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TEXTILE INDUSTRY STANDARD OF
THE PEOPLE'S REPUBLIC OF CHINA

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FZ/T 43015-2021

Replacing FZ/T 43015-2011

Knitted silk garments

桑蚕丝针织服装

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Knitted silk garments

1 Scope

This Standard specifies the specifications, requirements, test methods, inspection rules, marking, packaging, transportation and storage of knitted silk garments.

This Standard applies to knitted garments, which are made of pure mulberry silk, and interwoven or blended mulberry silk with other fibers (with a mulberry silk content of 30% and above).

This Standard does not apply to knitted silk noil garments.

2 Normative references

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

GB/T 250, Textiles - Tests for colour fastness - Grey scale for assessing change in colour

GB/T 1335, Standard sizing systems for garments

GB/T 2828.1-2012, Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 2910, Textiles - Quantitative chemical analysis

GB/T 3920, Textiles - Tests for colour fastness - Colour fastness to rubbing

GB/T 3921-2008, Textiles - Tests for colour fastness - Colour fastness to washing with soap or soap and soda

GB/T 3922, Textiles - Tests for colour fastness - Colour fastness to perspiration

GB/T 4802.1-2008, Textiles - Determination of fabric propensity for fuzzing and pilling - Part 1: Circular locus method

GB/T 4841.3, Colour cards of standard depths for dyeing with dyestuffs 2/1, 1/3, 1/6, 1/12, 1/25

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

GB/T 5713, Textiles - Tests for colour fastness - Colour fastness to water

GB/T 6411, A series of size of knitted underwear

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

GB/T 8427-2019, Textiles - Tests for color fastness - Color fastness to artificial light: Xenon arc

GB/T 8629-2017, Textiles - Domestic washing and drying procedures for textile testing

GB/T 8630, Textiles - Determination of dimensional change in washing and drying

GB/T 14576, Textiles - Tests for colour fastness - Colour fastness to light of textiles wetted with artificial perspiration

GB/T 14801, Test method for skewness and bow in woven and knitted fabrics

GB 18401, National general safety technical code for textile products

GB/T 19976, Textiles - Determination of bursting strength - Steel ball method

GB/T 21294-2014, Testing methods of physical and chemical performance of garments

GB/T 23319.3-2010, Textiles - Determination of spirality after laundering - Part 3: Woven and knitted garments

GB/T 24121, Textile products - Determination of the remains of broken sewing needle

GB/T 29862, Textiles - Identification of fiber content

GB 31701, Safety technical code for infants and children textile products

FZ/T 01026, Textiles - Quantitative chemical analysis - Multi-component fibre mixtures

FZ/T 01057, Test method for identification of textile fibres

4.5.4.3 The stitches of the lockstitch sewing machine shall be stitched back to the edges; use clamps to roll back stitches at the joints of the collar, sleeves, and waist.

4.5.4.4 Leak, slotting, off-line and broken line are not allowed for each sewing process.

5 Test methods

5.1 Basic safety performance test method

Carry out according to GB 18401, GB 31701.

5.2 Inherent quality test method

5.2.1 Fiber content test method

Carry out according to GB/T 2910 (all parts), FZ/T 01026, FZ/T 01057 (all parts), FZ/T 01095, FZ/T 01101.

5.2.2 Bursting strength test method

Carry out according to GB/T 19976; the test condition is humidified; the diameter of the steel ball is (38 ± 0.02) mm.

5.2.3 Washing size change rate test method

Carry out the test method according to GB/T 8629-2017 and GB/T 8630. Adopt the type A standard washing machine in GB/T 8629-2017, 4H washing procedure, A-method (hanging and drying) drying procedure, and take 3 samples. Take the arithmetic average of 3 samples as the test result. If there are shrinkage and elongation samples at the same time, take the arithmetic average of the two samples of shrinkage (or elongation) as the test result; the final result shall be rounded off in accordance with GB/T 8170; one decimal place shall be kept.

5.2.4 Test method for distortion after washing

Take the 3 air-dried samples after the test in 5.2.3; spread them on a smooth table; pat them flat with hands; inspect them in accordance with Method B in GB/T 23319.3-2010. Take the arithmetic average of 3 samples as the test result.

5.2.5 Test method for color fastness

5.2.5.1 The test method for color fastness to washing with soap or soap and soda shall be carried out in accordance with GB/T 3921-2008; use the test condition A(1).

5.2.5.2 The test method for color fastness to water shall be carried out in accordance with GB/T 5713.

5.2.5.3 The test method for color fastness to perspiration shall be carried out in accordance with GB/T 3922.

5.2.5.4 The test method for color fastness to rubbing shall be carried out in accordance with GB/T 3920; only do it in the vertical direction.

5.2.5.5 The test method for color fastness to light shall be carried out in accordance with Method 3 of GB/T 8427-2019.

5.2.5.6 The test method for colour fastness to light of textiles wetted with artificial perspiration shall be carried out in accordance with GB/T 14576.

5.2.6 Pilling test method

Carry out according to method E in GB/T 4802.1-2008.

5.2.7 Test method for appearance after washing

Take 3 samples which are dried after the test in 5.2.3; evaluate them according to 8.5 in GB/T 21294-2014 and Table 1 of this Standard.

5.2.8 Test method for remains of broken sewing needle

Perform according to GB/T 24121. The detection sensitivity is 1.0 mm.

5.3 Test method for appearance quality

5.3.1 Inspection tools

Steel ruler whose graduation is 1 mm; GB/T250 grey scale.

5.3.2 Inspection conditions

5.3.2.1 Generally, use light inspection. Use a 40 W white (or blue) fluorescent lamp; add a lampshade on it. The vertical distance between the lampshade and the center of the inspection table is $80\text{ cm} \pm 5\text{ cm}$.

5.3.2.2 If natural light is used indoors, the direction of the light source is north to the left (or right) upper corner; direct sunlight is not allowed to shine on the product.

5.3.2.3 During the inspection, spread the product flat on the inspection table, which is laid with a layer of white cloth. The inspector's line of sight shall be squarely on the surface of the product, with a visual distance of about 60 cm.

5.3.3 Determination of color difference

6 Inspection rules

6.1 Inspection classification

Inspection is divided into type inspection and factory inspection (delivery inspection). The timing of the type inspection is based on the actual conditions of the manufacturer or the contractual agreement. It is generally carried out when the production is changed, the production is resumed after the production is stopped, and the raw materials or processes have major changes. The factory inspection is carried out before the delivery of the product.

6.2 Inspection items

Type inspection items are all inspection items in Chapter 4. Factory inspection items are the appearance quality inspection items in 4.5.

6.3 Batch rules

For type inspection, the same variety and design shall be the same inspection lot. For factory inspection, take products of the same contract or production batch number as the same inspection lot. When the same inspection lot has a large quantity and needs to be delivered in installments or batches, it can be appropriately divided into batches and inspected separately.

6.4 Sampling plan

Samples shall be randomly selected from qualified batches of products passing the factory inspection. The number of samples shall be in accordance with the general inspection level II in GB/T 2828.1-2012. Use the normal inspection one-time sampling plan (see Appendix A). For samples for basic safety performance and inherent quality inspections, randomly select one sample, respectively, from the samples; however, for the washing size change rate (distortion after washing, appearance after washing), take 3 samples; for the color fastness, respectively take one sample for each design and color. The size and sampling location of each sample shall be in accordance with the requirements of the method standard.

When the batch is large, the production is normal, and the quality is stable, the number of items can be in accordance with the general inspection level II in GB/T 2828.1-2012, and the reduced inspection one-time sampling plan (see Appendix A) can be adopted.

6.5 Determination of the test result

Appearance quality is graded according to pieces; basic safety performance and inherent quality are graded according to batches; the final grade of the sample is assessed with the lowest grade among all test results.

When all the items of the basic safety performance and inherent quality inspection results of the sample meet the requirements of the standard, judge the internal quality of the inspection lot represented by the sample to be qualified. The batch appearance quality is judged according to the general inspection level II in GB/T 2828.1-2012; the acceptance quality limit AQL is 2.5 unqualified products percentage. When both the inherent and appearance quality of the batch are qualified, judge it as a qualified batch. Otherwise, judge it as an unqualified batch.

6.6 Reinspection

If the delivery parties disagree with the inspection results, a re-inspection can be carried out. The re-inspection shall be carried out in accordance with the regulations of the first inspection; the results of the re-inspection shall prevail.

7 Marking, packaging, transportation and storage

7.1 The product instructions shall meet the requirements of GB/T 5296.4 and GB 31701.

7.2 Each product (set) shall be packaged. The packaging materials shall ensure that the product is not scattered, damaged, stained, or damp during storage and transportation. Special requirement of the user, if any, shall be determined by both parties.

7.3 Product transportation shall be moisture-proof, fire-proof and pollution-proof.

7.4 Products shall be placed in a cool, ventilated, dry and clean place; appropriate fire and moisture-proof measures shall be taken in the warehouse.

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