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THE PEOPLE'S REPUBLIC OF CHINA

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FZ/T 24019-2012

Printing cashmere knitting goods

印花羊绒针织品

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Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard was proposed by China National Textile and Apparel Council.

This Standard shall be under the jurisdiction of the National Standardization Technical Committee on Textile Cashmere Products Subcommittee (SAC/TC 209/SC9).

The main drafting organizations of this Standard: Inner Mongolia Erdos Group Co., Ltd. and National Cashmere Products Engineering Technology Research Centre.

The main drafters of this Standard: Yang Guifen, Wang You, Tian Jun, Zhang Yun, An Heli and Qu Xiulan.

Printing cashmere knitting goods

1 Scope

This Standard specifies the technical requirements, test methods, inspection rules, use instructions, packaging, transportation and storage of printing cashmere knitting goods.

This Standard applies to combing, carding and semi-worsted pure cashmere knitting products after printing and cashmere blended knitting goods containing more than 30% of cashmere.

2 Normative references

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

GB/T 250, Leather – Tests for colour fastness – Gray scale for assessing change in colour

GB/T 1335 (all parts), Standard sizing systems for garments

GB/T 2828.1-2003,

GB/T 4841.3, Sampling procedures for inspection by attributes – Part1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB 5296.4, Instructions for use of products of consumer interest – Part 4: Textiles and apparel

GB 18401, National general safety technical code for textile products

FZ/T 73009, Cashmere knitting goods

3 Technical requirements

3.1 Safety requirements

General safety specifications of printing cashmere knitting goods are specified in GB 18401.

3.2 Classification provision

				at major positions	
	Flushing	Not allowed	Inconspicuous	Conspicuous	
	Entire fabric pattern dislocation	Dislocation not more than ± 0.05 cm	Dislocation not more than ± 1.0 cm	Conspicuous	
	Pattern deformation	Not allowed	Inconspicuous	Conspicuous	
	Cross colour	Not allowed	Not allowed	inconspicuous	
	Spot	Not allowed	Not allowed	Inconspicuous at major positions	
Sewing defects	Poor sewing	Not allowed	Not allowed	Allowed at minor positions	
	Poor button hole sewing	Not allowed	Inconspicuous	Conspicuous	
	Burl mark	Not allowed	Inconspicuous	Conspicuous	
NOTE 1 Descriptions of appearance defects and appearance defects degrees are specified in Annex A.					
NOTE 2 Minor positions refer to positions where a defect is located and which have small effects, e.g. the 1/6 place on the left and right of upper garment side seam and sleeve bottom seam, 1/5 of outside length of trousers under the waist and 1/6 of the left and right of inside trouser seam.					
NOTE 3 Refer to similar ratings of defects for the appearance defects not listed in the table.					

4 Test method

4.1 Test method for inner quality test is specified in FZ/T 73009. The preset number of rotations for piling test of semi-worsted products shall be 7 200 r. If sample photographs are used for rating, the sample photographs of carded knitting goods can be compared. The test area for bursting strength is 7.3 cm² (diameter 30.5 mm).

4.2 All requirements for appearance quality test are specified in FZ/T 73009.

5 Inspection rules

5.1 Sampling

5.1.1 A test batch is composed of the same style, the same printed pattern and the same delivery unit.

5.1.2 Samples for inner quality and appearance quality shall be taken randomly from a test batch.

Annex A

(Normative)

Descriptions of appearance defects and degrees

A.1 Descriptions of appearance defects

A.1.1 Descriptions of yarn, weaving and sewing defects

Descriptions of yarn, weaving and sewing defects are specified in FZ/T 73009.

A.1.2 Descriptions of printing defects

A.1.2.1 Printing off register (stagger or exposed base): on printed fabrics of two or more colours, one or more colours of all or part of patterns comes away or coincides.

A.1.2.2 Pattern asymmetry: the positions of symmetrical patterns deviates from a centre line or some side line.

A.1.2.3 Excessive pattern: pattern or colour printed which should not be printed.

A.1.2.4 Uneven printing of repeats: irregular colour of fabrics caused by uneven strength applied or uneven plate during printing.

A.1.2.5 Colour smear: pigment paste sticks to or piles up on fabrics.

A.1.2.6 Flushing: outlines of patterns on fabrics are not clear; surroundings of patterns are rough; colours seeps into each other; patters are blurry or become larger, not conforming to original patterns.

A.1.2.7 Entire fabric pattern dislocation: during all over printing, pattern edges and rib edges are not jointed accurately; or patterns are printed at a specified location.

A.1.2.8 Pattern deformation: fabrics are not spread out during printing or garment blanks are not ironed along the grains before or after printing, so deformation of pattern is generated.

A.1.2.9 Cross colour: printing colour stains bottom colour or different colours stain each other.

A.1.2.10 Spot: yellow spots of different areas appear on the unprinted part, as well as other blotted areas, e.g. colour spots, rusty spots, water spots and greasy spots.

A.2 Descriptions of degrees of appearance defects

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