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FZ

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

FZ/T 54025-2009

Polyamide 66 pre-oriented yarn
(English Translation)

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1 Scope

This standard specifies the product classification and identification, technical requirements, test methods, inspection rules and marking, packaging, transportation, storage requirements of polyamide 66 pre-oriented yarn.

This standard is applicable to the quality identification, acceptance, arbitration of pre-oriented yarns (mainly used for processing elastic yarns) made of polyhexamethylene adipamide as raw materials, as well as glossy, semi-matte and full-matte yarns which have a nominal linear density range of 8 dtex ~ 167 dtex, a single yarn linear density of

1.0

dtex ~ 5.5 dtex, a circular cross-sectional shape.

2 Normative references

The clauses in the following documents become the clauses of this standard through reference in this standard. For all referenced documents with dates, all subsequent amendments (excluding errata) or revisions are not applicable to this standard. However, parties reaching an agreement based on this standard are encouraged to study whether the latest versions of these documents can be used. For all referenced documents without dates, the latest versions are applicable to this standard.

GB/T 2828.1-2003 Sampling procedures - Part 1. retrieval by acceptance quality limit (AQL) for lot-by-lot inspection sampling plan

GB/T 3291.1 Textiles - Terms of textile material properties and test - Part 1.Fiber and yarn

GB/T 3291.3 Textiles - Terms of textile material properties and test - Part 3.General

GB/T 4146.1 Textiles - Man-made fibres - Part 1.Generic names

GB/T 6502 Sampling method of man-made filament yarns

GB/T 6503 Testing method for moisture regain of man-made fibres

GB/T 6504 Testing method for oil content of man-made fibres

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

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

6.1.1.2.2 Test

- Temperature (20 ± 2) °C;
- Relative humidity $(65 \pm 2)\%$.

6.1.1.2.3 Others

Others shall be carried out in accordance with the provisions of GB/T 6529.

6.1.2 Sampling and specimen preparation

According to GB/T 6502, 20 laboratory samples are obtained and humidified under the conditions specified in 6.1.1.2.If the supplier and the purchaser have an agreement, the humidity can be adjusted according to the rapid humidity adjustment method in

Appendix B. Specimens exceeding the specified moisture regain need to be pre-humidified.

6.2 Linear density test

It is performed according to GB/T 14343.

6.3 Tensile property test

It is performed according to GB/T 14344.

6.4 Yarn uniformity test

It is performed according to GB/T 14346.

6.5 Oil content test

It is performed according to GB/T 6504.

6.6 Appearance inspection

Refer to Appendix A or it is performed according to the agreement between the supplier and the purchaser.

6.7 Numerical rounding

The data of the test results shall be processed according to the provisions of GB/T 8170; the decimal places shall be rounded as shown in Table 1.

7.1.1 Inspection items

7.1.1.1

Appearance inspection items refer to Appendix A or are inspected according to the requirements of both parties.

7.1.1.2

Physical performance items in Table 1 are all assessment items and are inspected according to the test methods specified in Chapter 6.

7.1.2 Group-batching rules

Periodic sampling is used to form inspection lots within a certain range. A production lot can be composed of one inspection lot or several inspection lots.

7.1.3 Sampling requirements

7.1.3.1

All appearance items are inspected. The appearance and barrel weight of the laboratory samples taken shall meet the corresponding grades.

7.1.3.2

Laboratory samples of physical performance items are taken for inspection according to GB/T 6502.

7.1.4 Comprehensive evaluation

7.1.4.1

Appearance inspection items are evaluated barrel by barrel, according to the requirements specified in Appendix A or the requirements of the supplier and purchaser.

7.1.4.2

The calculated values of each physical performance test item are compared with the limit values of the performance item indicators in Table 1, according to the rounding value comparison method in GB/T 8170, to evaluate the grade of each item.

7.1.4.3

The lowest grade of the physical performance items and appearance items in the inspection lot is finally determined as the grade of the batch of products.

7.2 Re-inspection rules

Within three months after a batch of products arrives at the consignee, it can be used for acceptance or re-submitted for reinspection where there is an objection to the quality.

If more than one-third of the batch of products are used, re-inspection shall not be applied. If the quality of the batch of products affects the quality of the post-processing products and causes serious losses, the supplier and the purchaser shall analyze the reasons, clarify the responsibilities, negotiate to deal with it. Damaged packages shall not be sampled.

7.2.1 Inspection items

Same as 7.1.1.

8 Signs

8.1

The product name, specification, grade as required by Chapter 4 shall be marked in eye-catching colors on both sides of the packaging box.

8.2

The identification mark of the producer includes the name of the manufacturer, batch number, net weight or gross weight, number of rolls inside, production date, implemented standard number, detailed address.

8.3

The sign of the general distributor includes the product name, trademark, identification mark, detailed address, etc.

8.4

The sign shall indicate requirements such as avoiding moisture and handle with care.