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INDUSTRY STANDARD

OF THE PEOPLE'S REPUBLIC OF CHINA

QB/T 4329-2012

Cloth shoes

布 鞋

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Foreword

This Standard was drafted according to the rules given in GB/T 1.1-2009.

This Standard replaces SG 169-1984, FZ/T 82001-1991, FZ/T 82003-1993 and FZ/T 82004-1999.

Compared with SG 169-1984, FZ/T 82001-1991, FZ/T 82003-1993 and FZ/T 82004-1999, the main changes of this Standard are as follows:

- Change the standard name;
- Extend the scope of application;
- Revise the description methods of technical requirements;
- Add and deleted the items of organic inspection;
- Revise the indicators of physical and mechanical;
- Add the requirements for shanks;
- Revise the description methods of inspection rules.

This Standard was proposed by China National Light Industry.

This Standard shall be under the jurisdiction of National Technical Committee 305 on Footwear of Standardization Administration.

Draft organizations of this Standard: Yantai Rongshun Footwear Industry Co., Ltd, Beijing Neiliansheng Footwear Industry Co., Ltd., and China Leather and Footwear Industry Research Institute.

The historical versions replaced by this Standards are:

- SG 169-1984, FZ/T 82001-1991, FZ/T 82003-1993, and FZ/T 82004-1999.

Cloth shoes

1 Scope

This Standard specifies classification, requirements, test methods, inspection regulations and sign, packing, transportation, storage of cloth shoes.

This Standard is applicable to footwear which adopts textile and knitwear as the main upper materials; and which adopts gluing, sewing, mold pressing, vulcanizing, and injection molding as the process.

The standard is not applicable to the cloth footwear and cloth rubber shoes for safety and protection.

2 Normative References

The articles contained in the following documents have become part of this Standard when they are quoted herein. For the dated documents so quoted, all the modifications or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

- GB/T 251 Textiles - Tests for Color Fastness - Grey Scale for Assessing Staining
- GB/T 2703 Technical Terms for Leather Shoes Industry
- GB/T 2912.1-2009 Textiles - Determination of Formaldehyde - Part 1: Free and Hydrolized Formaldehyde (Water Extraction Method)
- GB/T 3293 Chinese last Systems
- GB/T 3293.1 Shoes Sizes
- GB/T 3903.1-2008 Footwear - General Test Methods - Flexing Resistance
- GB/T 3903.2-2008 Footwear - General Test Methods - Abrasion Resistance
- GB/T 3903.3-2011 Footwear - General Test Methods - Peeling Strength
- GB/T 3903.4-2008 Footwear - General Test Methods - Hardness
- GB/T 3903.5-2011 Footwear - General Test Methods - Appearance Quality
- GB/T 6677 Classification of cloth shoes
- GB/T 17592-2006 Textiles - Determination of the Banned Azo Colourants

GB/T 19941-2005 Leather and Fur - Chemical Tests - Determination of Formaldehyde Content

GB/T 19942-2005 Leather and Fur - Chemical Tests - Determination of Banned Azo Colourants

GB 20400 Leather and Fur - Limit of Harmful Matter

QB/T 1187 Regulations for Acceptance, Labeling, Packaging, Transportation and Storage

QB/T 2673 Footwear - Specification of Marking

QB/T 2882-2007 Footwear - Test Methods for Uppers Linings and Insocks - Colour Fastness to Rubbing

QB/T 4108-2010 Metal Accessories for Footwear

QB/T 4340-2012 Footwear - Chemical Test Method - Determination of Total Heavy Metal Content - Inductively Coupled Plasma Atomic Emission Spectrometry Method

3 Terms and Definitions

For the purpose of this Standard, the following terms and definitions as well as those defined in GB/T 2703 apply.

3.1

Infants' cloth shoes

The cloth shoes with size less than 170mm. They are for the infants aging 3 years old and younger.

3.2

Children's cloth shoes

The cloth shoes with size more than 250mm. They are for children aging 3 to 14 years old.

3.3

Primary parts

Generally it refers to the parts such as upper exterior, front part, counter, and toe-box.

3.4

Subsidiary parts

Generally it refers to the uppers interior, and back-part.

3.5

Low upper footwear

The footwear of which the quarter is lower than anklebone.

4 Classifications

It is classified according to the provisions of GB/T 6677.

5 Technical requirements

5.1 General requirements

5.1.1 The sizes of shoes shall comply with the requirements of GB/T 3293.1.

5.1.2 The sizes of shoes-last shall comply with the requirements of GB/T 3293. For those footwear that are explicitly indicated as complying with GB/T 3293, it is deemed as complying with the provisions of this clause.

Note: The enterprise shall reasonably apply GB/T 3293. If it does not comply with it, it must not indicate complying with the standard. Generally, the Quality Inspection Testing Organization does not take the responsibility to identify the conformity with the standard.

5.1.3 Marks shall comply with the requirements of QB/T 2673.

5.1.4 Materials adopted by the shoes shall comply with the requirements of corresponding product standards. For example, leather and fur shall comply with GB 20400; metal ornaments, fasteners and fittings shall comply with the requirements of QB/T 4108-2010.

5.1.5 It must not have such defects which may affect the wearing.

5.2 Sensory quality

The requirements for sensory quality shall comply with provisions of Table 1. In which, the items 1 - 5 and the serious defect items are the main items; others are subsidiary items.

Table 1 The requirements for sensory quality

Serial No.	Item	Superior Product	Qualified Product
1	Overall appearance	The whole footwear shall be upright, smooth, clean and symmetrical. The innersole shall not show the nail point and the nail tail shall not protrude. There is no obvious color difference on the upper and lining; and the shoes-pad shall be secure and smooth. There are no obvious sensory defects. The height of glue mark on the seam allowance shall be not more than 3mm. There shall not be sharp tips and edges on shoes for infants and children.	

5.3.5.2 Indicators of heel hardness of molding sole are shown in Table 6.

Table 6 Heel hardness of molding sole

Heel height	Indicators / Shore A
<25 mm	—
25 mm - 50 mm	≥55
>50 mm	≥75

5.4 Safety performance indicators

5.4.1 Steel shank

5.4.1.1 This is applicable for heel height more than 20 mm and heel mouth more than 8 mm.

5.4.1.2 Steel shank shall comply with the provisions of GB 28011-2011.

5.4.2 Content of decomposable carcinogenic aromatic amine dyes

Indicators of content of decomposable carcinogenic aromatic amine dyes are shown in Table 7.

Table 7 Content indicators of decomposable carcinogenic aromatic amine dyes

Unit: milligrams per kilogram

Item	Content index
Textile ^a	≤20
Leather ^a	≤30

^a It refers to Appendix A for unallowable decomposition carcinogenic aromatic amines list in dyes, under reducing conditions.

5.4.3 Free or partially hydrolyzed formaldehyde content

5.4.3.1 For infants' cloth shoes, it is Class A. For other footwear products, materials directly contacting with feet are Class B; those not contacting with feet are Class C.

5.4.3.2 Content indicators of free or partially hydrolyzed formaldehyde are shown in Table 8.

Table 8 Content indicators of free or partially hydrolyzed formaldehyde

Unit: milligrams per kilogram

Item	Content index
Class A and Class B	≤75
Class C	≤300

5.4.4 Total content of heavy metals

5.4.4.1 This is applicable for infants' and children's cloth shoes.

5.4.4.2 Total content indicators of heavy metals in infants' and children's cloth shoes: Arsenic is not more than 100 mg/kg; lead is not more than 100mg/kg; and cadmium is not more than 100 mg/kg.

5.5 After-sales quality judgment

See Appendix B.

5.6 Selection guide for main raw and auxiliary materials of hand-sewn cloth shoes

See Appendix C.

6 Test methods

6.1 Sensory quality

Inspect according to GB/T 3903.5-2011

6.2 Upper-sole peeling strength

Inspect according to GB/T 3903.5-2011. Cutting width is 20mm.

6.3 Folding resistant performance of finished shoes

Inspect according to GB/T 3903.1-2008. Continuous fold for 40000 times.

6.4 Wear-resisting performance of outsole

Inspect according to GB/T 3903.2-2008.

6.5 Friction-resisting color fastness of lining and inner pad

6.5.1 Take lining and inner pad materials as the samples. If there is no lining, take the contact surface between the upper and feet as the lining to test. If it cannot sample from the finished shoes, the same material can be used to test.

6.5.2 Wet-rub for 50 times to inspect according to the method A in QB/T 2882-2007.

6.6 Heel hardness of molded sole

Inspect according to GB/T 3903.4-2008.

6.7 Steel shank

Inspect according to GB 28011-2011.

6.8 Content inspection of decomposable carcinogenic aromatic amine dyes in textile

6.8.1 Lining and upper is shall be tested separately. Different materials are tested separately too. If the lining and upper cannot be separated, detect them together, and the detection method shall be according to the lining material.

6.8.2 Inspect textiles according to GB/T 17592-2006. The detection limit is 5mg/kg.

6.9 Content inspection of decomposable carcinogenic aromatic amine dyes in leather

The sample preparation is same as 6.8.1. Inspect according to GB/T 19942-2005. The detection limit is 30mg/kg.

6.10 Content inspection of methanol in textile

The sample preparation is same as 6.8.1. Inspect according to GB/T 2912.1-2009.

6.11 Content inspection of methanol in leather

The sample preparation is same as 6.8.1. Inspect according to GB/T 19941-2005.

6.12 Total content inspection of heavy metals

Inspect according to QB/T 4340-2012.

7 Inspection items and qualified judgment

7.1 The inspection items shall comply with provisions of Table 9.

Table 7 Inspection items [Translator: This should be Table 9]

Inspection item	Ex-factory inspection items	Type-inspection item	Requirement	Test method
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- c) If there is 1 or more than 1 unqualified-item of general requirements or physical and mechanical properties; or 1 or more than 1 unqualified-item of main items in sensory quality; or more than 2 unqualified-items of subsidiary items; or 1 or more than 1 item of safety performances that does not comply with this Standard, the product is judged as unqualified.

8 Inspection rules, signs, packing, transportation and storage

Inspecting rules, signs, packaging, transportation, storage are executed according to QB/T 1187.

Annex B

(Informative)

After-sales quality judgment

B.1 After-sales service deadline

It can be determined by enterprises according to product grades. And it shall be clearly indicated in the after-sales service provisions.

B.2 After-sales quality judgment

Following problems can be judged as quality problems, under the normal wear within after-sales service deadline.

- a) It does not meet the quality requirements of qualified products in product standards;
- b) Upper is crack; upper feet area is break or crack; serious hoarfrost; decolorization; coating layer is chipped or cracked; upper contacts to ground and wears off;
- c) Split thread and chip.
- d) Counter or toe-box is deformed;
- e) Heel is deformed, cracked, broken or fall-off. Heel surface is detached;
- f) Shank is soft, broken or loosen;
- g) Obvious decolorization of lining and it pollutes the socks;
- h) Outsole or insole is cracked, broken, or it is uneven and affects the wear;
- i) Foxing is chipped and broken;
- j) Protruded nail (head) in shoes, it is uneven in shoes and affects the wear.

B.3 Inspection methods

B.3.1 Sensory inspection is conducted according to the provisions of GB/T 3903.5.

B.3.2 Decolorization: TAKE the white absorbent cotton or gauze sucked with clear water (based on there is no drip with finger press). USE hand to softly press within 10cm length at inner side of upper. Repeatedly RUB for 10 times. OBSERVE the absorbent cotton or gauze. It must not have obvious pollution.

B.4 Treatment methods

It can be processed according to the after-sales service provisions formulated by the enterprise or according to the unified provisions of the local sales organization.

Annex C
(Informative)

Selection guide for main raw and auxiliary materials of hand-sewn cloth shoes

C.1 Selection guide of main raw materials and auxiliary materials of hand-sewn cloth shoes is shown in Table C.1.

Table C.1

Item	Material name
Vamp and inner-shoes	Cotton, linen, silk, wool, synthetic fabrics, felt and velvet, leather, etc.
Shoes lining	Cotton cloth, vinyl cotton cloth, Gebei, cotton, felt, or brown velvet, fur (wool)
Upper string	No. 14 (42 branches) 3 strands, No. 18 (32 branches) 3 strands of cotton or waxed string No. 9.8 (60 branches) 3 strands of polyester string, No. 19.5 (30 branches) and above string
Donato string	No. 14 (42 branches) 3 strands, No. 18 (32 branches), No. 19.5 (30 branches) 3 strands of cotton or waxed string
Sole-fixing and sole string	6 strands ramie strings and 7 strands ramie
Sole	Cloth: yarns density is 10 × 10, cotton content is not less than 60% of white cloth Leather, etc.

————— **END** —————