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ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

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ISO RECOMMENDATION

R 1532

CUTTING KNOTTED NETTING TO SHAPE ("TAPERING")

1st EDITION

June 1970

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BRIEF HISTORY

The ISO Recommendation R 1532, *Cutting knotted netting to shape ("tapering")*, was drawn up by Technical Committee ISO/TC 38, *Textiles*, the Secretariat of which is held by the British Standards Institution (BSI).

Work on this question led to the adoption of Draft ISO Recommendation No. 1532, which was circulated to all the ISO Member Bodies for enquiry in February 1969. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Iran	South Africa, Rep. of
Belgium	Israel	Spain
Brazil	Italy	Sweden
Czechoslovakia	Japan	Switzerland
Denmark	Netherlands	Turkey
France	Norway	U.A.R.
Germany	Peru	United Kingdom
Greece	Poland	U.S.S.R.
Hungary	Portugal	
India	Romania	

No Member Body opposed the approval of the Draft.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as an ISO RECOMMENDATION.

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ISO Recommendation R 1532 June 1970

CUTTING KNOTTED NETTING TO SHAPE ("TAPERING")

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1. SCOPE

This ISO Recommendation defines the different kinds of cutting knotted netting to shape by straight cut, the types of cutting (N-, T- and Bar-cut) and the rules for the designation of the cutting rate.

2. TERMINOLOGY

The expression *cutting knotted netting to shape* is here understood to mean the cutting from knotted netting of pieces in the shape of trapezia, triangles, parallelograms or other polygons.

3. TYPES OF CUTTING

Depending on the desired final shape of the netting, tapering cuts must be made in suitable ways. The various cutting rates are obtained by combining different lengths of cuts, either along a row of sequential knots (N- or T-cuts* respectively) or parallel to a line of sequential mesh bars (B-cuts).

The cuts along a row of sequential knots are distinguished by their situation in the drawing of the net or in the netting that has been hung up for tapering as described in clauses 3.1.1 and 3.1.2 below.

3.1 **K-cuts** (knot cuts) Cuts just beyond the knots.

Symbol K

NOTE. – The term "K-cut" may be used instead of the two following terms in cases where the relation to the general course of the netting yarn is insignificant.

* For the definition of the symbols N and T relating to directions in netting see ISO Recommendation R 1107, *Netting for fishing – Basic terms and definitions.*

3.1.1 *N-cut* (vertical cut)

Symbol N

A cut at right angles to the general course of the netting yarn just beyond the knots.

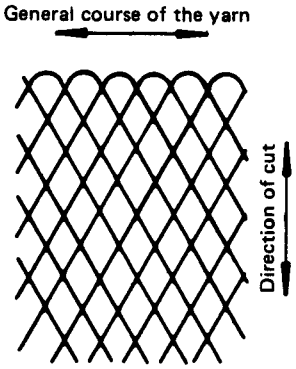

FIG. 1

3.1.2 *T-cut* (horizontal cut)

Symbol T

A cut parallel to the general course of the netting yarn just beyond the knots.

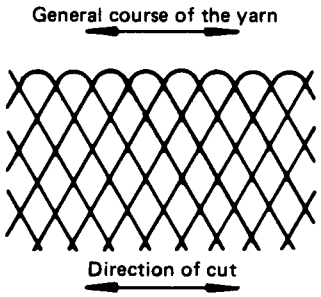

FIG. 2

3.2 **Bar-cut**

Symbol B

A cut parallel to a line of sequential mesh bars, each from adjacent meshes, and severing one or more bars.

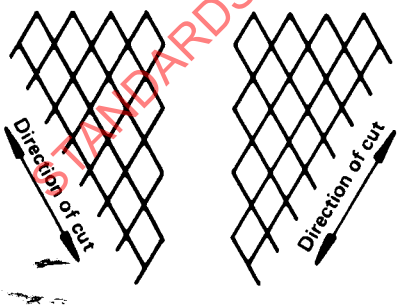

FIG. 3

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4. CUTTING RATE

4.1 Definition of cutting rate

To obtain a desired shape and area of netting by tapering, N- or T-cuts and B-cuts of a distinct length must follow each other in a rhythmical way. This rhythmical alternation of the various types of cuts is called "cutting rate".

4.2 Designation of the cutting rate

The cutting rate is determined by the lengths of consecutive sections of N- or T-cuts and B-cuts.

The lengths of the various cuts are indicated

- for the N- and T-cuts by the number of consecutive meshes cut;
- for the B-cut by the number of consecutive bars severed along the cutting edge, not counting the bars on the preceding knot.

To describe the cutting rate for tapering netting, the number and the type of each cut are indicated, giving first N- or T-cuts, then B-cuts.

The following combinations are used for cutting netting to shape :

N- and B-cuts

T- and B-cuts

N- and T-cuts

Exceptions are cutting rates where any of the named types of cutting is used alone. For these the following symbols are valid :

AB = all bars cut

AN = all cuts entirely in N-direction
(at right angles to the general course of the netting yarn)

AT = all cuts entirely in T-direction
(parallel to the general course of the netting yarn)

4.3 Examples of the designation of the cutting rate

4.3.1 *Example* : 1N2B means the rhythmical alternation of one N-cut and two B-cuts.

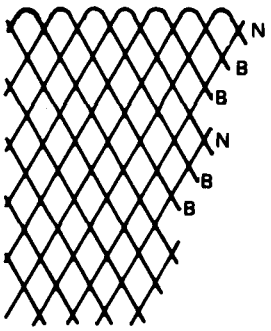

FIG. 4

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4.3.2 *Example* : 1T2B means the rhythmical alternation of one T-cut and two B-cuts.

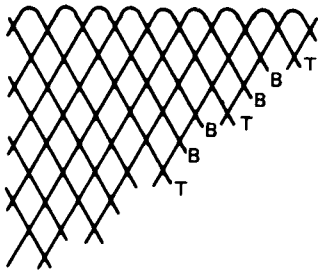

FIG. 5

4.3.3 *Example* : 1N2T means the rhythmical alternation of one N-cut and two T-cuts.

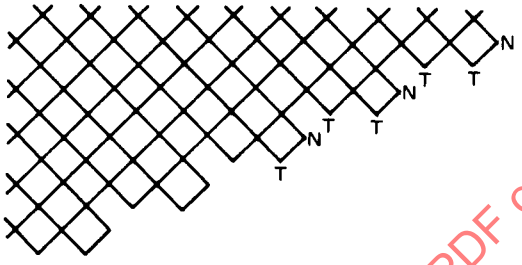

FIG. 6

NOTE. – Further examples of cutting rates are given on pages 10 and 11.

5. VARIOUS KINDS OF CUTTING (TAPERING)

5.1 By tapering only one edge of the netting, right-angled trapezia or right-angled triangles are made.

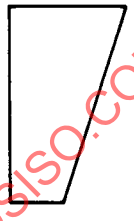

FIG. 7

FIG. 8

5.2 By using the same cutting rate in the same direction on two opposite edges of the netting, parallelograms are made.

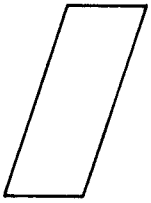

FIG. 9

FIG. 10

In the case of netting in the shape of a parallelogram, the triangular piece cut off on one side may be joined to the other edge (see Fig. 10).

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5.3 Netting in the shape of isosceles trapezia or isosceles triangles

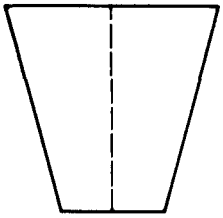

FIG. 11

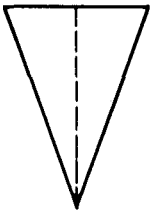

FIG. 12

The area of such netting may be divided into two right-angled trapezia or triangles respectively, each of these parts being tapered correspondingly in opposite directions.

For triangular shaped netting (see Fig. 12) each of the two halves must be tapered to a point.

5.4 Netting in the shape of asymmetrical trapezia

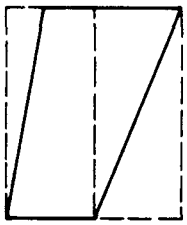

FIG. 13

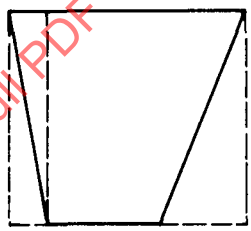

FIG. 14

The area of such netting may be divided into one right-angled trapezium and one right-angled triangle respectively, each of these parts being tapered correspondingly.

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