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THE INTERDEPENDENCE BETWEEN WARP YARN TENSION AND MATERIAL PROPERTIES

Muslimbek Abdujabborov

Head of Department, "Aisha Textile" LLC

Ph.D. in Technical Sciences

Rakhim Karimov

Head of Research Department, "ArtSoftTex" LLC

Candidate in Technical Sciences, Associate Professor

Dilbar Aliyeva

Professor, "Textile Materials Technology " Department,

Namangan State Technical University, D.Sc. in Technical Sciences

Abstract

The optimal setting for warp tension in weaving is not a universal constant but a function of the intrinsic properties of the yarn material being processed. This paper investigates the complex relationship between yarn composition (cotton, synthetics, blends), structural mechanics (count, strength, elongation), and the required applied tension. We present methodologies for calculating optimal tension based on material parameters and detail the detrimental effects of mismatched tension settings, including permanent yarn damage and product deformation. The research concludes that a deep understanding of material science is essential for optimizing the weaving process for any given yarn.

Keywords: Yarn Properties, Material Science, Cotton, Synthetic Yarn, Elasticity, Optimal Tension.

I. Introduction

In weaving, the warp yarns are the backbone of the fabric, subjected to cyclic stresses, abrasion, and bending. Their response to these forces is governed by their material composition and physical structure. Therefore, applying a "standard"



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tension to all materials is a recipe for suboptimal performance. This paper delves into the critical interplay between yarn properties and warp tension, arguing that tension must be treated as a dependent variable derived from the characteristics of the input material.

II. Yarn Composition and Tensile Behavior

Different fibers exhibit vastly different mechanical behaviors under load.

A. Cotton Yarns: Being cellulosic and of staple-fiber construction, cotton yarns have lower initial elasticity and higher friction. They require a moderate, stable tension to prevent stretching and to maintain evenness.

B. Synthetic Filament Yarns: Yarns like polyester or nylon have high strength and high elastic elongation. They can withstand higher tensions but are prone to "creep" (plastic deformation) under sustained load if tension is set too high.

C. Blended Yarns: Their behavior is a complex hybrid of their constituent fibers, requiring tension settings that are often determined empirically.

III. Influence of Physical Yarn Properties

A. Yarn Count and Strength: Heavier (coarser) yarns generally require higher tension than finer yarns due to their greater stiffness and mass. The tension must always be a fraction of the yarn's breaking strength, typically 15-30%.

B. Elongation at Break: This is a critical parameter. A yarn with high elongation (e.g., wool) can be woven with a higher tension margin without breaking, but this may lead to excessive relaxation and shrinkage later.

C. Plasticity vs. Elasticity: A perfectly elastic yarn returns to its original length after tension is released. Most textile yarns are viscoelastic, meaning they have both elastic and plastic components. High tension can permanently stretch (plastic deformation) a yarn, changing its diameter and luster, leading to barré effects in the fabric.

IV. Calculating Optimal Tension and Mitigating Damage

A. Calculation Methods: A common rule-of-thumb is $\text{Tension (gf)} = \text{Yarn Count (Ne)} * K$, where K is a factor (e.g., 1.2 to 2.0) dependent on the fiber and loom type.



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More sophisticated models incorporate modulus of elasticity and predicted frictional forces.

B. Damages from Incorrect Tension:

Over-tensioning: Causes a permanent reduction in yarn diameter, loss of tensile strength due to molecular slippage, and a harsh fabric hand.

Under-tensioning: Leads to a loose fabric structure, poor cover, and potential shrinkage issues in finishing.

V. Conclusion

The selection of warp tension is a fundamental decision that must be made in the context of material science. Ignoring the specific properties of the yarn—its composition, count, strength, and elongation—leads to either process inefficiency or a substandard product. A scientific approach, combining theoretical calculations with practical trials, is essential for defining the optimal tension window for any given material, thereby ensuring both weaving performance and final fabric quality.

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