

ANALYSIS OF COMFORT PROPERTIES OF MULBERRY SILK AND VISCOSE BLENDED KNITTED FABRICS FOR SUITABILITY IN CLOTHING IN TEMPERATE REGIONS

Abstract

This study reports on the impact of textile properties of knitted fabrics blended in three unlike proportions of mulberry silk and viscose fibre, on desired comfort for temperate regions. Attempt was made on four knitted fabrics, blended in proportions of 50% mulberry silk: 50% viscose and 40% mulberry silk: 60% viscose, each in **two unequal** counts. **Objective assessment** of the fabrics has been carried out in order to obtain the scores on various aspects of comfort. Parameters like thermal conductivity, air permeability and water permeability were chosen for experimental design. The influence of fabric weight, thickness, weight, stitch length and tightness factor have been statistically analyzed and discussed. Also, thermal conductivity has been correlated with air permeability and water permeability. It has been exercised to bring about a knitted fabric with desired properties in temperate climates. Results suggest that knitted fabrics blended in 60% mulberry silk: 40% viscose in both yarn counts 15 and 20 Nm, were found most suitable for apparel use in temperate regions. These fabrics were holding a good mix of warmth and coolness by having thermal conductivity of 1.140 and 1.145 Clo, air permeability of 439.2 and 435.7 CFM and water permeability of grades 3 for both fabrics. A worthy influence of constructional properties was observed on comfort characteristics. A feeble negative correlation of thermal conductivity with air permeability and water perm was noticed.

Keywords: *Comfort, Insulation, Permeability, Property, Thermal*

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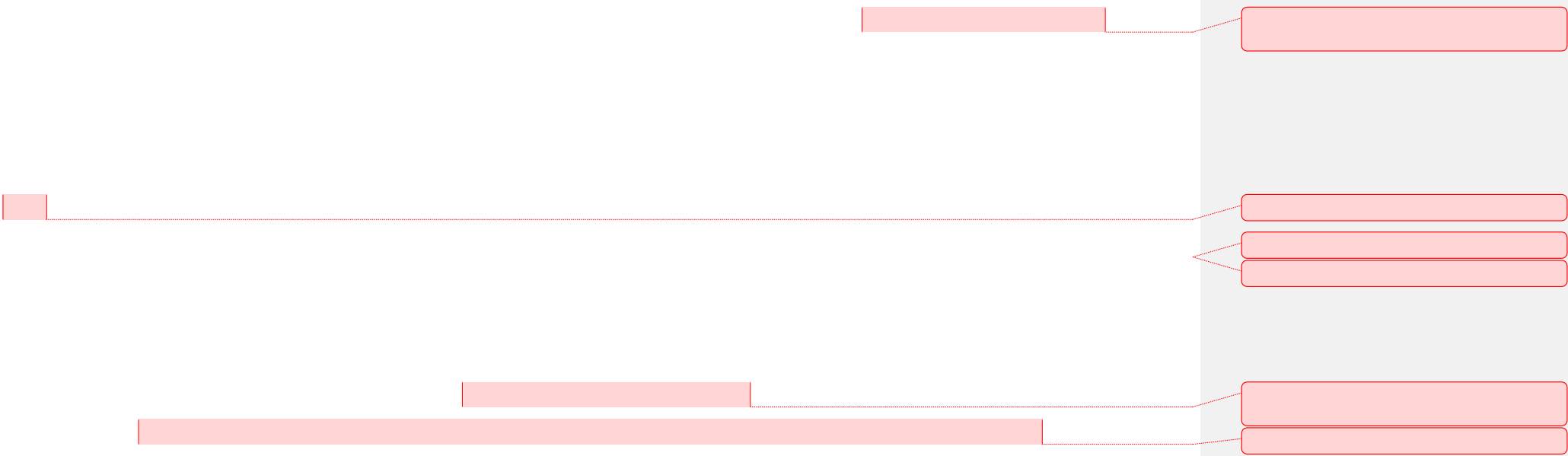
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1. Introduction

Human comfort is manifold, mostly subjective and is influenced psychologically by clothing (Song 2011). The term comfort associated with absence of unpleasantness or discomfort or a neutral state compared to the more active state of contentment. The comfort can be interpreted as an amiable state of physiological, psychological, and physical conformity between a human and its environment (Marulleau et al 2017). It banks of the activity of the wearer, the type of clothing, the climatic environment (humidity, temperature, and wind velocity) and the sensibility of each subject. The understanding of heat and moisture transfers through clothing is a major concern for scientific researchers, designers, developers and manufacturers. Worn apparel works as a barrier for heat and vapour transport between the skin and the environment. It is composed of fibers materials, air enclosed between skin and garment, and still air bounded to the outer surface of it (Havenith 2005). Different clothing properties affect the thermal comfort for various climates.

Of the all the climates, temperate climates are temperatures can change greatly here, between summer and winter. So, most places with a temperate climate have four seasons viz. summer, autumn, winter and spring. Other areas with a temperate climate can have very unpredictable weather. One day it may be sunny, the next may be rainy, and after that it may be cloudy. This is normal in summer as well as in winter (Pandey 2018). Therefore, apparel for such climates should be not so warm and not so cool at the same time. The fabrics used should be allow the air to pass and should trap it as well to provide certain amount of thermal insulation. It was understood that the heat and moisture transmission through apparel was doubtlessly the most significant factor in clothing comfort (Dhinakaran et al 2007). Data reveals that wear comfort is highly demanded characteristic in clothing (Hipler and Elsner 2006). The comfort of swaddled body in relation to warmth largely banks on the nature of the equilibrium established between the properties held by the fabric. Although mostly discussed subjectively, objective measurement of the same has been attempted in the present paper by analyzing the desired properties.

2. Objectives

The goal of this study is to analyze the influence of parameters related to comfort for blended knitted fabrics by using mulberry silk and viscose fibre, for suitability in temperate regions. Also, the research aims to bring out the fabrics with appropriate mix of properties to be used in temperate climates for apparel use.

3. Materials and methods

3.1 Test fabrics

Six types of fabrics were knitted by using blended yarns of two different yarn counts, each in three different blending proportions viz. 60% mulberry silk: 40% viscose, 50% mulberry silk: 50% viscose and 40% mulberry silk: 60% viscose. Blended knitted fabrics were utilized for present course of experimentation.

3.1.1 Fibre characteristics

Table 1 Physical parameters of mulberry silk waste and viscose fibre

Physical parameters	Mulberry silk waste	Viscose
Fibre length (cm)	130.667	139.789
Fineness (denier)	1.87 ± 0.045	3.96 ± 0.119
Fibre diameter (microns)	12.73 ± 0.226	27.46 ± 0.364

Fibres were washed in soft water and dried at room temperature for 48 hours. Mulberry silk waste fiber with linear density 1.87 denier and cut length 130.667 was blended with viscose tops exhibiting linear density 3.96 denier and cut length 139.789 mm (Table 1).

3.1.2 Development of blended yarns

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A worsted spinning system was used to blend mulberry silk waste and viscose fibre. Yarns were developed in two different counts. Mulberry silk waste was opened properly by hand and then was fed into carding machine. Further to this, the fibres were blended using gillbox. At this step, fibres were blended in three different ratios of 60: 40, 50:50 and 40:60. After this, drawing procedure was carried out. Sheikhi et al (2010) also used gill box machinery for blending of acrylic fibres with varying fineness. Since, twist per inch is a parameter that influences output behavior of yarns, it was viewed as being held constant. Variables are viewed as changing while parameters typically either don't change or change more slowly (Nykamp 2012), therefore, all the yarns were incorporated with same amount of twist (10 twists per inch). The developed yarn cones weighed 50 g each. Yarn characteristics have been depicted in table 2.

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Table 2 Physical properties of blended yarns

Yarn density	Blended ratio	Twist per inch (TPI)	Unevenness percentage
15	60% mulberry silk: 40% viscose	10	28.30
15	50% mulberry silk: 50% viscose	10	25.10
15	40% mulberry silk: 60% viscose	10	23.78
20	60% mulberry silk: 40% viscose	10	29.50
20	50% mulberry silk: 50% viscose	10	28.12
20	40% mulberry silk: 60% viscose	10	24.94

Comment [D16]: Technically its wrong for different count have same TPI, see established literature and standard procedure.

3.1.3 Construction of knitted fabrics

Developed knitted fabrics were assigned codes for ease of discussion and understanding (Table 3). Fabric knitted in 60% mulberry silk: 40% viscose yarn and 15 Nm count was called M₁, fabric made in 50% mulberry silk: 50% viscose in the same count was assigned code M₃, whereas fabric knitted in 40% mulberry silk: 60% viscose yarn in 15 Nm count was called M₅. In the similar pattern, fabric knitted in 60% mulberry silk: 40% viscose yarn and 20 Nm count was called M₂, fabric made in 50% mulberry silk: 50% viscose in the same count was assigned code M₄ and fabric knitted in 40% mulberry silk: 60% viscose yarn in 20 Nm count was called M₆.

Comment [D17]: Type of knitted fabric? Incomplete data

Table 3 Coding of developed fabric proportions

Blending proportion	Yarn count (Nm)	Code assigned
60% mulberry silk: 40% viscose	15	M ₁
50% mulberry silk: 50% viscose	15	M ₃
40% mulberry silk: 60% viscose	15	M ₅
60% mulberry silk: 40% viscose	20	M ₂
50% mulberry silk: 50% viscose	20	M ₄
40% mulberry silk: 60% viscose	20	M ₆

Comment [D18]: Mentioned knitted machine parameters and images

Table 4 elucidates structural parameters of blended knitted fabrics. Yarn densities, tightness factor and fabric thickness for blended knitted fabrics have been determined. It is apparent from the results depicted that thickness of fabric M₁, M₂, M₃ and M₅ was more than that of fabric M₄ and M₆. Also, weight of fabrics M₁, M₂ and M₃ was more than fabrics M₄, M₅ and M₆. The reason for this difference was the difference in yarn counts of yarns used for knitting the fabrics. Fabrics M₁, M₃ and M₅ were knitted by using a thicker yarn (15 Nm) as compared to M₂, M₄ and M₆ (20 Nm) thus carry more thickness and weight. Maximum

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tightness factor was calculated for fabric M₃ and M₅, however, there was no significant difference found among the values for all the fabrics.

Table 4 Physical properties of knitted fabrics made by blending different proportions of mulberry silk and viscose fibres.

Parameter	Fabric M ₁	Fabric M ₂	Fabric M ₃	Fabric M ₄	Fabric M ₅	Fabric M ₆
Yarn count (Ne)	15	20	15	20	15	20
Wales/ inch (WPI)	13	12	14	15	14	16
Courses/ inch (CPI)	19	18	19	20	20	18
Fabric thickness (mm)	0.883	0.840	0.763	0.663	0.883	0.703
Fabric weight, GSM	204.000	200.000	203.667	175.333	180.667	134.333
Stitch length (inch)	0.077	0.083	0.071	0.066	0.071	0.0625
Tightness factor	4.093	3.367	4.529	4.219	4.529	4.456

Comment [D19]: Procedure should be mentioned .

3.2 Method

3.2.1 Thermal insulation

KES-F 7 THERMO LABO II, Thermal insulation tester was used for measurement of thermal insulation in knitted fabric samples. The sample to be tested was placed over a heat plate and a constant temperature (room temperature) was maintained and heat was applied continuously to the sample surface. The amount of heat lost

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through the sample was then measured by the instrument for calculating the heat retention rate (%). There are two methods of measurement in general. One is dry method that measures direct values for the condition when contact is made between dry skin and textile material. The other one is wet method that takes values for condition when contact is made between sweaty skins. The test was therefore conducted by using dry contact method. For each specimen, the procedure was repeated three times and final calculation was made by taking mean of all the three readings.

Comment [D21]: Standard procedure should be mentioned

3.2.2 Air permeability

The air permeability values of the blended knitted fabrics were measured by using automatic air permeability tester. A circle of fabric (5cm²) was clamped into the tester and through the use of a vacuum, the 125 Pa of air pressure was made different on one side of the fabric. Airflow happened from the side with higher air pressure, through the fabric, to the side with the lower air pressure. From this rate of air flow, the air permeability of the fabric was determined. For each specimen, the procedure was repeated three times and final calculation was made by taking mean of all the three readings.

Comment [D22]: Standard should be mentioned

3.2.3 Water permeability

Water permeability was tested by using spray tester TF160 (AATCC 22). Spray tester is such an instrument which measures the water repellency of a fabric. In this test a 50 ml of water poured through a spray nozzle. The water fell on to the specimen which was mounted over a 6 inches diameter embroidery hoop and fixed at an angle of 45 degrees. When the water was used up, it was observed and grade was given to the specimen. For each specimen, the procedure was repeated three times and final calculation was made by taking mean of all the three readings.

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Fig 1 Water permeability tester

Spray rating:

Grade 1: All of the surface is wet.

Grade 2: Half of the surface is wet. It usually means the sum of small and disconnected areas of wet.

Grade3: Only small and disconnected areas of wet on the surface.

Grade4: The surface appears water drop but not wet.

Grade5: The surface is neither wet nor water drop

4. Results and Discussion

4.1 Thermal insulation

The thermal insulation characteristics of various knitted fabrics (blended in 3 different proportions) were analyzed (Table 5). It was observed that fabrics with higher content of silk fibre *viz.* fabric M₁ and M₂ showed higher values for thermal insulation (Fig 2). The outcome reveals that fabric M₁ and M₂ hold significantly higher ($p \leq 0.05$) insulating character than other fabrics. This may be understood by considering figures for fabric thickness and weight for blended knitted fabrics.

This is because of higher fabric thickness, lesser air permeability and higher tightness factor. Also, it was observed that the thermal insulation value of the knitted fabrics depends on the stitch/loop length (Ramchandran et al 2010), the knitted fabric having higher stitch length shows lower thermal insulation behavior. With higher density of fibres, thermal insulation value tends to increase (Marolleau et al 2007). In the present case also, fabrics with higher tightness factor exhibit higher thermal insulation values. In temperature region, where there is never too hot and never too cold, insulating character of fabric should be more than 1 Clo, however, higher than 2 Clo may produce unnecessary heat for the climate. Fabric M₁ and M₂ seem appropriate for usage in this case.

Table 5 Analysis of fabrics blended knitted fabrics for comfort properties

Comfort parameter	Fabric M ₁	Fabric M ₂	Fabric M ₃	Fabric M ₄	Fabric M ₅	Fabric M ₆	Critical difference
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Thermal insulation (Clo)	1.140 ^a	1.145 ^a	0.980 ^{bc}	1.028 ^b	0.972 ^b	1.034 ^b	0.095
Air permeability (CFM)	439.2 ^a	435.7 ^b	687.4 ^c	571.8 ^a	715.7 ^d	505.8 ^c	14.642
Water permeability (Grade)	3 ^a	3 ^a	3.5 ^b	2 ^d	2.5 ^c	2 ^d	0.057

^{a,b,c} Significant at 5 % level of significance, same alphabet= no significant difference, different alphabet= significant difference, CD= Critical difference, NS= Not significant

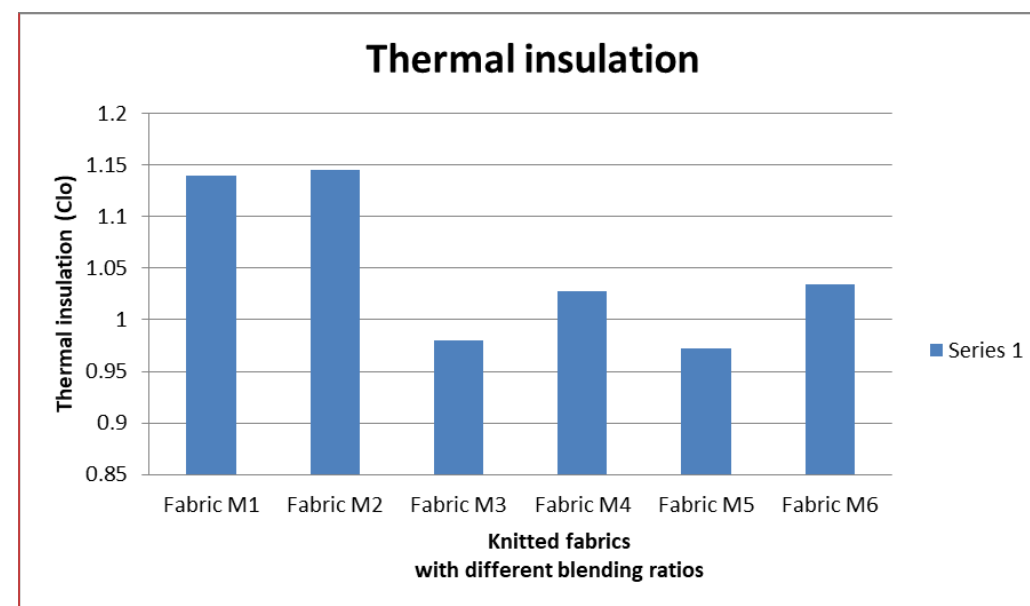


Fig2 Thermal insulation behaviour of knitted fabrics blended in three different proportions

4.1.1 Effect of Fabric thickness, Fabric weight, Stitch length and Tightness factor on Thermal insulation.

Table 5 shows statistical analysis of results at 5 % level of significance. The thermal insulation values of the knitted fabrics show significant difference (critical difference 0.095) at 95% degree of freedom. Table 6 elucidates the findings of regression analysis of thermal insulation in relation to four independent variables viz. Fabric thickness, fabric weight, stitch length and tightness factor. Regression coefficient shows positive impact of fabric thickness and fabric weight on thermal insulation, which clearly means that thermal insulation also raises with rise in the value of fabric thickness and weight, however, effect was not found to be significant in both the cases. As regards to stitch length, a negative coefficient reveals a non significant negative relationship. Tightness factor, again positively influences insulating character of the fabric. The relationship was also found to be significant in this case. Frydrych et al (2002) also concluded in their study that higher insulating properties can be achieved by right choice of fabric thickness and fabric cover factor. Other than this, type of content of the fabric greatly affects the thermal insulation character of the fabric. In the present study, fabrics M₁ and M₂ were knitted by using 60% mulberry silk: 40% viscose and therefore silk content is more than the other fabrics. Silk composition shows higher insulating properties in comparison to cellulosic fabrics.

Comment [D24]: Duplication of reported results in table 5, what information will be drawn from this graph

Comment [D25]: Explain your fixed and variable parameters and model formulation , number of trail and validation techniques

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Table 6 Effect of fabric thickness, fabric weight, stitch length and tightness factor on thermal insulation of blended knitted fabrics

Thermal Insulation	Independent parameters	Coefficient	Standard error	t-value	p value
	Constant	1.995	0.593	3.364	0.005
	X1	0.141	0.218	0.646	0.530
	X2	0.001	0.001	0.613	0.550
	X3	-5.507	5.061	-1.088	0.296
	X4	0.180	0.065	-2.754	0.016
	R ² (%)	0.724			

t-value= t statistic value, p= probability value, *Significant at 5 percent level of significance

X1= Fabric thickness

X2= Fabric weight

X3= Stitch length

X4= Tightness factor

4.2 Air permeability

Air permeability was found to be the highest for fabric M₅ followed by fabric M₃.Ogulata (2006) stated that air permeability is mainly dependent upon the fabric's weight and construction (thickness and porosity). It can be clearly seen in table 7 that fabrics with lower thickness and weight have scored higher figures for air permeability. Air permeability is a significant measure of comfort as it can influence the body in more than one way. When fabrics allow the air to pass in a momentous quantity, the human body cools itself by sweat production and evaporation during periods of high activity. Also, the thermal resistance of a fabric is strongly dependent on the enclosed still air, and this factor is in turn influenced by the fabric structure (Dhinakaran 2007). However, too much allowance to air can hinder the convenience of body in temperate regions. It will cause too much passage of air which is not suitable for a region of temperature 18°C or around (The Environment Literary council 2017).

4.2.1 Effect of Fabric thickness, Fabric weight, Stitch length and Tightness factor on air permeability

Table 7 reveals impact of various constructional parameters on air permeability of the fabric. Regression coefficient shows negative impact of fabric thickness and fabric weight on air permeability, which means that air permeability of blended knitted fabrics will decrease with rise in the value of fabric thickness and weight, however, effect was not found to be significant in both the cases. Air permeability decreases with fabric weight and have significant negative correlation (Debnath and Madhusootheran 2010). As regards to stitch length, a positive coefficient reveals a significant negative relationship. Tightness factor, again negatively influences air permeability of the fabric. The relationship was also found to be significant in this case. Herath (2013) concluded in his study that there was a correlation with fabric tightness, air permeability and fabric thickness such as knitted fabrics became tighter, their weight and thickness were higher, while their air permeability was found to be lower.

Table 7 Effect of fabric thickness, fabric weight, stitch length and tightness factor on air permeability of blended knitted fabrics

Air permeability	Independent parameters	Coefficient	Standard error	t-value	p value
	Constant	81.419	1432.088	0.57	0.956
	X1	-531.377	527.399	-1.008	0.332
	X2	-1.168	2.325	-0.502	0.624
	X3	13960.610	123.827	1.143	0.274

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Comment [D27]: Weak literature review was referenced.

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	X4	-23.234	157.650	0.147	0.885
	R ² (%)	0.339			

t-value= t statistic value, p= probability value, *Significant at 5 percent level of significance

X1= Fabric thickness

X2= Fabric weight

X3= Stitch length

X4=Tightness factor

Comment [D28]: See table 6 comments

4.3 Water permeability

Highest score was obtained by fabric M₃ (3.5), followed by similar grade of 3 by fabrics M₁ and M₂ (Table 5). Results reveal that water permeability of most fabrics was not so high. For a temperate region, fabrics with average level of permeability to water will work well Hyun-Ah Kim (2021), however, the fabrics under study, fabrics M₁, M₂ and M₃ show average levels of water permeability, while fabrics M₄, M₅ and M₆ may be called poor performers on this scale. Fabrics M₁ and M₂ however, carry lesser amount of hydrophilic fibre (viscose rayon), still exhibited higher grades of water permeability. The reason for this may understood by considering the influence of fabric thickness, fabric weight, stitch length and tightness factor on fabric performance.

4.3.1 Effect of Fabric thickness, Fabric weight, Stitch length and Tightness factor on water permeability

Table 8 reveals impact of various constructional parameters on water permeability of the fabric. Regression coefficient shows negative impact of fabric thickness water permeability, which means that water permeability of blended knitted fabrics will witness a fall with rise in the value of fabric thickness, however, the relationship was found to be non significant. Wilbik-Halgas et al (2005) concluded in their study that water vapour permeability has no correlation with thickness in knitted fabrics. Fabric weight, however, will negatively affect the amount of water entering into fabric surface. As regards to stitch length, again a negative coefficient is sign of significant negative relationship. Also, in a study by Chidambaram et al (2011), the anticipated increase in air permeability and relative water-vapour permeability with a decrease in yarn linear density and increase in loop length was observed. In the present study, if densities of yarns used for knitting were analyzed, it was observed that fabrics knitted with yarn of lower densities have exhibited higher permeability to water. Tightness factor, on the other hand, also negatively influences water permeability of the fabric. The relationship was also found to be significant in this case. Tightly constructed fabrics transmit water vapour predominantly by a diffusion-controlled mechanism similar to air permeability (Lomax 1985).

Table 8 Effect of fabric thickness, fabric weight, stitch length and tightness factor on water permeability of blended knitted fabrics

Water permeability	Independent parameters	Coefficient	Standard error	t-value	p value
	Constant	3.302	4.227	0.781	0.449
	X1	-2.646	1.557	-1.700	0.113
	X2	0.004	0.007	0.639	0.534
	X3	-9.860	36.066	-0.273	0.789
	X4	-0.131	0.465	0.281	0.783
	R ² (%)				

t-value= t statistic value, p= probability value, *Significant at 5 percent level of significance

X1= Fabric thickness

X2= Fabric weight

X3= Stitch length

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X4=Tightness factor

4.4 Relationship of Air permeability with Thermal insulation

It has been observed that quality of air permeability also has great impact on insulating power of the fabrics. Ramachandran et al (2010) mentioned that thermal conduct values increase with rise in air permeability of knitted fabrics. In other words, thermal insulation values decrease with increase in fabric air permeability. During testing, it was viewed that both the properties were seen to have inverse association.

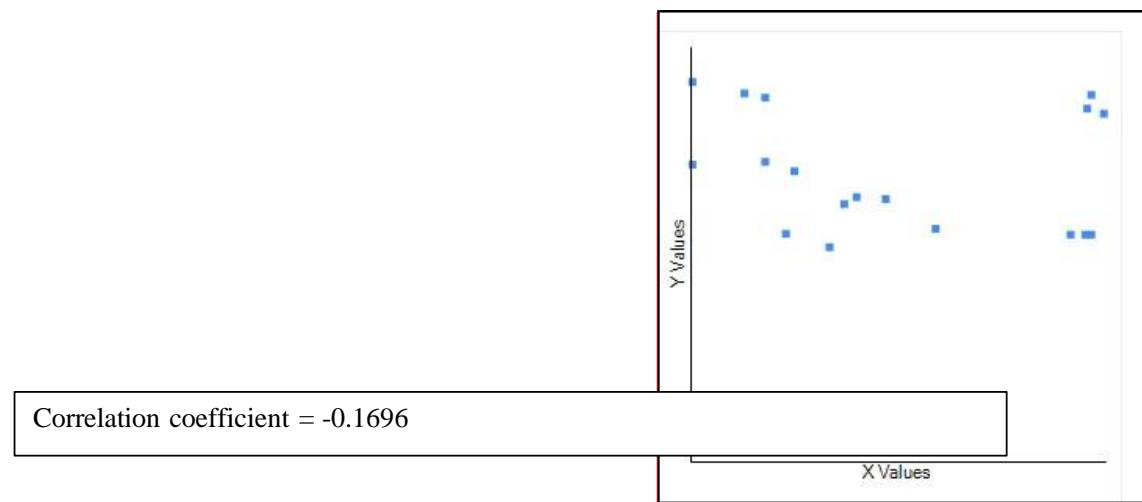


Fig 3 Correlation between Thermal insulation and Air permeability

(X values= Thermal insulation, Y values= Air permeability)

Correlation coefficient was calculated and a technically negative, but non significant, correlation between both variables was noticed. Air layers trapped within a clothing microenvironment contribute to the thermal insulation afforded by the ensemble. Any exchange of air between the external environment and these trapped air layers results in a change in the ensemble's thermal insulation (Bouskill 2002). Therefore the harmony between the two parameters can only bring about a appropriate fabric for temperate regions.

4.5 Relationship of water permeability with Thermal insulation

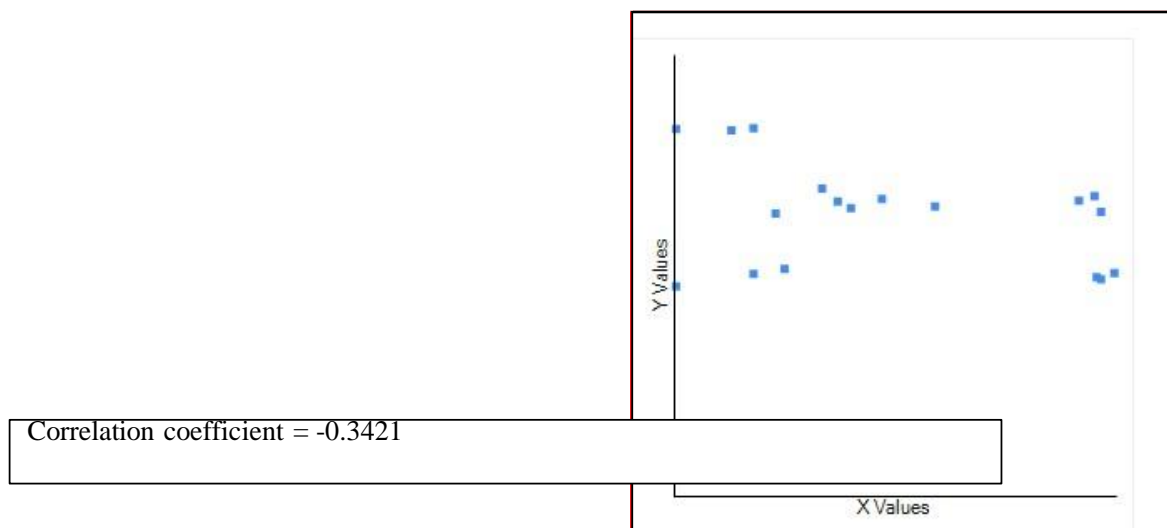


Fig 4 Correlation between Thermal insulation and Water permeability

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(X values= Thermal insulation, Y values= Water permeability)

Heat transfer through clothing is an important topic related to thermal comfort in environmental engineering and functional clothing design. The total heat transmitted through clothing is commonly considered as the sum of the dry heat transfer and the evaporative heat transfer (Chen et al 2003). Hence, permission to moisture to enter the fabric surface is an important parameter which will affect the insulating power of the material to large extent. When tested statistically for the present test samples, a negative correlation was found between the two variables; however the relationship was not significant.

5. Conclusion

Comfort is mostly a subjective expression and not been judged much in objective manner so far. It can be expressed by the experience of a person, however, objective computation of the same by considering factors and properties influencing comfort. In case of apparel, properties viz. thermal insulation, air permeability and water permeability were judged and findings were analyzed for suitability to temperate regions. Figures for thermal insulation of fabrics knitted with 60% mulberry silk: 40% viscose, in both yarn counts, 15 and 20 Nm were 1.140 and 1.145 Clo respectively which appropriately suit general climate of temperate regions. Higher silken content alongwith constructional parameters of fabric thickness, weight, stitch length and tightness factor has played vital role in giving values above 1 Clo. Air permeability on the other hand is much higher for fabrics knitted with a composition of 50% mulberry silk: 50% viscose and 40% mulberry silk: 60% viscose in yarn count 15 and 20 Nm. But too much airflow can cause feeling of uneasiness and cold in temperatures of 18°C or below. Figures for fabrics knitted with 60% mulberry silk: 40% viscose in both yarn counts 15 and 20 Nm were found to be 439.2 and 435.7 CFM, which were not too high, but will allow a good amount of air to pass through it. An average score for water permeability was also scored by both these fabrics making them suitable to be used in temperate climates for apparel use. A mix and balance of available figures assert on having evenness in warm and cool feeling. Study agrees with past reviews that constructional parameters hugely affect the performance of fabrics in terms of comfort. Changes in thickness, weight, tightness factor and stitch length has affected the final properties of blended knitted fabrics. Also, higher silk content in fabrics knitted with 60% mulberry silk: 40% viscose in both the counts was responsible for convenient insulating aspect and water permeability.

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Marolleau A , Salaun F, Dupont D, Gidik H, Ducept S. Influence of textile properties on thermal comfort. IOP Conf. Se. Mater. Sci. Eng, 254, 18,2017.

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