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FZ

TEXTILE INDUSTRY STANDARD

OF THE PEOPLE'S REPUBLIC OF CHINA

ICS 61.020

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FZ/T 81006-2007

Replacing FZ/T 81006-1992

Jeanswear

牛仔服装

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Issued on: May 29, 2007

Implemented on: November 01, 2007

**Issued by: Ministry of Industry and Information Technology of the
People's Republic of China**

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Foreword

4.1 and 4.12.10 of this Standard are compulsory provisions. Requirements for qualified products of colour fastness to water, colour fastness to perspiration, colour fastness to dry friction and colour fastness to saliva in 4.12.3 are compulsory provisions.

This Standard replaces FZ/T 81006-1992 "Jeanswear".

Compared with FZ/T 81006-1992, this Standard has the following main changes:

- Modify the application scope of the standard;
- Supplement normative references;
- Add Chapter 3 "Terms and Definitions";
- Add the requirements for instructions for use and warp and weft direction;
- Modify the requirements for colour difference and splicing;
- Add the description to appearance defects and degree;
- Add the requirements for torsion resistance before washing;
- Add the requirements for the examination of breaking force, tearing strength, abrasion resistance, torsion resistance before and after washing, seam slippage degree, trouser back crotch seam strength, peeled off strength of fusible interlining covered position, etc. of finished product;
- Add the requirements for colour fastness of finished product;
- Add the requirements for dimensional change ratio of finished product after washing, torsion resistance and torsion resistance movement after washing;
- Add the requirements for examination of formaldehyde content, pH value, odour and dissolvable aromatic amine dye;
- Add the requirements for examination of raw material composition and content;
- Divide the product quality grade into high-grade product, first-grade product and qualified product;
- Replenish and perfect product quality defect judgment content.

Appendix A, Appendix B, Appendix C and Appendix D of this Standard are normative.

Jeanswear

1 Scope

This Standard specifies the requirements, inspection (test) methods, inspection classification rules as well as marking, packing, transport and storage and other technical characteristics of jeanswear.

This Standard is applicable to regular and colour jeanswear produced with coloured woven jean blended and interwoven mainly in pure cotton and cotton fiber as the main raw material.

2 Normative References

The following standards contain the provisions which, through reference in this Standard, constitute the provisions of this Standard. For dated reference, the subsequent amendments (excluding correction) or revisions of these publications do not apply. However, the parties who enter into an agreement based on this Standard are encouraged to investigate the possibility of applying the most recent editions of the standards. For undated references, the latest edition of the normative document is applicable to this Standard.

GB 250 Gray Scale for Assessing Change in Colour

GB 251 Gray Scale for Assessing Staining

GB/T 1335.1 Standard Sizing Systems for Garments - Men

GB/T 1335.2 Standard Sizing Systems for Garments - Women

GB/T 1335.3 Standard Sizing Systems for Garments - Children

GB/T 2910 Textile - Binary Fibre Mixtures - Quantitative Chemical Analysis

GB/T 2911 Textiles - Ternary Fibre Mixtures - Quantitative Analysis

GB/T 2912.1 Textiles - Determination of Formaldehyde - Part 1: Free and Hydrolyzed Formaldehyde (Water Extraction Method)

GB/T 3917.1 Textiles - Tear Properties of Fabrics - Part 1: Determination of Tear Force Using Ballistic Pendulum Method (Elmendorf)

GB/T 3920 Textiles - Tests for Colour Fastness - Colour Fastness to Rubbing

FZ/T 32004 - 1996 Flax Cotton Blended Grey Yarn

FZ/T 80002 Marking Packaging Transportation and Storage for Garments

FZ/T 80004 Rule for Garments Exit-factory inspection

FZ/T 80007.1 Test Method of Peeled off Strength Value for Garments Used Adhesive Interlining

3 Terms and Definitions

For the purposes of this Standard, the terms and definitions specified in GB 18401 as well as the following ones apply.

3.1

Washing product

Jeanswear, of which the finished product or shell fabric used is subjected to stone washing, enzyme washing, rinsing, ice washing, snow washing, etc. or washed, processed and arranged through multiple combination modes.

3.2

Original product

Jeanswear, of which the finished product or shell fabric used is only subjected to desizing and shrink resistant finish but not processed or arranged through washing mode.

3.3

Regular jeanswear

Garment that is fabricated with jean-style shell fabric by mainly taking cotton, indigo which is blended with cotton, and sulfur dye colour yarn as warp and grey yarn as weft.

3.4

Colour jeanswear

Garment that is fabricated with jean-style coloured woven shell fabric by mainly taking cotton and cotton blended colour yarn as warp and weft.

4 Requirements

4.1 Instructions for use

The instructions for use of finished product shall comply with GB 5296.4 and GB 18401, and washing product or original product shall be indicated.

4.2 Size and specification

4.2.1 Size setting shall be selected according to those specified in GB/T 1335.1, GB/T 1335.2 and GB/T 1335.3.

4.2.2 Specification for main parts of finished product shall be designed by itself according to the relevant requirements of GB/T 1335.1, GB/T 1335.2 and GB/T 1335.3.

4.3 Raw materials

4.3.1 Shell fabric

Shell fabric suitable for jeanswear shall be selected according to FZ/T 13001 or relevant standards for textile shell fabric.

4.3.2 Lining

The lining with appropriate property and colour and lustre with shell fabric used shall be adopted (except special design).

4.3.3 Accessory fabric

4.3.3.1 Liner, shoulder pad and pocket bag

The liner, shoulder pad and pocket bag with appropriate property and colour and lustre with shell fabric used shall be adopted.

4.3.3.2 Suture

Suture suitable for the quality of accessories and lining used shall be adopted; the shrinkage of embroidery thread shall be appropriate to the shell fabric; button thread shall be suitable for button in colour and lustre; brand thread shall be suitable for the brand ground colour (except ornamental thread).

4.3.3.3 Button, zipper and metallic accessories

Button (except ornamental button), zipper and metallic accessories suitable for the shell fabric used shall be adopted and free from defects. Button and accessories shall be free from deformation, discolouring and rust after washing and ironing.

4.4 Warp and weft direction

4.8.2 The seam allowance width of the seamed pocket and loop shall not be less than 0.6cm and the seam allowance width of the rest positions shall not be less than 0.8cm.

4.8.3 All the exposed seam allowances shall be finish edge folded or overseamed (except special design).

4.8.4 Sewing lines on each position shall be smooth, straight, regular, flat and firm.

4.8.5 The open thread shall be free from stitch overlapping within a distance of 20cm, but once may be allowed above 20cm; skipping stitch and break are not allowed.

4.8.6 The position of brand and size mark shall be upright and the content shall be distinct, normalized and accurate.

4.8.7 The button hole shall be positioned accurately and suitable in size; the button and hole shall be aligned; the sewing button shall be firm; the joint force shall be adequate; and the noose position shall be accurate.

4.8.8 Ornament (embroidery, inlay, etc.) shall be firm and flat.

4.9 Permissible deviation of specification

The permissible deviation of specification for main position of the finished product shall be in accordance with those specified in Table 3.

Table 3		In cm	
Position name		Permissible deviation of specification	
		Washing product	Original product
Coat length		±1.5	±1.0
Chest girth		±2.5	±1.5
Collar length		±1.0	±0.6
Total shoulder width		±1.0	±0.8
Sleeve length	Inset sleeve	±1.0	±0.8
	Raglan sleeve	±1.2	±1.0
Trouser (skirt) length		±2.0	±1.5
Waist girth		±2.0	±1.0
Note: For weft-direction elastic product, the specification deviation in weft direction is not examined.			

4.10 Torsion resistance before washing

The torsion resistance of finished trousers (skirt) before washing shall not exceed 2cm (that specially designed with larger front and back difference in width is not examined).

Table 6

cm

Grade	Allowable degree of torsion resistance
High-grade product	≤ 2.0
First-grade product and qualified product	≤ 3.0
Note 1: Shorts and short skirts are not examined.	
Note 2: That specially designed with larger front and back width difference is not examined.	

4.12.2.2 The allowable degree of torsion resistance movement of finished trousers (skirt) shall be in accordance with those specified in Table 7.

Table 7

cm

Grade	Allowable degree of torsion resistance
High-grade product	≤ 1.5
First-grade product and qualified product	≤ 2.5
Note: Shorts and short skirts are not examined.	

4.12.3 Colour fastness

4.12.3.1 The allowable degree of colour fastness of original product shall be in accordance with those specified in Table 8.

Table 8

Grade

Item		Allowable degree of colour fastness		
		High-grade product	First-grade product	Qualified product
Washing fastness	Discolouration	≥4	≥3-4	≥3
	Staining	≥3	≥2-3	
Light fastness		≥4	≥3	
Dry friction fastness	Staining	≥3-4(infant products≥4)	≥3(infant products≥4)	
Water fastness	Discolouration	≥4	≥3-4	≥3(infant products≥3-4)
	Staining	≥3-4	≥3(infant products≥3-4)	
Perspiration fastness	Discolouration	≥4	≥3-4	≥3(infant products≥3-4)
	Staining	≥3-4	≥3(infant products≥3-4)	
Saliva fastness (only infant products are examined)	Discolouration	≥4-5	≥4	
	Staining	≥4		

4.12.3.2 The colour fastness of washing product shall be in accordance with those specified in Table 9.

Table 9

Grade

Item	Allowable degree of colour fastness	
	High-grade product	First-grade product and

Table 14

Item	Trouser back crotch seam strength
Textiles below 339g/m ²	≥140N/(5.0cm×10.0cm)
339g/m ² or above textiles	≥180N/(5.0cm×10.0cm)

4.12.10 Basic safety performance

The basic safety performance of finished product shall be in accordance with those specified in Table 15.

Table 15

Item	Infant product	Direct contact skin product	Non-direct contact skin product
Formaldehyde content/(mg/kg)	≤20	≤75	≤300
pH value	4.0~7.5	4.0~7.5	4.0~9.0
Odour	No		
Dissolvable aromatic amine dye	Forbidden		
Note: List of carcinogenic aromatic amines that are not allowed to be dissolved from dyes under reducing condition is detailed in GB 18401.			

4.12.11 Component and content of raw material

The component and content of the raw material used in finished product shall meet the requirements of FZ/T 01053.

5 Inspection (Test) Method

5.1 Inspection tools

5.1.1 Steel tape.

5.1.2 Grey scale for assessing change in colour (GB 250).

5.1.3 Gray scale for assessing staining (GB 251).

5.1.4 Standard sample photos for appearance defects of jeanswear.

5.2 Finished product specification measurement

5.2.1 The specification selection for main positions of the finished product shall be in accordance with those specified in Table 4.2.2.

5.2.2 The permissible specification deviation of main positions of the finished

product shall be in accordance with those specified in 4.9, and the measurement method shall be in accordance with those specified in Table 16 and Figure 2.

Table 16

SN	Position name	Measurement method
1	Coat length	Vertically measure from the highest point of the shoulder seam of left front to the bottom edge, or vertically measure from the rear collar to the bottom edge
2	Chest girth	Close up buttons (or close zipper), flatten front and back part, and horizontally measure along arm hole bottom seam (calculate the periphery)
3	Collar length	Flatten collar and transversely measure the upper opening (only stand collar is examined)
4	Raglan sleeve length	Measure from the highest point of shoulder seam to sleeve opening edge middle
5	Sleeve length	Measure from intersection point of shoulder sleeve seam to sleeve opening edge middle
6	Total shoulder width	Flatten from intersection point of shoulder sleeve seam and transversely measure
7	Trouser length	Flatten from waist upside along side seam, and vertically measure to the trouser bottom
8	Waist girth (trousers)	Do up the trouser hook (button), and measure along the middle line of waist width (calculate the periphery)
9	Skirt length	Flatten from waist upside along front centre line and vertically measure to the skirt bottom
10	Waist girth (skirt)	Do up the trouser hook (button), and measure along the middle line of waist width (calculate the periphery)

the three products shall be taken as the result.

5.4.2 The torsion resistance and torsion resistance movement of finished trousers (skirt) after washing shall be in accordance with those specified in 4.12.2; the test method shall be in accordance with those specified in Appendix B, therein the washing and drying methods are the same as 5.4.1, and the mean of the three products shall be taken as the result (right and left trouser legs shall be calculated respectively).

5.4.3 The allowable degree of colour fastness of finished product shall be in accordance with those specified in 4.12.3; the test method shall be in accordance with those specified in GB/T 3921.3, GB/T 8427 (tested according to Method 3; end conditions: solarize Grade 4 blue mark to Grade 4 gray scale discoloration), GB/T 3920, GB/T 5713, GB/T 3922 and GB/T 18886 respectively.

5.4.4 The abrasion resistance of shell fabric of finished product shall be in accordance with those specified in 4.12.4 and the test method shall be in accordance with those specified in FZ/T 20020.

5.4.5 The slippage degree of seam of main position of the finished product shall be in accordance with those specified in 4.12.5; the sampling position shall be in accordance with those specified in Table 17; and the test method shall be in accordance with those specified in Appendix C.

Table 17

Name of sampling position	Requirements for sampling position
Side seam	10cm downward from arm hole
Trouser (skirt) side seam	One third on trouser (skirt) side seam is the centre

5.4.6 The breaking force of shell fabric of finished product shall be in accordance with those specified in 4.12.6 and the test method shall be in accordance with those specified in GB/T 3923.2.

5.4.7 The tearing strength of shell fabric of finished product shall be in accordance with those specified in 4.12.7 and the test method shall be in accordance with those specified in GB/T 3917.1.

5.4.8 The allowable degree of peel strength of fusible interlining covered of finished product shall be in accordance with those specified in 4.12.8 and the test method shall be in accordance with those specified in FZ/T 80007.1.

5.4.9 The trouser back crotch seam strength of finished product shall be in accordance with those specified in 4.12.9; one trouser shall be sampled and the position shall be in accordance with those specified in Appendix D, and the test method shall be in accordance with those specified in GB/T 3923.1.

5.4.10 The formaldehyde content limit of finished product shall be in accordance with those specified in Table 15 and the test method shall be in accordance with those specified in GB/T 2912.1.

5.4.11 The pH value limit of finished product shall be in accordance with those specified in Table 15 and the test method shall be in accordance with those specified in GB/T 7573.

5.4.12 The odour of finished product shall be in accordance with those specified in Table 15 and the test method shall be in accordance with those specified in GB 18401.

5.4.13 The dissolvable aromatic amine dye of finished product shall be in accordance with those specified in Table 15 and the test method shall be in accordance with those specified in GB/T 17592.

5.4.14 The composition and content of raw material used for finished product shall be in accordance with those specified in 4.12.11 and the test method shall comply with FZ/T 01057, GB/T 2910, GB/T 2911, FZ/T 01026, Appendix B of FZ/T 32004-1996, etc., and the test result shall be calculated in combination with the net drying content.

5.4.15 The sampling positions for the test of physical and chemical properties not mentioned may be selected randomly from the finished product according to test items.

6 Inspection Classification Rules

6.1 Inspection classification

The product inspection is divided into exit-factory inspection, general type inspection and type inspection.

6.1.1 Exit-factory inspection shall be in accordance with those specified in Chapter 4, except 4.12. Exit-factory inspection rules shall be in accordance with those specified in FZ/T 80004.

6.1.2 General type inspection shall be in accordance with those specified in Chapter 4, except 4.12.4, 4.12.5, 4.12.6, 4.12.7, 4.12.8 and 4.12.9.

6.1.3 Type inspection shall be in accordance with those specified in Chapter 4 (only used on quality arbitration, etc.).

6.2 Quality grade division

Quality grade division of the finished product is based on whether there is defect and

			above 0.5cm; overseam has skipping stitch.	
	13	There is stitch overlapping once within 20cm length and twice within 20cm~60cm length.		
	14	Stitch has staggered seam; back stitching is not firm.		
	15	The width of decorative stitch is inconsistent and less than 0.3cm; open thread is bent; double open threads are not parallel; stitch marks are nonuniform.	The width of decorative stitch is inconsistent and larger than 0.3cm; stitch marks are nonuniform seriously.	
	16	Deflection of attach collar (collar shoulder seam comparison) is larger than 0.6cm.	Deflection of attach collar (collar shoulder seam comparison) is larger than 1.0cm.	
	17	Shoulder seam is not smooth, straight or flat; widths of two shoulders are inconsistent and the mutual deviation is larger than 0.5cm.	Shoulder seam is seriously not smooth, straight or flat; widths of two shoulders are inconsistent and the mutual deviation is larger than 1.0 cm.	
	18	Mutual deviation of right and left sleeve lengths is larger than 0.5cm; that of two sleeve openings is larger than 0.3cm.	Mutual deviation of right and left sleeve lengths is larger than 1.0cm; that of two sleeve openings is larger than 0.8cm.	
	19	Pocket and pocket cover are not round or smooth; pocket cover and patch pocket are improper in size; pocket opening and inserted thread are not straight or inconsistent in width; pocket corners are not regular; mutual deviation of front and back as well as high and low pocket position is larger than 0.5cm.	Pocket opening is not knot sealed firm; there is loop; pocket bag padding burr has no overseam.	
	20	Length, deflection, distortion and position of loops are	Loops are missed.	

		inaccurate.		
	21	Zipper inserting easing is nonuniform; width of zipper inserting pressing line is inconsistent; zipper is arched or not flat; zipper is not smooth; grinning stitch is inconsistent.		
	22	Button hole is too large or too small; button, snap fastener, rivet, button hole and as well as loop are not aligned or inaccurate in position.	Button, snap fastener, hook, etc. are not firm or damaged.	
	23	Closure and under fly is straight or not flat; unfavouring fly facing.	Unfavouring fly facing obviously.	
	24	Back crotch seam deviates from centre line.		
	25	Closure is 0.5cm~1.0cm longer than under fly; under fly is below 0.5cm longer than closure.	Closure is above 1.0cm longer than under fly; under fly is above 0.5cm longer than closure.	
	26	Length mutual deviation of two trouser legs (right and left side seam of skirts) is 0.5cm~1.0cm.	Length mutual deviation of two trouser legs (right and left side seam of skirts) is above 1.0cm.	
	27	Stitch size spacing is nonuniform and less than 2 stitches (including 2 stitches) below that specified in this Standard.	Stitch size spacing is above 2 stitches below that specified in this Standard.	
	28	The seamed pocket and loop seam allowance width is less than 0.6cm and the seam allowance width of the rest positions is less than 0.8cm.	Seam allowance width (excluding pocket and loop position) is less than 0.5cm; exposed seam allowance is not finish edge folded or overseamed.	
	29	Mutual deviation of button hole spacing is larger than 0.4cm or the deflection is larger than 0.2cm; yarn splits out.	Button hole has skipped thread, split thread, hair, missing or hole opening missing.	

unqualified products). Physical and chemical property test reaches the index requirements of high-grade products.

High-grade product batch: quantity of above first-grade products in appearance sample $\geq 90\%$; quantity of qualified products $\leq 10\%$ (excluding unqualified products). Physical and chemical property test reaches the index requirements of first-grade products.

Qualified product batch: quantity of above qualified products in appearance sample $\geq 90\%$; quantity of unqualified products $\leq 10\%$ (excluding unqualified products with critical defects). Physical and chemical property test reaches the index requirements of qualified products.

If the appearance sewing quality judgment is inconsistent with the physical and chemical property judgment, the lower grade judgment shall be carried out.

6.4.3 In the random inspection, if the judging quantity of each batch meets the requirements of this Standard, it shall be delivered as graded product.

6.4.4 In random inspection, if the judging quantity of each batch fails to meet the requirements of this Standard, a second random inspection shall be carried out. The random inspection quantity shall be increased by one times; if the result still fails to meet the requirements of this Standard, all the products shall be refitted or degraded.

7 Marking, Packing, Transport and Storage

Marking, packing, transport and storage shall comply with FZ/T 80002.

Appendix A

(Normative)

Description to Appearance Defects and Defect Degree

A.1 Warp direction defects

Yarn defects, weaving defects and post-general finish defect extending along warp direction, mainly including coarse warp, slack warp, wale, buckling, reed streak.

A.2 Weft direction defects

Yarn defects, weaving defects and post-general finish defect extending along weft direction, mainly including coarse weft, weft missing, unevenness of textile strands, shade bar, stretch missing and wrinkling.

A.3 Disperse defects

Disperse fine defects present in order or disorderly (generally it is difficult to count and meter) and a large-area colour difference, etc., mainly including white star, white mark, white block, bad bleaching, neps, piece difference, uneven whitening, uneven sanding and dead fold.

A.4 Breakage defects

Defects produced carelessly by weaving of shell fabric or washing of garments, like broken warp, broken weft, excess breakage, etc.

A.5 Spot and stain defects

They cover mainly water stain, stain, oil stain, rusty stain, size stain, mould stain, pink marking, etc.

A.6 Description of defect degree

A.6.1 Slight defects: defects seen through careful identification and not obvious visually, including coarse warp and coarse weft with coarseness not larger than twice the yarn count, weft missing short of one rope of yarn, reed streak short of 1~2 ropes of yarn, undetectable slack warp, wale, buckling, reed streak, unevenness of textile strands, shade bar, stretch missing, wrinkling, white star, white mark, neps, piece difference, uneven whitening, uneven sanding and dead fold as well as stain within an area of 1cm².

A.6.2 Obvious defects: defects seen obvious visually but without obvious influence

on the overall effects, including coarse warp and coarse weft with coarseness larger than twice the yarn count, weft missing short of 2~3 ropes of yarn, reed streak short of 3 or above 3 ropes of yarn, detectable slack warp, wale, buckling, reed streak, unevenness of textile strands, shade bar, stretch missing, wrinkling, white star, white mark, neps, piece difference, uneven whitening, uneven sanding, dead fold, broken warp and broken weft as well as stain of an area of 1cm² or above 1cm².

A.6.3 Critical defects: serious breakage defects and defects with notable influence on the overall effects, including excess breakage, weft missing short of over 3 ropes of yarn, serious buckling, reed streak, unevenness of textile strands, shade bar, dead fold, broken warp and broken weft as well as the stretch missing above an area with width 0.5cm and length 10cm or of an equivalent area.

Appendix C

(Normative)

Test Methods for Slipping Degree of Seam

C.1 Principle

Apply a certain of load on the direction perpendicular to textile fabric seam and the seam becomes open and then measure the maximum open distance.

C.2 Applied load

Shell fabric below 339g/m²: 100N±5N; shell fabric of 339g/m² or above: 150N±5N;

Lining: 70N± 5N.

C.3 Equipment and materials

C.3.1 Common household and industrial sewing machine and the sewing machine shall select the models suitable for the dress material used.

C.3.2 Sewing thread shall select the stitch thread suitable for the quality of dress material used.

C.3.3 The upper and lower clamps of the strength tester of the textile fabric shall be at a distance of 10.0cm; for the lower clamp, the descent speed is 5.0 cm/min and the pre-tension (heavy punch) is 2N under the conditions of no loading.

C.3.4 Clamp with width 2.5cm shall be adopted.

C.4 Test environment

At standard atmospheres for conditioning and testing, temperature of 20°C±2°C and relative humidity of 60%~70%.

C.5 Test requirements and preparation

C.5.1 Sample three finished products with edges vertical to the stitch and the dimension shall be 5.0 cm×20.0 cm (including clamping parts).

C.5.2 The specimen shall be the shell fabric or the lining and three pieces shall be cut from the specimen along the warp direction or the weft direction (above 20cm from the edge of the specimen). Fold the cut specimen, seam with the sewing machine at 1.3cm parallel to the folding, knot the stitch thread firmly and open the specimen along

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