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TEXTILE INDUSTRY STANDARD

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Fiber Grade Recycled Polyester Chip (PET)

纤维级再生聚酯切片 (PET)

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Fiber Grade Recycled Polyester Chip (PET)

1 Scope

This Standard specifies the terms and definitions, product classification, technical requirements, test methods, inspection rules and marking, packaging, transportation, and storage requirements for fiber grade recycled polyester chips (PET).

This Standard applies to fiber grade chips processed from recycled PET polyester (waste silk, pulp blocks, bottle flakes, waste textiles, etc.). Other similar products can be used as a reference.

2 Normative References

The following documents are essential to the application of this Document. For the dated documents, only the versions with the dates indicated are applicable to this Document; for the undated documents, only the latest version (including all the amendments) is applicable to this Document.

GB/T 4146.3 Textiles - Man-made fibers - Part 3: Terms of inspection

GB/T 6678 General principles for sampling chemical products

GB/T 6679 General rules for sampling of solid chemical products

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

GB/T 14190 Testing methods of fiber grade polyester (PET) chip

3 Terms and Definitions

For the purposes of this Document, the terms and definitions given in GB/T 4146.3 and GB/T 14190 and the following apply.

3.1 Fiber grade recycled polyester chip (PET)

Using recycled polyester (PET) as material, chips that are obtained by granulation for producing fibers.

6 Test Methods

Carry out in accordance with the provisions of GB/T 14190, in principle follow Method-A. The expression results of all performance indicators are according to the number of significant digits specified in Table 1 and rounded-off in accordance with the numerical rounding rules of GB/T 8170.

7 Inspection Rules

7.1 Types of inspections

Inspection types are divided into type inspection and exit-factory inspection. Type inspection is required under the following circumstances:

- a) During specified periodic inspections;
- b) When there are changes in production design, technology, and materials that may affect product quality;
- c) When the results of exit-factory inspection are significantly different from the last type inspection;
- d) When the national inspection agency requires type inspection.

7.2 Inspection items

7.2.1 All performance items in Table 1 are type inspection items.

7.2.2 The four performance items in Table 1, including intrinsic viscosity, chroma, abnormal-shaped chips, and ash content, are exit-factory inspection items.

7.3 Batching rules

Periodic sampling is used within a certain range to form inspection batch numbers. A production batch can consist of one inspection batch or several inspection batches.

7.4 Sampling provisions

7.4.1 During exit-factory inspection, samples are automatically drawn by an online sampler or manually drawn on the production line at certain intervals.

7.4.2 The sampling of packaged products shall be carried out in accordance with the provisions of GB/T 6679; and the number of sampling packages shall be carried out in accordance with the provisions of GB/T 6678.

7.4.3 The sample size for testing shall be no less than 500g, and the sample size for arbitration shall be no less than 1000g.

7.5 Judgment rules

7.5.1 The measured value or calculated value of the performance item shall be compared with the limit value in the index of Table 1 according to the rounded value comparison method specified in GB/T 8170; and the grade shall be evaluated.

7.5.2 Determine the grade item by item, and determine the grade of the batch of products based on the lowest grade among the various performance indicators.

7.6 Retest rules

7.6.1 General

When the product arrives at the recipient, the outer packaging, number of pieces, and quality of the package shall be checked in a timely manner to see if they are consistent with the manifest. If the quality is affected due to transportation or storage, etc., the responsibility needs to be identified and the responsible party shall assume the responsibility.

Within three months after the product arrives at the recipient, if the product quality is found to be inconsistent with the quality report or the quantity is inconsistent, it can be submitted for retest. If more than one-third of the batch of products is used, retest shall not be applied.

If the recipient can provide relevant evidence to prove that the batch of products has indeed affected the quality of the processed products and caused serious losses, the causes shall be analyzed, the responsibilities of both parties shall be clarified, and the matter shall be negotiated. If necessary, apply for an arbitration.

7.6.2 Inspection items

The same as 7.2. During arbitration, if an item involves more than two test methods, in principle, the test shall be carried out according to Method-A of the relevant test methods in GB/T 14190; if both parties in interest reach an agreement, Method B may be used.

7.6.3 Batching provisions

Batching shall be conducted according to the original production batch number.

7.6.4 Sampling provisions

The same as 7.4.

7.6.5 Retest assessment

7.6.5.1 The measured value or calculated value of the performance item is compared with the

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