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**TEXTILE INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

FZ/T 01110-2020

**Testing method for adhesive penetration of interlining after
pressing**

粘合衬粘合压烫后的渗胶试验方法

(English Translation)

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces FZ/T 01110-2011 "Test Method for Penetration of Adhesive Interlining after Bonding and Pressing". Correspond to FZ/T 01110-2011 the main technical changes are as follows.

---Adjusted the standard range;

---Adjusted the principle (see Chapter 3);

---In the equipment and utensils, the pressing machine (see 4.1, 2011 edition of 4.1), thermometer (see 4.2, 2011 edition of 4.2), measuring tools have been adjusted (See 4.4, 4.5 in the 2011 edition), thin tissue paper (see 4.6, 4.3 in the 2011 edition);

---Added the requirements for the test of backside bleeding to thin tissue (see 4.6b) and sample preparation (see 5.2), and adjusted the operation of backside bleeding Procedures (see 6.4, 2011 edition of 6.3.2) and the requirements of backside glue evaluation (see 7.2, 2011 edition of 7.2).

---Added laminated woven fusible interlining, enzyme washable nonwoven fusible interlining, fusible interlining for coated fabrics, woven fusible interlining for garment dyeing, the pressing conditions of weft knitted fusible interlining, elastic woven fusible interlining, hidden point woven fusible interlining, and hot melt film fusible interlining (see Table 1).

This standard was proposed by the China National Textile and Apparel Council.

This standard is under the jurisdiction of the Cotton Textile Subcommittee of the National Textile Standardization Technical Committee (SAC/TC209/SC10).

Drafting organizations of this standard. Webster Interlining (Nantong) Co., Ltd., Shanghai Textile Industry Technical Supervision Institute, Shanghai Tianyang Hot Melt Adhesive Materials Co., Ltd., Changxing Sanwei Hot Melt Adhesive Co., Ltd., Nantong Jianghuai Interlining Co., Ltd., Shenghe New Material Technology (Jiashan) Co., Ltd.

Division, China Industrial Textile Industry Association.

1 Scope

This standard specifies the test method for hot melt adhesive penetration after the adhesive interlining is bonded to the standard fabric.

This standard applies to fusible interlinings based on woven fabrics, knitted fabrics and non-woven fabrics.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article. For undated references, the latest version (including all amendments) applies to this document.

GB/T 6529 Standard atmosphere for textile humidity control and testing GB/T 8170 Numerical rounding rules and the expression and determination of limit values GB/T 19022 Measurement Management System Requirements for Measurement Process and Measurement Equipment FZ/T 01076 Fusible Lining Combination Sample Making Method FZ/T 01085 Test method for peel strength of adhesive lining

3 Principle

When using a continuous pressing machine or a flat-plate pressing machine to press the combined sample, the adhesive lining is heated under the specified temperature, pressure and time.

The penetration of melt adhesive on the front of the fabric or the back of the adhesive lining.

4 Equipment and utensils

4.1

Pressing machine. Comply with FZ/T 01076 regulations.

4.2

Thermometer. The range is 0~200°C, can measure the temperature of continuous or flat ironing machine, the maximum allowable error is 2°C.

4.3

Standard fabrics. comply with FZ/T 01076 regulations.

4.4

Steel ruler. in accordance with GB/T 19022, its length is greater than 200mm, and the graduation value is 0.5mm.

4.5

Cutting knife.

4.6

Thin tissue paper is divided into two types. thin tissue paper and hollow thin tissue paper according to the test requirements.

a) Thin cotton paper. Choose thin cotton paper that does not affect the test results after melting and pressing, the unit area mass is $15\text{g/m}^2 \sim 20\text{g/m}^2$, and the thickness $\leq 0.1\text{mm}$.

b) Hollow thin cotton paper. According to a), cut according to the shape and size of Figure 1. Among them, there are two rules for the width of thin cotton paper According to the width of the adhesive lining sample, choose as follows.

---The width of the adhesive lining sample is 70mm, the inner width of the thin tissue paper frame is $50\text{mm} \pm 0.5\text{mm}$, and the width of the paper frame is 70mm.

---The width of the adhesive lining sample is 45mm, the inner width of the thin tissue paper frame is $25\text{mm} \pm 0.5\text{mm}$, and the width of the paper frame is 45mm.