference in shade from adjoining picks.
19 and 20	Box mark Shuttle mark	A fine line parallel with the filling.
21	Tear drop or teariness	A fabric condition characterized by short elliptical distortions of one or more adjoining picks.
22	Finger mark Pressure mark	An irregular spot showing variations in picks per inch for a limited width.
23	Pick-out mark Cleaning place Rip out	A fillingwise band or bar characterized by a chafed or fuzzy appearance.
24	Soiled pick Dirty filling Oily filling	Self-descriptive.
25	Uneven filling	Self-descriptive.

**3.2 Imperfections in the warp direction.**

**3.2.1 Thick places.** Imperfections which cause places in the cloth to be thicker than normal.

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Glossary No.	Imperfection Commercial Terminology	Definition
26	Coarse end	A yarn larger in diameter or containing more plies than normally being used in the cloth.
27	Slub or slug Bunch	An abruptly thickened place in the yarn.
28	Kink Loop	A place in the cloth where a short length of yarn has spontaneously doubled on itself.
29	Knot	Self-descriptive.
30	Hang or loose threads	Self-descriptive.

**3.2.2 Thin places.** Imperfections which cause places in the cloth to be thinner than normal.

Glossary No.	Imperfection Commercial Terminology	Definition
31	Fine end	A warp yarn smaller in diameter than normally used in the cloth.
32	Drop-ply	A yarn containing fewer plies than normally used in the cloth.
33	Broken or missing end End out	A warp yarn missing for a portion or the entire length of the cloth.

**3.2.3 Misweaves.** Imperfections in weave usually found in the warp direction.

Glossary No.	Imperfection Commercial Terminology	Definition
34	Warp float Harness skips Harness drop	A place in the cloth where a warp yarn extends unbound over the pick(s) with which it should be interlaced.
34A	Bad mend	Self-descriptive.
35	Hitch-back Draw-back Tie-back Warp holding place Sticker	A distortion in the weave characterized by tight and slack places in the same warp yarns.
35A	Uneven weaving	Self-descriptive.

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**3.2.4 Miscellaneous warpwise imperfections.**

Glossary No.	Imperfection Commercial Terminology	Definition
36	Mixed end Misply	Warp yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.
37	Tight end	Self-descriptive.
38	Slack end	Self-descriptive.
39	Slack warp	A cloth having an overall crimped or cockled appearance, woven under tension less than proper.
40	Wrong draw	A place in the cloth where one or more ends have been drawn through the wrong heddle, or dent.
41	Reed mark	A mark running warpwise in the cloth.
42	Temple marks	Small holes, impressions, or marks adjacent to the edge of the cloth.
43	Hard size Sticker Starch lumps	Spots or bars in the cloth containing an excessive quantity of sizing.
44	Warp streak	A narrow warpwise band or an overall warpwise striation characterized by apparent differences in color from adjoining ends.
45	Fuzz balls Balling up Pilling	Loose or frayed fibers which have formed into a ball.
46	Soiled end	Self-descriptive.
47	Uneven end	Self-descriptive.

**3.3 Bad selvages.**

Glossary No.	Imperfection Commercial Terminology	Definition
48	Curled selvage Folded selvage Rolled selvage Doubles	Self-descriptive.
49	Slack selvage	Self-descriptive.

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Glossary No.	Imperfection Commercial Terminology	Definition
50	Tight selvage	Self-descriptive.
51	Scalloped selvage	Self-descriptive.
52	Wavy selvage	Self-descriptive.
53	Stringy selvage	Self-descriptive.
54	Corded selvage Beaded selvage Rough selvage Loopy selvage	An improperly woven selvage of excessive thickness or a selvage containing irregular filling loops extending beyond the outside selvages.
55	Cut selvage Broken selvage	Cuts or breaks that occur in the selvage only and do not extend into the body of the cloth.
56	Torn selvage	Self-descriptive.

**3.4 Finishing imperfections.**

Glossary No.	Imperfection Commercial Terminology	Definition
57	Finishing bar Calendar mark	Uneven appearance extending partly or entirely across the cloth.
58	Blanket mark Sanforizing mark	A crimped, rippled, wavy, pebbled, or cockled place in the cloth showing distortion of the weave.
59	Crease Mill wrinkle Hard crease	Self-descriptive.
60	Selvage mark	A more or less regular mark in the finished cloth along the selvage produced by folded or doubled selvage during finishing operations.
61	Wrinkle mark Seam mark	A more or less regular mark in the finished cloth produced by pressure during finishing operations.
61A	Off shade	Not within established shade tolerance, shaded side to side, side to center or end to end.
62	Uneven shade Uneven dyeing	Color is not uniform throughout the cloth.
63	Off-register printing	Pattern displacement caused by improper alignment of printing rolls.



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Glossary No.	Imperfection Commercial Terminology	Definition
63A	Uneven finish	Cloth does not have the same degree and character of finish throughout.
64	Uneven napping	Cloth in which the nap is not raised uniformly.
65	Misprint	Self-descriptive.
66	Doctor streak	A wavy white or colored streak in the warp direction on printed cloth.
67	Crowfeet	Short indistinct markings on dyed or finished goods.
68	Rope marks	Long irregular indistinct markings on dyed or finished goods.
69	Dye stain	An area of discoloration in the cloth.
70	Dye streak Snap	A dye stain extended as an irregular stripe in the cloth.
71	Mottled	A blotchy or spotted appearance of the cloth.
72	Uneven shrinkage	A wavy warpwise condition in the cloth, which prevents it from lying flat on a horizontal surface. This condition may appear along one selvage or both selvages or through sections in the center of the cloth.
73	Tentering marks Clip marks Pin marks	Enlarged pinholes, tears, or shift marks along the edge of the cloth.

**3.5 General imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
74 and 75	Spot Stain	An area of discoloration on the surface of the cloth.
76	Streak	A spot or stain extended as an irregular stripe in the cloth.
77, 81, and 83	Woven in waste Gout Flyers, loom fly	Waste that has been woven into the cloth, or spun into the yarn.
78	Smash Breakout	A damaged area where the texture has been ruptured by the breaking of a group of yarns, principally the warp.

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Glossary No.	Imperfection Commercial terminology	Definition
79	Abrasion mark Chafe mark Bruise Sand roll mark	A place where the surface of the cloth has been damaged by friction.
80	Objectionable odor Bad odor	Self-descriptive.
82	Burr	Seed fragments with bristles projecting from them.
84 and 85	Neps	All definite fiber tangles.
86	Neppiness	A speckled condition of the cloth characterized by a number of neps.
87	Shift mark	A place in the cloth where warp ends have shifted on the filling picks or vice versa, causing adjacent light and heavy spots.
88	Bias filling Bowed filling	Cloth in which the filling yarn does not run at right angle to the warp.
89	Weak spots Tender spots	Places in the cloth which have been abnormally weakened during any of the operations through which it has passed.
90	Hole	Self-descriptive.
91	Cut	Self-descriptive.
92	Tear	Self-descriptive.
93	Uneven tension Ridgy cloth Crooked cloth Baggy cloth Wavy cloth Puckering	A wavy or ridgy cloth that will not lie flat.
94	Pile missing	Self-descriptive.
95	Crushed pile	Self-descriptive.
96	Pile improperly formed	Self-descriptive.
97	Uncut pile	Self-descriptive.

## SECTION II—WOVEN WOOLEN AND WORSTED FABRICS

## 1. PURPOSE AND SCOPE

1.1 This section consists of a complete listing of woven woolen and worsted fabric imperfections, with definitions, arranged according to whether they are the result of the spinning, weaving, or finishing operations. The purpose is to bring together in one publication the general information on woven woolen and worsted fabric imperfections.

## 2. ALPHABETICAL INDEX OF FABRIC IMPERFECTIONS

## 2.1 Imperfections and glossary numbers.

## ALPHABETICAL INDEX

Imperfection Commercial terminology	Glossary No.
Abrasion mark .....	74
Bad mend .....	35
Bad set mark (heavy side) .....	2
Bad set mark (light side) .....	10
Baggy cloth .....	86
Balling up .....	45
Barré mark .....	20
Beaded selvage .....	54
Bias filling .....	83
Bowed filling .....	83
Box mark .....	21
Breakout .....	73
Broken end .....	33
Broken pick .....	12
Broken selvage .....	55
Bruise .....	74
Bunch .....	5 and 27
Burrs .....	78
Chafe mark .....	74
Change-in-filling .....	15
Cleaning place .....	23
Clip marks .....	70
Coarse end .....	26
Coarse filling .....	1
Coarse pick .....	1
Corded selvage .....	54
Crack .....	14
Crease .....	57
Crooked cloth .....	86

## ALPHABETICAL INDEX—Continued

Imperfection Commercial terminology	Glossary No.
Crowfeet .....	67
Crushed pile .....	88
Curl .....	7
Curled selvage .....	48
Cut .....	85
Cut selvage .....	55
Dark hairs .....	91
Decating mark .....	62
Dirty filling .....	24
Double pick .....	4
Doubles .....	48
Draw-back .....	34
Drop-ply .....	15 and 32
End out .....	33
Extended tuck .....	19
Fine end .....	31
Fine filling .....	9
Fine filling bar .....	10
Fine pick .....	9
Finger mark .....	22
Finishing bar .....	56
Flat .....	41
Float .....	77
Folded selvage .....	48
Fuller rub .....	74
Fuzz balls .....	45
Hang pick .....	18
Hang shot .....	18
Hang thread .....	30
Heavy filling .....	1
Heavy filling bar .....	2
Heavy pick .....	1
Heavy place .....	2
Hitch-back .....	34
Hole .....	85
Jerked-in filling .....	3
Kink .....	7 and 28
Knot .....	8 and 29
Lashed-in filling .....	3
Light filling .....	9
Light filling bar .....	10
Light pick .....	9
Light place .....	10
Loop .....	7 and 28
Loopy selvage .....	54
Loose threads .....	30
Lump .....	5
Mill wrinkle .....	60
Mispick .....	11

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**ALPHABETICAL INDEX—Continued**

Imperfection Commercial terminology	Glossary No.
Misply .....	15 and 37
Misreed .....	41
Missing end .....	33
Missing pick .....	13
Mixed end .....	37
Mixed filling .....	15
Mottled .....	69
Neps .....	80
Neppiness .....	81
Objectionable odor .....	75
Off shade .....	61
Olly filling .....	24
Overall uncleanness .....	84
Overshot .....	77
Pick-out mark .....	21
Pile improperly formed .....	89
Pile missing .....	87
Pilling .....	45
Pin marks .....	70
Pressure mark .....	22
Puckering .....	86
Pull down .....	10
Pull-in filling .....	3
Reed mark .....	42
Ridgy cloth .....	86
Rip out .....	23
Rolled selvage .....	48
Rope marks .....	68
Roped filling .....	6
Rough selvage .....	54
Sand roll mark .....	74
Scalloped selvage .....	51
Seam mark .....	59
Selvage mark .....	58
Shade bar .....	15
Shell-off .....	6
Shift mark .....	82
Shiner .....	16
Shive .....	79
Shuttle mark .....	21
Shyer (Shirer) .....	14
Sidelines .....	3
Sisal .....	79
Skip .....	77
Slack end .....	39
Slack filling .....	17
Slack pick .....	17
Slack selvage .....	49
Slack warp .....	40
Slough-off .....	6
Slub .....	5 and 27

**ALPHABETICAL INDEX—Continued**

Imperfection Commercial terminology	Glossary No.
Slug .....	5 and 27
Smash .....	73
Snarl .....	7
Soiled end .....	46
Soiled pick .....	24
Speck .....	79
Spot .....	71
Stain .....	71
Starting mark (heavy side) .....	2
Starting mark (light side) .....	10
Sticker .....	34
Stop mark .....	2 and 10
Streak .....	72
Stretched filling .....	16
Tear .....	85
Temple marks .....	43
Tentering marks .....	70
Thick selvage .....	53
Thin place .....	10
Tie-back .....	34
Tight end .....	38
Tight filling .....	16
Tight pick .....	16
Tight selvage .....	50
Torn selvage .....	55
Uncut pile .....	90
Uneven end .....	47
Uneven filling .....	25
Uneven finish .....	63
Uneven napping .....	64
Uneven shade .....	66
Uneven shearing .....	65
Uneven tension .....	86
Uneven weaving .....	36
Warp holding place .....	34
Warp streak .....	44
Washer break .....	60
Washer rub .....	74
Washer wrinkle .....	60
Wavy cloth .....	86
Wavy selvage .....	52
Woven-in waste .....	76
Wrinkle mark .....	59
Wrong draw .....	41

**3 IMPERFECTIONS AND DEFINITIONS**

**3.1 Imperfections in filling direction.**

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**3.1.1 Thick places.** Imperfections which cause places in the cloth to be thicker than normal.

Glossary No.	Imperfection Commercial terminology	Definition
1	Coarse or heavy filling Coarse or heavy pick	A yarn larger in diameter than normally being used in the cloth.
2	Heavy place Heavy filling bar Bad set mark (heavy side) Stop mark Starting mark (heavy side)	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of larger diameter than normally being used in the cloth or containing more than the normal number of picks.
3	Jerked-in filling Lashed-in filling Pull-in filling Sidelines	Extra yarn or yarns dragged into the shed with a proper pick and extending only a part of the way across the cloth.
4	Double pick	Two or more picks in the same shed across the full width of the cloth.
5	Slub or slug Bunch Lump	An abruptly thickened place in the yarn.
6	Slough-off Shell-off Roped filling	Excess filling which has slipped off the bobbin and has been woven into the cloth along with the required pick.
7	Kink Loop Snarl Curl	A place in the cloth where a short length of yarn has spontaneously doubled on itself.
8	Knot	Self-descriptive.

**3.1.2 Thin places.** Imperfections which cause places in the cloth to be thinner than normal.

Glossary No.	Imperfection Commercial terminology	Definition
9	Fine or light filling Fine or light pick	A yarn smaller in diameter than normally being used in the cloth.
10	Light place Fine filling bar Light filling bar	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of smaller diameter than normally being used in the

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Glossary No.	Imperfection Commercial terminology	Definition
	Pull down Bad set mark (light side) Stop mark Starting mark (light side) Thin place	cloth or containing less than the normal number of picks.

**3.1.3 Misweaves.** Imperfections in weave usually found in the filling direction.

Glossary No.	Imperfection Commercial terminology	Definition
11	Mispick	A pick woven in improper order.
12	Broken pick	A pick partially missing.
13	Missing pick	A pick missing the entire width of the cloth.
14	Crack Shyer (Shirer)	An open streak parallel with the filling and extending partly or entirely across the cloth.
15	Mixed filling Change-in-filling Shade bar Drop-ply Misply	Filling yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.
16	Tight pick or filling Stretched filling Shiner	Self-descriptive.
17	Slack pick or filling	Self-descriptive.
18	Hang pick Hang shot	A pick which is pulled out of line for a short distance producing a small triangular shaped hole in the cloth.
19	Extended tuck	Tuck in pick of cloth woven on shuttleless looms extended into body of cloth beyond selvage resulting in a nap (fuzziness) adjacent to the selvage in body of cloth.

**3.1.4 Miscellaneous filling defects.**

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Glossary No.	Imperfection Commercial terminology	Definition
20	Barré mark	One or more picks in the cloth characterized by an apparent difference in shade from adjoining picks.
21	Shuttle mark Box mark	A line parallel with the filling usually darker or lighter in color than normal shade.
22	Finger mark Pressure mark	An irregular spot showing variations in picks per inch for a limited width.
23	Pick-out mark Cleaning place Rip out	A fillingwise hand or bar characterized by a chafed or fuzzy appearance.
24	Soiled pick Dirty filling Oily filling	Self-descriptive.
25	Uneven filling	Self-descriptive.

### 3.2 Imperfections in the warp direction.

3.2.1 *Thick places.* Imperfections which cause places in the cloth to be thicker than normal.

Glossary No.	Imperfection Commercial terminology	Definition
26	Coarse end	A yarn larger in diameter or containing more plies than normally being used in the cloth.
27	Slub or slug Bunch	An abruptly thickened place in the yarn.
28	Kink Loop	A place in the cloth where a short length of yarn has spontaneously doubled on itself.
29	Knot	Self-descriptive.
30	Hang or loose threads	Self-descriptive.

3.2.2 *Thin places.* Imperfections which cause places in the cloth to be thinner than normal.

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Glossary No.	Imperfection Commercial terminology	Definition
81	Fine end	A warp yarn smaller in diameter than normally used in the cloth.
82	Drop-ply	A warp yarn containing fewer plies than normally used in the cloth.
83	Broken or missing end End out	A warp yarn missing for a portion of or the entire length of the cloth.

**3.2.3 Misweaves.** Imperfections in weave usually found in the warp direction.

Glossary No.	Imperfection Commercial terminology	Definition
84	Hitch-back Draw-back Tie-back Warp holding place Sticker	A distortion in the weave characterized by tight and slack places in the same warp yarns.
35	Bad mend	Self-descriptive.
36	Uneven weaving	Self-descriptive.

**3.2.4 Miscellaneous warpwise imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
37	Mixed end Misply	Warp yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.
38	Tight end	Self-descriptive.
39	Slack end	Self-descriptive.
40	Slack warp	A cloth having an overall crimped or cockled appearance, woven under tension less than proper.
41	Wrong draw Flat Misreed	A place in the cloth where one or more ends have been drawn through the wrong heddle or reed.



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Glossary No.	Imperfection Commercial terminology	Definition
42	Reed mark	Thick or thin lines or both running warpwise in the cloth.
43	Temple marks	Small holes, impressions, or marks adjacent to the edge of the cloth.
44	Warp streak	A warpwise band characterized by apparent differences in the color from adjoining ends.
45	Fuzz balls Balling up Pilling	Loose or frayed fibers which have formed into a ball.
46	Soiled end	Self-descriptive.
47	Uneven end	Self-descriptive.

**3.3 Bad selvages.**

Glossary No.	Imperfection Commercial terminology	Definition
48	Curled selvage Folded selvage Rolled selvage Doubles	Self-descriptive.
49	Slack selvage	Self-descriptive.
50	Tight selvage	Self-descriptive.
61	Scalloped selvage	Self-descriptive.
52	Wavy selvage	The selvage will not lie flat when the cloth is laid out.
53	Thick selvage	An improperly constructed selvage resulting in greater diameter roll at selvage than body of cloth.
54	Corled selvage Beaded selvage Rough selvage Loopy selvage	An improperly woven selvage of excessive thickness or a selvage containing irregular filling loops extending beyond the outside selvages.
55	Cut selvage Broken selvage Torn selvage	Cuts, tears or breaks that occur in the selvage only and do not extend into the body of the cloth.

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**3.4 Finishing imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
56	Finishing bar	Uneven appearance across entire width of cloth.
57	Crease	Self-descriptive.
58	Selvage mark	A more or less regular mark in the finished cloth along the selvage.
59	Wrinkle mark Seam mark	A more or less regular mark in the finished cloth.
60	Washer break Washer wrinkle Mill wrinkle	Warpwise indistinct streaks which may alternately appear as wrinkles, abrasions, shifting of yarns or excess or absence of felting cover.
61	Off shade	Not within established shade tolerance.
62	Decating mark	A crease mark or impression extending fillingwise across the cloth.
63	Uneven finish	Cloth does not have the same degree and character of finish throughout.
64	Uneven napping	Cloth in which the nap is not raised uniformly.
65	Uneven shearing	Cloth which has not been uniformly sheared.
66	Uneven shade	Color is not uniform throughout the cloth.
67	Crowsfeet	Short indistinct markings on dyed or finished goods.
68	Rope marks	Long irregular indistinct markings on dyed or finished cloth.
69	Nottled	A general blotchy or spotted appearance of the cloth.
70	Teetering marks Clip marks Pin marks	Enlarged pinholes or marks along the edge of the cloth.

**3.5 General imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
71	Spot Stain	An area of discoloration on or in the cloth.

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Glossary No.	Imperfection Commercial terminology	Definition
72	Streak	A spot, stain or an off-shade area extended as an irregular stripe in the cloth.
73	Smash Breakout	A damaged area where the texture has been ruptured by the breaking of a group of yarns, principally the warp.
74	Abrasion mark Chafe mark Bruise Sand roll mark Fuller rub Washer rub	A place where the surface of the cloth has been damaged by friction.
75	Objectionable odor	Self-descriptive.
76	Woven-in waste	Waste or extraneous material that has been woven into the cloth, or spun into the yarn.
77	Float Skip Overshot	A place in the cloth where a filling or warp yarn extends unbound over the end or pick with which it should be interlaced.
78	Burrs	Seed fragments with bristles projecting from them.
79	Shive Sisal Speck	Vegetable matter other than burrs.
80	Neps	All definite fiber tangles.
81	Neppiness	A speckled condition of the cloth characterized by a number of neps.
82	Shift mark	A place in the cloth where warp ends have shifted on the filling picks or vice versa, causing adjacent light and heavy spots.
83	Bias filling Bowed filling	Cloth in which the filling yarn does not run at right angle to the warp.
84	Overall uncleanness	Self-descriptive.
85	Hole Tear Cut	Self-descriptive.
86	Uneven tension Ridgy cloth Crooked cloth Baggy cloth Wavy cloth Puckering	A wavy or ridgy cloth that will not lie flat when laid on a cutting table.

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Glossary No.	Imperfection Commercial terminology	Definition
87	Pile missing	Self-descriptive.
88	Crushed pile	Self-descriptive.
89	Pile improperly formed	Self-descriptive.
90	Uncut pile	Self-descriptive.
91	Dark hairs	Black or dark-brown hairs in light-colored cloth.

## SECTION III—WOVEN SYNTHETIC FABRICS

## 1. PURPOSE AND SCOPE

1.1 This section consists of a complete listing of woven synthetic fabric imperfections, with definitions, arranged according to whether they are the result of the spinning, weaving, or finishing operations. The purpose is to bring together in one publication the general information on woven synthetic fabric imperfections.

## 2. ALPHABETICAL INDEX OF FABRIC IMPERFECTIONS

## 2.1 Imperfections and glossary numbers.

## ALPHABETICAL INDEX

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Bias filling	80
Bowed filling	80
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Hang shot	18
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Hard crease	59
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Harness skips	34
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Heavy place	2
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Kink	7 and 28
Knot	8 and 29
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Light place	10
Loop	7 and 28
Loopy selvage	55
Lump	5

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## ALPHABETICAL INDEX—Continued

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Mispick	11
Misply	15 and 38
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Mixed filling	15
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Objectionable odor	78
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Oily filling	24
Overshot	14
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Pile missing	86
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Puckering	85
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Rope marks	67
Ropy filling	6
Rough selvage	55
Sand roll mark	77
Scalloped selvage	52
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Selvage mark	60
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Shiner	91
Shuttle mark	20
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Slack pick or filling	17
Slack selvage	50
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## ALPHABETICAL INDEX—Continued

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Tight pick or filling	16
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Uncut pile	89
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Uneven finish	64
Uneven end	48
Uneven filling	25
Uneven napping	65
Uneven shade	63
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Uneven tension	85
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Warp holding place	36
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Wavy selvage	53
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Wrong draw	42

### 3. IMPERFECTIONS AND DEFINITIONS

#### 3.1 Imperfections in filling direction.

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**3.1.1 Thick places.** Imperfections which cause places in the cloth to be thicker than normal.

Glossary No.	Imperfection Commercial terminology	Definition
1	Coarse or heavy filling Coarse or heavy pick	A yarn larger in diameter than normally being used in the cloth.
2	Heavy place Heavy filling bar Bad set mark (heavy side) Stop mark Starting mark (heavy side)	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of larger diameter than normally being used in the cloth or containing more than the normal number of picks.
3	Jerked-in filling Lashed-in filling Pull-in filling Whip-in	An extra thread dragged into the shed with a proper pick and extending only a part of the way across the cloth.
4	Double pick Flat	Two or more picks in the same shed across the full width of the cloth.
5	Slub or slug Bunch Lump	An abruptly thickened place in the yarn.
6	Slough-off Shell-off Ropy-filling	Filling which has slipped off bobbin and has been woven into the cloth along with the required pick.
7	Klink Loop Snarl Curl	A place in the cloth where a short length of yarn has spontaneously doubled on itself.
8	Knot	Self-descriptive.

**3.1.2 Thin places.** Imperfections which cause places in the cloth to be thinner than normal.

Glossary No.	Imperfection Commercial terminology	Definition
9	Fine or light filling Fine or light pick	A yarn smaller in diameter than normally being used in the cloth.
10	Light place Fine filling bar Light filling bar Pull down Bad set mark (light side) Stop mark Starting mark (light side) Thin place	A fillingwise band or bar either across the full width of the cloth or a portion of it, containing picks of smaller diameter than normally being used in the cloth or containing less than the normal number of picks.

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**3.1.3 Misweaves.** Imperfections in weave usually found in the filling direction.

Glossary No.	Imperfection Commercial terminology	Definition
11	Mispick	A pick woven in improper order.
12	Broken pick Missing pick	A pick wholly or partially missing.
13	Crack Shyer (Shirer) Thin place	An open streak parallel with the filling and extending partly or entirely across the cloth.
14	Filling float Skip Overhot Harness drop	A place in the cloth where a filling yarn extends unbound over the ends(s) with which it should be interlaced.
15	Mixed filling Change in filling Shade bar Mispily	Filling yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.
16	Tight pick or filling Stretched filling	Self-descriptive.
17	Slack pick or filling	Self-descriptive.
18	Hang pick Hang shot	A pick which is pulled out of line for a short distance producing a small triangular shaped hole in the cloth.

**3.1.4 Miscellaneous fillingwise imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
19	Barré mark	One or more picks in the cloth characterized by an apparent difference in shade or lustre from adjoining picks.
20	Box mark Shuttle mark	A fine line parallel with the filling.
21	Tear drop or teariness	A fabric condition characterized by short elliptical distortions on one or more adjoining picks.
22	Finger mark Pressure mark	An irregular spot showing variations in picks per inch for a limited width.
23	Pick-out mark Cleaning place Rip out	A fillingwise band or bar characterized by a chafed or fuzzy appearance.



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Glossary No.	Imperfection Commercial terminology	Definition
24	Soiled pick Dirty filling Oily filling	Self-descriptive.
25	Uneven filling	Self-descriptive.

**3.2 Imperfections in the warp direction.**

**3.2.1 Thick places.** Imperfections which cause places in the cloth to be thicker than normal.

Glossary No.	Imperfection Commercial terminology	Definition
26	Coarse end	A yarn larger in diameter or containing more plies than normally being used in the cloth.
27	Slub or slug Bunch	An abruptly thickened place in the yarn.
28	Kink Loop	A place in the cloth where a short length of yarn has spontaneously doubled on itself.
29	Knot	Self-descriptive.
30	Hang or loose threads	Self-descriptive.

**3.2.2 Thin places.** Imperfections which cause places in the cloth to be thinner than normal.

Glossary No.	Imperfection Commercial terminology	Definition
31	Fine end	A warp yarn smaller in diameter than normally used in the cloth.
32	Drop-ply	A yarn containing fewer plies than normally used in the cloth.
33	Broken or missing end End out	A warp yarn missing for a portion or the entire length of the cloth.

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**3.2.3 Misweaves.** Imperfections in weave usually found in the warp direction.

Glossary No.	Imperfection Commercial terminology	Definition
34	Warp float Harness skips Harness drop	A place in the cloth where a warp yarn extends unbound over the pick(s) with which it should be interlaced.
35	Bad mend	Self-descriptive.
36	Hitch-back Draw-back Tie-back Warp holding place Sticker	A distortion in the weave characterized by tight and slack places in the same warp yarns.
37	Uneven weaving	Self-descriptive.

**3.2.4 Miscellaneous warpwise imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
38	Mixed end Misply	Warp yarn which differs from that normally being used in the cloth, such as wrong twist, wrong number of plies, wrong color, mixed yarn lots.
39	Tight end	Self-descriptive.
40	Slack end	Self-descriptive.
41	Slack warp	A cloth having an overall crimped or cockled appearance, woven under tension less than proper.
42	Wrong draw Flat	A place in the cloth where one or more ends have been drawn through the wrong heddle, or dent.
43	Reed mark	A mark running warpwise in the cloth.
44	Temple marks	Small holes, impressions, or marks adjacent to the edge of the cloth.
45	Warp streak	A narrow warpwise band or an overall warpwise striation characterized by apparent differences in color or lustre from adjoining ends.
46	Fuzz balls Balling up Pilling	Loose or frayed fibers which have formed into a ball.
47	Soiled end	Self-descriptive.
48	Uneven end	Self-descriptive.

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**3.3 Bad selvages.**

Glossary No.	Imperfection Commercial terminology	Definition
49	Curled selvage Folded selvage Rolled selvage Doubles	Self-descriptive.
50	Slack selvage	Self-descriptive.
51	Tight selvage	Self-descriptive.
52	Scalloped selvage	Self-descriptive.
53	Wavy selvage	Self-descriptive.
54	Stringy selvage	Self-descriptive.
55	Corded selvage Beaded selvage Rough selvage Loopy selvage	An improperly woven selvage of excessive thickness or a selvage containing irregular filling loops extending beyond the outside selvages.
56	Cut selvage Broken selvage	Cuts or breaks that occur in the selvage only and do not extend into the body of the cloth.
57	Torn selvage	Self-descriptive.

**3.4 Finishing imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
58	Finishing bar Calendar mark	Uneven appearance extending partly or entirely across the cloth..
59	Crease Mill wrinkle Hard crease	Self-descriptive.
60	Selvage mark	A more or less regular mark in the finished cloth along the selvage produced by folded or doubled selvage during finishing operations.
61	Wrinkle mark Seam mark	A more or less regular mark in the finished cloth produced by pressure during finishing operations.
62	Off shade	Not within established shade tolerance, shaded side to side, side to center or end to end.

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Glossary No.	Imperfection Commercial terminology	Definition
63	Uneven shade Uneven dyeing	Color is not uniform throughout the cloth.
64	Uneven finish	Cloth does not have the same degree and character of finish throughout.
65	Uneven napping	Cloth in which the nap is not raised uniformly.
66	Crowfeet	Short indistinct markings on dyed or finished goods.
67	Rope marks	Long irregular indistinct markings on dyed or finished goods.
68	Dyestain	An area of discoloration in the cloth.
69	Dye streak Snap	A dye stain extended as an irregular stripe in the cloth.
70	Mottled	A blotchy or spotted appearance of the cloth.
71	Uneven shrinkage	A wavy warpwise condition in the cloth, which prevents it from lying flat on a horizontal surface. This condition may appear along one selvage or both selvages or through sections in the center of the cloth.
72	Tentering marks Clip marks Pin marks	Enlarged pinholes, tears, or shift marks along the edge of the cloth.

**3.5 General imperfections.**

Glossary No.	Imperfection Commercial terminology	Definition
73	Spot Stain	An area of discoloration on the surface of the cloth.
74	Streak	A spot or stain extended as an irregular stripe in the cloth.
75	Woven-in waste Gout Flyers Loom fly	Waste that has been woven into the cloth, or spun into the yarn.
76	Smash Breakout	A damaged area where the texture has been ruptured by the breaking of a group of yarns, principally the warp.

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Glossary No.	Imperfection Commercial terminology	Definition
77	Abrasion mark Chafe mark Bruise Sand roll mark	A place where the surface of the cloth has been damaged by friction.
78	Objectionable odor Bad odor	Self-descriptive.
79	Shift mark	A place in the cloth where warp ends have shifted on the filling picks or vice versa, causing adjacent light and heavy spots.
80	Bias filling Bowed filling	Cloth in which the filling yarn does not run at right angle to the warp.
81	Tails	A mend in which ends protrude from the cloth.
82	Hole	Self-descriptive.
83	Cut	Self-descriptive.
84	Tear	Self-descriptive.
85	Uneven tension Ridgy cloth Crooked cloth Baggy cloth Wavy cloth Puckering	A wavy or ridgy cloth that will not lie flat.
86	Pile missing	Self-descriptive.
87	Crushed pile	Self-descriptive.
88	Pile improperly formed	Self-descriptive.
89	Uncut pile	Self-descriptive.
90	Stripback Broken filament Split filament Split end	Self-descriptive.
91	Shiner	A streak caused by a lustrous section of a filament yarn.

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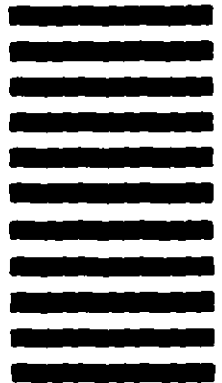
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