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**Polyvinyl chloride artificial leather**

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# Polyvinyl chloride artificial leather

## 1 Scope

This standard specifies the product classification, requirements, test methods, inspection rules and marking, packaging, transportation, storage of polyvinyl chloride artificial leather.

This standard applies to the polyvinyl chloride artificial leather, which is made of plain weave or twill fabric as the base, by adding plasticizers and other additives to the polyvinyl chloride resin, through calendering or coating.

This standard does not apply to knitted cloth-based polyvinyl chloride artificial leather.

## 2 Normative references

The provisions in following documents become the provisions of this Standard through reference in this Standard. For the dated references, the subsequent amendments (excluding corrections) or revisions do not apply to this Standard; however, parties who reach an agreement based on this Standard are encouraged to study if the latest versions of these documents are applicable. For undated references, the latest edition of the referenced document applies.

GB/T 250-2008 Textiles - Tests for colour fastness - Grey scale for assessing change in colour

GB/T 1040.3-2006 Plastics - Determination of tensile properties - Part 3: Test conditions for films and sheets

GB/T 1539-2007 Paperboard - Determination of bursting strength

GB/T 2828.1-2003 Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 2918-1998 Plastics - Standard atmospheres for conditioning and testing

GB/T 3920-2008 Textiles - Tests for colour fastness - Colour fastness to rubbing

GB 7565-1987 Textiles - Tests for colour fastness - Specification for standard adjacent fabric - Cotton and viscose

GB/T 8808-1988 Test method for peel force of flexible laminated plastics

- a) Measuring force: 0.8 N ~ 1.5 N;
- b) Probe diameter: 7 mm ~ 10 mm;
- c) Division value: 0.01 mm.

#### **5.4.2 Test procedure**

Along the width direction of the product, use a dial gauge thickness gauge to measure 3 points of left, middle, right. The measurement result is expressed as an arithmetic mean, accurate to 0.01 mm.

#### **5.5 Length**

Use a suitable measuring tool or instrument, to make measurement; the result is accurate to 1 cm.

#### **5.6 Appearance**

Carry out visual inspection under natural light; make measurement with a corresponding gauge.

#### **5.7 Tensile load and elongation at break**

Carry out in accordance with the provisions of GB/T 1040.3-2006. Use the type 2 specimens; the distance between the marking lines of the specimens is 100 mm; the tensile speed is 200 mm/min.

#### **5.8 Tear load**

Cut 75 mm, parallel to the length direction, at the centerline of the width of the specimen. Clamp the two cut ends, in opposite directions, on the grips of the tensile testing machine, which is specified in 5.7. Carry out the test, at a speed of 200 mm/min. Record the maximum tear load of the specimen. The test result is expressed as the arithmetic mean of 3 specimens, in the warp and weft directions, accurate to 0.1 N.

#### **5.9 Peeling off load**

It is carried out, according to the provisions of GB/T 8088-1988.

#### **5.10 Surface color fastness**

It is carried out, according to the provisions of GB/T 3920-2008, wherein the standard lining fabric for friction shall comply with the provisions of GB/T 7565-1987; the test results shall be evaluated, according to the provisions of GB/T 250-2008.

#### **5.11 Cold resistance**

that the top end is in contact with the screw, AND the fold line is flush with the bottom edge of the clamp. Then fold the other end of the specimen inward; insert it into the lower clamp. Then adjust the temperature in the chamber to  $(-10 \pm 2) ^\circ\text{C}$ . When the counter reaches 30000, stop the test. Observe the change of the folded part. Take the worst test data as the test result.

## **5.16 Rub resistance**

### **5.16.1 Test instruments**

Scott-type rubbing tester.

### **5.16.2 Test procedure**

Overlap the 2 specimen cloth surfaces with each other, in the same direction. Then load it into the rubbing tester's clamp, which has a clamp spacing of 30 mm. Gradually reduce the distance between the clamps, so that the cloth surfaces of the 2 specimens are in light contact. Then apply a load. Reduce the distance, until the load is 9.8 N. Under the conditions of a frequency of 120 times/min and a stroke of 50 mm, make 1000 reciprocations, to observe whether there are cracks, damage or separation of the cloth base and the coating, on the surface of the artificial leather. If there is one specimen with the above phenomenon, the rub resistance of the specimen is judged to be unqualified.

## **5.17 Light fastness**

It is carried out, in accordance with the provisions of QB/T 2727-2005. The exposure method adopts method 3; the most serious discoloration degree, among the 3 specimens, is recorded as the final discoloration and fading grade.

## **5.18 Vulcanization**

Immerse the specimen in a saturated aqueous solution of hydrogen sulfide, that has been flowing with hydrogen sulfide gas for 5 minutes. Then take out the specimen. Immediately use water to rinse it clean. Judge the discoloration grade of the specimen, according to the provisions of GB/T 250-2008.

## **5.19 Adhesion**

### **5.19.1 Instruments**

Constant temperature oven, which is equipped with blower.

### **5.19.2 Test procedure**

Attach the polyvinyl chloride coating surfaces of the 2 specimens, to each other. Use 2 pieces of smooth glass, which has a length and width of about 60 mm, to align them with the width of the specimen. Then sandwich the specimen, in between the 2 pieces

of glass. Then use a weight, which has a bottom length and width of 60 mm and a load of 30 N, to press on the glass plate. Place them together, in a constant temperature oven, at  $(70 \pm 2) ^\circ\text{C}$ . Take them out after 24 h. Remove the weight. Cool it at room temperature for 1 h. Then slowly peel off the 2 specimens. Observe whether there is any abnormality, such as damage on the film surface.

## **6 Inspection rules**

### **6.1 Inspection classification and items**

#### **6.1.1 Exit-factory inspection**

The exit-factory inspection items are the items in 4.1, 4.2, 4.3.1 in the requirements.

#### **6.1.2 Type inspection**

Type inspection shall be carried out, in one of the following situations:

- a) When the type-finalization of new products or old products after transplant production;
- b) After formal production, if there are major changes in structure, material, process, which may affect the performance of the product;
- c) When the normal production lasts more than three months;
- d) When the production is resumed, after suspension for more than three months, for some reason;
- e) When there is a big difference, between the exit-factory inspection results and the last type inspection;
- f) When the national quality supervision and inspection agency puts forward the requirements for type inspection.

The items of type inspection are all the items, as specified in this standard.

### **6.2 Exit-factory inspection**

#### **6.2.1 Group-batching and sampling**

##### **6.2.1.1 Group-batching**

Artificial leather shall be checked and accepted in batches. Products of the same cloth base, same color, same pattern, same specification are one batch. The quantity of each batch shall not exceed 15000 m.

qualified. If there are unqualified items, the batch of products will be judged as unqualified.

### **6.3 Type inspection**

#### **6.3.1 Sampling**

A roll is randomly selected from the products, that have passed the exit-factory inspection, for the inspection of appearance and specifications. The 1 m is taken, for the inspection of physical-mechanical properties.

#### **6.3.2 Judgment rules**

Specifications and appearance shall be carried out, in accordance with the provisions of 4.1 and 4.2. If it is not qualified, 3 rolls shall be re-selected randomly from the original product, for re-inspection. If the re-inspection results are all qualified, the specification and appearance are judged to be qualified.

If any of the physical-mechanical properties test results are unqualified, it shall re-take double quantity of samples from the original product, for re-inspection of the unqualified items. If the reinspection results are all qualified, the physical-mechanical properties are unqualified.

If the inspection results of all items are qualified, the type inspection is judged to be qualified.

## **7 Marking, packaging, transportation, storage**

### **7.1 Marking**

Each roll of product shall be accompanied by a certificate of conformity AND have the following marks:

- a) The name and address of manufacturer;
- b) The product name;
- c) The product category;
- d) The product specifications (thickness, width, length, color, pattern, etc.);
- e) The production date and production batch number;
- f) The trademarks;
- g) The product standard number implemented;

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