

Translated English of Chinese Standard: FZ/T01085-2009

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TEXTILE INDUSTRY STANDARD OF
THE PEOPLE'S REPUBLIC OF CHINA

ICS 59.080.01

W 10

FZ/T 01085-2009

Replacing FZ/T 01085-2000

Testing method for adhesion for fusible interlinings

热熔粘合衬剥离强力试验方法

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Issued on: January 20, 2010

Implemented on: June 1, 2010

**Issued by: Ministry of Industry and Information Technology of the
People's Republic of China.**

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Foreword

This Standard substitutes FZ/T 01085-2000 *Method of adhesion test for fusible interlinings*. Compared with FZ/T 01085-2000, the major changes in this Standard are as follows:

- CHANGE the standard name into *Testing method for adhesion for fusible interlinings*;
- ADD the definition of peeled off length and the method for calculation of adhesion;
- ADJUST the contents of “Equipment and appliances”;
- ADD the processing principles of preliminary test and nonconformity test for the adhesion testing procedures;
- ADJUST the Chapter 7 “Testing procedures” in the previous edition to Chapter 7 “Operating procedures” and Chapter 8 “Calculation of results” in this edition; and
- ADJUST the Chapter 8 “Test report” in the previous edition to Chapter 9 “Test report” in this edition.

This Standard was proposed by China National Textile and Apparel Council.

This Standard shall be under the jurisdiction of the Technical Subcommittee of Cotton Textile Printing and Dyeing of the National Technical Committee for Standardization of Textiles.

Drafting organizations of this Standard: Shanghai Textile Industry Institute of Technical Supervision, China Nonwovens & Industrial Textiles Association, Shanghai Tianyang Hotmelt Adhesives Co., Ltd, Nantong Haihui Garment Accessories Co., Ltd, Anhui Runwei Non-woven Cloth Co., Ltd, Shaoxing Rongshida Interlining Co., Ltd, and Shanghai Garment Research Institute.

Main drafters of this Standard: Zhang Baoqing, Li Guimei, Li Zhelong, Cao Ping, Zhu Guangming, Tang Guohua and Chen Lu.

The previous released editions of the standards substituted by this Standard are as follows:

- GB/T 11402-1989, FZ/T 01085-1999, FZ/T 01085-2000.

Testing method for adhesion for fusible interlinings

1 Scope

This Standard specifies the testing method for adhesion after fusible interlinings are bonded with garment fabrics.

This Standard **is applicable to** the determination of adhesion for the fusible interlinings using woven fabrics, knitted fabrics and nonwovens of various materials as base fabrics.

2 Normative references

The provisions in the following documents become the provisions of this Standard through reference in this Standard. For 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 editions of these documents are applicable. For undated references, the latest editions apply to this Standard.

GB/T 6529 *Textiles - Standard atmospheres for conditioning and testing*

GB/T 8170 *Rules of rounding off for numerical values & expression and judgement of limiting values*

FZ/T 01076 *Making method of composite specimen of fusible interlinings for garments*

FZ/T 01083 *Testing method for surface appearance and dimensional change on dry cleaning for fusible interlinings*

FZ/T 01084 *Testing method for surface appearance and dimensional change after washing for fusible interlinings*

3 Terms and definitions

The following terms and definitions are applicable to this Standard.

3.1 Adhesion

fabric.

6.3.2 When pressing the sample with a flat-plate press machine, PLACE the interlining sample underneath, with the side coated with hot melt adhesive facing up, covered with the standard fabric. The standard fabric shall be consistent with the machine and cross-machine (longitudinal and transverse) directions of the interlining sample.

6.4 PRESS the composite sample according to the pressing conditions specified in FZ/T 01076. Carefully REMOVE after slight cooling. PLACE in the standard atmosphere specified in GB/T 6529 for 4-hour equilibrium.

7 Operating procedures

7.1 An about 50mm gap was manually peeled off at the end of the sample, and the peeling points were kept on the same straight line.

7.2 The distance between the upper and lower clamps of the tensile testing machine was adjusted to 50mm, and the traction speed to 100mm/min \pm 10mm/min.

7.3 Preliminary test: Appropriate adhesion range was selected through a few preliminary tests. For products with empirical data, the forecasting procedure can be exempted.

7.4 Official test: The standard fabric end and the interlining sample end in one end of the prepared sample were sandwiched by the two clamps of the tensile machine, respectively, so that the peeled off line was located at one half of the two clamps and the lengthwise direction of the sample was perpendicular to the clamps. The tensile machine was then started, along with data acquisition after 5s. Each peak within the peeled off length of 100mm was recorded.

7.5 The clamps returned to the starting position. REMOVE the sample, and REPEAT another group of sample tests according to the Subclauses 7.1 to 7.3. A total of five groups of samples were tested. CALCULATE the mean value of the five test results.

7.6 Adhesion test after dry cleaning or washing: The remaining five unpeeled composite samples were washed and dried as specified by FZ/T 01083 or FZ/T 01084, were then conditioned as specified by GB/T 6529, and were conducted with the adhesion test according to the procedures 7.1 to 7.5 in this Standard. CALCULATE the mean value of the five adhesion test results after washing or dry cleaning afterwards.