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TEXTILE INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

ICS 61.020
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FZ/T 81018-2014

Woven artificial leather garments

机织人造革服装

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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 (CNTAC).

This standard shall be under the jurisdiction of National Costume Standardization Technical Committee (SAC/TC 219).

The main drafting organizations of this standard: Shenzhen Institute of Metrology and Quality Inspection, Shanghai Institute of Clothing, National Garment Quality Supervision and Inspection Center (Shanghai), Fujian Seven Brand Group Co., Ltd., Hunan Unforgettable Clothing Co., Ltd.

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Woven artificial leather garment

1 Scope

This standard specifies products requirements, testing methods and test classification rules of woven artificial leather garments, as well as logo, packaging, transportation, storage and all other technical features.

This standard applies to the clothing that is produced by artificial leather (textile machine fabric is the base cloth) as the main fabric.

This standard does not apply to the clothing of infants aged 36 months and below.

2 Normative references

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

GB/T 250 Textiles - Tests for color fastness - Gray sample card for discoloration

GB/T 251 Textiles - Tests for color fastness - Gray sample card for staining

GB/T 1335 (all parts) Clothing size

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

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

GB/T 6040 General rules for infrared analysis

GB/T 8949 Polyurethane dry-processing artificial leather

GB 18401 National general safety technical code for textile products

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

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

GB 21550 Restriction of hazardous materials in polyvinyl chloride artificial leather

GB/T 29862 Textiles - Identification of fiber content

GB/T 31907 Method of garment measurement

QB/T 2714 Leather - Physical and mechanical tests - Determination of flex resistance

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

FZ/T 80004 Rule for garments delivery inspection

3 Requirements

3.1 Instructions for use

Leatherette fabric shall be marked with the main types of coating; the instructions of the rest of finished-product are according to the regulations of GB 5296.4.

3.2 Size specifications

Size setting is chosen according to the provisions of GB/T 1335.

3.3 Raw materials

3.3.1 Fabric

Select and use the artificial leather fabric to comply with the quality requirements of the standard according to national standards for artificial leather.

3.3.2 Lining

Use the lining suitable for the fabric used and to comply with the quality requirements of the standard.

3.3.3 Accessories

3.3.3.1 Lining and shoulder pads

Use the lining and the shoulder pads suitable for the performance and the color of the fabric used, and the quality shall be consistent with the provisions of this standard.

3.3.3.2 Stitches

Use the stitches suitable for the performance and the color of fabric and accessories; shrinkage of embroidery thread shall be compatible with the fabric.

3.3.3.3 Buttons, zippers and accessories

Use buttons, zippers and other accessories suitable for the fabric used. The surface of buttons shall be smooth and defect-free; accessories shall be free from scratches, sharp points and sharp edges; moreover, after washing and/or ironing they have no deformation, discoloration, staining and rusting. Zippers' mesh is well, smooth and easy.

		Perspiration resistance	
		Water resistance	
	Seam slippage degree/cm		Conform to the provisions of GB/T 21295

3.10.2 According to the provisions of GB/T 4841.3, if the color is darker than 1/12, then the dyeing standard depth is dark color; if the color is lighter than or equal to 1/12, then the dyeing standard depth is light-color.

3.10.3 Limit for hazardous substances of PVC artificial leather only checks PVC artificial leather.

3.10.4 Anti-yellowing only checks light-colored and white leatherette fabric.

3.10.5 Seam slippage degree only checks woven fabric lining.

4 Test methods

4.1 Inspection tools

4.1.1 Steel tape or steel ruler, indexing value is 1mm.

4.1.2 Use gray sample card (GB/T 250) to test and assess the coloration of textile color fastness.

4.1.3 Use gray sample card (GB/T 251) to test and assess the staining of textile color fastness.

4.1.4 1/12 Color cards of standard depths for dyeing with dyestuffs (GB/T 4841.3).

4.2 Finished-product specification determination

4.2.1 The specification of the main parts of finished-product is according to 3.2 regulations.

4.2.2 The measurement of the main parts of finished-product is according to GB/T 31907; allowed specification deviation is according to 3.8 regulations.

4.3 Appearance determination

4.3.1 The appearance determination of finished-product generally uses lighting; the illumination is no less than 600 lx. If possible, use north-sky-light illumination too.

4.3.2 When assessing the degree of finished-product's color difference, incident light is about 45° to the surface of fabric. The observation direction shall be perpendicular to the surface, and the distance shall be 60cm from visual inspection, compared with GB/T 250 sample card.

4.3.3 The appearance quality of finished-product is according to 3.6 regulations.

4.3.4 The sewing quality of finished-product is according to 3.7 regulations.

4.3.5 Ironing of finished-product is according to 3.9 regulations.

4.4 Determination of physical-chemical properties

4.4.1 Limit for hazardous substances of PVC artificial leather of finished-product is tested according to the provisions of GB 21550.

4.4.2 Tensile strength, peeling strength, tearing strength and anti-yellowing of finished-product are tested according to the provisions of GB/T 8949.

4.4.3 Flexing endurance of finished-product is tested according to the provisions of QB/T 2714, and use dry samples.

4.4.4 Anti-blocking of finished-product is tested according to the provisions of Appendix A.

4.4.5 Alkali solution hydrolysis fastness of finished-product: prepare 3 samples of size 4cmX6cm. Place the test sample and a certain amount of sodium hydroxide solution -- temperature $(23 \pm 2) ^\circ\text{C}$, concentration of 5% -- together into a flat-bottom glass container; immerse it for 24h at room temperature. If necessary, add additional mass to the test sample in order to immerse the test sample in the solution completely. Take out the sample from the solution. Rinse it thoroughly with deionized water. Observe the erosion cracking of the surface and the separation of outside-inside layers after drying at room temperature.

4.4.6 Other physical-chemical properties are tested according to the provisions of GB/T 21294, in which the main types of artificial leather coatings shall be tested in accordance with the provisions of GB/T 6040.

4.4.7 The test items which do not mention the sampling location are according to the needs to select the sample from the finished-product.

5 Inspection classification rules

5.1 Inspection classification

5.1.1 Finished-product inspection is divided into factory inspection and type inspection.

5.1.2 Factory inspection is according to the provisions of Chapter 3 (except 3.10). Factory inspection rules of finished-product are according to the provisions of FZ/T 80004.

Sample 20 pieces for 500 to 1000 pieces (including 1000 pieces).

Sample 30 pieces for more than 1000 pieces.

Sampling for physical-chemical properties will sample at least 4 pieces according to the items.

5.4 Decision rules

5.4.1 Appearance determination for single piece (sample)

Top-grade product: Serious defects = 0 Heavy defects = 0 Light defects ≤ 4

First-grade product: Serious defects = 0 Heavy defects = 0 Light defects ≤ 7 or

 Serious defects = 0 Heavy defects ≤ 1 Light defects ≤ 3

Qualified product: Serious defects = 0 Heavy defects = 0 Light defects ≤ 8 or

 Serious defects = 0 Heavy defects ≤ 1 Light defects ≤ 6

5.4.2 Batch determination

If one item or above is not qualified according to physical-chemical properties, the sampled batch is not qualified.

Top-grade product batch: in sample appearance, the number of top-grade product is more than 90%, the number of first-grade and qualified products is less than 10%. Physical-chemical properties test can achieve the index requirements of top-grade product.

First-grade product batch: in sample appearance, the number of first-grade product or above is more than 90%, the number of qualified product is less than 10% (excluding non-qualified product). Physical-chemical properties test can achieve the index requirements of first-grade product.

Qualified product batch: in sample appearance, the number of qualified products or above is more than 90%, the number of non-qualified product is less than 10% (excluding non-qualified products of serious defects). Physical-chemical properties test can achieve the index requirements of qualified product.

When the determination of appearance sewing quality is inconsistent with the determination of physical-chemical properties, determine it according to the low grade.

5.4.3 Determination number qualified

In the sampling test, when the determination number of each batch conforms to the above provisions, the corresponding-grade products can leave factory.

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