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TEXTILE INDUSTRY STANDARD

OF THE PEOPLE'S REPUBLIC OF CHINA

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Casual wear

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Casual wear

1 Scope

This document specifies the requirements, inspection methods, inspection rules, marking, packaging, transportation, and storage of casual wear.

This document applies to casual wear made of woven fabrics as the main fabric.

This document does not apply to clothing for infants and young children aged 36 months and under.

2 Normative references

The following documents contain the provisions which, through normative reference in this document, constitute the essential provisions of this document. For the dated referenced documents, only the versions with the indicated dates are applicable to this document; for the undated referenced documents, only the latest version (including all the amendments) is applicable to this document.

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

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

GB/T 2668 Specifications for single, layer apparels and clothing sets

GB/T 3917.2 Textiles - Tear properties of fabrics - Part 2: Determination of tear force of trouser-shaped test specimens (Single tear method)

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

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 5711 Textiles - Tests for colour fastness - Colour fastness to drycleaning

using perchloroethylene solvent

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 14801 Test method for skewness and bow in woven and knitted fabrics

GB 18401 National general safety technical code for textile products

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

GB/T 21295-2014 Requirements of physical and chemical performance of garments

GB/T 29778 Textiles - Tests for colour fastness - Assessment of the potential to phenolic yellowing of materials

GB/T 29862 Textiles - Identification of fiber content

GB/T 31127-2014 Textiles - Tests for colour fastness - Colour fastness to transfer in joints

GB 31701 The safety technical code for infants and children textile products

GB/T 31702 Testing method for sharpness of attached components on textile products

GB/T 31907 Method of garment measurement

FZ/T 80002 Marking, packaging, transportation and storage for garments

FZ/T 80004 Rule for garments delivery inspection

FZ/T 80007.3 Dry wash resistance test method for garments used adhesive interlining

Sample photos of appearance defects of men's and women's single-layer and padded garments, and boys' and girls' single-layer garments (Ministry of Textile Industry of the People's Republic of China)

3 Terms and definitions

This document does not have terms and definitions that need to be defined.

4 Requirements

4.1 Instructions for use

The instructions for use of the product shall meet the requirements of GB/T 5296.4, and the products for children aged 3 to 14 shall also meet the requirements of GB 31701.

4.2 Size specifications

4.2.1 Size setting shall be selected according to the provisions of GB/T 1335 (all parts).

4.2.2 The specifications of the main parts of the finished product shall be designed in accordance with the relevant regulations of GB/T 1335 (all parts) and GB/T 2668.

4.3 Raw materials

Shell fabrics and linings shall comply with the relevant requirements of this document. The linings, accessories, and sewing threads used shall be suitable for the shell fabric; buttons, decorative buckles, zippers, and other accessories shall have a smooth surface, no burrs, no damage, no defects, and no sharp points and sharp edges that can be touched. The zippers shall engage well and run smoothly.

NOTE: Accessible sharp points and sharp edges refer to sharp points and edges on the finished product that may cause harm to human skin.

4.4 Warp and weft direction

The yarn skewness of the collar, body, sleeves, and trousers shall not exceed 3%, and the hem of the front body shall not be warped.

4.5 Stripes and plaids matching

4.5.1 Fabrics with obvious stripes and plaids, with a width of 1.0 cm or more, shall meet the requirements in Table 1, except for special designs.

and width of the pocket flaps shall be consistent; the pockets shall be flat and straight, and the corners of the pockets shall be neat.

4.8.10 The lengths of the top fly and the under fly shall be appropriate, and the under fly shall not turn out; the top fly shall be straight and flat. The zipper tape attached to the top fly shall be flat and straight, and the symmetrical parts of the top fly shall be the same height on the left and right.

4.8.11 The buttonhole shall be positioned accurately, the size shall be suitable for the button, and the buttonhole shall be neat and firm. The buttonhole position shall not deviate, and its stitches shall be beautiful, neat, and flat.

4.8.12 The buttons shall be sewn firmly and the thread knots shall not be exposed. Buttons shall not be sewn to a single layer of cloth (except for decorative buttons), the height of the shank shall be appropriate for the position of the buttonholes, and it shall be wrapped 3 times or more (the decorative buttons are not wrapped), and the stopper knot shall be firm and complete.

4.8.13 Buttons and buttonholes shall be aligned with each other. The snap fastener shall be firm, the upper and lower sides shall be in place, fit appropriately, and there shall be no deformation or over-tightening.

4.8.14 The zipper shall be flat, and the teeth shall be consistent; the zipper shall have no missing teeth, and the zipper puller shall be firm.

4.8.15 The waist shall be flat and straight, with the same width; the lining shall not turn out at the seam allowance; the tightness of the elastic band shall be even; the detachable lining shall be overlapped.

4.8.16 The length of the trouser legs and the size of the leg opening shall be consistent.

4.8.17 The side seams of trousers shall be straight and the distortion shall not be more than 2%. Shorts (the length is no longer than the knee) are not assessed.

4.8.18 The decorations (embroidery, inlay, etc.) shall be firm and flat; the embroidery shall not be omitted; there shall be no color staining on the printing.

4.8.19 The welt and stitched piping shall be flat and uniform in width.

4.8.20 The symmetrical parts are basically consistent.

4.8.21 The positions of trademarks and durable labels shall be regular and flat.

4.9 Allowable deviation of specifications and dimension

The specification and dimension deviation of the main parts of the finished product shall meet the requirements in Table 4.

5.3.3 When measuring the appearance defects, visually observe the fabric at a distance of 60 cm, and use a steel tape or ruler to measure if necessary, and compare it with the sample photos of appearance defects of men's & women's single-layer garments, padded garments, and boys' & girls' single-layer garments.

5.3.4 The stitch density shall be measured at any 3.0 cm on the sewing stitches of the finished product (except the thick and thin parts).

5.3.5 The warp and weft yarn skewness shall be measured according to the provisions of GB/T 14801, and the results shall be calculated according to formula (1).

$$S = \frac{100d}{W} \dots\dots\dots (1)$$

where:

S -- skewness of warp or weft yarn, %;

d -- the maximum vertical distance between the warp or weft and the ruler, in millimeters (mm);

W -- the width of the measuring part, in millimeters (mm).

5.3.6 Refer to Figure 2 for the measuring method of the distortion, and calculate the distortion according to formula (2). The result is rounded according to GB/T 8170, and one decimal place is retained.

$$k = \frac{100(b - a)}{c} \dots\dots\dots (2)$$

where:

k -- distortion, %;

b -- the distance between the side seam and the end point on the bottom edge of the trouser leg opening, in centimeters (cm);

a -- the distance between the side seam and the end point on the thigh line of the trousers, in centimeters (cm);

c -- the vertical distance from the thigh line of the trousers to the bottom edge of the trouser leg opening, in centimeters (cm).

5.4.5 The color fastness to light shall be tested according to the provisions of GB/T 8427-2019, and the exposure shall be under normal conditions, and the sample shall be exposed according to method 3 for the first stage.

5.4.6 The color fastness to transfer in joints shall be tested according to the provisions of method A in GB/T 31127-2014.

5.4.7 Pilling shall be tested according to GB/T 4802.1-2008, and parameter D shall be used for the test (parameter E for combed wool fabrics and combed wool-like fabrics, and parameter F for carded wool fabrics, carded wool-like fabrics and loose structure fabrics).

5.4.8 The seam slippage shall be tested according to the provisions in 9.2.1 of GB/T 21294-2014. Among them, the test load shall be applied according to the provisions in Table 6. If two or more samples are qualified in the test results, the average value of the qualified samples is taken as the final result of the testing part, and the index of the testing part is judged to be qualified; if two or more samples are unqualified in the test results, the average value of the unqualified samples is taken as the final result of the testing part, and the index of the testing part is judged to be unqualified. If the test result of each testing part is qualified, it is judged that the index is qualified; otherwise, the index is unqualified. If there are any abnormal phenomena such as yarn slippage, seam breakage, or fabric breakage during the test, these abnormal phenomena shall be described in the test report at the same time.

5.4.9 The phenolic yellowing shall be tested according to the provisions of GB/T 29778.

5.4.10 The tearing strength shall be tested according to the provisions of GB/T 3917.2.

5.4.11 For the test method for appearance after washing and drying, after the sample is washed and dried as specified in 5.4.2, under the appearance test conditions specified in 5.3, combined with the requirements of Table 5, the appearance evaluation shall be carried out according to the evaluation method in GB/T 21294, in which:

- a) The distortion after washing shall be tested according to the provisions in 5.3.6;
- b) The evaluation method for discoloration after washing is as follows: before washing, a sample with a color difference greater than 4-5 grades from the

sample to be washed is selected to be reserved, and the degree of discoloration is compared between the washed sample and the reserved sample; if the color difference between the samples is less than or equal to 4-5 grades, then the reserved sample shall be taken directly from the part of the sample to be washed that does not affect the structure of the garment.

5.4.12 Other physical and chemical performance items shall be tested according to the provisions of GB/T 21294. Among them, a single fiber lining is selected for the color fastness arbitration test of soaping resistance, dry cleaning resistance, perspiration resistance, and water resistance.

5.4.13 About the test items for which the sampling positions are not mentioned, samples can be selected from the finished product according to the test needs.

6 Inspection rules

6.1 Inspection types

6.1.1 Finished product inspection is divided into exit-factory inspection and type inspection. The timing of the type inspection is based on the actual situation of the manufacturer or the provisions of the contract agreement. It is generally carried out when the production is switched to other products, the production is resumed after the suspension, or the raw materials or processes have major changes.

6.1.2 The exit-factory inspection items shall be in accordance with the regulations in Chapter 4, except 4.11. The exit-factory inspection rules for finished products are in accordance with FZ/T 80004.

6.1.3 The type inspection items shall be in accordance with Chapter 4.

6.2 Appearance quality grade and defect classification rules

6.2.1 Classification of appearance quality

The classification of finished product quality is based on the existence and severity of defects. The single product in the chosen sample is classified according to the number of defects and their severity, and the batch grade is classified according to the quantity of the quality grade of single products in the chosen sample.

6.2.2 Classification of appearance defects

A single product does not meet the technical requirements specified in this document, that is a defect.

Defects are divided into 3 categories according to the degree to which the product does

6.3.2 The number of samples used for physical and chemical performance inspection shall be determined according to the needs of the test, generally not less than 6 pieces (or sets).

6.4 Judgment rules

6.4.1 Single piece (sample) determination

Superior product:	critical defects=0,	major defects=0,	minor defects $\leq$ 4;
First-class product:	critical defects=0,	major defects=0,	minor defects $\leq$ 7 or
	critical defects=0,	major defects $\leq$ 1,	minor defects $\leq$ 3;
Qualified product:	critical defects=0,	major defects=0,	minor defects $\leq$ 8 or
	critical defects=0,	major defects $\leq$ 1,	minor defects $\leq$ 6.

6.4.2 Batch grade determination

Superior product batch: the proportion of superior products in the appearance inspection samples is $\geq 90\%$, the total proportion of first-class products and qualified products is $\leq 10\%$, and no unqualified products are included. All physical and chemical performance test results meet the index requirements of superior products.

First-class product batch: the total proportion of first-class and above products in the appearance inspection samples is $\geq 90\%$, the proportion of qualified products is $\leq 10\%$, and no unqualified products are included. All physical and chemical performance test results meet the index requirements of the first-class products.

Qualified product batch: the proportion of qualified and above products in the appearance inspection samples is $\geq 90\%$, the proportion of unqualified products is $\leq 10\%$, and there are no unqualified products with critical defects. All physical and chemical performance test results meet the index requirements of qualified products.

When the judgment of appearance sewing quality is inconsistent with the judgment of physical and chemical properties, the products shall be judged as a lower grade.

6.4.3 Eligibility determination

In the random inspection, if the judgment number of a batch conforms to the corresponding grade regulations in 6.4.2, then it is judged as a qualified batch.

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Linkin: <https://www.linkedin.com/in/waynezhengwenrui/>

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