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Polyester filament embroidery threads

涤纶长丝绣花线

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Polyester filament embroidery threads

1 Scope

This Standard specifies classification, requirements, grading rules, test methods, acceptance rules as well as packaging, marks, storage and transportation for polyester filament embroidery threads.

This Standard is applicable to polyester filament embroidery threads.

2 Normative references

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

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

GB/T 251, *Textiles - Tests for colour fastness - Grey scale for assessing staining*

GB/T 3916, *Textiles - Yarns from packages - Determination of single-end breaking force and elongation at break*

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 4743-2009, *Textiles - Yarn from packages - Determination of linear density (mass per unit length) by the skein method*

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

GB/T 6152-1997, *Textiles - Tests for colour fastness - Colour fastness to hot pressing*

GB 18401, *National general safety technical code for textile products*

The test method of linear density is carried out according to procedure 3 in GB/T 4743-2009. The linear density deviation rate is calculated according to formula (1). The result retains 2 significant digits.

$$D_T = \frac{T_t - T_0}{T_0} \times 100 \quad \dots\dots\dots (1)$$

Where,

D_T - Linear density deviation rate, %;

T_t - Actual linear density, in tex;

T_0 - Nominal linear density, in tex.

6.2 Tests of single thread breaking strength and variation coefficient of single thread breaking strength

According to GB/T 3916.

6.3 Length test

6.3.1 The length measuring device used for length test shall meet the requirements of GB/T 4743.

6.3.2 When testing the length, the pre-tension of single thread is (0.5 ± 0.1) cN/tex.

6.3.3 When the sample is on the length gauge, after every 100m, it shall be set aside and then continue shaking until all is done. If it is less than 1m long, use a meter ruler to measure, to the nearest of 0.01m.

6.3.4 The measured length shall be expressed as the arithmetic average of all test values of the sample. Round the calculation result to one decimal place.

6.4 Test of color fastness to soaping

According to the provisions of test method C (3) in GB/T 3921-2008.

6.5 Test for color fastness to rubbing

According to GB/T 3920.

6.6 Test of color fastness to heat pressing

According to dry press at a temperature of $(150 \pm 2)^\circ\text{C}$ in GB/T 6152-1997.

6.7 Test method for the number of knots

7.2 Evaluation of results

7.2.1 The internal quality shall meet the requirements of 4.2 and 4.3. If there is any non-conformity in the inherent quality, the same quantity of products can be re-inspected. The re-inspection result is the final result of the batch of products.

7.2.2 The appearance quality shall meet the requirements of 4.4. If the appearance quality does not meet the rate of 5% or less, the products that do not meet the requirements shall be replaced on site. When the non-conformity rate exceeds 5% and does not exceed 7%, one re-inspection is allowed. If it still exceeds 5% after re-inspection, then this batch of finished products shall be rearranged. Only the products that pass the re-inspection shall be allowed to leave factory. If the non-conformity rate exceeds 7%, the product will be returned.

8 Packaging, marks, storage and transportation

8.1 Packaging

Products are packed in boxes according to different colors, varieties, specifications, batch numbers and grades. Mixed packing is prohibited.

8.2 Marks

8.2.1 The marks on the packaging shall be specific, clear, complete with items, easy to identify, according to GB 5296.4.

8.2.2 The mark shall indicate that the product meets the category of GB 18401.

8.3 Transportation

The product shall be tightly covered during transportation. The product cannot be exposed to rain, moisture, sun exposure and high temperature to prevent deterioration.

8.4 Storage

Products shall be stacked in a dry, clean and ventilated place. And keep them at a distance of 5cm or more from the foundation and 10cm or more of space. Do a good job of ventilation and moisture dissipation to prevent moisture.

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