

ICS 59.080.30
CCS W 59

FZ

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

FZ/T 64033-2014

Replacing FZ/T 64004-1993

**Spun-thermal bonded nonwoven
(English Translation)**

Issued on: December 24, 2014

Implemented on: June 1, 2015

**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 GB/T 1.1-2009 given rules.

Instead of the standard FZ/T 64004-1993 "thin bonding nonwoven fabric" in spunbond nonwovens.

This standard FZ/T 64004-1993 spunbond nonwovens compared to the requirements, the main differences are as follows.

--- The separated FZ/T 64004-1993 spunbond nonwovens section to "hot-rolled spunbond non-woven fabric" as the standard name;

--- On the scope of the table has been modified;

--- References to normative standard references, the referenced standard replace the corresponding national standards;

--- Delete the original standard product classification and terminology of two chapters;

--- Technical requirements "mechanical performance" with "intrinsic quality" to delete the first-class goods and qualified for classification, increasing the unit area Product quality coefficient of variation, elongation at break;

--- Technical requirements "appearance of defects" to "visual quality", adds color, bad trimming, soft pleated and lumps, turning net, oil and splicing times to frit, poor lapping, foreign bodies and joints;

--- Standard test method replace the corresponding national standards, increase the content of the test method;

--- Modify the sampling inspection rules, determining the intrinsic quality, appearance and quality determination result of the determination;

--- Signs, packaging, transportation and storage of content has been modified.

The standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee Textile (SAC/TC209) centralized.

This standard was drafted. Zhejiang Huayin Nonwovens Co., Ltd., Jiangxi State Bridge Industrial Co., Ltd., China Textiles Industry Association Council Ouhai Changlong Chemical Fiber Plant, Jinjiang Xingtai Nonwoven Products Co., Ltd., Foshan City Salong Pute kinds of materials Co., Ltd., Zhejiang Three new Textile Group Co., Ltd. Shandong Thai-Peng non-woven, fabric Burghardt Dalian Group Co., Ltd., Shandong Chun Fu Nonwovens Ltd., Nanhai, Foshan City shall be blessed Nonwovens Co., Hongda Research Institute Co., Ltd., Dalian Huayang Engineering Co., Ltd., Quanzhou East Xiang Chemical Textile Co., Ltd.

1 Scope

This standard specifies the hot rolling spunbond nonwovens technical requirements, test methods, inspection rules, packaging, labeling, transport and storage.

This standard applies to polypropylene, polyester as the main raw material, melt spinning into the net, made of hot rolled bonded nonwoven fabric.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 250 textile color fastness test assessing change in color like the gray card
Determination of GB/T 4666 Textiles length and width of GB/T 5709 Textiles Nonwovens term Determination of mass per unit area. GB/T 24218.1 Textiles nonwovens Test methods - Part 1 GB/T 24218.3 Nonwoven Textiles - Test methods - Part 3. breaking strength and elongation measurement (strip method)

3.1 Intrinsic quality

3.1.1

Hot-rolled polypropylene spunbond nonwovens inherent quality requirements to comply with Table 1.

Table 1 hot-rolled polypropylene spunbond nonwovens internal quality requirements project

Specifications/(g/m²) 1,015,203,040,506,070 8,090,100,110,120,150 Width deviation/mm ± 3 Partial mass per unit area Slip /% $\pm 8 \pm 7 \pm 5 \pm 4 \pm 3$ Variation of mass per unit area coefficient/% $\leq 7 \leq 6$ Breaking strength/N 13 2,025,406,075,100,110,120 135,140,145,150,180 9,141,627,355,565,758,090 100 110 120 130.

Elongation at break /% ≥ 30 Note. Specifications expressed in mass per unit area. Specifications Table dimension between adjacent between specifications, according to the interpolation method to calculate the corresponding evaluation indicators; out of spec Products, as per contract.

3.1.2

Hot-rolled polyester spunbond nonwovens intrinsic quality requirements shall be in accordance with Table 2.