

# ACETex® GT Polyester (PET) Woven Geotextile

## High Strength Woven Geotextile

Ability to develop high strengths at relatively low strains



### Product Information

ACETex® woven geotextiles are manufactured from the extrusion of a polymer (polypropylene or polyester) into either a flat tape or filament product which may be then further processed by slitting or bundling and then weaving to form a fabric.

ACETex® woven geotextiles are ideally suited for applications of reinforcement or separation as the strength of the tape or filament within the fabric may be increased to suit a specific application. ACETex® GT Polyester (PET) woven geotextiles additionally have the ability to develop high strengths at relatively low strains which is a very important requirement in applications of reinforcement. Fabric strength is manufactured in two directions and may be varied to suit a particular reinforcement application. In applications of reinforcement and where a load may need to be sustained by the geotextile for significant periods of time the choice of polymer used in the construction of the fabric will determine the choice of woven product.

### Applications

Soil Reinforcement in applications of:

- Embankment support over soft soils
- Embankment support over soft soils with wick drain treatment
- Embankment support over piles
- Support over voids
- Load Transfer Platforms

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## Benefits

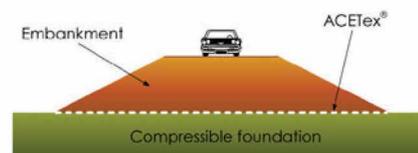
ACETex® GT is an engineered woven geotextile that has exceptionally high tensile strength characteristics at low levels of strain. These products may be constructed with strengths up to 1600kN/m. Strains generated at characteristic tensile strength are typically less than 10%. Being composed of high tenacity polyester fibres there are low creep strains when subject to high tensile loads. Creep strains of less than 1% at design loads of 40%+ of the initial tensile strength at 120 year design life are obtained.

ACETex® GT woven geotextile has a demonstrated history of performance both here in Australia and around the world. ACETex® has the ability to carry significant loads imposed upon the product from large embankment structures, reduce pile group size and spacing and provide innovative solutions for engineered, load carrying platforms in very low strength foundation areas.

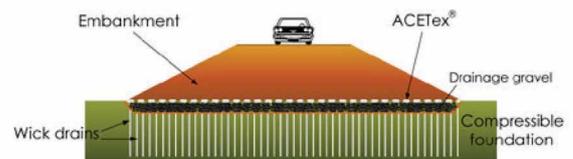
ACETex® GT woven geotextile is suitable for use in short term as well as very long term ground support applications with design lives in excess of 120 years. The product may be manufactured for site specific requirements. The rolls are available in wide widths up to 5.2m to minimise wastage from overlap requirements

## Features

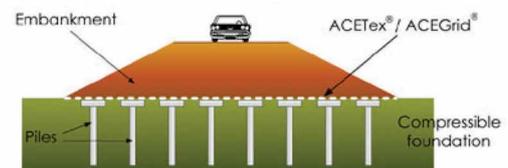
- High strength up to 1600kN/m
- High strengths at relatively low strains
- Testing-approved short term and long term behavior
- Proven for use in road works, retaining structures and platforms
- Stocked in Australian warehouses
- Wide-width rolls
- Long proven history of use in Australasia



A. Construct embankment and wait for settlement



B. Use wick drains to accelerate settlement



C. Use foundation treatment (piling) to prevent settlement



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## The Challenge

Road and geotechnical design engineers are facing an increasing challenge throughout Australia of building roads, mining platforms and other infrastructure works on very problematic soils. Previous treatments might have involved very expensive excavation and replacement techniques, surcharging the site and waiting extended periods of time for increases in strength through pore water dissipation and consolidation or abandonment of the site option through cost. ACETex® provides engineers with a cost effective, proven alternative.

## Meeting the Challenge

### Quality

Ace Geosynthetics have a commitment to using the latest technology in weaving processes that delivers highest strengths possible, at low soil compatible strains. Quality control within the manufacturing process ensures consistency of manufacture at all times. Ace Geosynthetics hold a number of internationally recognised accreditation approvals for their manufacturing processes.

### Materials

Ace Geosynthetics use the best available polymers and the highest tenacity yarn to make the ACETex® product. Of importance is the choice of polymer used to make the ACETex® structural geotextile. Polyester polymer, in such applications of structural reinforcement, is the most resistant to loss of strength through creep effects over very long periods of time. The use of low carboxyl end group, high molecular weight, base polymer, has been proven to withstand the effects of hydrolysis and subsequent loss of strength in alkaline environments. Polyester polymer is the least susceptible to long term temperature effects.

### Testing

Ace Geosynthetics have a commitment to fully understand the short term and long term behaviour of their product. Significant internal and external testing has been carried out at some of the world's most well recognised research and test facilities to independently verify product performance when subjected to physical damage, chemical resistance, load and temperature effects. Both real time and accelerated test methods have been performed to ensure that the ACETex® product performance is understood over design lives in excess of 120 years.

### History

ACETex® structural geotextile has been used for years on many Australian soil reinforcement projects with outstanding success. ACETex® geotextile is stocked locally in Australia with efficient lead times to suit construction requirements. ACETex® can be custom manufactured to suit specific project demands such as roll width or length. ACETex® product is supported in Australia, new Zealand and the south pacific by Global synthetics engineers. ACETex® has been approved for use under the strict specification requirements of NSW RMS and QLD department of Transport.



# ACETex® GT Polyester (PET) Woven Geotextile

## 1. General

The ACETex® GT woven, high strength reinforcement geotextile range, are engineered products for applications of short term and long term soil reinforcement. The product is woven with strength in both the roll length direction (commonly called the machine direction- MD) and with strength manufactured in the cross roll direction (commonly called the cross machine direction-CD). Generally the strength of the product will be dominant in one direction of the roll (normally the MD) with sufficient strength in the other direction of the fabric (normally CD) such that the fibres are dimensionally stable and the roll may be easily deployed. In applications of soil reinforcement the use of engineered geotextiles allows significant tensile strength to be imparted to soils. soils are very weak in tension. The ACETex® GT geotextile effectively “bridges” potential failure planes behind or below structures that normally would require significant additional cost to construct. The use of soil reinforcement techniques has proven to be a very cost effective method of construction. ACETex® GT woven geotextiles are manufactured from high tenacity polyester (PET) fibres with high molecular weights and low carboxyl end groups such that the product is suitable for use in normally occurring soil environments, for design lives in excess of 120 years.

ACETex® GT uniaxial woven geotextile is available in a range of tensile strengths from 100kN/m to 1,600kN/m.

## 1. Load Assessment of ACETex®

The use of ACETex® GT woven geotextiles, in long term soil reinforcement applications, requires an assessment of the long term load carrying capabilities of the product. The procedure adopted for ACETex® GT woven geotextiles follows a partial factor approach that accounts for influences of time, temperature, environment and load. The assessment procedures for ACETex® GT woven geotextiles are compatible with US Federal Highway of Administration (FHWA), British Code of Practice BS8006 ISO/TR 20432 and Australian Standard AS 4678. Australian Standards Handbook HB154-Geosynthetics-Guidelines on Durability may be read in conjunction with this data sheet.

The following procedure is an accepted method for determining the long term design strength of the reinforcement at differing design lives.

$$T_d = \frac{T_c}{f_c \cdot f_d \cdot f_e \cdot f_{m1} \cdot f_{m2}}$$

where,

$T_d$  is the long term design strength of the reinforcement at the required design life.

$T_c$  is the characteristic short term tensile strength of the reinforcement.

$f_c$  is the partial factor relating to creep effects over the required design life of the reinforcement.

$f_d$  is the partial factor relating to damage effects on the reinforcement.

$f_e$  is the partial factor relating to environmental effects on the reinforcement.

$f_{m1}$  is the partial factor relating to consistency of manufacture of the reinforcement.

$f_{m2}$  is the partial factor relating to extrapolation of test data.

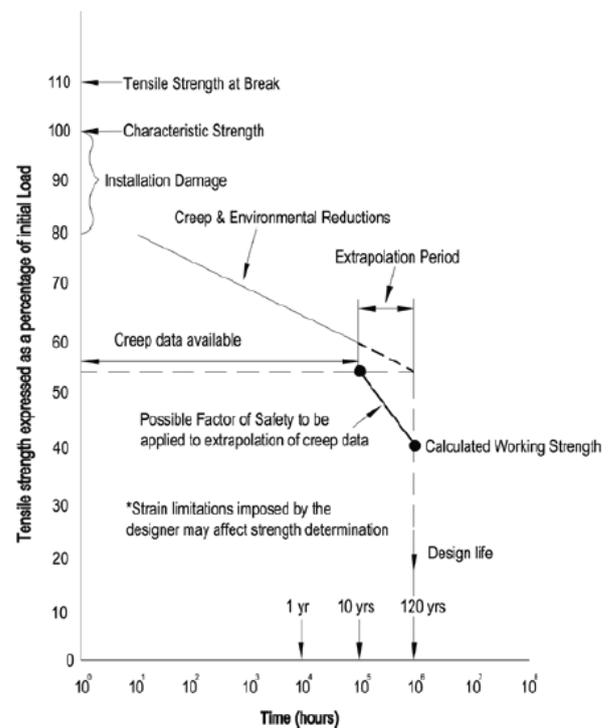


Fig. 1 Partial Factor Reductions to be Considered in Long Term Strength Derivation

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## 3. Partial Factor Relating to Creep, $f_c$

In any assessment of the partial factor for creep,  $f_c$ , the creep rupture characteristics of the reinforcement must be known. Significant independent testing has been carried out using both conventional creep rupture testing under long term loading conditions as well as accelerated test methods. From Fig.2 the values of  $f_c$  can be obtained for different design lives. For example, at 60 years design life the ACETex® GT shows a 72% strength retention which equates to a partial factor of  $f_c = 1.38$ . ACETex® GT woven geotextiles, being composed of high tenacity polyester fibres exhibit very low creep strains even at high tensile load levels. Creep strains of less than 1% over a 120 year design life at a design load of 40% of initial tensile strength are obtained. The treatment of long term total and creep strains is referenced in section 8 of this document. The reader is encouraged to carefully consider strain requirements and the effects on the allowable design strength of the geotextile

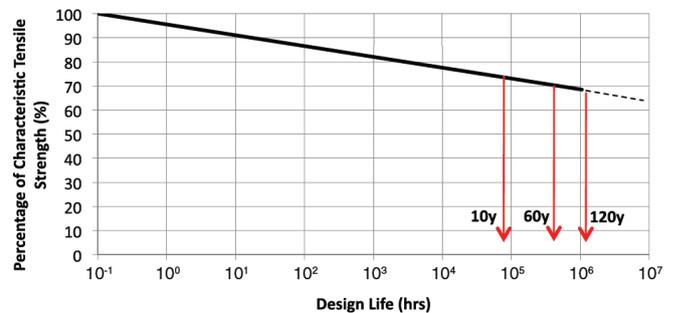


Fig. 2 Creep Rupture Curve for ACETex® GT Woven Geotextile

## 4. Partial Factor Relating to Installation Damage, $f_d$

The magnitude of damage,  $f_d$ , imposed upon the ACETex® GT woven geotextile is a function of the structure of the reinforcement, the aggressiveness of the fill placed either side of the reinforcement, the method of placement of the fill and the level of compaction performed. The damage factors used for ACETex® GT woven geotextiles are derived from independent field and large scale laboratory tests. Values of  $f_d$  for ACETex® GT woven geotextiles placed in one soil environment are listed on this data sheet. Additional values for damage for more extreme soil environments may be obtained from Global Synthetics.

## 5. Partial Factor Relating to Environmental Effects, $f_e$

The magnitude of the partial factor,  $f_e$ , is a function of the polymers used as well as the structure of the reinforcement. ACETex® GT woven geotextiles are manufactured from virgin, high tenacity polyester fibres. Polyester fibres have over many years demonstrated high resistance to strength loss when buried in soil environments for long periods of time. The ACETex® GT woven geotextiles are made of high molecular weight, low carboxyl end group fibres that are very stable in a range of pH environments. A range of partial factors,  $f_e$ , are given in the data sheet for a range of design lives in various environments.

## 6. Partial Factor Relating to Consistency of Manufacture, $f_{m11}$

ACETex® GT woven geotextiles are manufactured according to independently audited Quality Control and Assurance standards to meet a confidence level of 95% of the published tensile strengths. The partial factor adopted for ACETex® GT woven geotextiles for consistency of manufacture,  $f_{m11}$ , has a value of 1.0 for design lives up to 120 years.

## 7. Partial Factor Relating to Extrapolation of Creep Data, $f_{m12}$

ACETex® GT woven geotextiles have been extensively tested both in real time creep testing and using time, temperature, shifting curves to account for long period of time. Both methods are carried out using ASTM and ISO test protocols. The examination of creep data and the suitability of use to extrapolate such data is referenced to BS8006 and ISO/TR 20432. The partial factor based on the validity of the statistical envelope between real time testing and time temperature shifting methods (SIM) allows  $f_{m12}$  to be assigned a value of 1.0 for design lives up to 120 years.

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## 8. Tensile Strength Strain Properties

### Short Term Tensile Strength and Strain with Time = 0 hours

The short term tensile strength relationship to strain of ACETex® GT Geotextile is shown as a master curve in Fig.3. The graph shows, as the “y” ordinate, the strength of the ACETex® GT Geotextile as a percentage of the characteristic tensile strength. Thus one master curve may be used to represent all ACETex® GT grades available by converting the percentage values into actual strength values for individual grades. It is important to note that a relationship exists between strength, strain and time for all geosynthetic soil reinforcement. Isochronous stress curves (refer to Fig.4) must be used to calculate the long term design strength that will limit design strain for a given design life. Some manufacturers do not provide such information on data sheets which may lead to an over estimation of achievable geotextile strength for a long term design strain requirement.

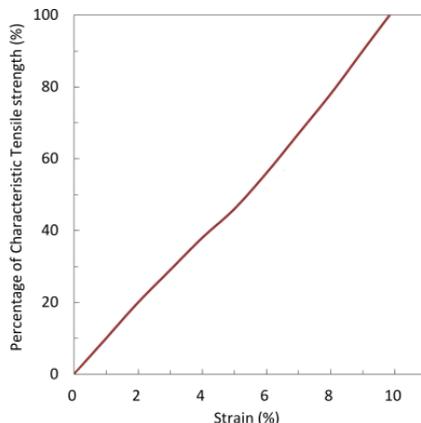


Fig. 3 Short Term Tensile Strength-Strain Relationship for ACETex® GT Woven Geotextile

### Long Term Tensile Strength and Strain with Time = 120 years

The long term tensile strength relationship to strain with the influence of time dependency for ACETex® GT Geotextile is shown as a master curve in Fig.4. The graph shows, as the “y” ordinate, the strength of the ACETex® GT Geotextile as a percentage of the characteristic tensile strength. The “x” axis is the strain component. Superimposed upon the curves is the time relationship. A number of long term design lives have been plotted that allow the designer to limit the load within the geotextile such that a design strain limit is not exceeded for the structure to be constructed. Thus one master curve may be used to represent all ACETex® GT grades by converting the percentage values into actual strength values for individual grades. Shown in Fig.5 are the components of strain that are necessary to understand when specifying any structural soil reinforcement geosynthetic. If we assume the construction phase duration as approximately 1 month, then under these circumstances, to limit the post construction strain to 1%, for a design life of 120 years, we consider the isochronous creep curve of the material at t=1 month and t=120 years. A maximum load level of 60% of the characteristic short term tensile strength, will satisfy this criteria.

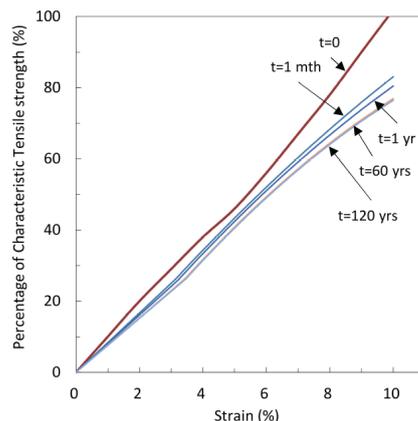
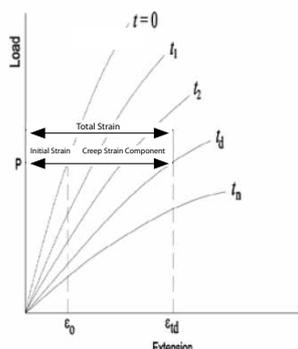


Fig. 4 Long Term Tensile Strength-Strain-Time Relationship for ACETex® PET Geotextile Isochronous Curves



Method of determining the initial extension  $\epsilon_0$ . The total extension  $\epsilon_{td}$  over time period  $t_d$

“Fig. 5 Method of Determining the Various Components of Strain.

# ACETex® GT Polyester (PET) Woven Geotextile

## Product Data Sheet

## Product Grade

Mechanical Properties	Strength Direction	Units	GT 100/50	GT 200/50	GT 300/50	GT 400/50	GT 500/50	GT 600/50	GT 800/50	GT 1000/50	GT 1200/50		
<b>Characteristic short term strength</b>	MD	kN/m	100	200	300	400	500	600	800	1000	1200		
<b>ISO 10319</b>	CD	kN/m	50	50	50	50	50	50	50	50	100		
<b>Strain at short term strength</b>	MD	%	10	10	10	10	10	10	10	10	11		
<b>Partial factor - creep rupture - <math>f_c</math></b>													
at 5 years design life			1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33		
at 10 years design life			1.34	1.34	1.34	1.34	1.34	1.34	1.34	1.34	1.34		
at 60 years design life			1.38	1.38	1.38	1.38	1.38	1.38	1.38	1.38	1.38		
at 120 years design life			1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40		
<b>Creep limited strength</b>													
at 5 years design life			MD	kN/m	75	150	226	301	376	451	602	752	902
at 10 years design life			MD	kN/m	74	149	224	299	373	448	597	746	896
at 60 years design life			MD	kN/m	72	145	217	290	362	435	580	725	870
at 120 years design life			MD	kN/m	71	143	214	286	357	429	571	714	857
<b>Partial factor - construction damage - <math>f_d</math></b>													
in clay, silt or sand			1.1	1.1	1.1	1.05	1.05	1.05	1.05	1.05	1.05		
<b>Partial factor - environmental effects in soil environment 2 &lt; soil pH &lt; 10 - <math>f_e</math></b>													
not exceeding 10 years design life			1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0		
at 60 years design life			1.03	1.03	1.03	1.03	1.03	1.03	1.03	1.03	1.03		
at 120 years design life			1.05	1.05	1.05	1.05	1.05	1.05	1.05	1.05	1.05		
<b>Long term design strengths - <math>t_d</math></b>													
in clay, silt or sand													
at 5 years design life			MD	kN/m	68	137	205	286	358	430	573	716	859
at 10 years design life			MD	kN/m	67	136	204	284	355	426	569	711	853
at 60 years design life			MD	kN/m	64	128	192	268	335	402	536	670	804
at 120 years design life			MD	kN/m	62	124	186	259	324	389	518	648	777
Nominal roll width			m	5	5	5	5	5	5	5	5	5	
Nominal roll length			m	100	100	100	100	100	100	100	50	50	

### Notes

- For strength direction, MD refers to machine direction and CD refers to cross machine direction
- Long term design strength is determined by compounding the reduction factors for creep, installation, and environmental effects.
- ACETex is made from polyester yarn with high molecular weight,  $M_n > 30,000$  and a Carboxyl End Group, CEG of  $< 14$  mmol/kg
- ACETex is resistant to all naturally occurring soil acids and alkalines, pH 2 - 10
- Values quoted are statistically 95% confident and are described as the characteristic value

# About Us

## Leaders in Geosynthetics

Global Synthetics is a 100% Australian-owned company, proud to offer a complete range of high-quality geosynthetic products backed by over 200 years of combined staff experience in the industry.

We have supplied products to some of the largest recent infrastructure works in Australia. Global Synthetics provides major benefits to any geotechnical engineering project with the right products and our technical expertise.

Global Synthetics products are used in the following applications:

- Pavement Stabilisation
- Ground Improvement
- Soil Reinforcement and Retaining Structures
- Water Management
- Drainage Systems & Hydraulic Works
- Landfills
- Coastal Erosion Structures

## Get in Touch

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