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THE PEOPLE'S REPUBLIC OF CHINA

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FZ/T 01085-2018

Replacing FZ/T 01085-2009

Testing method for peeling strength of fusible interlinings

粘合衬剥离强力试验方法

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Testing method for peeling strength of fusible interlinings

1 Scope

This Standard specifies the test method for the peel strength of fusible interlinings after bonding with standard fabrics.

This Standard applies to fusible interlinings with woven fabrics, knitted fabrics and non-woven fabrics of various materials as base fabrics, and other fusible interlinings can use this as a reference.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 6529 Textiles - Standard atmospheres for conditioning and testing

GB/T 8170 Rules of rounding off for numerical values & expression and judgement of limiting values

FZ/T 01076 Marking method of composite specimen of fusible interlinings for garments

FZ/T 01083 Determination of surface appearance and dimensional change on dry cleaning for fusible interlinings

FZ/T 01084-2009 Testing method for surface appearance and dimensional change after washing for fusible interlinings

3 Terms and definitions

For the purpose of this document, the following terms and definitions apply.

3.1

peeling strength

The force required to peel the fusible interlining from the standard fabric.

3.2

peeling length

6 Specimen preparation

6.1 According to the provisions of FZ/T 01076, cut 10 pieces of fusible interlining specimens along the warp (longitudinal) direction, with a size of 200 mm × 70 mm or 200 mm × 45 mm.

6.2 According to the provisions of FZ/T 01076, cut 10 pieces of standard fabric along the warp (longitudinal) direction, the size of which is slightly larger than the size of the fusible interlining specimen.

6.3 Composite specimen: according to the provisions of FZ/T 01076, place thin cotton paper (see 5.6) between the standard fabric and the adhesive interlining specimen.

a) When using a continuous press to press the specimen, place the standard fabric on the preparation table and cover it with the fusible interlining specimen (coated side facing down). The specimen and the standard fabric shall be consistent in the warp and weft (longitudinal and horizontal) direction.

b) When using a flat press to press the specimen, place the fusible interlining specimen at the bottom, with the coated side facing up, and the standard fabric on top. The standard fabric and the fusible interlining specimen shall be consistent in the warp and weft (longitudinal and horizontal) direction.

6.4 After the composite specimen is pressed according to the pressing conditions specified in FZ/T 01076, it is carefully removed after a slight cooling, and the composite specimen is placed in the standard atmosphere specified in GB/T 6529 to balance for 4 h (special products are balanced for 24 h).

7 Operation procedures

7.1 Test preparation

7.1.1 Peel off a 50 mm ± 5 mm slit at the A end of the specimen length in advance, and keep the peeling points on the same straight line.

7.1.2 Set the constant rate elongation tester to a gauge of 50 mm and a pulling speed of 100 mm/min.

7.1.3 Preliminary test: select the appropriate strength range through a small number of preliminary tests. For products with existing empirical data, the prediction procedure can be omitted.

7.2 Peeling strength test before washing

7.2.1 Clamp the standard fabric end and the fusible interlining specimen end of the peeled specimen in two clamps respectively, so that the peeling line is located at half of

the two clamps, and the length direction of the specimen is perpendicular to the clamps. Turn on the constant rate elongation tester, start collecting data after 5 s, and record each peak value within the 100 mm peeling length.

7.2.2 The clamp returns to the starting position, removes the specimen and repeats the test of another group of specimens according to 7.1.1 ~ 7.1.3. Test 5 groups of specimens in total and calculate the average value of the 5 test results.

7.3 Peeling strength test after washing

7.3.1 Wash and dry the remaining 5 composite specimens without slits according to the provisions of FZ/T 01083 or FZ/T 01084-2009, and place the composite specimens in the standard atmosphere specified in GB/T 6529 to balance for 4 h (special products are balanced for 24 h).

7.3.2 Perform peeling strength test according to the procedures of 7.2.1 and 7.2.2 of this Standard. Test 5 groups of specimens in total and calculate the average value of the 5 peeling strength test results after dry cleaning or washing.

7.4 Test processing

7.4.1 During the peeling strength test, if the test results change significantly due to reasons such as the specimen slipping out of the clamp or the specimen breaking irregularly on the extension line of the peeling port, the test data shall be eliminated, and the specimen shall be re-cut on the original sample for test.

7.4.2 If the fusible interlining breaks during the test, it shall be recorded as “fusible interlining tearing”. If the tearing phenomenon occurs in one specimen, the test result shall be eliminated; if two or more specimens are torn, the peeling strength of the specimen shall be recorded as “fusible interlining tearing”.

8 Result calculation

8.1 The record of each specimen during the peeling test is shown in Figure 1. The average peeling strength within 100 mm peeling length is measured, or at least the average value of 5 maximum peak values and 5 minimum peak values is taken.

8.2 The average peeling strength of each test is calculated according to formula (1) or formula (2). Finally, the average of the five average peeling strengths is taken as the peeling strength of the specimen according to formula (3). The calculation result is rounded to one decimal place according to GB/T 8170.

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