

ICS 59.080
CCS W 58

FZ

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

FZ/T 60027-2018

Replacing FZ/T 60028-2007; FZ/T 60027-2007

Testing method for sewing-ability of sewing threads

缝纫线可缝性测定方法 清晰版

(English Translation)

Issued on: April 30, 2018

Implemented on: September 1, 2018

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

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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 60027-2007 "Method for measuring the seamability of sewing thread", FZ/T 60028-2007 "Sewing thread seamability test" Special cotton belts, compared with FZ/T 60027-2007, FZ/T 60028-2007, except for editorial changes, the main technical changes are as follows.

- Expanded the scope of application of the standard;
- Integrate the contents of FZ/T 60028-2007 into the third chapter of FZ/T 60027-2007. The sample specifications are directly in accordance with GB/T 8629-2017 companion requirements;
- Modified the sample preparation, no longer prepare different samples according to different sewing threads;
- Modified the method of continuous sewing, on the basis of retaining the ring sewing, increased the folding back sewing test method;
- Increased the requirement of the bottom line when sewing, and listed the sewing tension reference value;
- Increased the special requirements for speed, needle number and stitch length.
- Removed the rating content and added a chapter on the trial report.

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

This standard is under the jurisdiction of the National Technical Committee for Home

Textiles Standardization Technical Committee (SAC/TC302/SC2).

This standard was drafted. Hujiang Line Industry Co., Ltd., Zhejiang Dongyi Line Co., Ltd., Shishi City Feilun Line Weaving Co., Ltd., Jiangsu Yufeng Line Industry Technology Co., Ltd., Zhejiang Hujiang Line Industry Co., Ltd., Shanghai Textile Industry Technology Supervision Institute.

1 Scope

This standard specifies the principle, equipment and materials, test conditions and operation of the sewing thread (flat seam) seamability measurement method.

This standard applies to polyester, nylon, vinylon, aramid, cotton sewing thread for sewing apparel, home textile fabrics, cotton wax sewing thread, core seam for sewing products, etc., sewing thread for other purposes can be referred to.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 6529 Standard atmosphere for textile commissioning and testing GB/T 8629-2017 Home washing and drying procedures for textile testing

3 Principle

Sewing thread sewability measurement is carried out on industrial high-speed sewing machine for sewing according to the specified speed, needle number, stitch length, sample and other conditions.

The number of disconnections of a predetermined length is used as a means of expressing the seamability of the sewing thread.

4 Equipment and samples

4.1

Equipment. Industrial high-speed sewing machine (single needle).

4.2

Needle. Industrial sewing machine needle.

4.3

The sample specifications shall comply with the specifications of Type B of washing machine type B in GB/T 8629-2017.

5.1 Test conditions

The sample and sample shall be conditioned for 24 h according to GB/T 6529, and the sewing test shall be carried out under standard temperature and humidity conditions.

5.2 Sampling

Three samples were randomly sampled per batch.

5.3.1 Method 1. Ring sewing test sample preparation

A sample having a length of 200 cm and a width of 10 cm was taken, and six samples were flattened, and the layers were arranged in a staggered manner. Sew the center line first, Then, a line is sewed equally to the two sides, and finally two side lines are sewn, and five parallel lines are sewed together. Stitched and flattened into a ring, ring joint According to Figure 1, a horizontal line is drawn with a colored stroke at the joint, and the number of turns is calculated starting from the joint.