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# GB

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## **Polyurethane dry-processing artificial leather**

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# Polyurethane dry-processing artificial leather

## 1 Scope

This Standard specifies the product classification, requirements, test method, inspection rule and marking, packaging, transportation, and storage of polyurethane dry-processing artificial leather.

This Standard is applicable to the polyurethane dry-processing artificial leather, of which knitted fabric base and woven fabric base are used as the base.

## 2 Normative references

The terms in the following documents become the terms of this Standard by reference to this Standard. For dated references, all subsequent amendments (not including errata content) or revisions do not apply to this standard. However, parties to agreements that are based on this Standard are encouraged to study whether the latest versions of these documents can be used. For undated references, the latest edition applies to this Standard.

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

GB/T 1040.1-2006, Plastics - Determination of tensile properties - Part 1: General principles

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

- C -- peeling load sample (length 150 mm, width 30 mm);
- D -- surface color fastness sample (length 220 mm, width 60 mm);
- E -- anti-blocking sample (length 60 mm, width 60 mm);
- F<sub>1</sub> -- flex resistance (normal temperature) sample (length 70 mm, width 45 mm);
- F<sub>2</sub> -- flex resistance (low temperature) sample (length 70 mm, width 45 mm);
- G -- cold resistance sample (length 60 mm, width 20 mm);
- H -- rubbing resistance sample (length 120 mm, width 30 mm);
- I -- bursting strength sample (length 100 mm, width 100 mm);
- J -- discoloration sample (length 60 mm, width 90 mm).

### **Figure 1 -- Sample preparation diagram**

## **5.3 Thickness**

### **5.3.1 Instruments**

The dial indicator thickness gauge shall meet the following requirements:

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

### **5.3.2 Test procedure**

Use a dial indicator thickness gauge to measure 3 points, left, middle, and right, along the width direction of the product. The measurement result is expressed as an arithmetic average, accurate to 0.01 mm.

## **5.4 Width**

Use a steel tape or a meter whose accuracy is 1 mm to measure 3 points arbitrarily along the length direction. Take the minimum one as the result, accurate to 1 mm.

## **5.5 Length**

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

## **5.6 Appearance**

**5.9.3.3** If the coating of the sample and base cloth cannot be peeled off by hand, the peeling load of the sample is qualified. If all the set of samples cannot be peeled off, the test result of the item is qualified.

## **5.10 Surface color fastness**

Perform it according to the provisions of GB/T 3920-2008; the standard lining fabric for friction shall meet the provisions of GB/T 7565-1987. The test results are evaluated according to GB/T 250-2008.

## **5.11 Anti-blocking**

### **5.11.1 Instruments**

Constant temperature oven with a blower device.

### **5.11.2 Test procedure**

Take 6 samples, namely 3 groups of coating and coating pairs. Clamp the 3 groups of samples in two glass clamping pieces of 60 mm × 60 mm × 3 mm; press a weight of 10 N on the clamping pieces; put them in the constant temperature oven with a blower device at a temperature of  $(80 \pm 2) ^\circ\text{C}$ ; after 3 hours of constant temperature, take out the samples; place them at room temperature for 30 min; then, uncover the paired samples by hand.

### **5.11.3 Test result**

The test result is judged according to the following method.

Grade 5: they can be peeled off gently.

Grade 4: they can be peeled off with a little force.

Grade 3: they can be peeled off with a certain amount of force; the surface is not damaged.

Grade 2: they can be peeled off under gravity; there is incomplete peeling.

Grade 1: they cannot be peeled off.

Take the lowest value of the three groups of samples as the test result.

## **5.12 Flex resistance**

Perform according to the provisions of QB/T 2714-2005.

## **5.13 Cold resistance**

Determine the test result according to the provisions of Chapter 8 in HG/T 3689-2001.

## **6 Inspection rules**

### **6.1 Batch**

The products shall be checked and accepted in batches. Products of the same raw material, same specification and same process shall be one batch; the quantity of each batch shall not exceed 15 000 m.

### **6.2 Delivery inspection**

The factory inspection items are all items in 4.1, 4.2 and Table 6.

### **6.3 Type inspection**

The type inspection items are all items in 4.1, 4.2, Table 6, and Table 7.

In any of the following cases, perform the type inspection:

- a) Trial production appraisal of new products or old products that are transferred to another factory for production;
- b) After formal production, when there are big differences in structure, materials, and technology;
- c) After 12 months of normal production;
- d) Reproduction after halt production for more than 6 months;
- e) When the factory inspection result is significantly different from the previous type inspection.

### **6.4 Sampling**

For the inspection of specifications and appearance, adopt the one-time normal sampling plan, of which the general inspection level is I and the acceptance quality limit AQL is 6.5, that is specified in GB/T 2828.1-2003. The batch, sample, and judgment group are shown in Table 9; for the physical and mechanical properties, a roll is randomly selected from each batch for inspection.

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